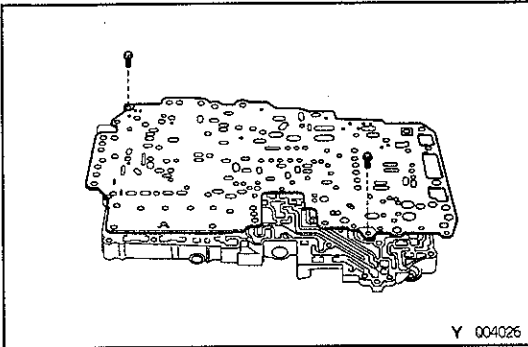


VALVE BODY ASSEMBLY

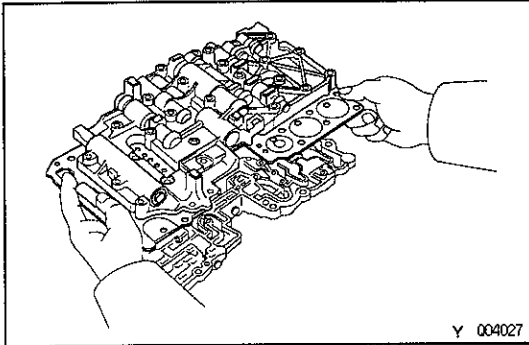
- 1. INSTALL ASSEMBLED GASKETS ON UPPER VALVE BODY**

Align the assembled gaskets with each bolt hole and install the screw.



- 2. PLACE UPPER VALVE BODY WITH GASKETS ON TOP OF LOWER VALVE BODY**

Align each bolt hole and gaskets in the valve body.



- 3. INSTALL THE 28 BOLTS UPPER VALVE BODY**

HINT: Each bolt length (mm, in.) is indicated below.

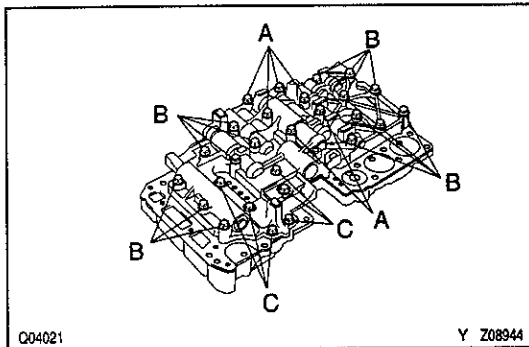
Torque: 6.5 N·m (65 kgf·cm, 56 in.-lbf)

Bolt length:

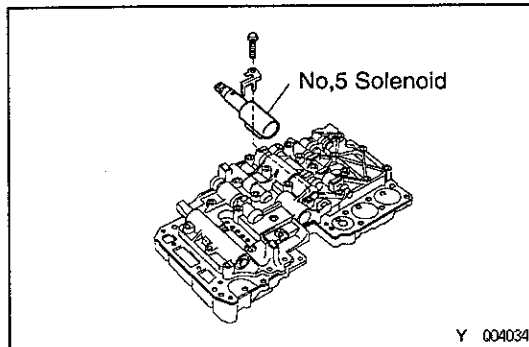
A bolt: 45 mm (1.772 in.)

B bolt: 35 mm (1.378 in.)

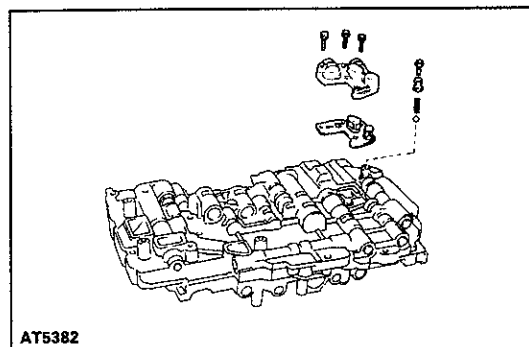
C bolt: 20 mm (0.787 in.)

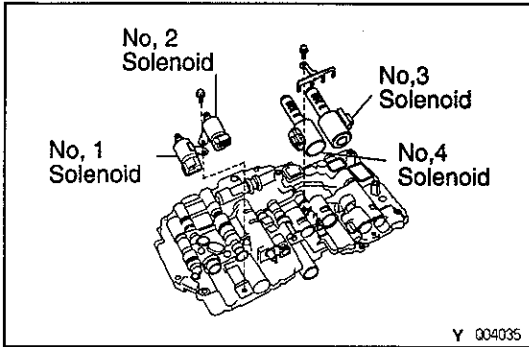


- 4. INSTALL NO.5 SOLENOID VALVE**

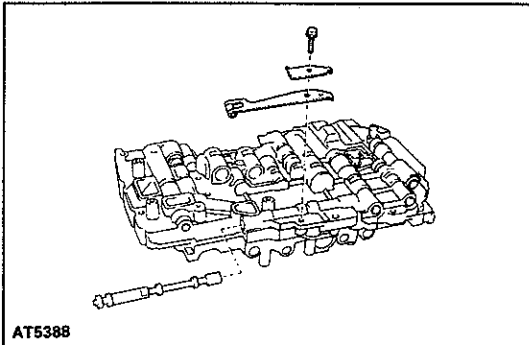


- 5. TURN OVER ASSEMBLY INSTALL OIL STRAINER AND PRESSURE RELIEF VALVE**





6. INSTALL NO. 1, NO. 2, NO. 3, NO. 4, SOLENOID VALVES



7. INSTALL MANUAL VALVE
8. INSTALL DETENT SPRING
Torque: 10 N·m (100 kgf·cm, 7 ft·lbf)
9. MAKE SURE MANUAL VALVE MOVES SMOOTHLY