

GROUP 4 MAIN CONTROL VALVE(up to #0119)

1. REMOVAL AND INSTALL

1) REMOVAL

- (1) Lower the work equipment to the ground and stop the engine.
- (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
- (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.

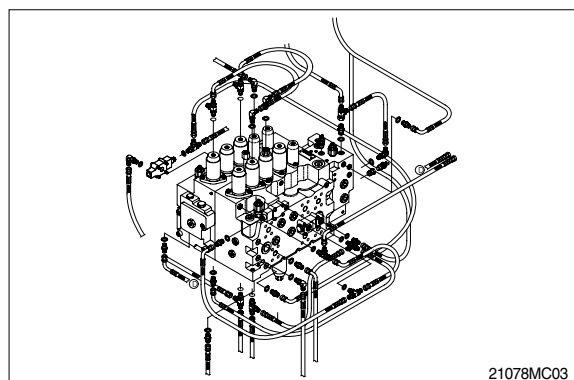
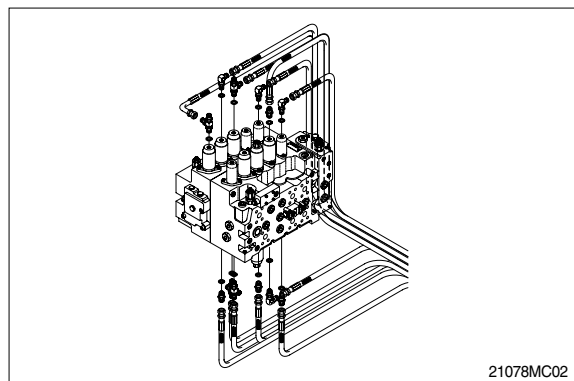
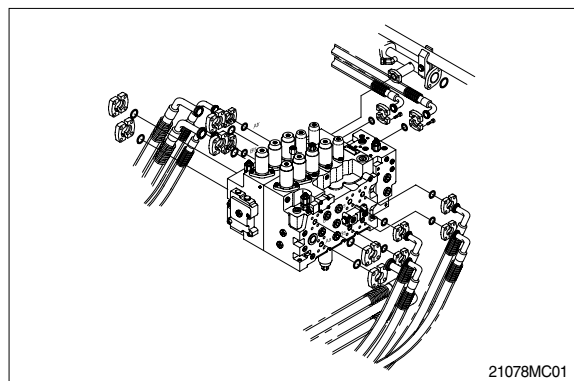
▲ Escaping fluid under pressure can penetrate the skin causing serious injury.

※ When pipes and hoses are disconnected, the oil inside the piping will flow out, so catch it in oil pan.

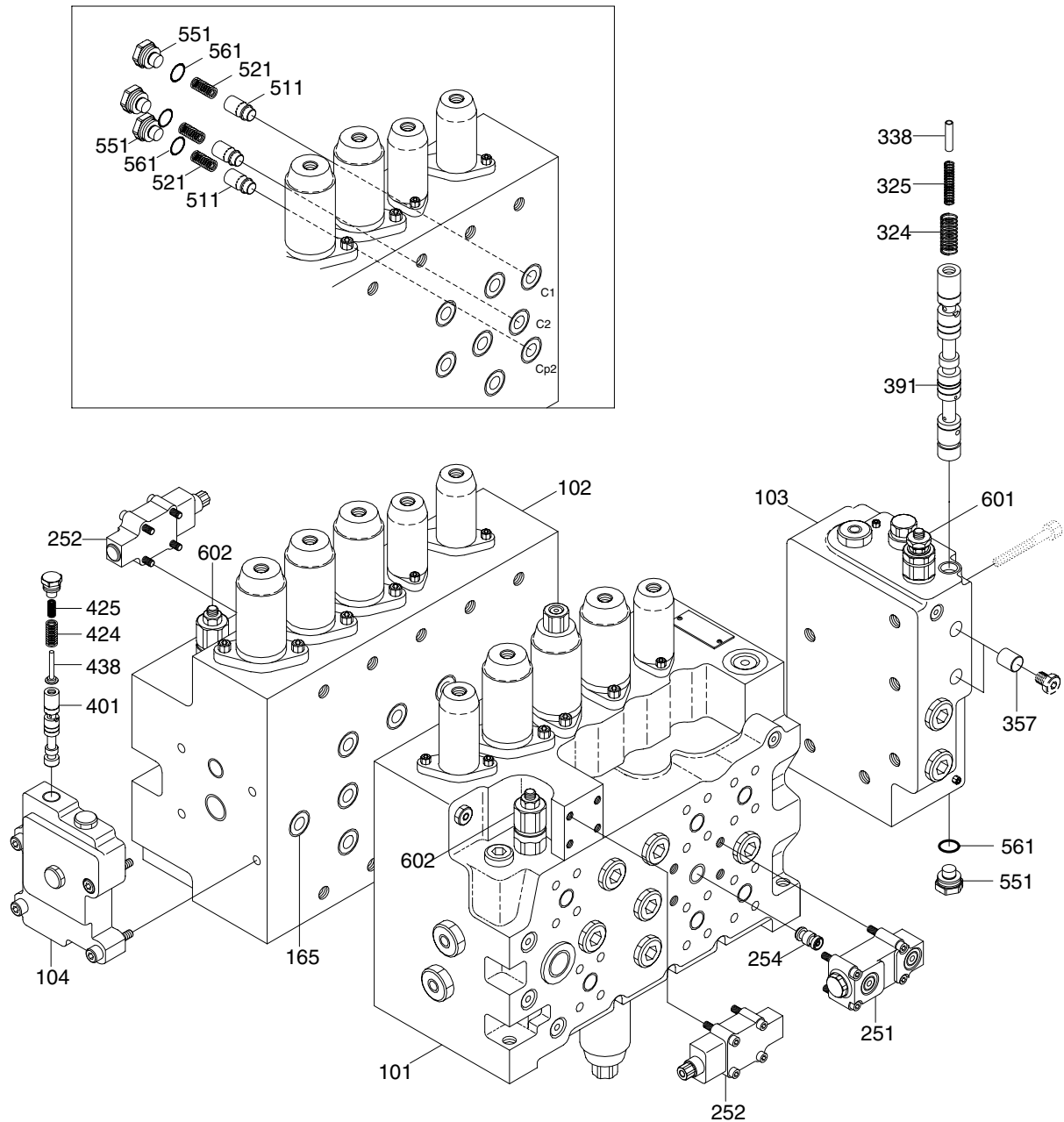
- (4) Remove bolts and disconnect pipe.
- (5) Disconnect pilot line hoses.
- (6) Disconnect pilot piping.
- (7) Sling the control valve assembly and remove the control valve mounting bolt.
· Weight : 200kg(425lb)
- (8) Remove the control valve assembly.
When removing the control valve assembly, check that all the piping have been disconnected.

2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- (2) Bleed the air from below items.
 - ① Cylinder(Boom, arm, bucket)
 - ② Swing motor
 - ③ Travel motor※ See each item removal and install.
- (3) Confirm the hydraulic oil level and recheck the hydraulic oil leak or not.



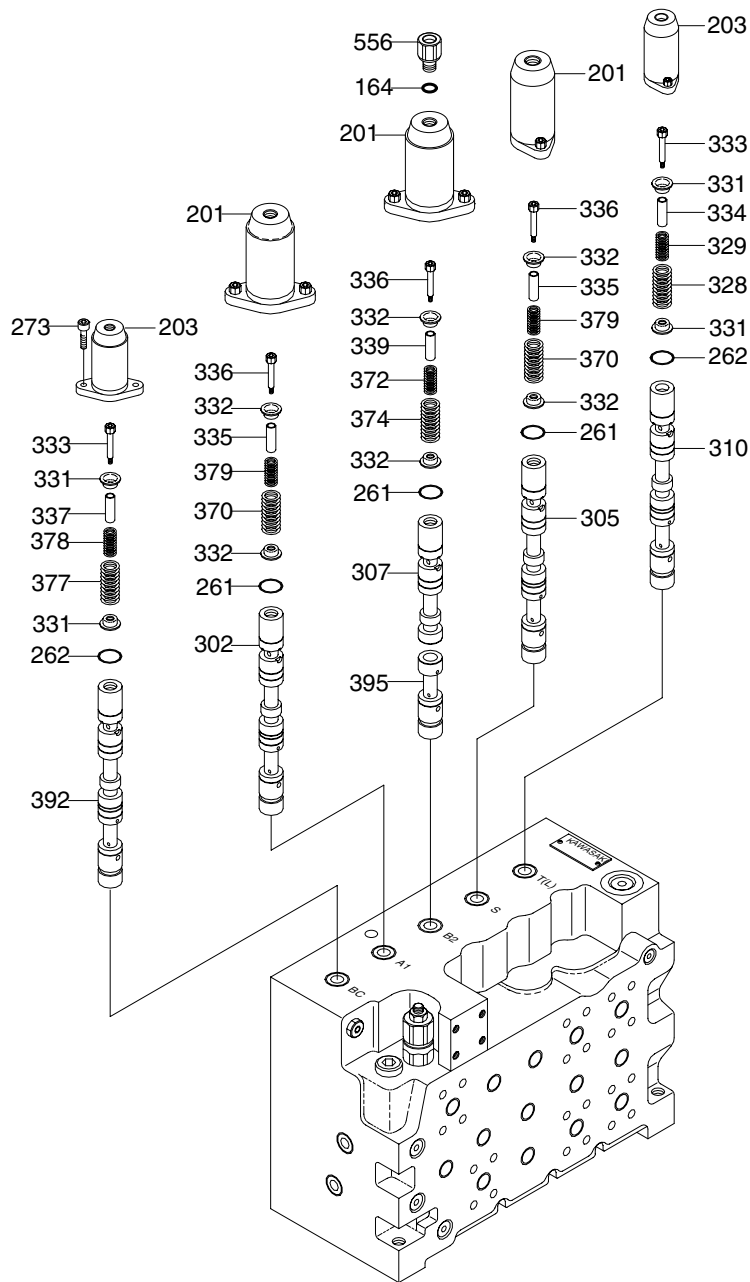
2. STRUCTURE(1/5)



