

Figure 5

Remove retaining clip.

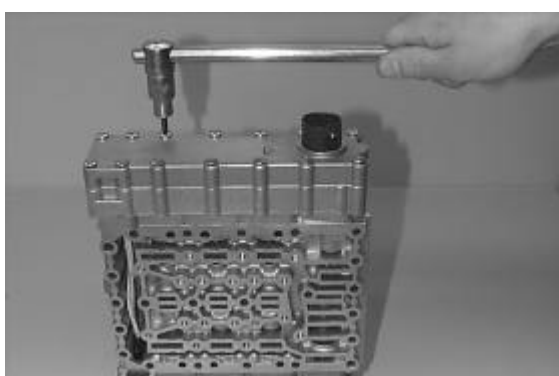


Figure 6

Loosen socket head screws and remove cover.
Demount opposite cover.

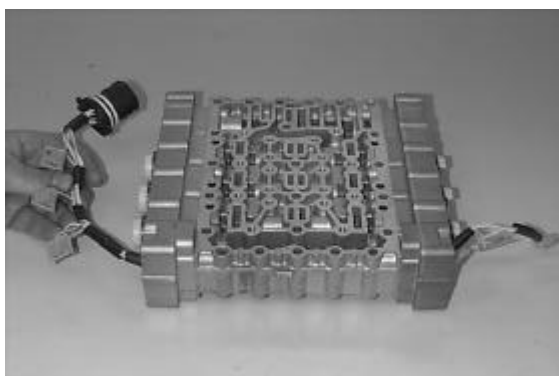


Figure 7

Remove cable harness.

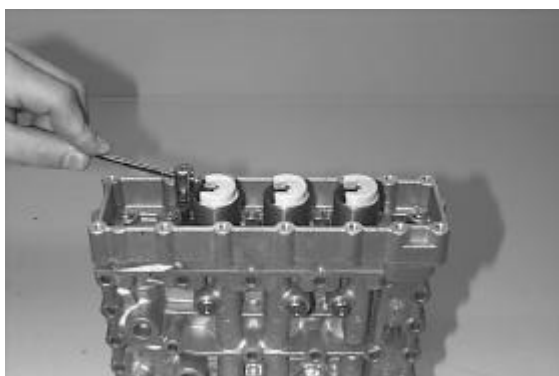


Figure 8

Loosen socket head screws, remove retaining plates and demount pressure regulator.

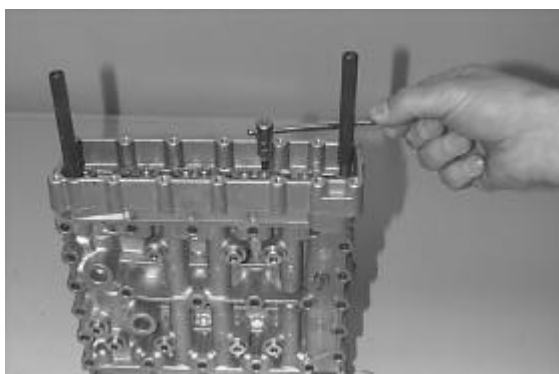


Figure 9

Loosen two socket head screws and locate the housing provisionally by means of adjusting screws.

(Housing is spring-loaded).

Now, loosen the remaining socket head screws.

(S) Adjusting screws 5870 204 036

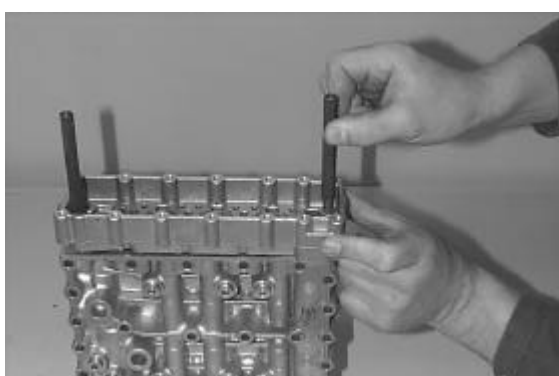


Figure 10

Separate housing from valve body by uniform loosening of the adjusting screws.

