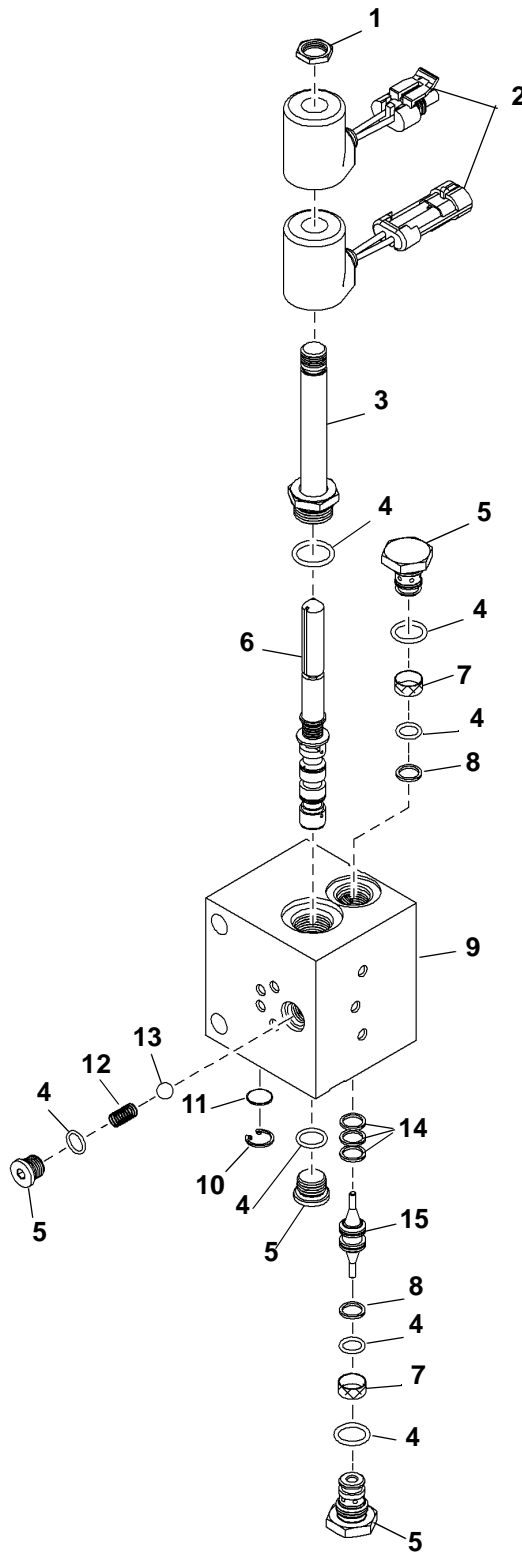


# HYDRAULIC X-CHANGE MANIFOLD (CONT'D)

## Parts Identification

1. Nut
2. Coil
3. Solenoid
4. O-ring
5. Plug
6. Stem
7. Screen
8. Back-up Ring
9. Body
10. Snap Ring
11. Screen
12. Spring
13. Ball
14. Seal Assembly
15. Spool



