INSTALLATION INSTRUCTIONS FOR MOUNTING C-3514-DM-BR TO REXROTH M4-12 VALVE

PREPARE VALVE FOR INSTALLATION:
1. MAKE SURE VALVE SPOOL AND VALVE FACE ARE FREE OF FOREIGN PARTICLES
2. REMOVE (2 EA.) CAPSCREWS HOLDING SPRING COVER ON VALVE HOUSING (DISCARD BOLTS & COVER)
3. REMOVE SHOULDER BOLT HOLDING SPRING CUPS AND SPRING (DISCARD BOLTS, SPRING CUPS, SPRING, AND STEEL SPACER PLATE)
4. REMOVE REMAINING COMPONENTS (DISCARD STEEL ADAPTER FLANGE, SEAL, ALUMINUM ADAPTER PLATE, & O-RING)
5. CLEAN VALVE FACE

INSTALLATION OF CYLINDER:
1. CYLINDER DOES NOT HAVE TO BE DISASSEMBLED TO INSTALL
2. INSTALL O-RING ① INTO FACE GROOVE OF ALUMINUM ADAPTER PLATE ③ (USE A SMALL AMOUNT OF GREASE TO ASSIST O-RING RETENTION)
3. APPLY A REMOVABLE GRADE OF "LOCTITE" ⑥ TO THREADED ID PORTION OF VALVE SPOOL (M12 x 1)
4. WHILE KEEPING O-RING RETAINED IN ADAPTER PLATE, ATTACH CYLINDER ASSY TO VALVE SPOOL BY USING A 3/16" HEX WRENCH ENGAGED IN PISTON ⑫ HEX POCKET (ACCESED THROUGH THE 1/8" NPT FITTING PORT IN BACK SIDE OF CYLINDER ASSY), AND THREAD THE STOP ⑬ INTO VALVE SPOOL.
5. HOLD SPOOL FROM ROTATING ON OPPOSING END, TIGHTEN TO ~ 10-12 FT. LBS
6. SEAT CYLINDER ASSY AGAINST VALVE FACE, AND ORIENT TO MATCH UP BOLT PATTERN MOUNT ADAPTER PLATE TO VALVE FACE WITH (2 EA.) M6-1 x 16 MM LG SKT. HD. CAP SCREWS, USING A 5MM (3/16") HEX WRENCH TIGHTEN BOLTS TO ~ 6-9 FT. LBS
7. TEST FOR PROPER ALIGNMENT BY TURNING VALVE SPOOL WITH A 3/16" HEX WRENCH ENGAGED IN PISTON ⑫, VALVE SPOOL SHOULD ROTATE FREELY
8. INSTALL FITTINGS AND AIRLINES, TEST FOR PROPER OPERATION

ITEM NO. PART NO. DESCRIPTION QTY
1 4510- O-RING 2-122, 1-5/16 OD x 1-1/8 ID 1
2 5034- O-RING, 23MM OD x 18MM ID x 2.5MM W 1
3 5035- PLATE, EXTENSION ADAPTER 1
4 46152- SHCS, M6-1.00 x 16 MM LG ZINC PL 2
5 1369- O-RING 2-026, 1-3/8 OD x 1-1/4 ID 1
6 5052- STOP, SPOOL THREAD ADAPTER 1
7 46191A BUSHING, FLANGE 1
8 36351A SPRING, 104 ID x 1.24 OD x 1.87 LG 1
9 36381A SPACER 1
10 LOCTITE 222 LOW STRENGTH THREAD LOCK COMPOUND 1
11 40541B PISTON, 1-1/4 RD STEEL 1
12 4029- QUADRING 4-214, 1-3/8 OD x 1-1/4 ID 1
13 4053E CYLINDER BODY, C-3526-DM 1
14 34042- SHCS, 1/4-20 x 2 LG ZINC PL 2
15 4478- LABEL BLANK, 1.75 x 1.25 1
16 LOCTITE 222 CUSTOMER SUPPLIED REMOVABLE LOW STRENGTH THREAD LOCK COMPOUND 1

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE AS FOLLOWS:
 Length = 0 + .006 Width = 0 + .003

DRAWN BY: J. S. 
CHECKED BY: J. S.
APPROVED BY: J. S.

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DO NOT SCALE DRAWING 1 - 1

B14V549 C-3514-DM-BR-EXP. B