(S) Adjusting screws 5870 204 036



Figure 11

Remove components.



Figure 12

Remove opposite pressure regulators, housing as well as components accordingly.

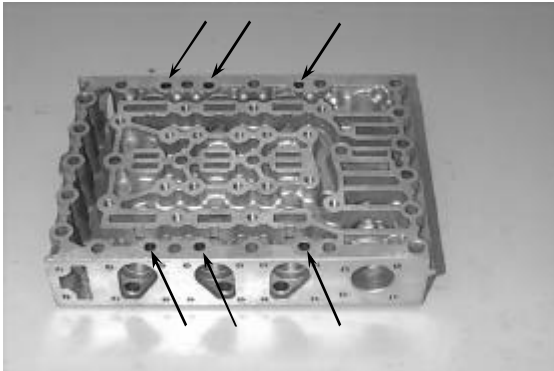


Figure 13

1.2 ASSEMBLY



Check all components for damage and renew if necessary !
Prior to the installation, check the free travel of the moving parts in the housing !
Spools can be exchanged individually !
Prior to the assembly, oil the components according to ZF-List of lubricants TE-ML 03 !

Insert orifices with the concave side showing upward, until contact is obtained !



Installation position, see Arrows !

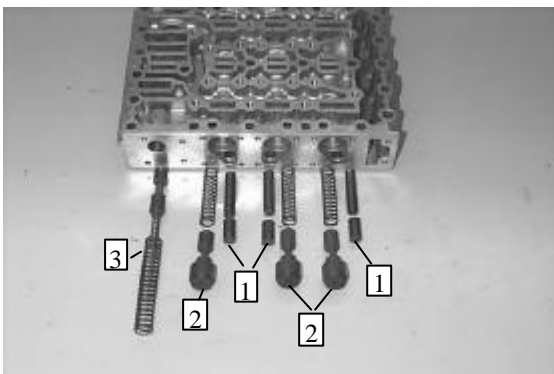


Figure 14

The Figure on the left shows the following components:

- 1 = Vibration damper (3x spool and compression spring)
- 2 = Follow-on slide (3x spool and compression spring)
- 3 = Pressure reducing valve (1x spool and compression spring)

Install components according to Figure 14.



Preload the compression springs of the follow-on slides and locate the spools provisionally by means of cylindrical pins \varnothing 5,0 mm (assembly aid), see Arrows/Figure 15 !

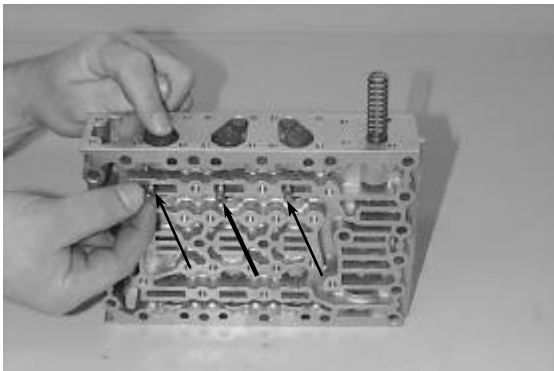


Figure 15

Install two adjusting screws.

Line up flat gasket (Arrow) and housing cover (see Figure 16).

Now, bring housing cover by means of adjusting screws uniformly against shoulder (Figure 17).