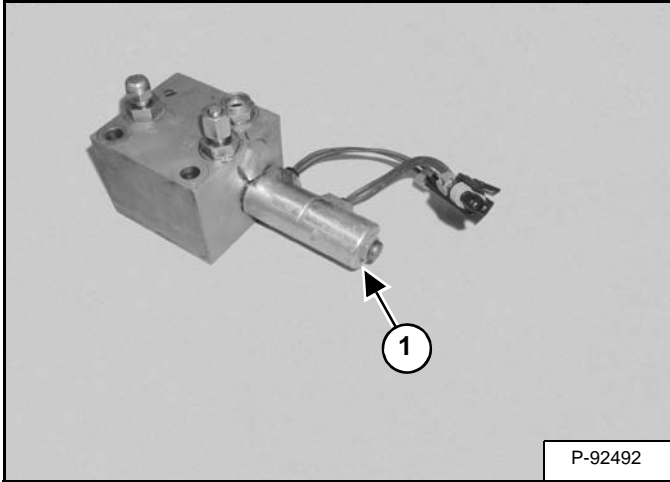
NA2303S

## HYDRAULIC X-CHANGE MANIFOLD (CONT'D)

### Disassembly And Assembly

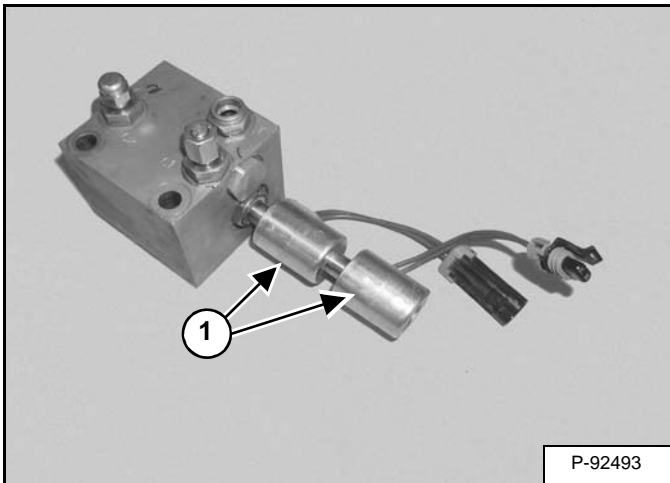
Clean the outside of the hydraulic X-Change manifold before disassembly.

**Figure 20-210-4**



Remove the nut (Item 1) [Figure 20-210-4].

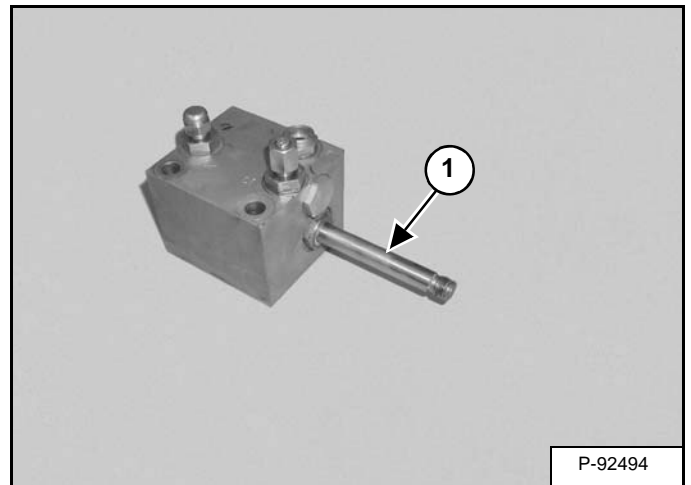
**Figure 20-210-5**



Remove the two solenoids (Item 1) [Figure 20-210-5].

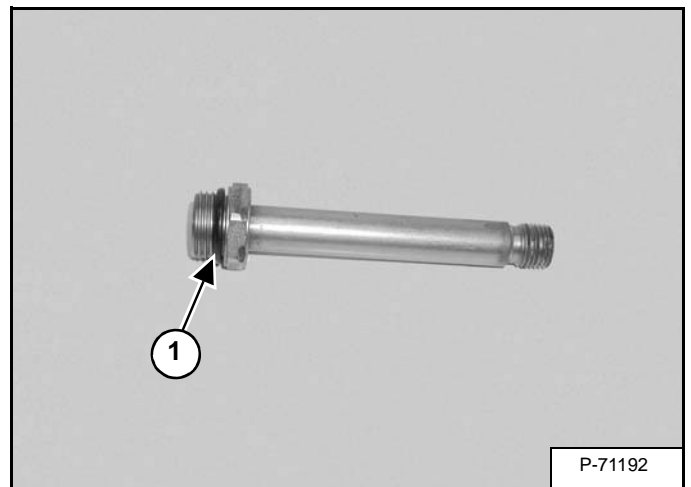
**NOTE: Mark the solenoids for correct assembly.**

**Figure 20-210-6**



Remove the spool (Item 1) [Figure 20-210-6].

