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C-3516-DM Cylinder Installation Instructions

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Note: Cylinder does not have to be disassembled to install.

Stage 1: Prepare Valve for Installation

Tools Needed: 3/16" Allen Wrench

1. Inspect Valve Spool and Valve Face to insure they are free of any foreign substance (dust, dirt, etc.).
2. If necessary, remove four (4) old/pre-existing Cap Screws holding Spring Cover on Valve Housing. Discard old/pre-existing Cap Screws and Spring Cover.
3. If necessary, remove Shoulder Bolt holding Spring Cups and Spring. Discard old/pre-existing Shoulder Bolt, Spring Cups, Spring, and steel Flange.

Stage 2: Cylinder Installation

Tools Needed: 3/16" Allen Wrench

1. Apply one (1) drop of Loctite to threaded portion of Valve Spool as shown in Figure 1.

Apply Loctite to
Valve Spool threads

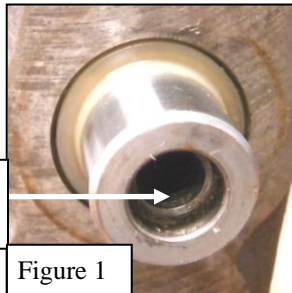


Figure 1

2. Using 3/16" Allen Wrench in rear fitting port of Cylinder, thread Cylinder onto Valve Spool as shown in Figure 2. Tighten firmly to 96 in-lbs by holding spool on opposite end.

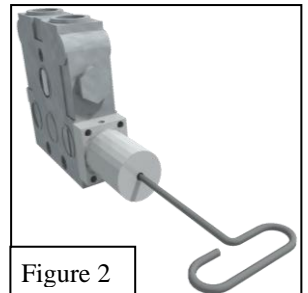


Figure 2

3. Thread Socket-Head Cap Screws through mounting holes in Cylinder Assembly to matching holes in Valve Housing as shown in Figure 3. Tighten firmly in a zig-zag pattern to 12 ft-lbs using 3/16" Allen Wrench and by holding spool on opposite end.

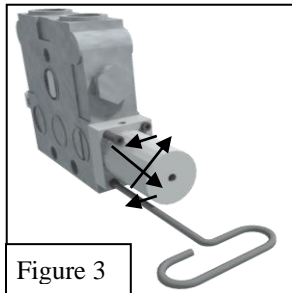


Figure 3

4. After assembly has been completed, test for proper alignment by turning Valve Spool using 3/16" Allen Wrench in rear fitting port of Cylinder as shown in Figure 4. Valve Spool should rotate freely.

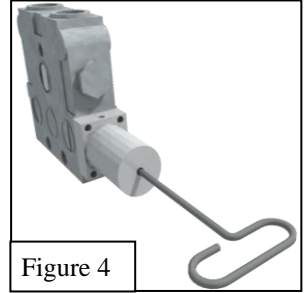


Figure 4

5. Once assembly has been completed, **APPLY THREAD SEALANT TO ALL FITTINGS**, install fittings and airlines and test for proper operation.