(S) Adjusting screws

5870 204 036

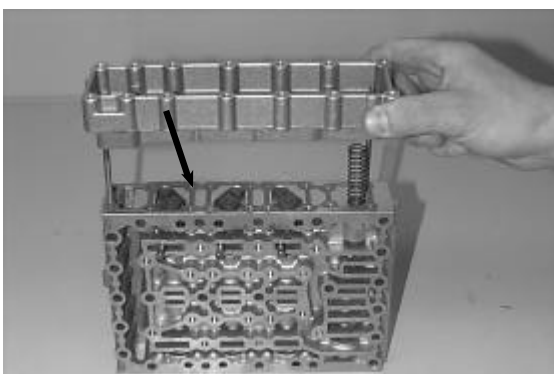


Figure 16

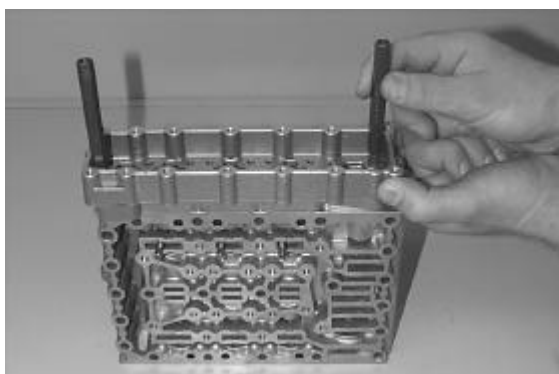


Figure 17

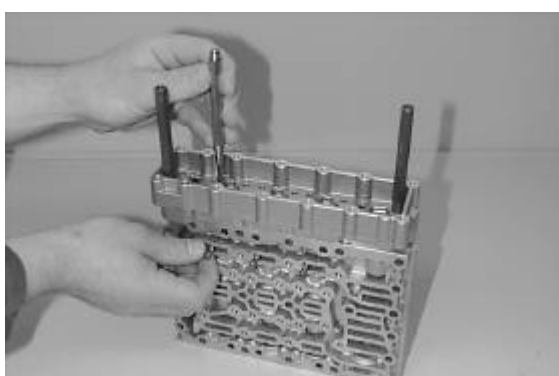


Figure 18

Preload spool and remove the cylindrical pins (assembly aid) again.

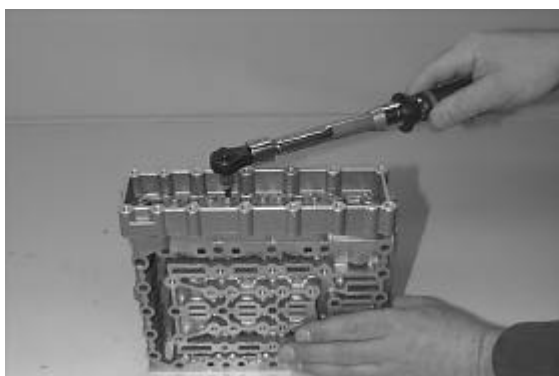


Figure 19

Fasten housing cover by means of socket head screws.

Torque limit..... 5,5 Nm



Figure 20

Introduce pressure regulators and fix them by means of retaining plates and socket head screws.



**Install retaining plates, with the claw showing downward !
Pay attention to the radial installation position of the pressure regulators, see Figure !**

Torque limit 5,5 Nm

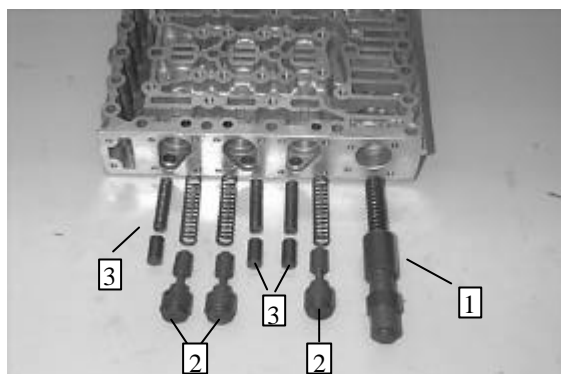


Figure 21

Pre-assemble opposite side

The Figure on the left shows the following components:

- 1 = Main pressure valve (1x spool and compression spring)
- 2 = Follow-on slide (3x spool and compression spring)
- 3 = Vibration damper (3x spool and compression spring)