**Figure 20-210-7**

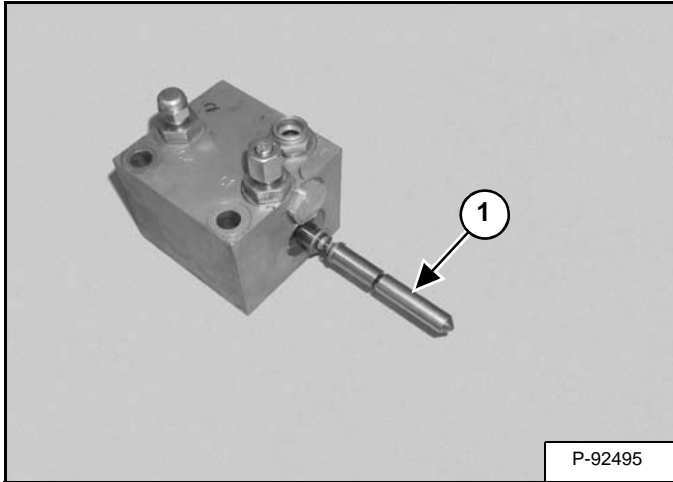


Remove the O-ring (Item 1) [Figure 20-210-7] from the spool.

## HYDRAULIC X-CHANGE MANIFOLD (CONT'D)

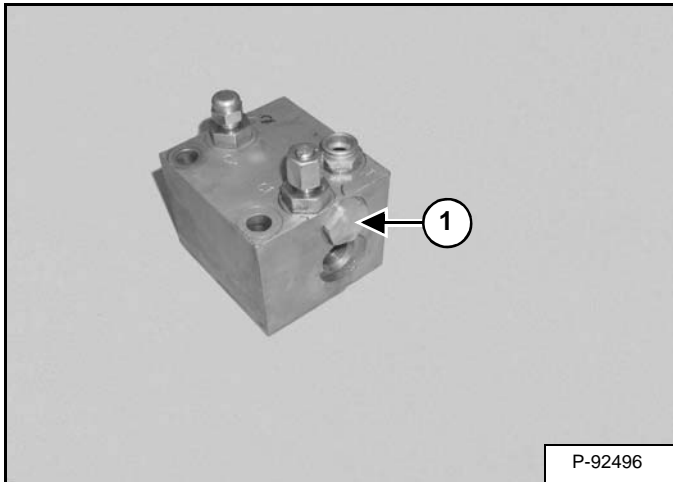
### Disassembly And Assembly (Cont'd)

Figure 20-210-8



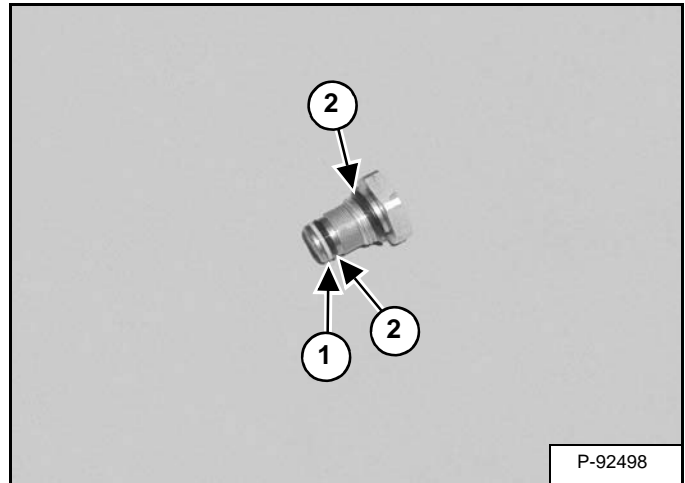
Remove the actuator assembly (Item 1) [Figure 20-210-8].

