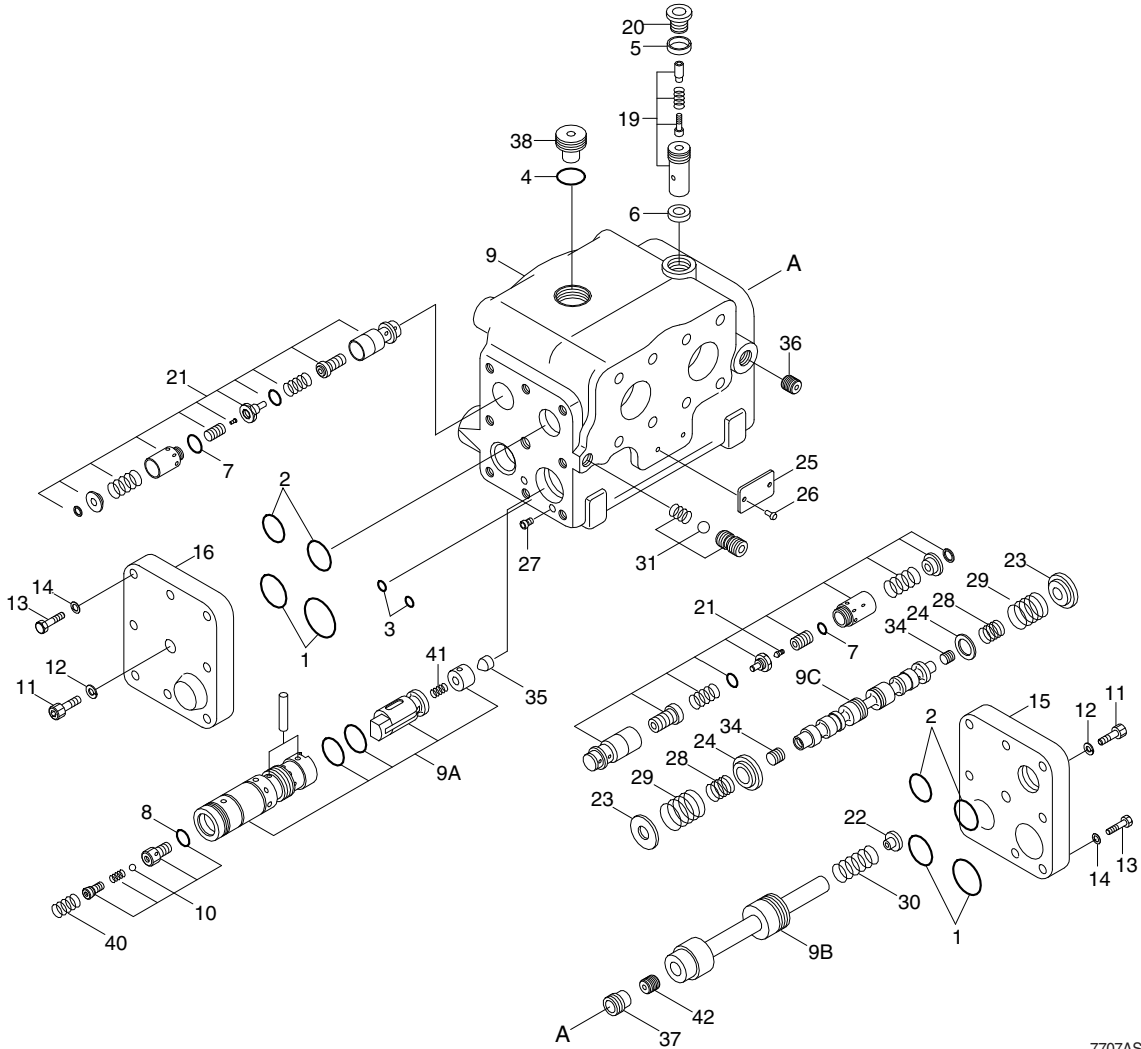


GROUP 4 DISASSEMBLY AND ASSEMBLY

1. FLOW AMPLIFIER

1) STRUCTURE

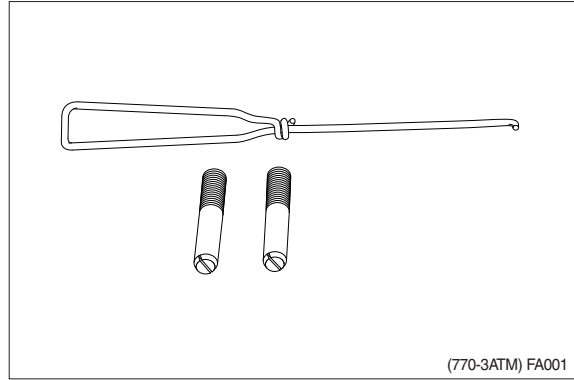


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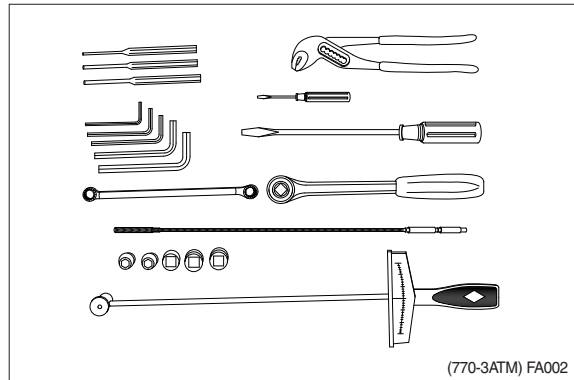
1	O-ring	12	Spring washer	28	Spring
2	O-ring	13	Screw	29	Spring
3	O-ring	14	Spring washer	30	Spring
4	O-ring	15	End cover	31	Throttle check valve
5	Washer	16	End cover	34	Orifice
6	Washer	19	Relief valve	35	Orifice
7	O-ring	20	Plug	36	Orifice
8	O-ring	21	Shock, suction valve	37	Plug
9	Housing	22	Spring seat	38	Plug
9A	Amplifier valve	23	Spring seat	40	Spring
9B	Priority valve	24	Spring guide	41	Spring
9C	Directional valve	26	Name plate	42	Orifice
