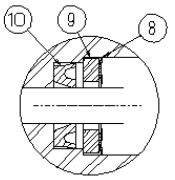
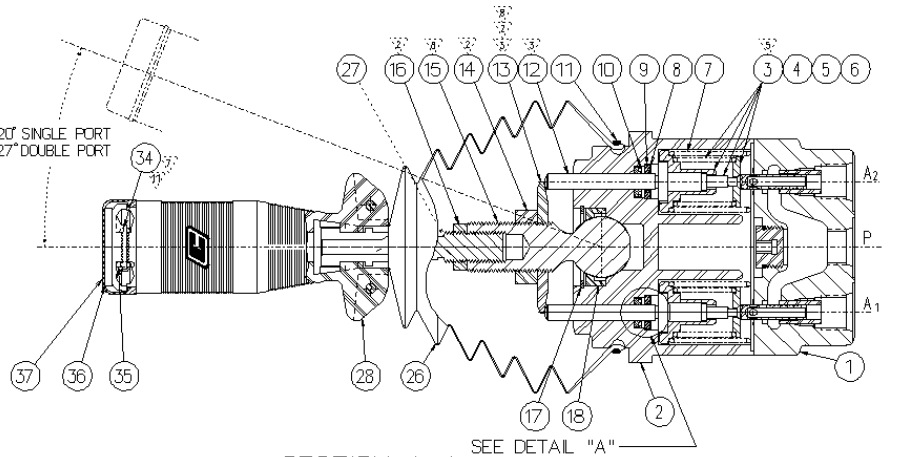
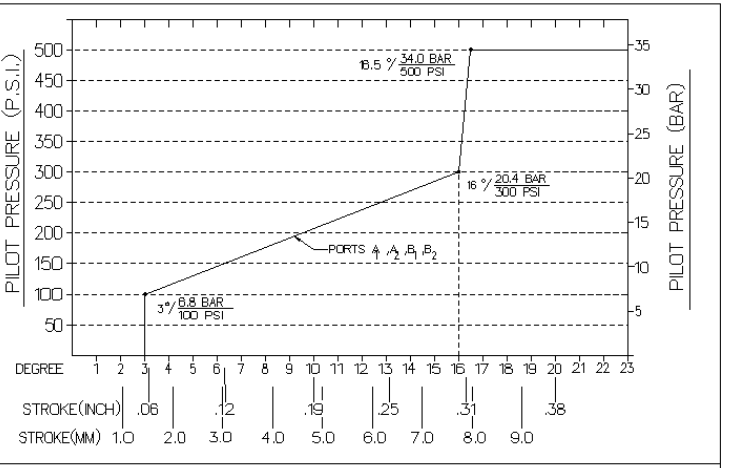


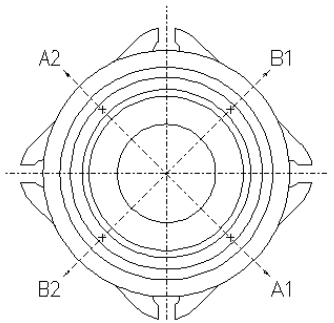
DETAIL "A"





