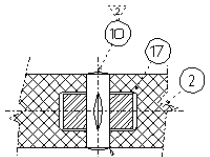
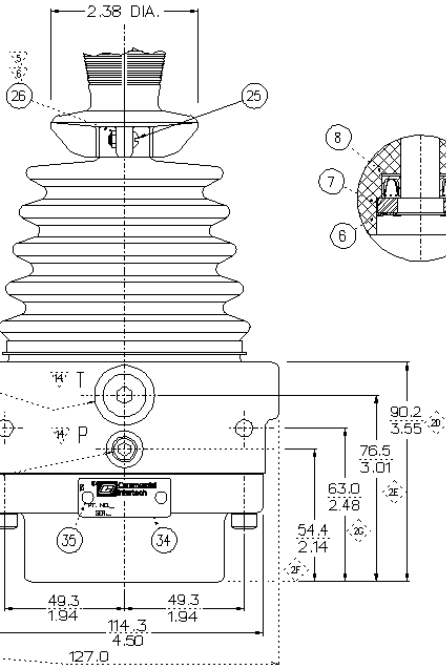


M6 X 1.0 THD. .50 DP.
TYP. @ 4 PLACES
(MAXIMUM TORQUE 55 N-LBS)



APPLY KRYTOX GPL 224 TO HOLE
IN ALUMINUM HOUSING BEFORE
PRESSING PIN.

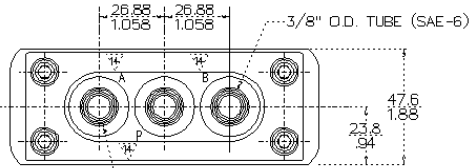
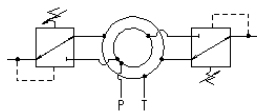
SECTION B-B



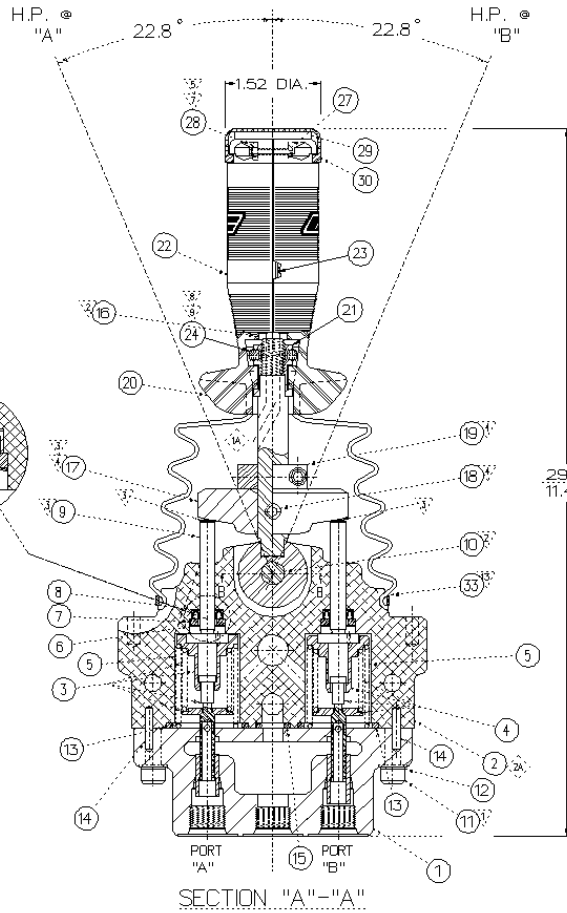
3/8" O.D. TUBE (SAE-6)
(PLUGGED)

28 DIA. TYP.

1/8" N.P.T. (PLUGGED)



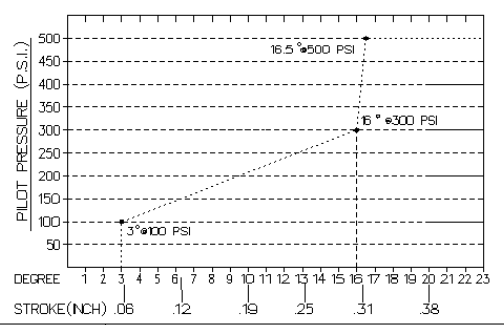
TYP.