10	Check valve	27	Orifice		
11	Screw				

2) TOOLS

- Guide screws : M8 × 1.0
- Hook : Wire



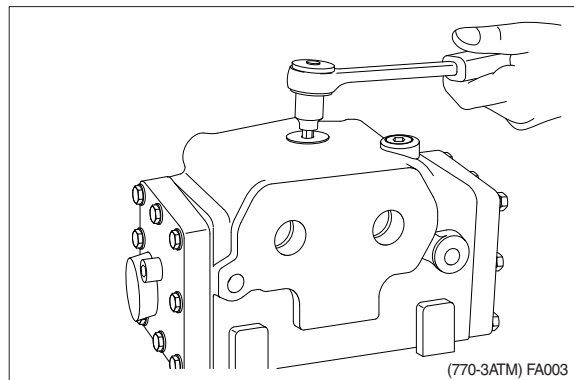
- Hexagon keys : 4, 5, 6, 8 and 10 mm
- Ratchet for socket spanners
- Hex socket for external : 13, 17 & 19 mm
- Hex socket for internal : 8 & 10 mm
- Multigrip pliers
- Ring spanner: 13 mm
- Screwdrivers : 3 and 10 mm
- Steel Mandrels : 3, 5 and 8 mm
- Torque wrench : 12.2 kgf · m (88 lbf · ft)
- Magnetic rod



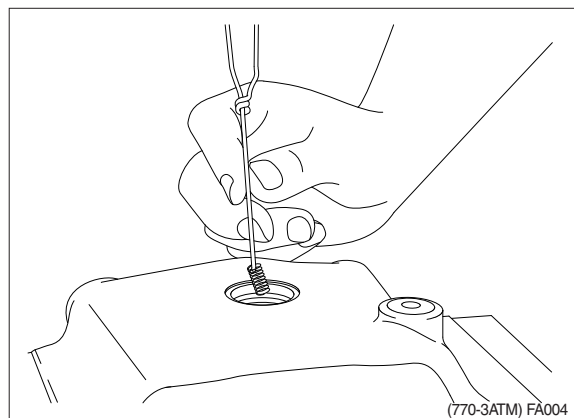
3) DISASSEMBLY

(1) Disassembly counter pressure valve

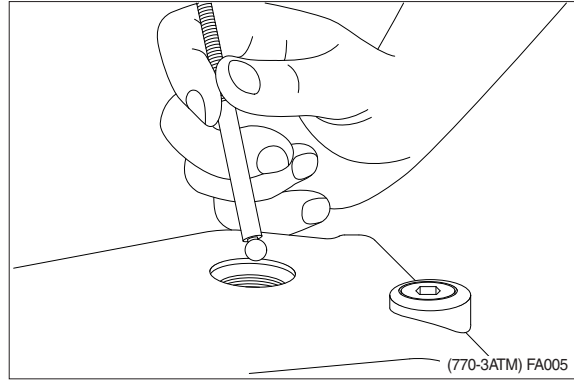
- ① Unscrew plug with O-ring (hexagon socket for 8 mm internal hexagon).