29078MC04

101	Casing A	324	Spring	438	Rod
102	Casing B	325	Spring	511	Poppet
103	Block	338	Stopper	521	Spring
104	Block	357	Orifice	551	Plug
165	O-ring	391	Travel spool	561	O-ring
251	Control valve	401	Bypass cut spool	601	Main relief valve
252	Lock valve	424	Spring	602	Port relief valve
254	Logic valve	425	Spring		

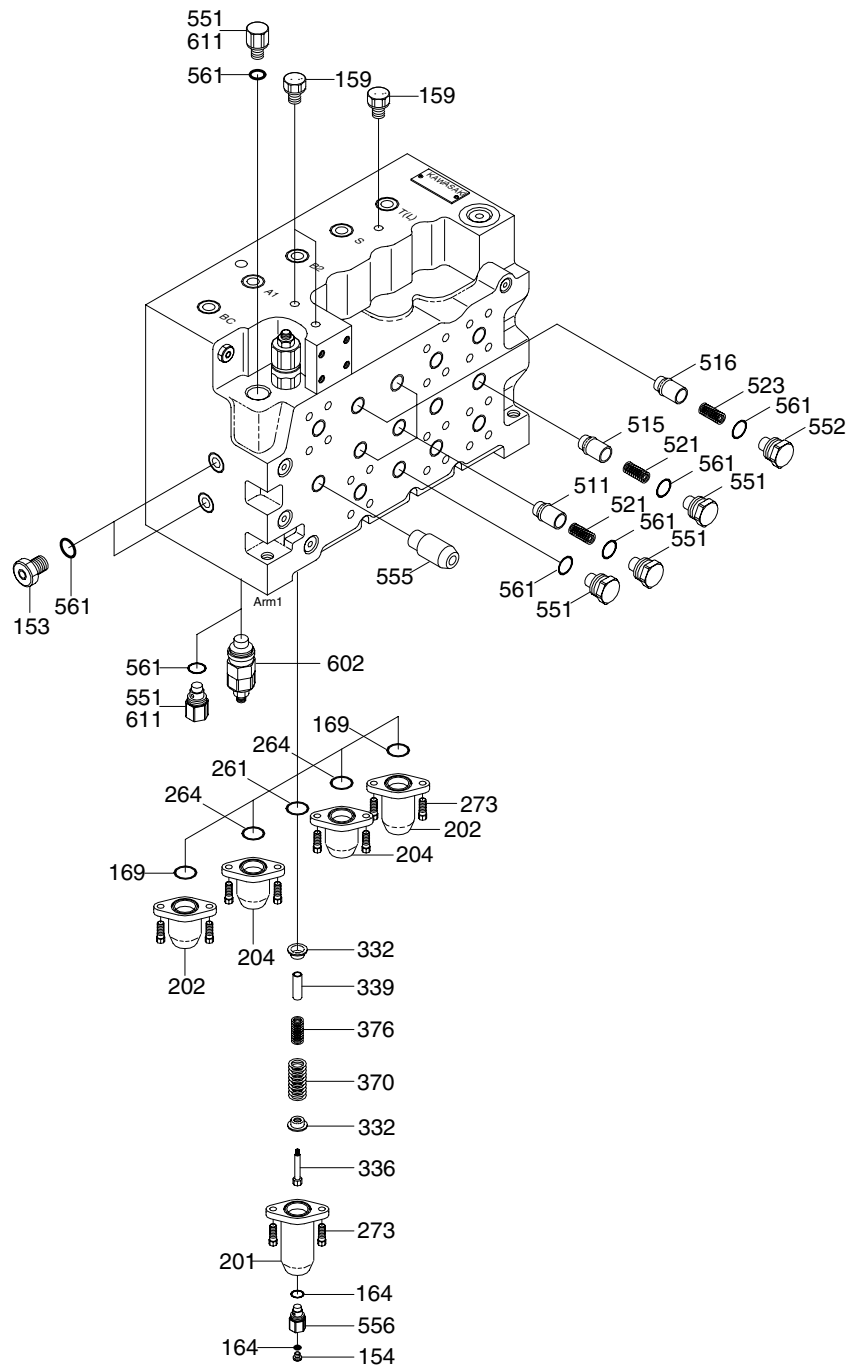
STRUCTURE(2/5)



29078MC05

164	O-ring	329	Spring	372	Spring
201	Cover	331	Seat	374	Spring
203	Cover	332	Seat	377	Spring
261	O-ring	333	Bolt	378	Spring
273	Socket screw	334	Stopper	379	Spring
302	Arm 1 spool	335	Stopper	392	Bypass cut spool
305	Swing spool	336	Bolt	395	Priority spool
307	Boom 2 spool	337	Stopper	556	Plug
310	Travel spool LH	339	Stopper		
328	Spring	370	Spring		

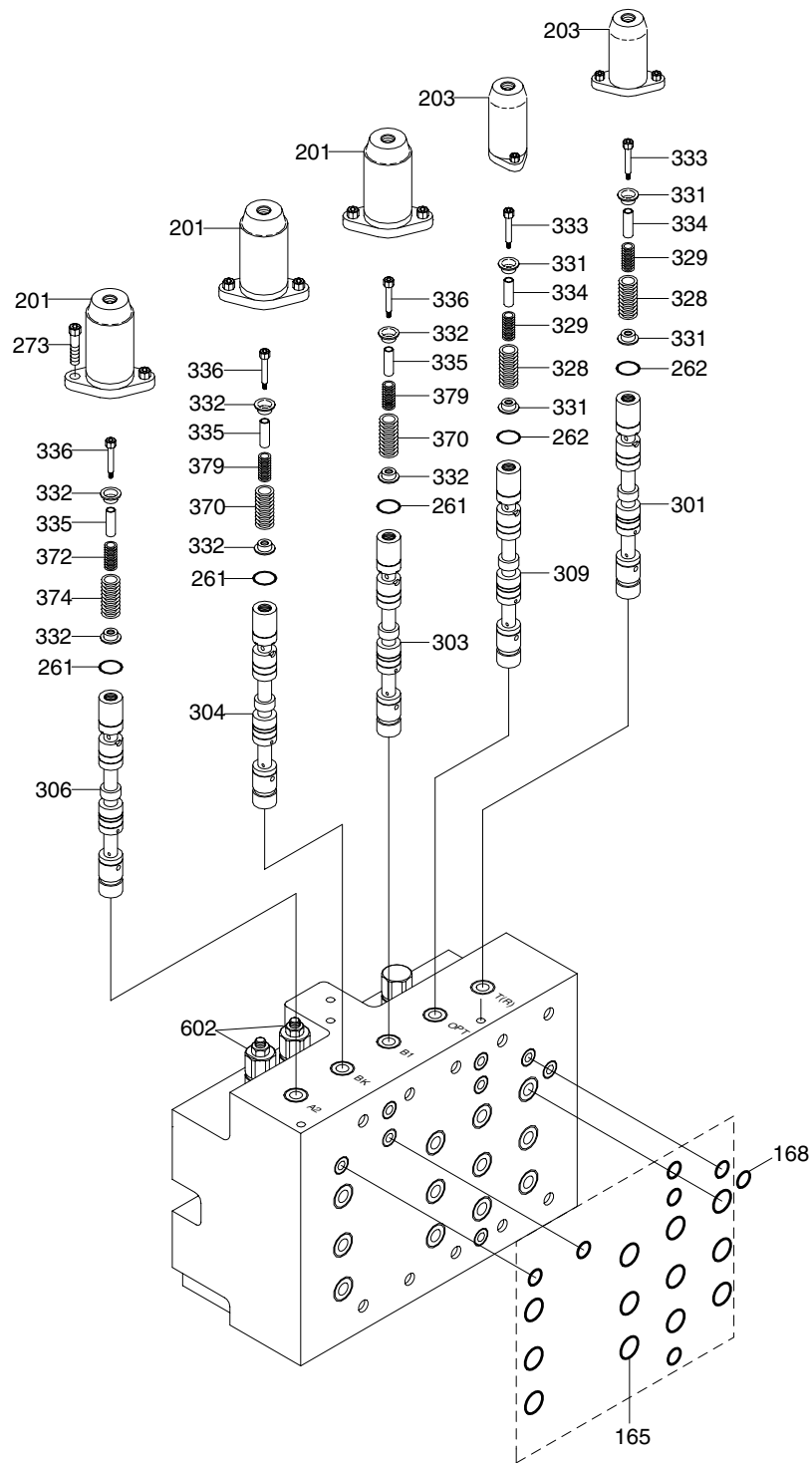
STRUCTURE(3/5)