Figure 20-210-9



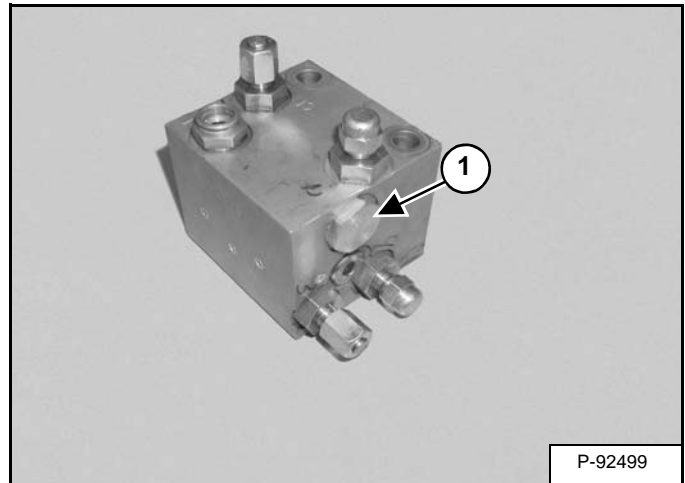
Remove the plug (Item 1) [Figure 20-210-9].

Figure 20-210-10



Remove the back-up ring (Item 1) and O-rings (Item 2) [Figure 20-210-10].

Figure 20-210-11

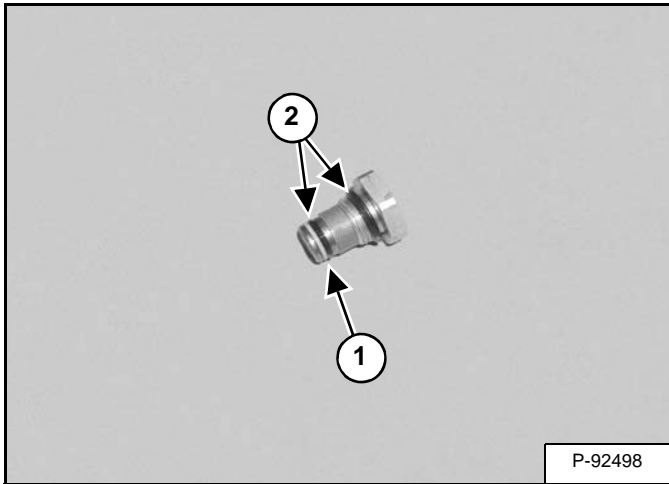


Remove the plug (Item 1) [Figure 20-210-11].

## HYDRAULIC X-CHANGE MANIFOLD (CONT'D)

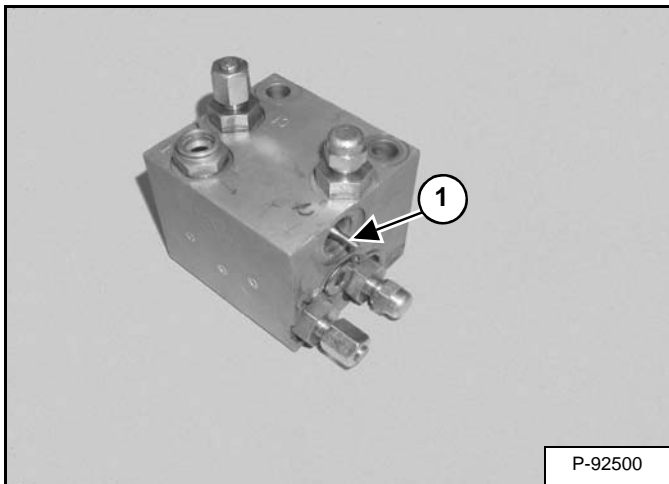
### Disassembly And Assembly (Cont'd)