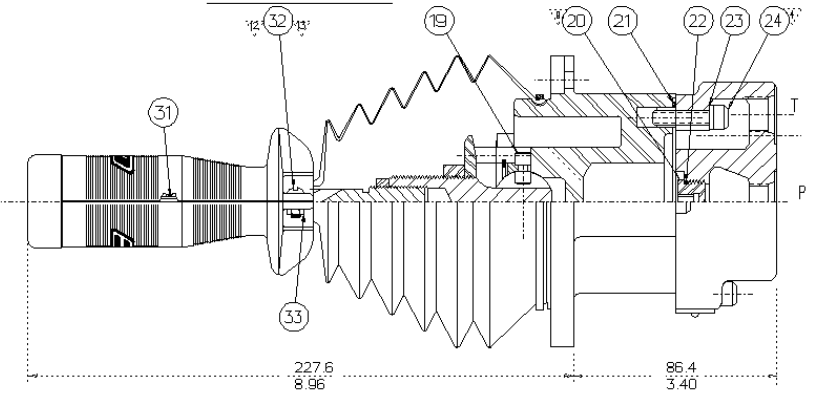
NOTES

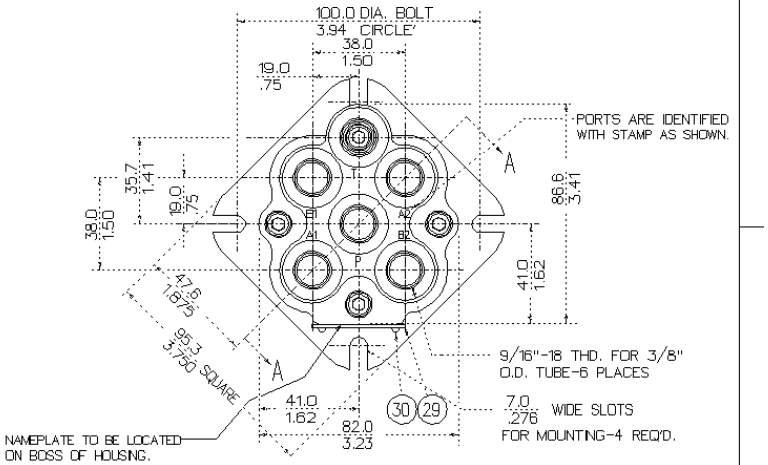
1. OPERATING PRESSURE 27-34 BAR 400-500 PSI
   FLOW 7.6-19.0 L/M 2-5 GPM
2. FOR ADHESIVE INSTRUCTIONS SEE H.E. STD. 35-20
3. CLEARANCE BETWEEN ITEMS 12 AND 13 IS TO BE .000-.25 MM .000-.010 IN.
4. TORQUE ITEM #24 TO 5.7 N-M 50 IN-LB.
5. NOTE!!PROPER SPRING ORIENTATION TO PORTS IS CRITICAL.
6. ITEM #25 IS NOT SHOWN.
7. TORQUE ITEM #34 TO 5 ±1 IN.-LBS.

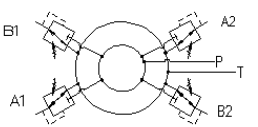


8. APPLY A LIGHT COATING OF DUPONT "KRYTOX GPL202" TO BALL OF IT.#15 AND BEVEL OF IT.#13.
9. TORQUE ITEM #20 TO 14.3 N-M 125 IN-LBS
10. REFER TO "A" SIZE DWG. WITH SAME PART NUMBER FOR TEST SPECS.
11. APPLY LOCTITE 222 (PURPLE) TO ITEM #34, PER MANUFACTURERS INSTRUCTIONS.
12. APPLY LOCTITE 242 (RED) TO ITEM #32 PER MANUFACTURERS INSTRUCTIONS.
13. TORQUE ITEM #32 TO 25-30 IN.-LBS.