153	Plug	273	Socket screw	521	Spring
154	Plug	332	Seat	523	Spring
159	Plug	336	Bolt	551	Plug
164	O-ring	339	Stopper	552	Plug
169	O-ring	370	Spring	555	Check valve
201	Cover	376	Spring	556	Plug
202	Cover	551	Poppet	561	O-ring
204	Cover	515	Poppet	602	Port relief valve
261	O-ring	516	Poppet	611	Main relief valve
264	O-ring				

29078MC06

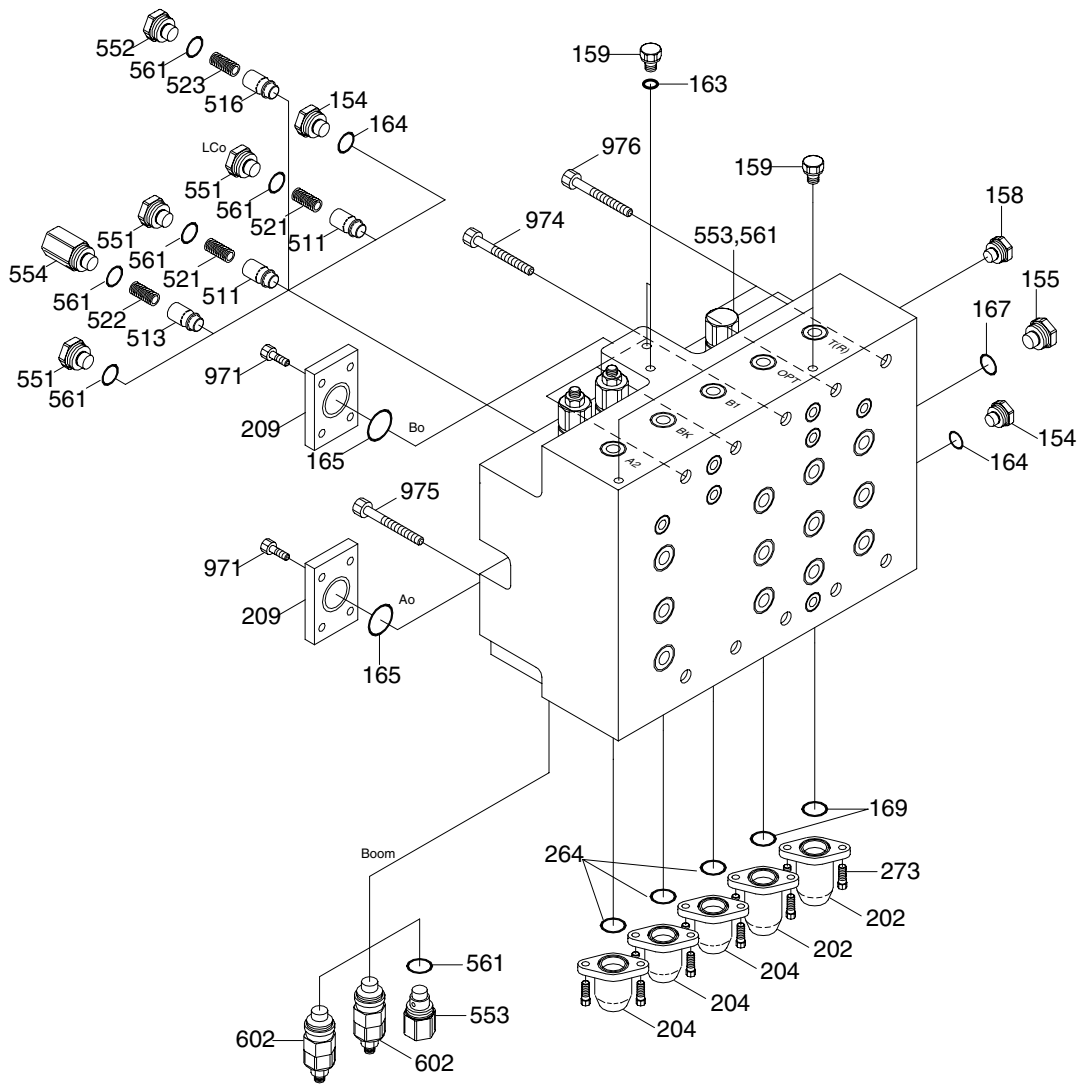
STRUCTURE(4/5)



165	O-ring	303	Boom 1 spool	334	Stopper
166	O-ring	304	Plug	335	Stopper
168	O-ring	306	Arm 2 spool	336	Bolt
201	Cover	309	Spool(Optional)	370	Spring
203	Cover	328	Spring	372	Spring
261	O-ring	329	Spring	374	Spring
262	O-ring	331	Seat	379	Spring
273	Socket screw	332	Seat	602	Port relief valve
301	Travel spool RH	333	Bolt		

29078MC07

STRUCTURE(5/5)



29078MC08

154	Plug	204	Cover	551	Plug
155	Plug	209	Flange	552	Plug
158	Plug	264	O-ring	553	Plug
159	Plug	273	Socket screw	554	Plug
163	O-ring	551	Poppet	561	O-ring
164	O-ring	513	Poppet	602	Port relief valve
165	O-ring	516	Poppet	971	Screw
167	O-ring	521	Spring	974	Screw
169	O-ring	522	Spring	975	Screw
202	Cover	523	Spring	976	Screw

3. DISASSEMBLY AND ASSEMBLY

1) GENERAL PRECAUTIONS

- (1) All hydraulic components are manufactured to a high precision. Consequently, before disassembling and assembling them, it is essential to select an especially clean place.
- (2) In handling a control valve, pay full attention to prevent dust, sand, etc. from entering into it.
- (3) When a control valve is to be removed from the machine, apply caps and masking seals to all ports. Before disassembling the valve, recheck that these caps and masking seals are fitted completely, and then clean the outside of the assembly. Use a proper bench for working. Spread paper or a rubber mat on the bench, and disassemble the valve on it.
- (4) Support the body section carefully when carrying or transferring the control valve. Do not lift by the exposed spool, end cover section etc.
- (5) After disassembling and assembling of the component it is desired to carry out various tests (For the relief characteristics, leakage, flow resistance, etc.), but hydraulic test equipment is necessary for these tests. Therefore, even when its disassembling can be carried out technically, do not disassemble such components that cannot be tested, adjusted, and so on. Additionally one should always prepare clean cleaning oil, hydraulic oil, grease, etc. beforehand.

2) TOOLS

Before disassembling the control valve, prepare the following tools beforehand.

Name of tool	Quantity	Size(mm)
Vice mounted on bench(Soft jaws)	1 unit	-
Hexagon wrench	Each 1 piece	5, 6, 10, 12 and 14
Socket wrench	Each 1 piece	27 and 32
Spanner	Each 1 piece	32(Main relief valve)

3) DISASSEMBLY

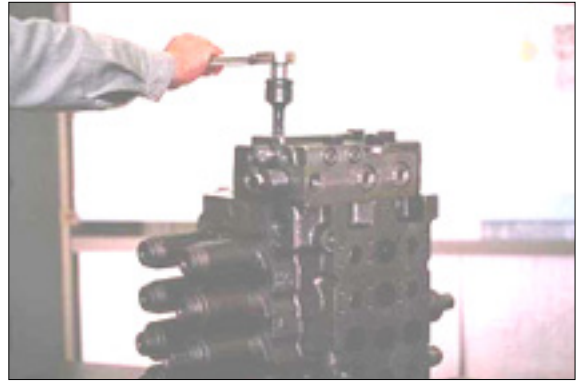
The figure in () shown after the part name in explanation sentence shows its number in the construction figures.

- (1) Place control valve on working bench.
 - ※ Disassemble the valve in a clean and dry environment and pay careful attention not to damage the sealing flange faces.

