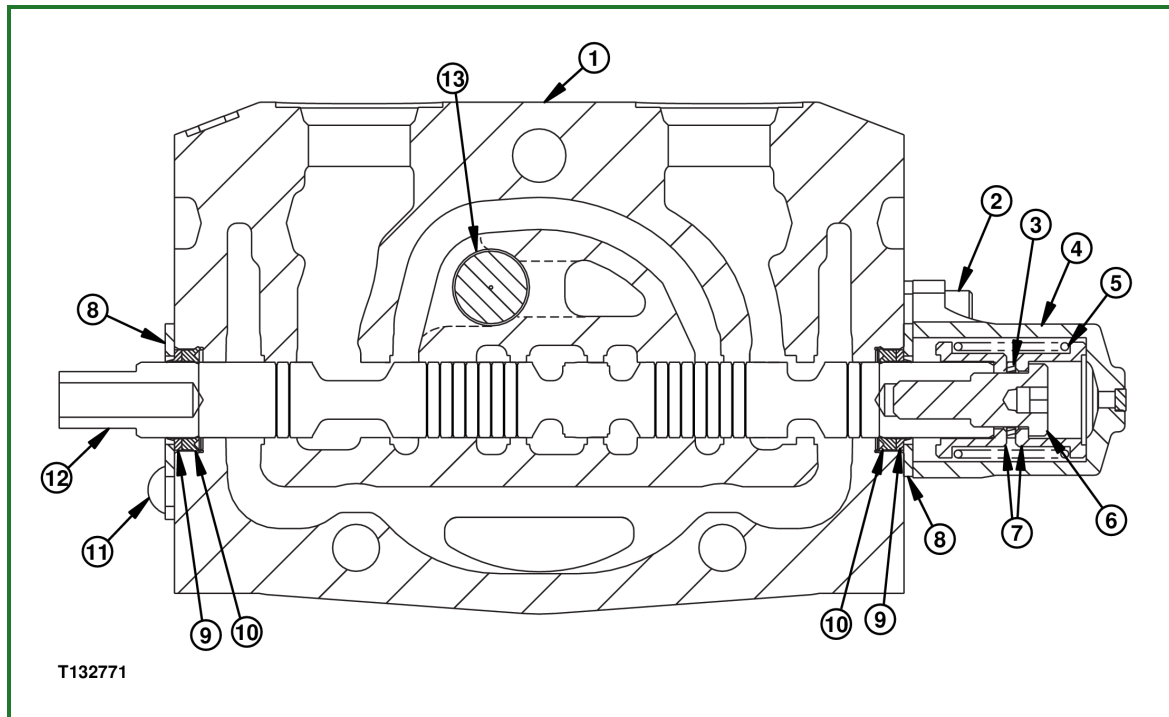


Tilt Control Valve Section Disassemble and Assemble

1. IMPORTANT:

Mark orientation of spools before disassembly. Spool MUST be installed into the valve housing at the same orientation it was removed for proper operation of the hydraulic function.



T132771-UN: Control Valve Tilt Section

LEGEND:

- 1 - Valve Housing
- 2 - Cap Screw (2 used)
- 3 - Spacer
- 4 - Cap
- 5 - Centering Spring
- 6 - Spool End Screw
- 7 - Spring Seat (2 used)
- 8 - Retaining Plate (2 used)
- 9 - Wiper Seal (2 used)
- 10 - Lip Seal (2 used)
- 11 - Screw (2 used)
- 12 - Spool
- 13 - Load Check and Spring

Mark orientation of spool (12) Remove parts (2, 4, 8 and 11) to remove spool from valve housing (1).

2. Using a protective cover or wooden blocks, put spool in vise. Remove spool end screw (6), spacer (3), spring (5), and spring seats (7).
3. Inspect parts for wear or damage. Replace all O-rings and seals.
4. Put clean hydraulic oil on spool and install spool into valve housing. Install lip seals (10) and wiper seals (9) using JDG734 Seal Installation Tool.
5. Install parts (3, 5—8) on spool. Clean threads of spool (12), and spool end screw (6) and apply cure

primer. Apply thread lock and sealer (high strength) on spool end screw. Install and tighten to specifications.

Item	Measurement	Specification
Tilt Valve Spool End Screw	Torque	9.4—9.6 N·m 83—85 lb-in.

6. Coat spring (5) with grease.

7. Assemble remaining parts. Tighten cap screws (2) and screws (11) to specifications.

Item	Measurement	Specification	Item	Measurement	Specification
Tilt Valve Spool Cap	Torque	9.4—9.6 N·m	Tilt Valve	Torque	5.4—5.6 N·m
Socket Head Screws		83—85 lb-in.	Retainer Plate Screws		48—49 lb-in.

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