NOTES:

- 1. CAP SCREWS ARE TO BE TORQUED TO 55 IN-LBS.
- 2. PIVOT PIN IS TO BE PRESSED THRU ALUMINUM HOUSING (IT.#2) AND HANDLE (IT.#16). PIN IS TO BE TIGHT ON ASSY. AND FREE MOVING ON ALUMINUM HOUSING.(SEE SECT. B-B)
- 3. APPLY KRYTOX GPL 224 TO PARTS AS INDICATED.
- 4. WITH SHAFT IN A CENTERED POSITION, DROP ROCKER DOWN TO LAY ON PLUNGERS. DO NOT DEPRESS PLUNGERS. SQUARE UP ROCKER ON PLUNGERS AND TIGHTEN SET SCREW (IT.#18) ON ROCKER. TIGHTEN COLLAR (IT.#19) TO 55 IN-LBS TORQUE. THEN TIGHTEN SET SCREW (IT.#18) N ROCKER TO 55 IN-LBS TORQUE.
- 5. APPLY LOCTITE 222 (PURPLE) PER MANUFACTURERS INSTRUCTIONS.
- 6. TORQUE TO 12 +2 IN.-LBS.
- 7. TORQUE TO 5 +1 IN.-LBS.
- 8. APPLY LOCTITE 242 (RED) PER MANUFACTURERS INSTRUCTIONS.
- 9. TORQUE TO 25-30 IN.-LBS.
- 10. TORQUE ITEM #31 TO 125 +5 IN.-LBS.
- 11. TORQUE ITEM #32 TO 125 +5 IN.-LBS. (USE PERMA-LOCK TEFLON THREAD SEALANT.)
- 12. TORQUE PROCEDURE:
IMPACT WRENCHES TO BE LIMITED TO 50% OF FINAL TORQUE VALUES. FINAL TORQUING IS TO BE PERFORMED WITH HAND TORQUE WRENCHES. USE AN "OPPOSITE CORNER" PATTERN WHEN TORQUING.
- 13. TIE WRAP IS TO BE ASSEMBLED, TIGHTENED AND EXCESS TRIMMED AFTER FINAL TESTING & EXTERNAL LEAKAGE TESTING IS COMPLETED. WHEN TRIMMING EXCESS STRAP, LEAVE APPROX. 1/2" EXTENSION TO FACILITATE REUSE OF STRAP.
- 14. STAMP PORT I.D. AS INDICATED, USE .12" TALL LETTER STAMP.

ITEM	PART NO.	REQD.	DESCRIPTION
35	391 1432 004	2	DRIVE SCREWS
34	391 2183 139	1	NAME PLATE
33	391 0921 006	1	TIE WRAP 14.50 LG.
32	391 2282 020	2	1/8" NPT PLUG
31	391 2281 012	1	3/8" ODT PLUG
30	391 4041 043	1	BOOT HANDLE
29	391 3385 092	1	SLUG NYLON
28	391 1451 125	2	NUT #4-40
27	391 1401 436	2	SCREW #4-40 x .625 RND. HD.
26	391 1451 126	2	NUT #8-32
25	391 1401 437	2	SCREW #8-32 x .500 RND. HD.
24	391 1431 155	2	SCREW SET #10-24UNF
23	391 2883 155	0	FOAM CORD (4.56)
22	361 8901 017	2	HANDLE SECTION
21	391 3384 298	1	RETAINER SLEEVE
20	391 4041 044	1	BOOT
19	391 3384 257	1	COLLAR CLAMP-TITE
18	391 1401 395	1	SCREW ALLEN
17	391 1841 073	1	ROCKER
16	361 9100 120	1	LEVER
15	391 2881 789	1	SEAL O-RING
14	391 2082 042	2	PIN BOWEL
13	391 2881 462	2	SEAL O-RING (1.11 ID X 1.32 OD)
12	391 3782 015	4	WASHER
11	391 1401 190	4	SCREW CAP
10	391 2080 031	1	PIN PIVOT
9	391 2383 059	2	PLUNGER
8	391 2885 035	2	SEAL WPER (FURON)
7	391 2584 122	2	WASHER
6	391 2694 096	2	RING RETAINING
5	391 3581 806	2	SPRING RETURN
4	361 9100 013	1	SPCOOL SUB-ASSY(PORTR B)(100-300 PSI)
3	361 9100 013	1	SPCOOL SUB-ASSY(PORTR A)(100-300 PSI)
2	361 1900 901	1	HOUSING #1
1	361 1700 901	1	HOUSING #2



032700 J/F 95571	ZH 11.46 WAS 11.33
EXP NO.	3C 2.48 WAS 2.36
	2F 2.14 WAS 2.02
	2E 3.01 WAS 2.90
	2D 3.55 WAS 3.42
FRST USED	2C ADDED 224 TO "KRYTOX GPL"
98-01-536	2B ITEM #13 WAS 391 2881 402
	2A PICTORIALLY UPDATED ITEM #2
361 9118 367	SWC REVISIONS 081500 JAB 95735

MATERIAL	QTY	UNIT	DESCRIPTION	DRBY	DATE	CHKD	DATE	SCALE
J/F	081500			J/F	022798	ESP	030398	FULL
CHRC-SGL/FUNCT-100/300PSI-38COT				Parker Hannifin Corp. Hydraulic Valve Division, Houston, TX 77068, USA				
361 9118 367				© 2000 Parker Hannifin Corp.				