(2) Travel straight valve block

Loosen hexagon socket head bolts to and remove straight travel valve block(103) in its assembled state.

- Hexagon wrench : 14mm



21078MC09

(3) Main spool

- ① Loosen hexagon socket head bolts(273) and remove spring cover(201, 203).

- Hexagon wrench : 6mm



21078MC10

- ② Remove spool, springs, stopper, spring seats and spacer bolt in spool assembly condition from casing.

- ※ When extracting each spool assembly from its casing, pay attention not to damage the casing.



21078MC11

(4) Covers

Loosen hexagon socket head bolts(273) and then remove the spool cover(202, 204).

- Hexagon wrench : 6mm

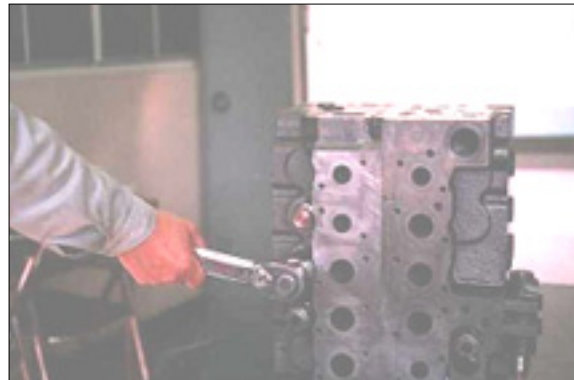


21078MC12

(5) Removal of port relief

Remove port relief valves(602) from casing.

- Socket wrench : 32mm



21078MC13

(6) Removal of plug (Option section)

Remove plugs(553) from casing.

- Socket wrench : 27mm

(7) Lock valve

Loosen hexagon socket head bolts and remove lock valve(252).

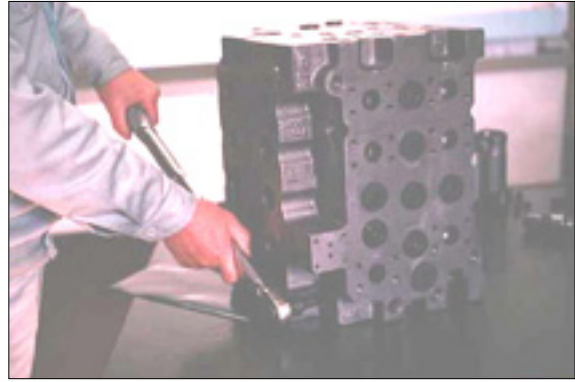
- Hexagon wrench : 5mm



21078MC14

(8) Negative control relief valve

- ① Remove plug(551).
 - Hexagon wrench : 12mm



21078MC15

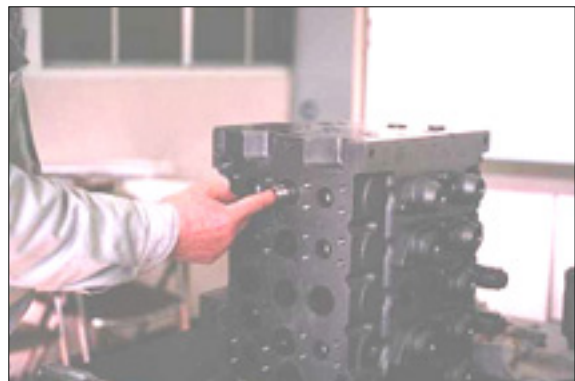
- ② Remove poppet(611), spring(621) and damping rod(631).



21078MC16

(9) Swing logic valve and check valve

- ① Loosen hexagon socket head bolts(251) and remove logic valve(251) and take check valve(254).
- ② Remove plug(551) or (552) and take out poppet(511) or (515, 516) and spring (521) or (523).
 - Hexagon wrench : 6, 12mm



21078MC17

(10) Boom priority valve

- Loosen hexagon socket head bolts(104) and remove boom priority valve(104).
 - Hexagon wrench : 10mm

(11) Inspection after disassembly

Clean all disassembled parts with clean mineral oil fully, and dry them with compressed air. Then, place them on clean papers or cloths for inspection.

① Control valve

- a. Check whole surfaces of all parts for burrs, scratches, notches and other defects.
- b. Confirm that seal groove faces of casing and block are smooth and free of dust, dent, rust etc.
- c. Correct dents and damages and check seat faces within the casing, if any, by lapping.
 - ※ Pay careful attention not to leave any lapping agent within the casing.
- d. Confirm that all sliding and fitting parts can be moved manually and that all grooves and paths are free from foreign matter.
- e. If any spring is broken or deformed, replace it with new one.
- f. When a relief valve does not function properly, repair it, following the prescribed disassembly and assembly procedures.
- g. Replace all seals and O-rings with new ones.

② Relief valve

- a. Confirm that all seat faces at ends of all poppets and seats are free of defects and show uniform and consistent contact faces.
- b. Confirm manually that main poppet and seat can slide lightly and smoothly.
- c. Confirm that outside face of main poppet and inside face of seat are free from scratches and so on.
- d. Confirm that springs are free from breakage, deformation, and wear.
- e. Confirm that orifices of main poppet and seat section are not clogged with foreign matter.
- f. Replace all O-rings with new ones.
- g. When any light damage is found in above inspections, correct it by lapping.
- h. When any abnormal part is found, replace it with a completely new relief valve assembly.

4) ASSEMBLY

(1) General comments

- ① In this assembly section, explanation only is shown.
For further understanding, please refer to the figures and photographs shown in the previous disassembly section.
- ② Figure in () shown after the part name in the explanation refers to the reference identity number shown on the construction figure shown in the spares section.
- ③ **Cautions in assembling seal**
 - a. Pay close attention to keeping all seals free from handling damage and inspect carefully for damage before using them.
 - b. Apply clean grease or hydraulic oil to the seal so as to ensure it is fully lubricated before assembly.
 - c. Do not stretch seals so much as to deform them permanently.
 - d. In fitting O-rings, pay close attention not to roll them into their final position in addition, a twisted O-ring cannot easily untwist itself naturally and could thereby cause inadequate sealing and thereby both internal and external oil leakage.
 - e. Tighten fitting bolts for all sections with a torque wrench adjusted to the respective tightening torque as shown on the cross section drawings of the spares section.

(2) Check valve

- ① Assemble poppets(511, 515, 516) and spring(521, 523).
- ② Put O-rings(561) on to plugs(551, 552).
- ③ Tighten plugs(551, 552) to the specified torque.
 - Hexagon wrench : 12mm
 - Tightening torque : 23~27kgf · m(166~195lbf · ft)

(3) Negative control relief valve

- ① Assemble the poppets, springs and damping rods(611 × 2) together into casing A(101).
- ② Put O-ring(561) on to plug(551) and tighten the latter to its specified torque.
 - Hexagon wrench : 12mm
 - Tightening torque : 23~27kgf · m(166~195lbf · ft)

(4) Lock valve

- ① Put O-rings onto the casing.
- ② Tighten hexagon socket head bolts to their specified torques.
 - Hexagon wrench : 5mm
 - Tightening torque : 1~1.4kgf · m(7.23~10.12lbf · ft)

(5) Assembly of main relief, port relief valves

- ① Install main relief valve(601), port relief valve(602) into the casing and tighten to the specified torque.

Components	Tools	Tightening torque	
		kgf · m	lbf · ft
Main relief valve	Spanner 32mm	7~8	50.6~57.8
Port relief valve	Socket wrench 32mm	7~8	50.6~57.8

(6) Main spools

- ① Carefully insert the previously assembled spool assemblies into their respective bores within of casing A(101) and casing B(102).
- ※ Fit spool assemblies into casing A(101) and casing B(102) carefully and slowly. Do not under any circumstances push them forcibly in.

(7) Covers

- ① Fit spool covers(202, 204) to the nonspring assembly end of the spool, and tighten the hexagonal socket head bolts(273) to the specified torque.
 - Hexagon wrench : 6mm
 - Tightening torque : 2.5~3.5kgf · m(18~25.3lbf · ft)
- ※ Confirm that O-rings(169, 264) have been fitted.
- ② Fit spring covers(201, 203) to the spring end for the spools, and tighten hexagon socket head bolts(273) to the specified torque.
 - Hexagon wrench : 6mm
 - Tightening torque : 2.5~3.5kgf · m(18~25.3lbf · ft)
- ※ Confirm that O-rings(261, 262) have been fitted.

(8) Travel straight valve, swing logic valve and boom priority valve

- ① Put O-rings onto the casing.
- ② Tighten hexagon socket head bolts to their specified torques.