Figure 20-210-12



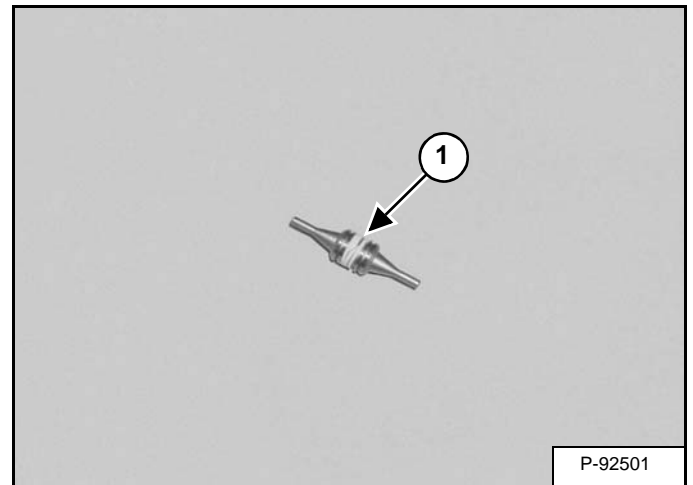
Remove the back-up ring (Item 1) and O-rings (Item 2) [Figure 20-210-12].

Figure 20-210-13



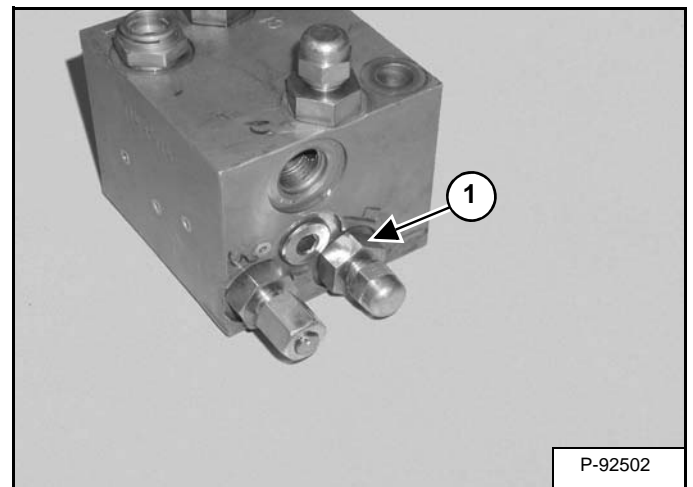
Remove the spool (Item 1) [Figure 20-210-13].

Figure 20-210-14



Remove the rings (Item 1) [Figure 20-210-14].

Figure 20-210-15

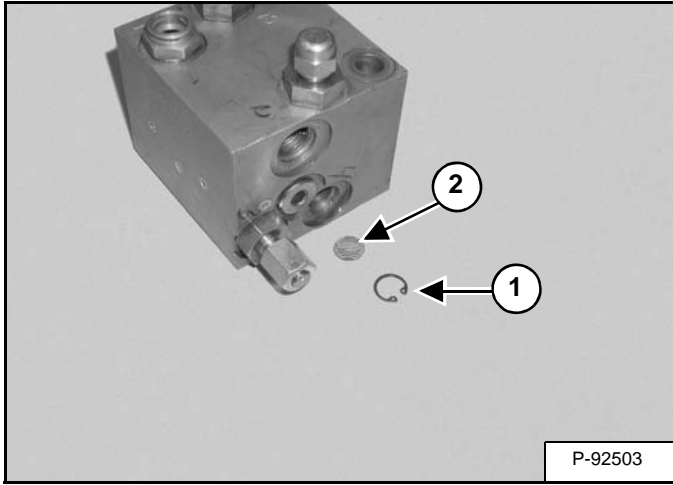


Remove the fitting (Item 1) [Figure 20-210-15] from the "S" port.