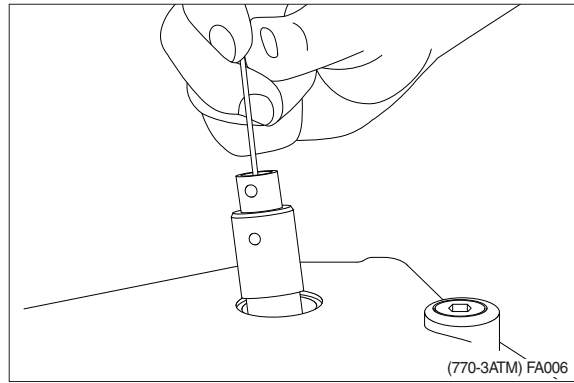
- ② Take out small spring (hook).



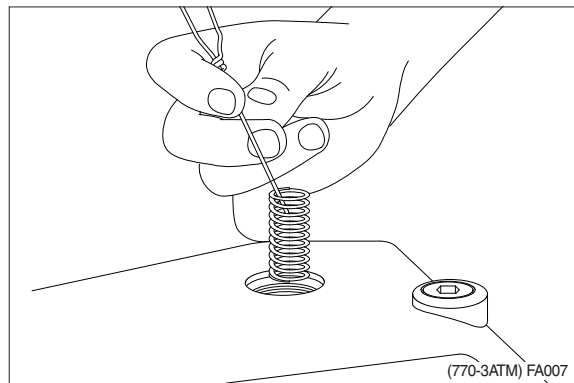
③ Take out ball (magnetic rod).



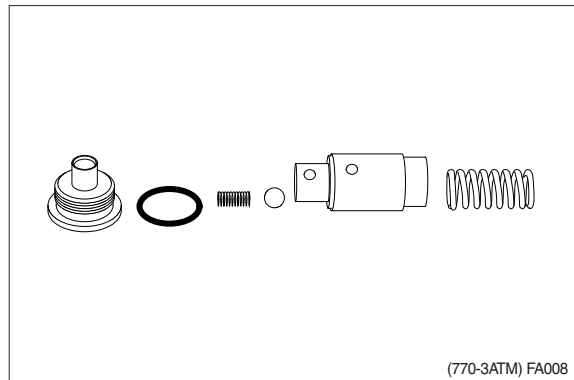
④ Take out piston.



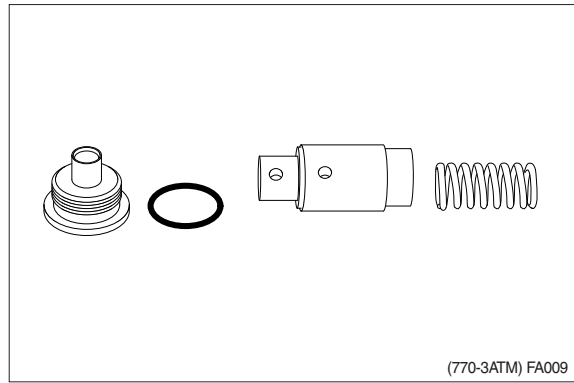
⑤ Take out spring.



⑥ Counter pressure valve shown disassembled.

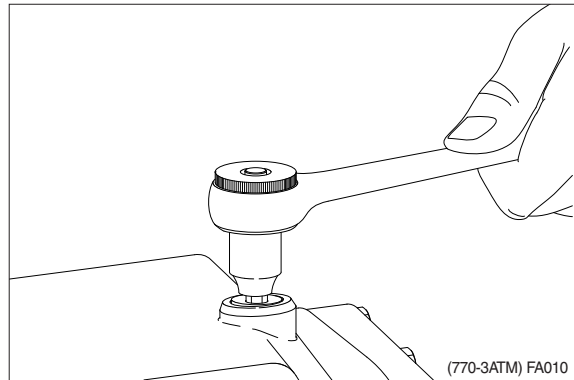


- ⑦ Counter pressure valve with orifice shown disassembled.