Components	Tools	Tightening torque	
		kgf · m	lbf · ft
Travel straight valve	Hexagon wrench 14mm	28~32	202~231
Swing logic valve	Hexagon wrench 6mm	2.5~3.5	18~25.3
Boom priority valve	Hexagon wrench 10mm	8.5~11.5	61.5~83.1

GROUP 4 MAIN CONTROL VALVE(#0120 and up)

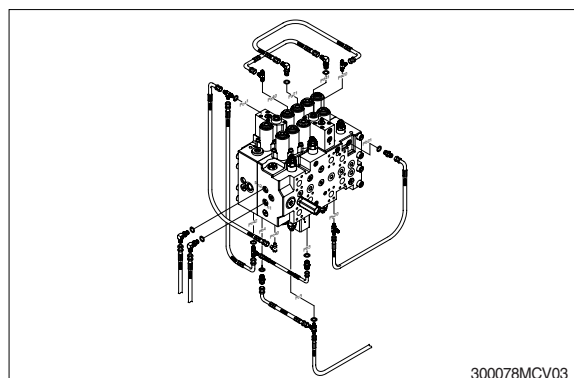
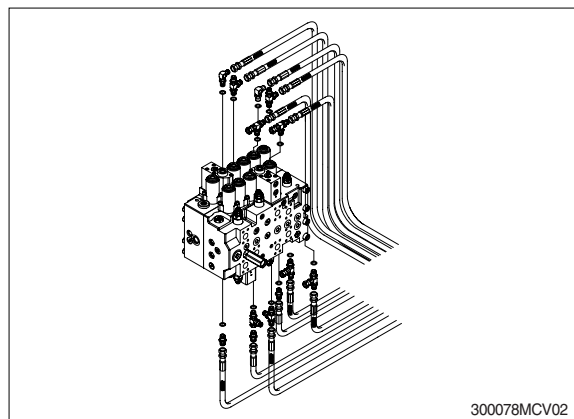
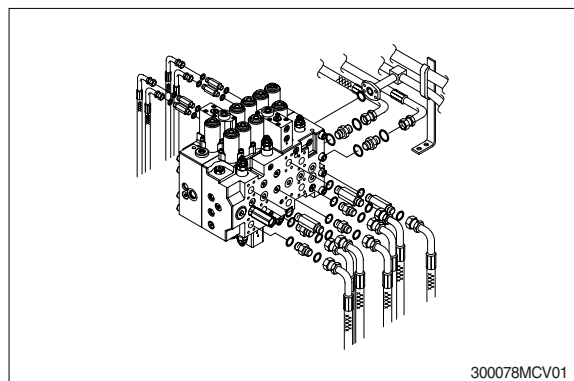
1. REMOVAL AND INSTALL OF MOTOR

1) REMOVAL

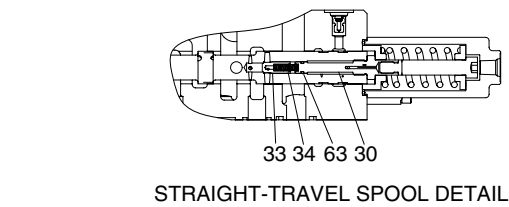
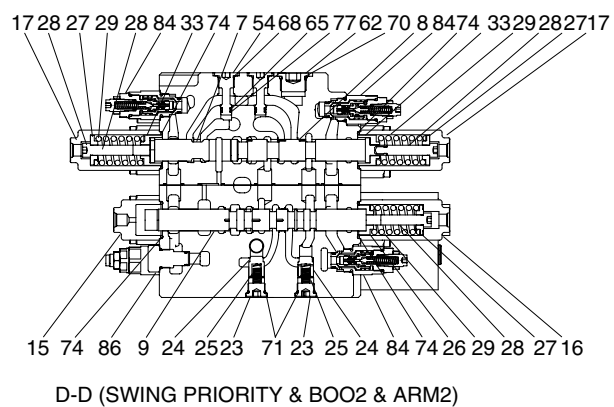
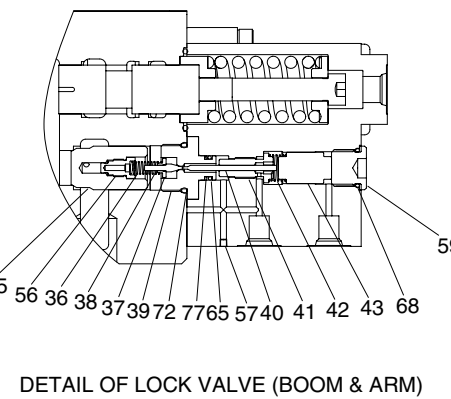
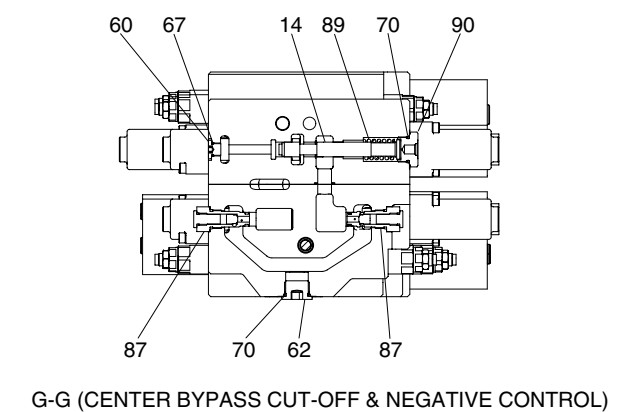
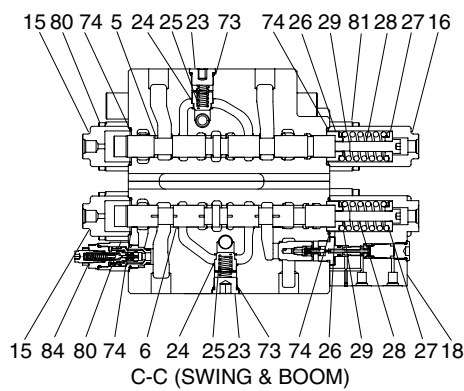
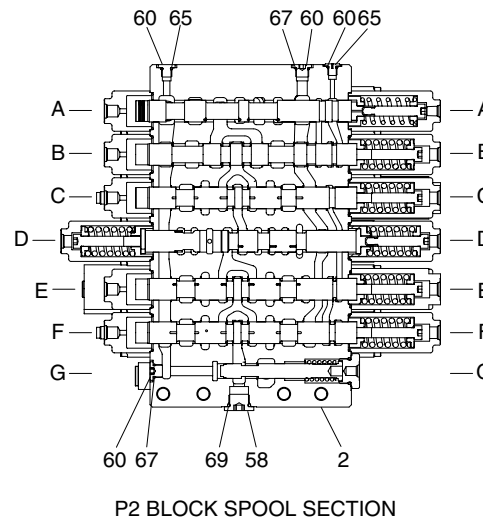
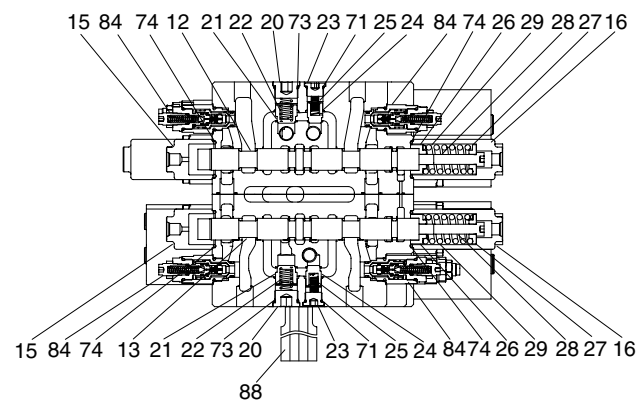
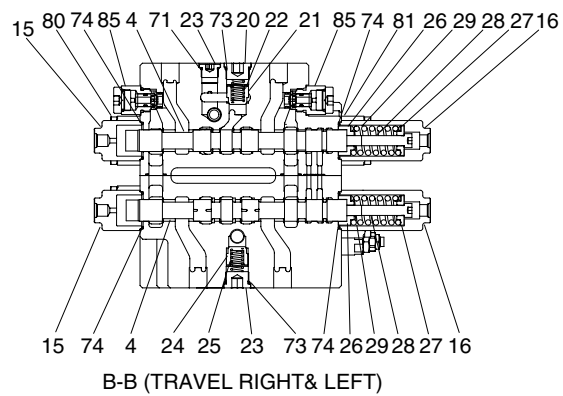
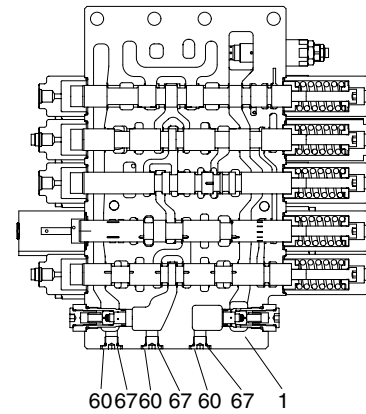
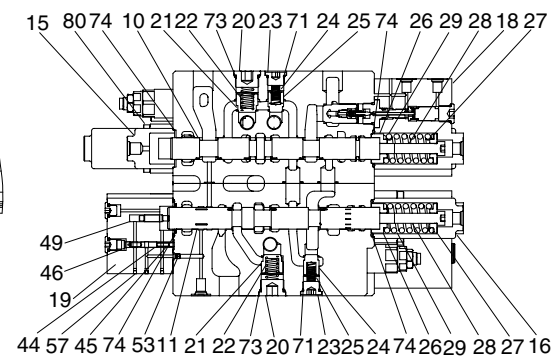
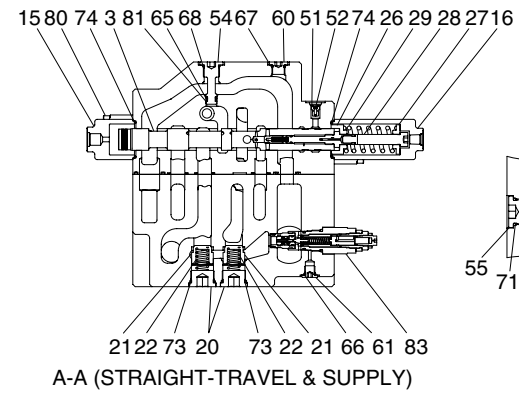
- (1) Lower the work equipment to the ground and stop the engine.
 - (2) Operate the control levers and pedals several times to release the remaining pressure in the hydraulic piping.
 - (3) Loosen the breather slowly to release the pressure inside the hydraulic tank.
- ▲ Escaping fluid under pressure can penetrate the skin causing serious injury.**
- ※ When pipes and hoses are disconnected, the oil inside the piping will flow out, so catch it in oil pan.
- (4) Remove bolts and disconnect pipe.
 - (5) Disconnect pilot line hoses.
 - (6) Disconnect pilot piping.
 - (7) Sling the control valve assembly and remove the control valve mounting bolt.
· Weight : 200kg(441lb)
 - (8) Remove the control valve assembly.
When removing the control valve assembly, check that all the piping have been disconnected.