SECTION A-A







ITEM	PART NO.	REQ'D	DESCRIPTION
37	391 4041 043	1	BOOT, HANDLE
36	391 3385 092	1	SLUG, NYLON
35	391 1451 125	2	NUT #4-40
34	391 1401 436	2	SCREW #4-40 x .625 RND. HD.
33	391 1451 126	2	NUT #8-32
32	391 1401 437	2	SCREW #8-32 x .500 RND. HD.
31	391 2883 155	0	FOAM CORD (4.56)
30	391 1432 004	2	SCREW, DRIVE (1/4 LG)
29	391 2183 139	1	NAMEPLATE
28	361 8901 017	2	HANDLE SECTION
27	391 1841 053	1	LEVER
26	391 4041 020	1	BOOT
25	391 2082 042	2	DOWEL PIN (1/8" X .62L)
24	391 1401 190	4	SCREW, SOC. HD. CAP(M6 X 1.00 X 25L)
23	391 3782 013	4	WASHER, LOCK
22	391 2881 246	0	"O"-RING (15/16" OD X 3/4" ID)
21	391 2884 031	1	SEAL, FACE
20	391 2281 012	1	PLUG, 3/8" O.D. TUBE
19	391 2088 018	1	PIN, ANTIROTATION
18	391 2582 008	1	RETAINER, BALL JOINT
17	391 2686 104	1	RING, RETAINING
16	391 1451 089	1	JAM NUT(M12 X 1.5)
15	391 1841 018	1	UNIVERSAL JOINT
14	391 1451 090	1	JAM NUT(M12 X 1.5)
13	391 2187 012	1	PUSH PLATE
12	391 2383 059	4	PLUNGER
11	391 0921 006	0	TIE WRAP
10	391 2885 035	4	WIPER SEAL
9	391 2584 122	4	SEAL RETAINER
8	391 2694 096	4	INTERNAL STOP RING
7	391 3581 806	4	SPRING, RETURN
6	361 9100 013	1	SPOOL SUB-ASSY @ PORT B2
5	361 9100 013	1	SPOOL SUB-ASSY @ PORT B1
4	361 9100 013	1	SPOOL SUB-ASSY @ PORT A2
3	361 9100 013	1	SPOOL SUB-ASSY @ PORT A1
2	361 1400 902	1	COMPOSITE HOUSING
1	361 1800 901	1	PRESS. BODY, 3/8" O.D.T.

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Commercial Intertech
Youngstown, Ohio 44501 U.S.A.

OHRC-DUAL/FUNCTION-.380DT-P.GRIP/HANDLE

MATERIAL	ECN	DRWN	DATE	CHKD	DATE	SCALE
H.E.-STD: 1-1, 35-20	CTR y REV 000000 STE WT. CODE 02	SJB	112196	EBP	112296	FULL

Tolerances Unless Otherwise Specified {WHOLE NUMBER ± .1 Place 1 PLACE DECIMAL} = dimensions

361 9148 301

DIMENSIONS ARE mm / inch

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EXP NO.	SYM.	REVISIONS
FIRST USED 96-10-509		
361 9148 301		

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(1) VISUAL CHECK FOR EXTERNAL LEAKAGE

A. PLUG PORTS A1,A2,B1,B2.
CONNECT PORT P TO 3-5 GPM SUPPLY @625 PSI.
CONNECT PORT T TO TANK RETURN.PRESSURE AT T SHOULD BE 20+-10 PSI.

B. AFTER FULLY CYCLING EACH PLUNGER SEVERAL TIMES RETURN TO NEUTRAL. USING A BLACK LIGHT INSPECT AT PINS AND AT INTERFACE SEAL FOR LEAKAGE. SLOWLY CYCLE EACH PLUNGER WHILE AGAIN CHECKING FOR LEAKAGE.

(2) MEASURE INTERNAL LEAKAGE

WITH SET-UP AS IN 1A AND LEVER IN NEUTRAL,LEAKAGE AT PORT T MUST BE LESS THAN 500 CC/MIN. THIS IS COMBINED LEAKAGE OF ALL FOUR SPOOLS.

(3) PLOT WORKPORT PRESSURE vs. HANDLE ROTATION

USE THE FOLLOWING PLASTIC OVERLAYS TO DECIDE ACCEPTANCE.

PORT	PRESS. RANGE	OVERLAY
A1	100-300	PVB-500E-23
A2	100-300	PVB-500E-23
B1	100-300	PVB-500E-23
B2	100-300	PVB-500E-23

(4) NITROGEN TEST

A. 10 PSI @ PORT T

B. 50 PSI @ PORT T

OHRC VALVE TEST SPECIFICATION SHEET

EXP NO.

FIRST USED 96-10-509

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SYM. | REVISIONS

ADM CTR REV V
DTE 000000
WT.
CODE

Commercial Intertech
Youngstown, Ohio 44501 U.S.A.

DR.BY	DATE	CH.BY	DATE	SCALE
SJB	112296	EBP	112296	NONE

361 9148 301 TS

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TBL.kav