## HYDRAULIC X-CHANGE MANIFOLD (CONT'D)

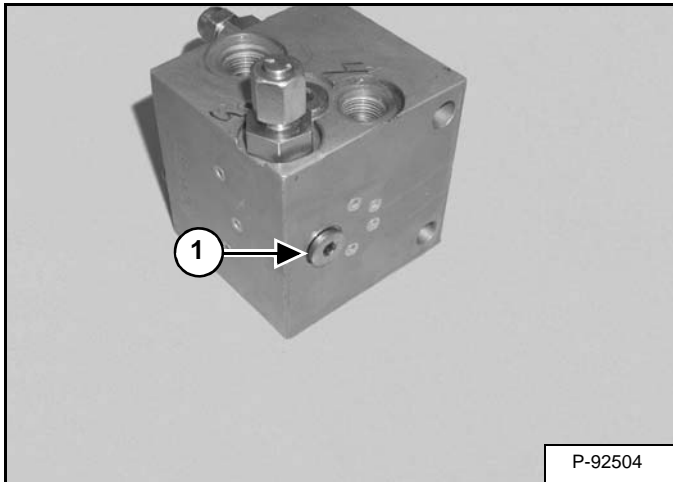
### Disassembly And Assembly (Cont'd)

Figure 20-210-16



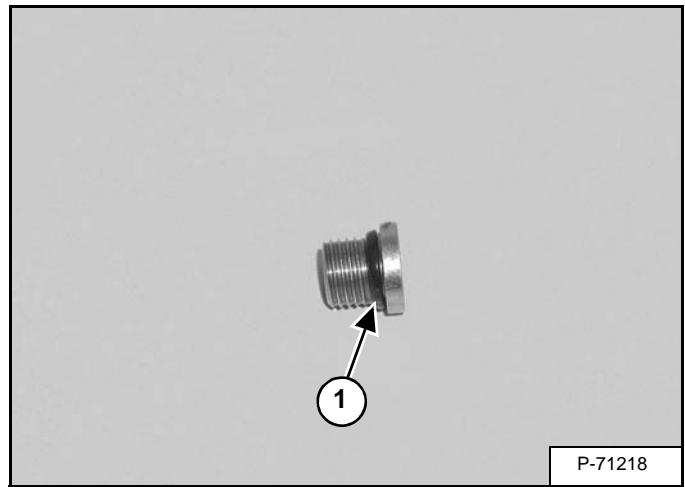
Remove the snap ring (Item 1) and screen (Item 2) [Figure 20-210-16] from the "S" port.

Figure 20-210-17



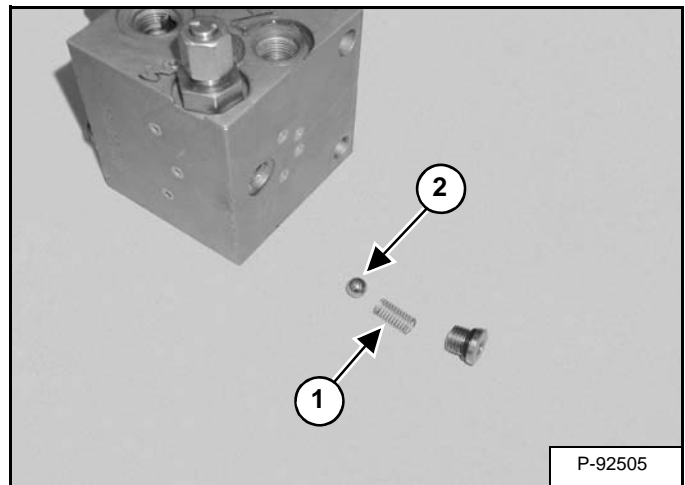
Remove the plug (Item 1) [Figure 20-210-17].

Figure 20-210-18



Remove the O-ring (Item 1) [Figure 20-210-18] from the plug.

Figure 20-210-19



Remove the spring (Item 1) and ball (Item 2) [Figure 20-210-19] from the manifold.

Clean all parts in solvent and dry with compressed air.

Inspect all parts for wear or damage. Replace any worn or damaged parts.

Always install new seals and O-rings. Lubricate all seals and O-rings with clean hydraulic fluid before installation.