2) INSTALL

- (1) Carry out installation in the reverse order to removal.
- (2) Bleed the air from below items.
 - ① Cylinder(Boom, arm, bucket)
 - ② Swing motor
 - ③ Travel motor※ See each item removal and install.
- (3) Confirm the hydraulic oil level and recheck the hydraulic oil leak or not.



2. STRUCTURE



- | | |
|----------------------------|---------------------------------|
| 1 Body(P1) | 47 Piston-cut off |
| 2 Body(P2) | 48 Poppet-signal |
| 3 Spool-travel straight | 49 Spring-signal |
| 4 Spool-travel | 50 Plug |
| 5 Spool-swing | 51 Orifice-signal |
| 6 Spool-boom | 52 Coin type filter |
| 7 Spool-swing priority | 53 Orifice-plug |
| 8 Spool-boom 2 | 54 Plug |
| 9 Spool-arm 2 | 55 Plug |
| 10 Spool-arm | 56 Restrictor-lock valve |
| 11 Spool-arm regeneration | 57 Plug |
| 12 Spool-bucket | 58 Plug |
| 13 Spool-option | 59 Plug |
| 14 Spool-bypass cut | 60 Plug |
| 15 Cover-pilot A | 61 Plug |
| 16 Cover-pilot B1 | 62 Plug |
| 17 Cover-pilot B2 | 63 O-ring |
| 18 Block-holding | 64 O-ring |
| 19 Block-regeneration | 65 O-ring |
| 20 Plug | 66 O-ring |
| 21 Poppet 1-check valve | 67 O-ring |
| 22 Spring-check valve | 68 O-ring |
| 23 Plug | 69 O-ring |
| 24 Poppet 2-check valve | 70 O-ring |
| 25 Spring-check valve | 71 O-ring |
| 26 Spring seat 1 | 72 O-ring |
| 27 Spring seat 2 | 73 O-ring |
| 28 Spacer bolt | 74 O-ring |
| 29 Spring-return(L) | 75 Back-up ring |
| 30 Stopper 1-TS | 76 Back-up ring |
| 31 Stopper 2-priority | 77 Back-up ring |
| 32 Spring seat 3 | 78 Socket head bolt with washer |
| 33 Poppet-check valve TS | 79 Socket head bolt with washer |
| 34 Spring-check valve TS | 80 Socket head bolt with washer |
| 35 Poppet-lock valve | 81 Main relief valve |
| 36 Spring-lock valve pilot | 82 Overload relief valve |
| 37 Guide poppet | 83 Plug-relief valve |
| 38 Poppet-pilot | 84 Plug-relief valve |
| 39 Seat-poppet | 85 Negative control valve |
| 40 Piston 1 | 86 Socket head bolt with washer |
| 41 Guide-piston | 87 Socket head bolt with washer |
| 42 Spring 1-lock valve | 88 Nipple-check valve |
| 43 Piston 2 | 89 Spring-bypass cut spool |
| 44 Spool-regen selector | 90 Plug-bypass cut spool |
| 45 Spring-regeneration | 91 Backup ring |
| 46 Stopper-regeneration | |

300072MCO2

3. DISASSEMBLY AND ASSEMBLY

1) GENERAL PRECAUTIONS

- (1) All hydraulic components are manufactured to a high precision. Consequently, before disassembling and assembling them, it is essential to select an especially clean place.
- (2) In handling a control valve, pay full attention to prevent dust, sand, etc. from entering into it.
- (3) When a control valve is to be removed from the machine, apply caps and masking seals to all ports. Before disassembling the valve, recheck that these caps and masking seals are fitted completely, and then clean the outside of the assembly. Use a proper bench for working. Spread paper or a rubber mat on the bench, and disassemble the valve on it.
- (4) Support the body section carefully when carrying or transferring the control valve. Do not lift by the exposed spool, end cover section etc.
- (5) After disassembling and assembling of the component it is desired to carry out various tests (For the relief characteristics, leakage, flow resistance, etc.), but hydraulic test equipment is necessary for these tests. Therefore, even when its disassembling can be carried out technically, do not disassemble such components that cannot be tested, adjusted, and so on. Additionally one should always prepare clean cleaning oil, hydraulic oil, grease, etc. beforehand.

2) TOOLS

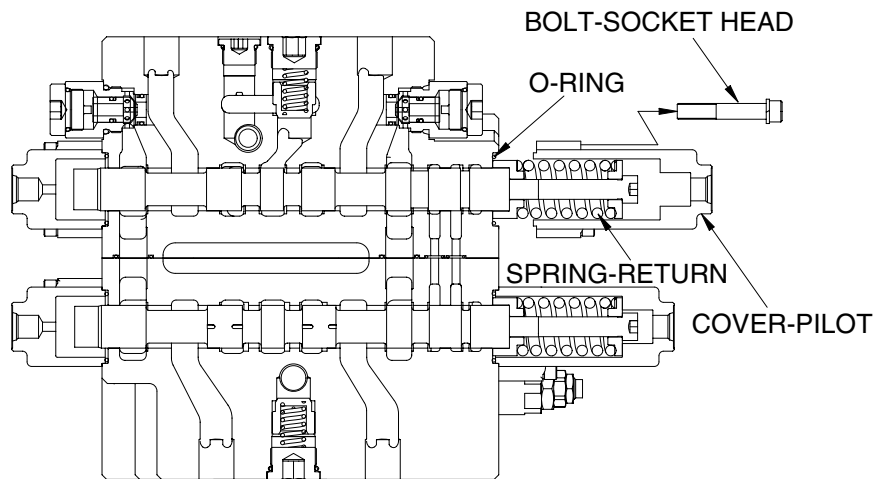
Before disassembling the control valve, prepare the following tools beforehand.

