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

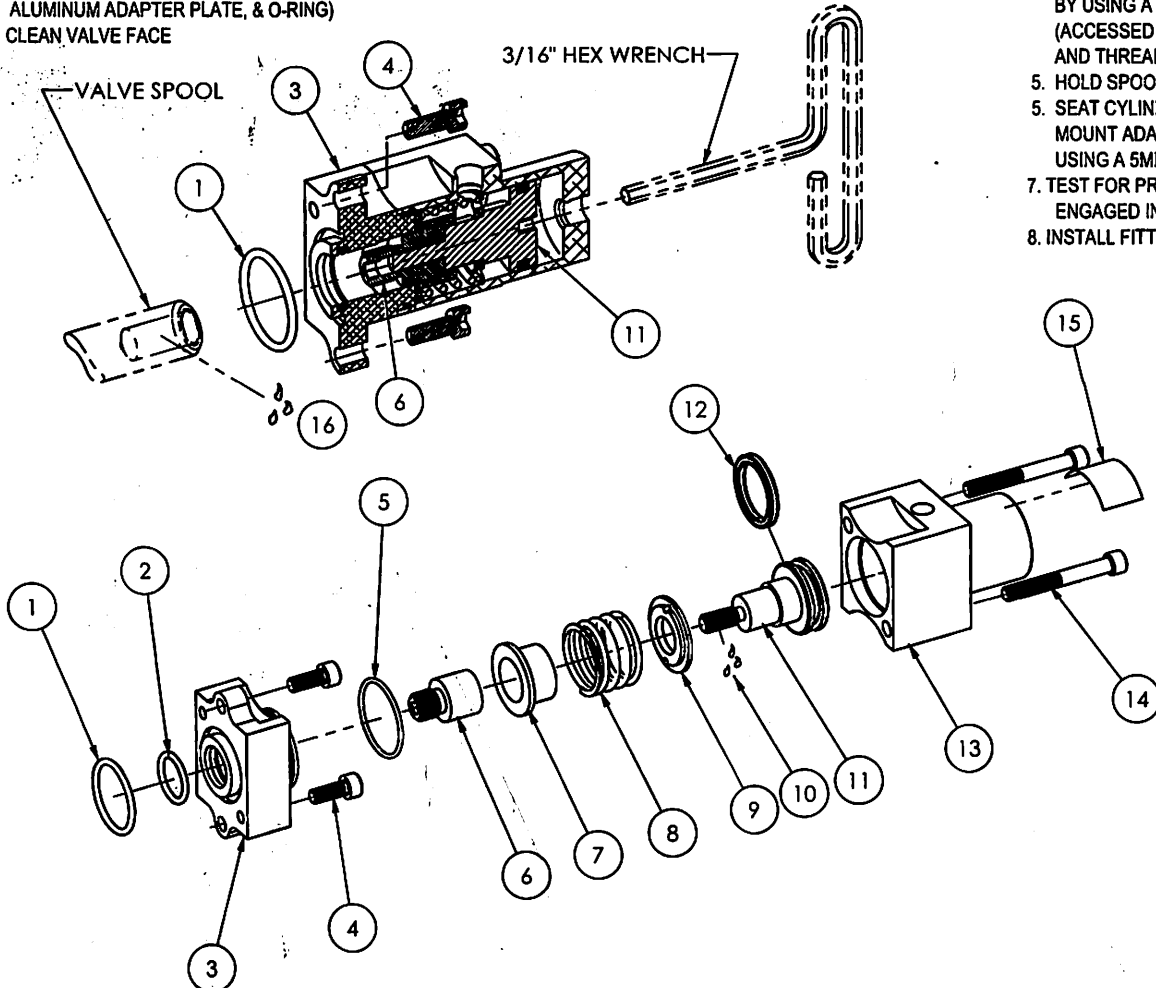
PREPARE VALVE FOR INSTALLATION:

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

REV		REVISIONS	APPROVAL	DATE
B		DESCRIPTION	GK	07/06/08
		LOCTITE 222 / LOW STRENGTH (LINE ITEM 10 & 16) WAS LOCTITE 271 / HIGH ST., LOCTITE 242 / MED ST.		

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" (16) TO THREADED ID PORTION OF VALVE SPOOL (M12 x 1)
4. WHILE KEEPING O-RING RETAINED IN ADAPTER PLATE, ATTACH CYLINDER ASSY ON TO VALVE SPOOL BY USING A 3/16" HEX WRENCH ENGAGED IN PISTON (11) HEX POCKET (ACCESSED THROUGH THE 1/8" NPT FITTING PORT IN BACK SIDE OF CYLINDER ASSY), AND THREAD THE STOP (6) INTO VALVE SPOOL,
5. HOLD SPOOL FROM ROTATING ON OPPOSING END, TIGHTEN TO ~ 10-12 FT. LBS
5. 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 (4), 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 (11), 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	4615Z)-	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 ADAPTOR	1
7	4619)A	BUSHING, FLANGE	1
8	3635)A	SPRING, 1.04 ID x 1.24 OD x 1.87 LG	1
9	3638)A	SPACER	1
10	LOCTITE 222	LOW STRENGTH THREAD LOCK COMPOUND	1
11	4054)B	PISTON, 1-1/4 RD STEEL	1
12	4029)-	QUADRING 4-214, 1-3/8 OD x 1-1/4 ID	1
13	4053)E	CYLINDER BODY, C-3526-DM	1
14	3404Z)-	SHCS, 1/4-20 x 2 LG ZINC PL	2
15	4498)-	LABEL BLANK, .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:
 ANGLES - ±1°
 DECIMALS
 .X = ±.010
 .XX = ±.005
 .XXX = ±.001
 SURFACE TEXTURE OR BETTER

APSCO, Inc.
 8178 EAST 44TH STREET
 TULSA, OK 74145

DATE 11-20-07	APPROVED GK	DATE 07-06-09
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**EXPLODED ASSY,
 C-3514-DM-BR**

SIZE B	DATE CODE 4V549	DRAWING NO. C-3514-DM-BR-EXP	REV B
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DO NOT SCALE DRAWING SHEET 1 of 1

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SOLDWORKS