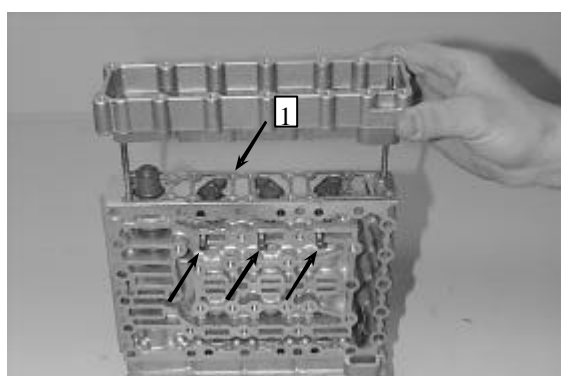


Figure 22

Install components according to Figure 21.

Preload compression springs of the follow-on slides and fix the spools provisionally with cylindrical pins $\varnothing 5$ mm (assembly aid), see Arrows !

Install two adjusting screws.

Line up flat gasket (Arrow 1) and housing cover and bring them uniformly against shoulder, using adjusting screws.

Now, fasten housing cover by means of socket head screws.

Torque limit 5,5 Nm

Remove cylindrical pins (assembly aid) again.

(S) Adjusting screws 5870 204 036

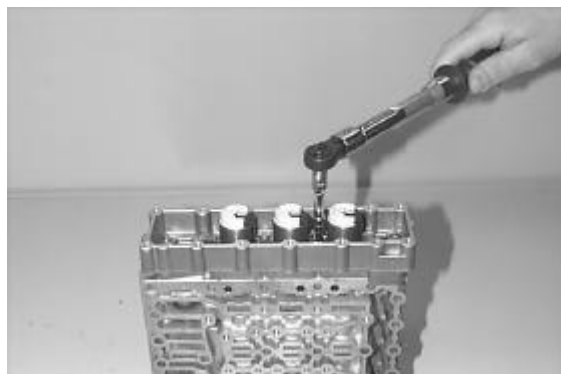


Figure 23

Introduce pressure regulators and fix them by means of retaining plates and socket head screws.



Install retaining plates, with the claw showing downward !
Pay attention to the radial installation position of the pressure regulators, see Figure !

Torque limit 5,5 Nm



Figure 24

Introduce cable harness and connect pressure regulators (6x).



Pay attention to the installation position of the cable harness, see also markings (Figure 3) !

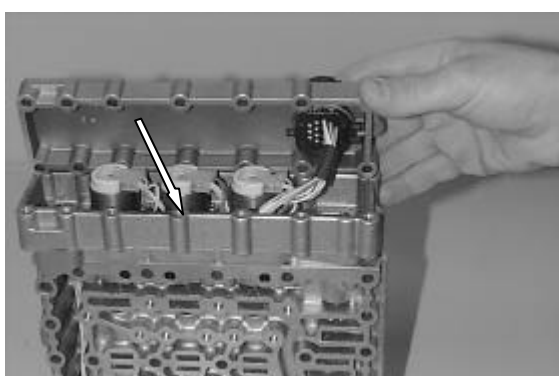


Figure 25

Mount flat gasket (Arrow).

Introduce femal connector, with the groove facing the guide nose of the cover, until contact is obtained.

Fasten cover with socket head screws.

Torque limit 5,5 Nm

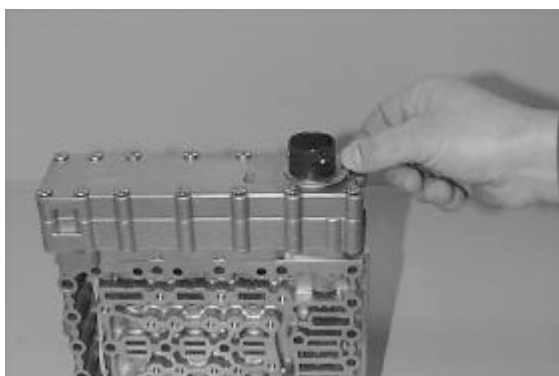


Figure 26

Locate the femal connector by means of retaining clip.

Install opposite cover.