Name of tool	Quantity	Size(mm)
Vice mounted on bench(Soft jaws)	1 unit	
Hexagon wrench	Each 1 piece	5, 6, 10, 12 and 14
Socket wrench	Each 1 piece	27 and 32
Spanner	Each 1 piece	26 and 32(Main relief valve)

3) DISASSEMBLY

(1) Disassembly of spools without holding valve

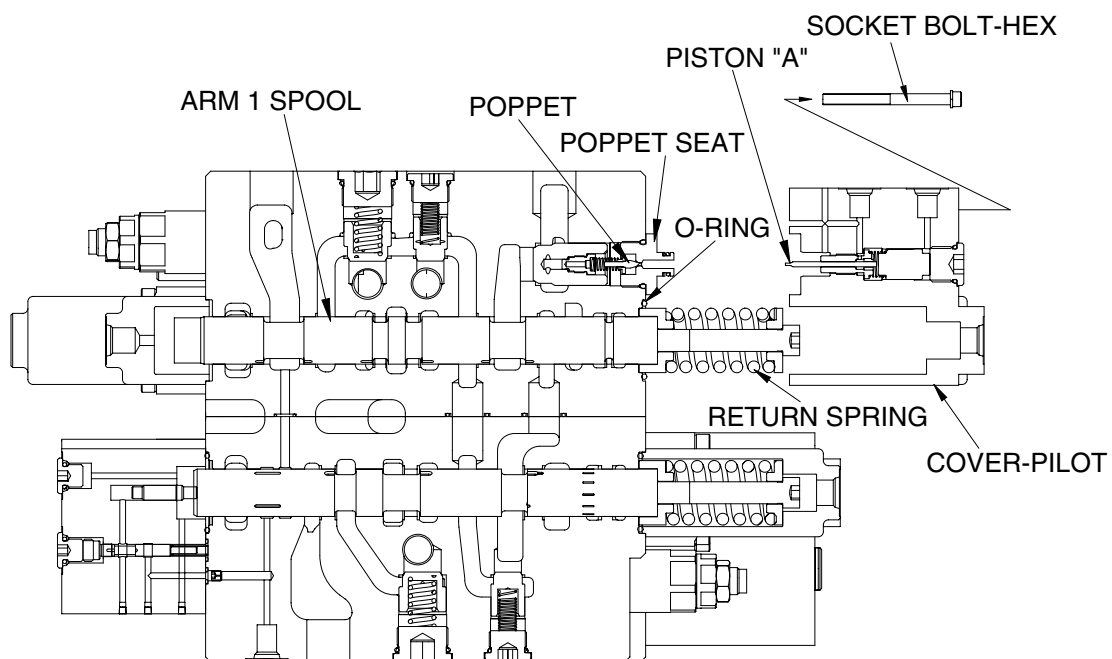
- ① Loosen hexagon socket head bolts with washer
(Hexagon wrench : 5mm)
- ② Remove the pilot cover.
 - ※ Pay attention not to lose the O-ring under the pilot cover.
- ③ Remove the spool assembly from the body by hand slightly.
 - ※ When extracting each spool from its body, pay attention not to damage the body.
 - ※ When extracting each spool assembly, it must be extracted from spring side only.
 - ※ When any abnormal parts are found, replace it with completely new spool assembly.
 - ※ When disassembled, tag the components for identification so that they can be reassembled correctly.



29078MC20

(2) Disassembly of spools with holding valve(Boom 1, Arm 1 spool)

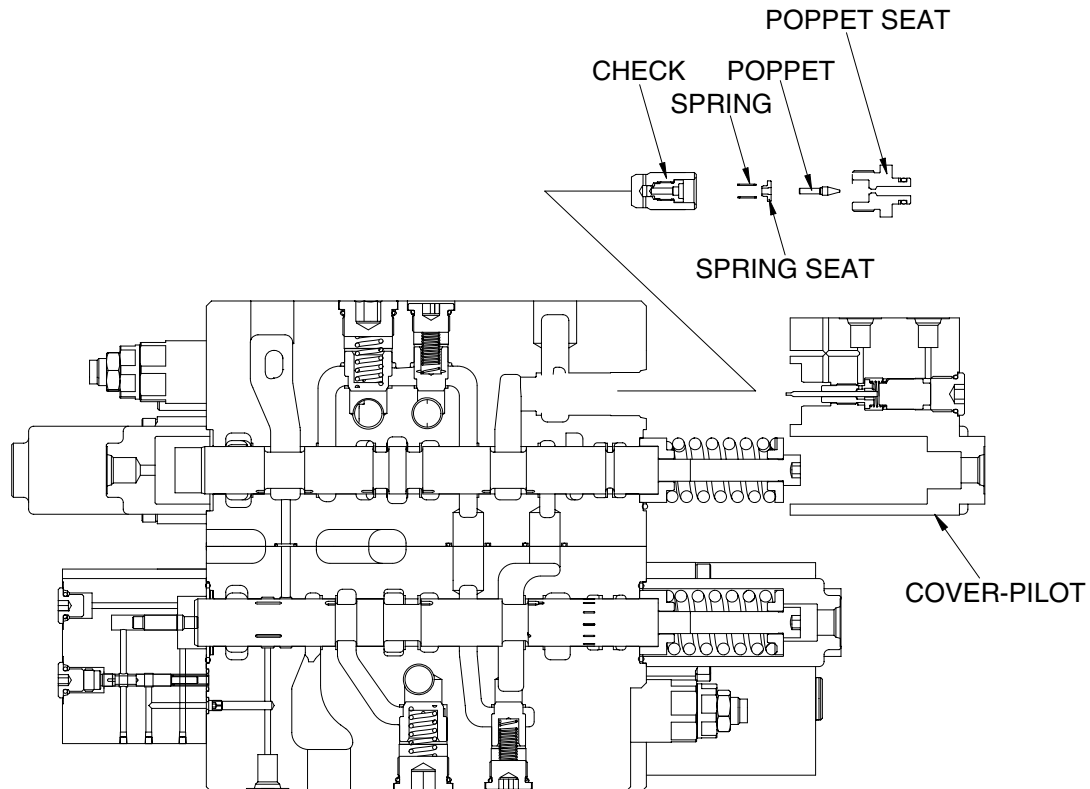
- ① Loosen hexagon socket head bolts with washer
(Hexagon wrench : 5mm)
- ② Remove the pilot cover with internal parts.
 - ※ Pay attention not to lose the O-ring and the poppet under the pilot cover.
 - ※ Pay attention not to damage the "piston A" under pilot cover.
- ③ Remove the spool assembly from the body by hand slightly.
 - ※ When extracting each spool from its body, pay attention not to damage the body.
 - ※ When extracting each spool assembly, it must be extracted from spring side only.
 - ※ When any abnormal parts are found, replace it with completely new spool assembly.
 - ※ When disassembled, tag the components for identification so that they can be reassembled correctly.



29078MC21

(3) Disassembly of the holding valve

- ① Remove the pilot cover with the holding valve as described on previous page.
 - ※ Do not disassemble internal parts of the pilot cover.
- ② Loosen the poppet seat and remove the poppet, the spring seat, the spring and the check.
(Spanner : 32mm)
 - ※ Pay attention not to lose the poppet.
 - ※ Do not disassemble internal parts of the check.

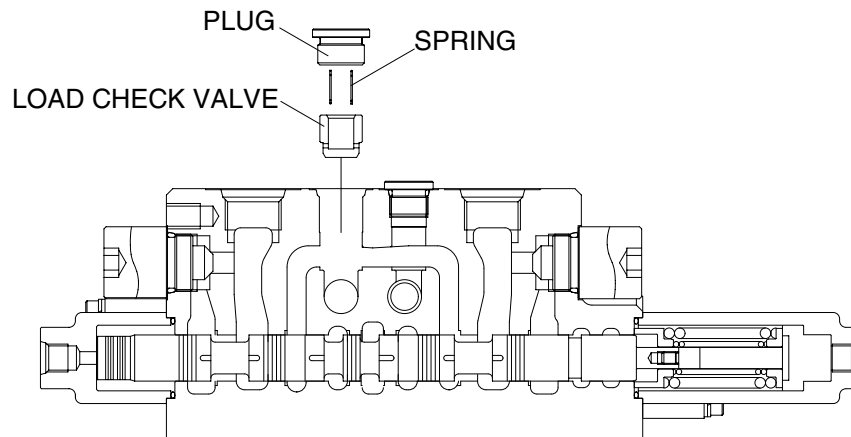


29078MC22

(4) Disassembly of the load check valve and the negative relief valve

① The load check valve

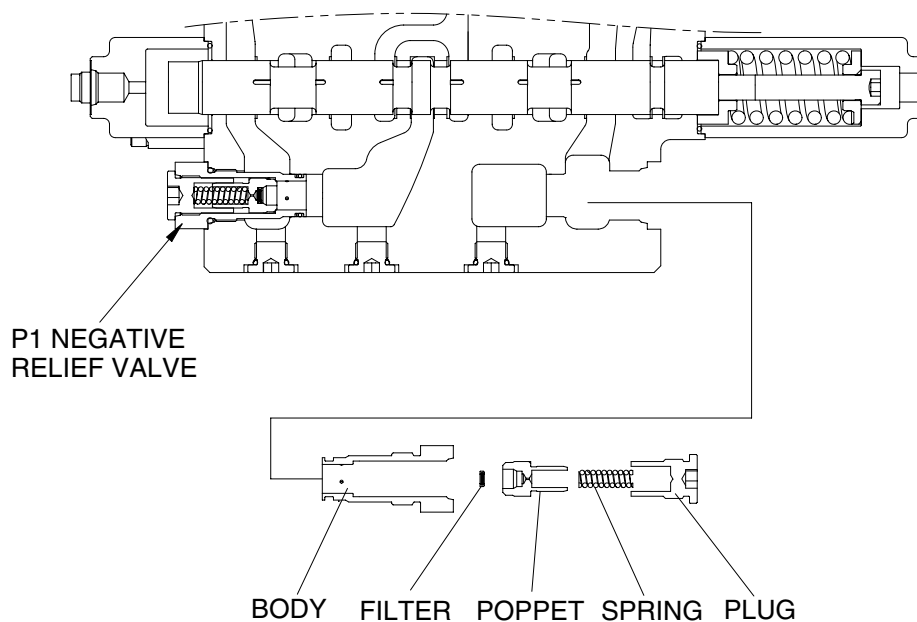
- a. Fix the body to suitable work bench.
- ※ Pay attention not to damage the body.
- b. Loosen the plug (Hexagon wrench : 10mm).
- c. Remove the spring and the load check valve with pincers or magnet.