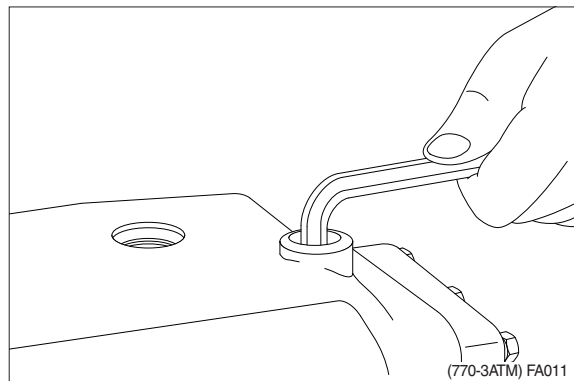


(2) Removing pressure relief valve

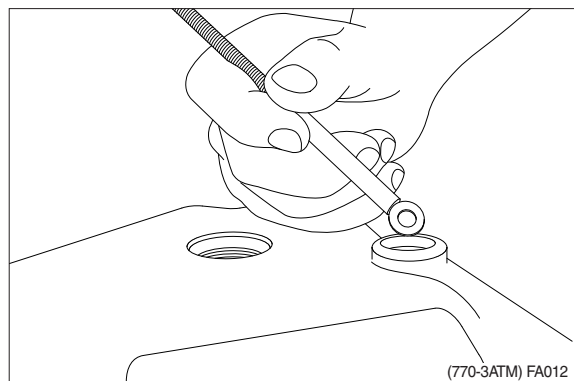
- ① Unscrew plug with washer (hexagon socket for 8 mm internal hexagon).



- ② Screw pressure relief valve out (10 mm hexagon key).

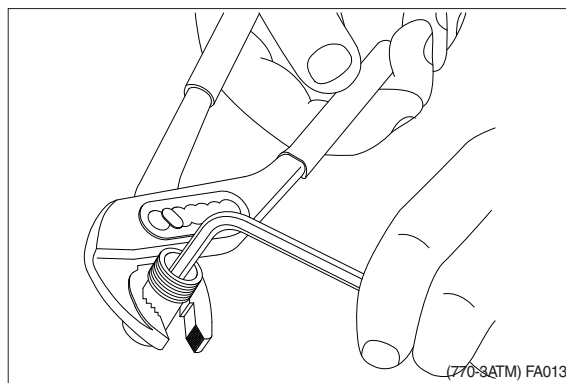


- ③ Take out washer (Magnetic rod).

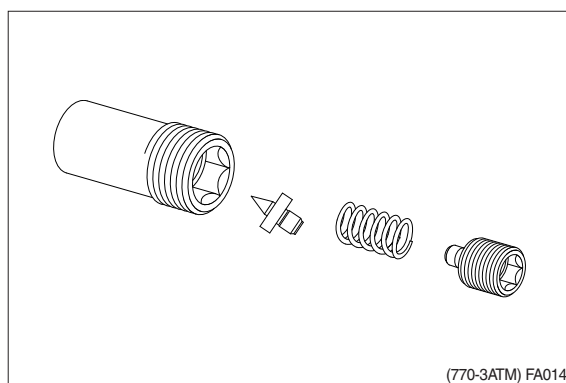


(3) Disassembly pressure relief valve

- ① Hold cartridge (multigrip pliers) and screw the adjustment screw out (5 mm hexagon key).

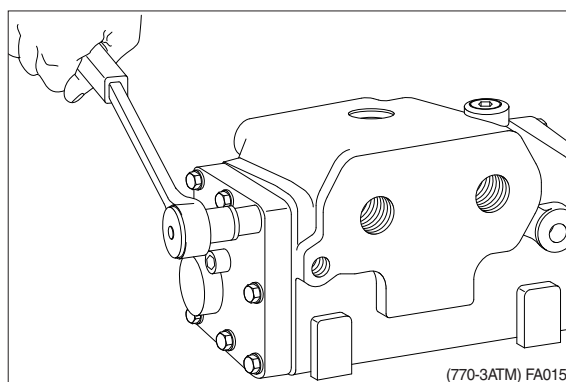


- ② Pressure relief valve shown disassembled.



(4) Removing end cover at PP-connection

- ① Unscrew screws with spring washer using hexagon socket for 13 mm external hexagon and 10 mm internal hexagon.



- ② Remove end cover.

