

## Sauer Danfoss PVG-32

### INSTALLATION INSTRUCTIONS C-3832-DM

#### Prepare Valve for Installation:

1. Make sure that valve spool and valve face is free of any foreign particles.
2. Remove (2) capscrews holding spring cover on valve housing. (Discard cover)
3. Remove shoulder bolt holding spring cups and spring. Discard bolt, spring cups and spring.
4. Remove (4) capscrews from seal plate (**Note: Sealing, Gasket and Capscrews will be reused**)

#### Installation of Cylinder:

1. Cylinder does not have to be disassembled to install.
2. Install new seal plate to valve reusing Sealing, Gasket and capscrews (Torque 48 in lbs)
3. Apply loctite to threaded portion of valve spool.
3. Secure piston assembly to valve spool by using a 3/16" hex wrench in rear fitting port of cylinder. Tighten by holding spool on opposing end. (Torque 10 ft lbs)
4. Secure cylinder housing to valve housing by using a 5 mm hex wrench (Torque 48 in lbs)
5. Test for proper alignment by turning valve spool with the 3/16 hex wrench. Valve spool should rotate freely.
6. Install fittings and airlines and test for proper operation.