29078MC23

② The negative relief valve

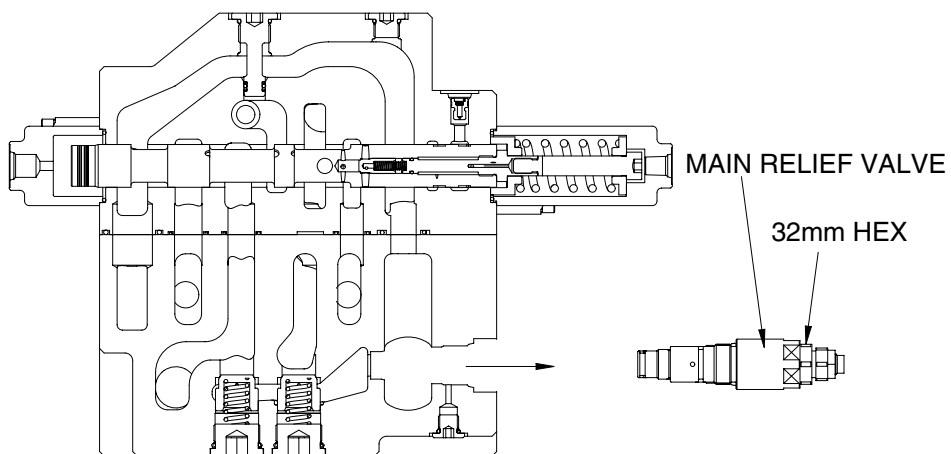
- a. Loosen the socket (Hexagon wrench : 12mm).
- b. Remove the spring, the spring holder, the piston and the negative control poppet.



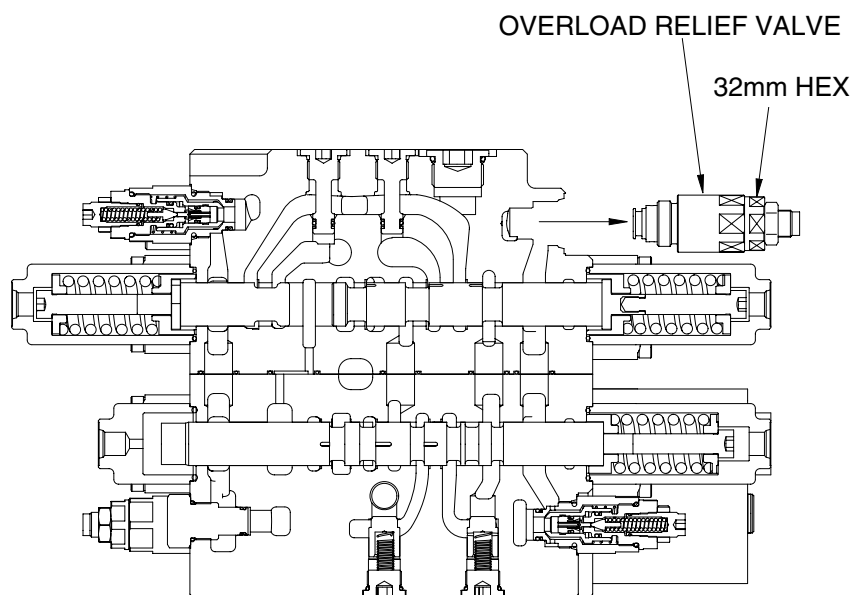
29078MC24

(5) Disassembly of the main and overload relief valve

- ① Fix the body to suitable work bench.
 - ② Remove the main relief valve.
(Spanner : 32mm)
 - ③ Remove the overload relief valve.
(Spanner : 32mm)
- ※ When disassembled, tag the relief valve for identification so that they can be reassembled correctly.
 - ※ Pay attention not to damage seat face.
 - ※ When any abnormal parts are found, replace it with completely new relief valve assembly.



29078MC25



29078MC26

(6) Inspection after disassembly

Clean all disassembled parts with clean mineral oil fully, and dry them with compressed air. Then, place them on clean papers or cloths for inspection.

① Control valve

- a. Check whole surfaces of all parts for burrs, scratches, notches and other defects.
- b. Confirm that seal groove faces of body and block are smooth and free of dust, dent, rust etc.
- c. Correct dents and damages and check seat faces within the body, if any, by lapping.
 - ※ Pay careful attention not to leave any lapping agent within the body.
- d. Confirm that all sliding and fitting parts can be moved manually and that all grooves and path's are free foreign matter.
- e. If any spring is broken or deformed, replace it with new one.
- f. When a relief valve does not function properly, repair it, following it's the prescribed disassembly and assembly procedures.
- g. Replace all seals and O-rings with new ones.

② Relief valve

- a. Confirm that all seat faces at ends of all poppets and seats are free of defects and show uniform and consistent contact faces.
- b. Confirm manually that main poppet and seat can slide lightly and smoothly.
- c. Confirm that outside face of main poppet and inside face of seat are free from scratches and so on.
- d. Confirm that springs are free from breakage, deformation, and wear.
- e. Confirm that orifices of main poppet and seat section are not clogged with foreign matter.
- f. Replace all O-rings with new ones.
- g. When any light damage is found in above inspections, correct it by lapping.
- h. When any abnormal part is found, replace it with a completely new relief valve assembly.

4) ASSEMBLY

(1) General precaution

- ① In this assembly section, explanation only is shown.
For further understanding, please refer to the figures shown in the previous structure & disassembly section.
- ② Pay close attention to keeping all seals free from handling damage and inspect carefully for damage before using them.
- ③ Apply clean grease or hydraulic oil to the seal so as to ensure it is fully lubricated before assembly.
- ④ Do not stretch seals so much as to deform them permanently.
- ⑤ In fitting O-rings, pay close attention not to roll them into their final position in addition, a twisted O-ring cannot easily untwist itself naturally and could thereby cause inadequate sealing and thereby both internal and external oil leakage.
- ⑥ Tighten fitting bolts for all sections with a torque wrench adjusted to the respective tightening torque.
- ⑦ Do not reuse removed O-rings and seals.

(2) Load check valve

- ① Assemble the load check valve and spring.
- ② Put O-rings on to plug.
- ③ Tighten plug to the specified torque.
 - Hexagon wrench : 10mm
 - Tightening torque : 6~7kgf · m(43.4~50.6lbf · ft)

(3) Negative control relief valve

- ① Assemble the nega-con poppet, piston, spring holder and spring together into body.
- ② Put O-ring on to plug and tighten the latter to its specified torque.
 - Hexagon wrench : 12mm
 - Tightening torque : 8~9kgf · m(57.8~65.1lbf · ft)

(4) Main relief, port relief valves

Install main relief valve, overload relief valve into the body and tighten to the specified torque.

Component	Tools	Tightening torque	
		kgf · m	lbf · ft
Main relief valve(81)	Spanner 32mm	8~9	57.8~65.1
Overload relief valve(82)	Spanner 32mm	8~9	57.8~65.1

(5) Main spools

- ① Carefully insert the previously assembled spool assemblies into their respective bores within of body.
 - ※ Fit spool assemblies into body carefully and slowly. Do not under any circumstances push them forcibly in.

(6) Covers

- ① Fit spool covers to the non-spring assembly end of the spool, and tighten the hexagonal socket head bolts to the specified torque.
 - Hexagon wrench : 5mm
 - Tightening torque : 1~1.1kgf · m(7.2~7.9lbf · ft)
- ※ Confirm that O-rings have been fitted.
- ② Fit spring covers to the spring end for the spools, and tighten hexagon socket head bolts to the specified torque.
 - Hexagon wrench : 5mm
 - Tightening torque : 1~1.1kgf · m(7.2~7.9lbf · ft)
- ※ Confirm that O-rings have been fitted.

(7) Holding valves

- ① Assemble the check, spring seat and poppet together into body.
- ② Tighten the poppet seat to the specified torque.
 - Spanner : 26mm
 - Tightening torque : 6~7kgf · m(43.4~50.6lbf · ft)
- ③ Fit the "piston A" under pilot cover with internal parts into hole on the poppet seat.
- ④ Tighten hexagon socket head bolt to specified torque.
 - Hexagon wrench : 5mm
 - Tightening torque : 1~1.1kgf · m(7.2~7.9lbf · ft)