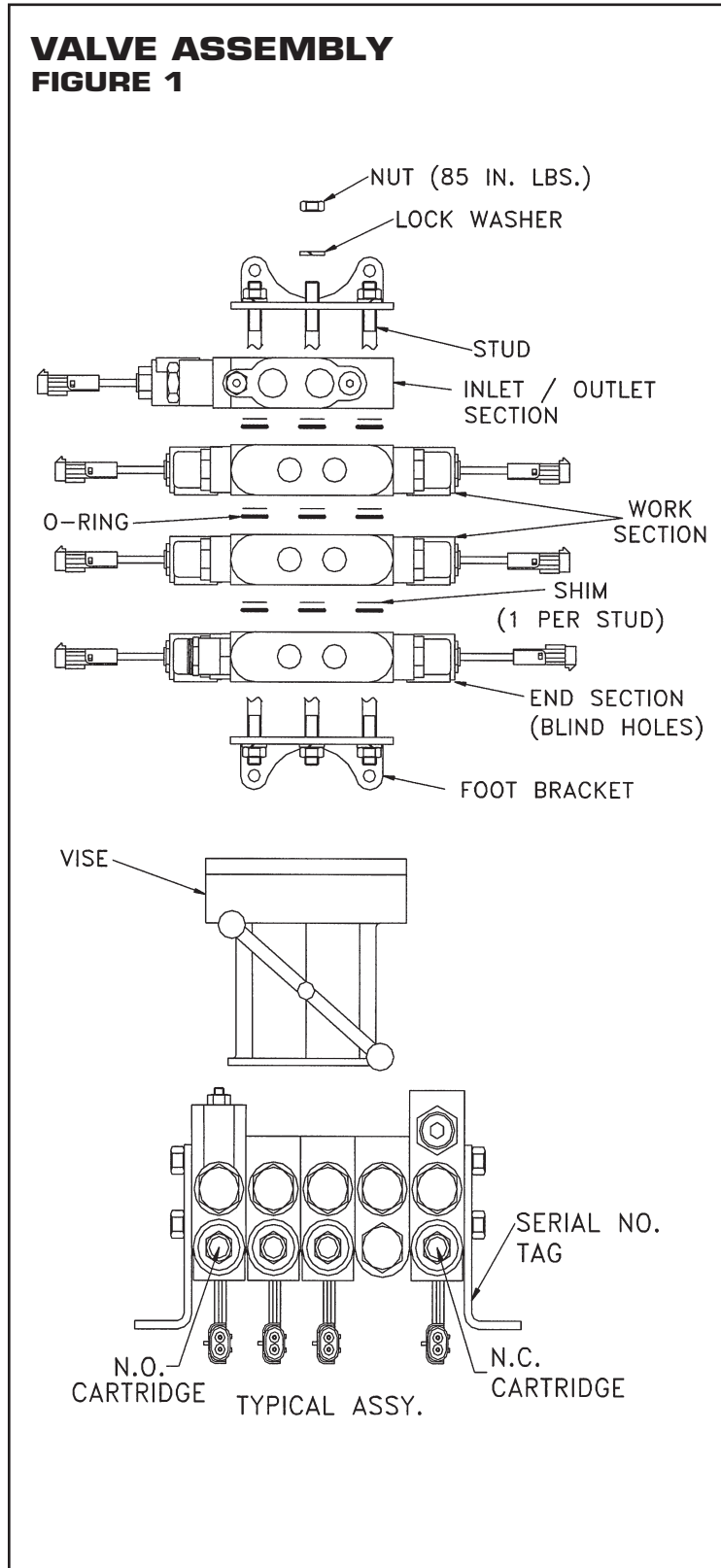




17 SERIES VALVE

ASSEMBLY INSTRUCTIONS

These instructions are provided as guidelines for the proper assembly of the 17V Series Valve. Failure to follow these instructions could result in leaks, binding spools, or poor performance.



REFERENCE FIGURE 1

1. Place foot bracket on a bench top or vise so that it sits level.
2. Place end work section on the foot bracket with the machined surface facing up, and the studs pointing up. The last work section must not have center passages machined clear through.
3. Install the washers and the nuts on the lower end, leaving approximately 1 thread exposed.
4. Inspect the machined surface of the work section for contamination.
5. Slide one shim over each stud. Inspect O-rings for damage, if O.K. install into grooves.
6. Slide each work section over the studs while repeating steps 4 and 5 between each work section.
7. Place foot bracket on top of the inlet/outlet section and install the upper washers and nuts so both the upper and lower studs ends have about the same length of threads exposed on each end.
8. Tighten the nuts finger tight, then place entire valve assembly with the foot brackets on the bench top.
9. Align valve assembly so that the foot bracket sits level on bench top.
10. Tighten each stud to 85 in.lbs.
11. Install serial number tag onto lower part of foot bracket. Be careful to not drill into work section.
12. The basic valve is now assembled. You can now proceed with any additional assembly or options.

17 SERIES VALVE WORK SECTION ASSEMBLY

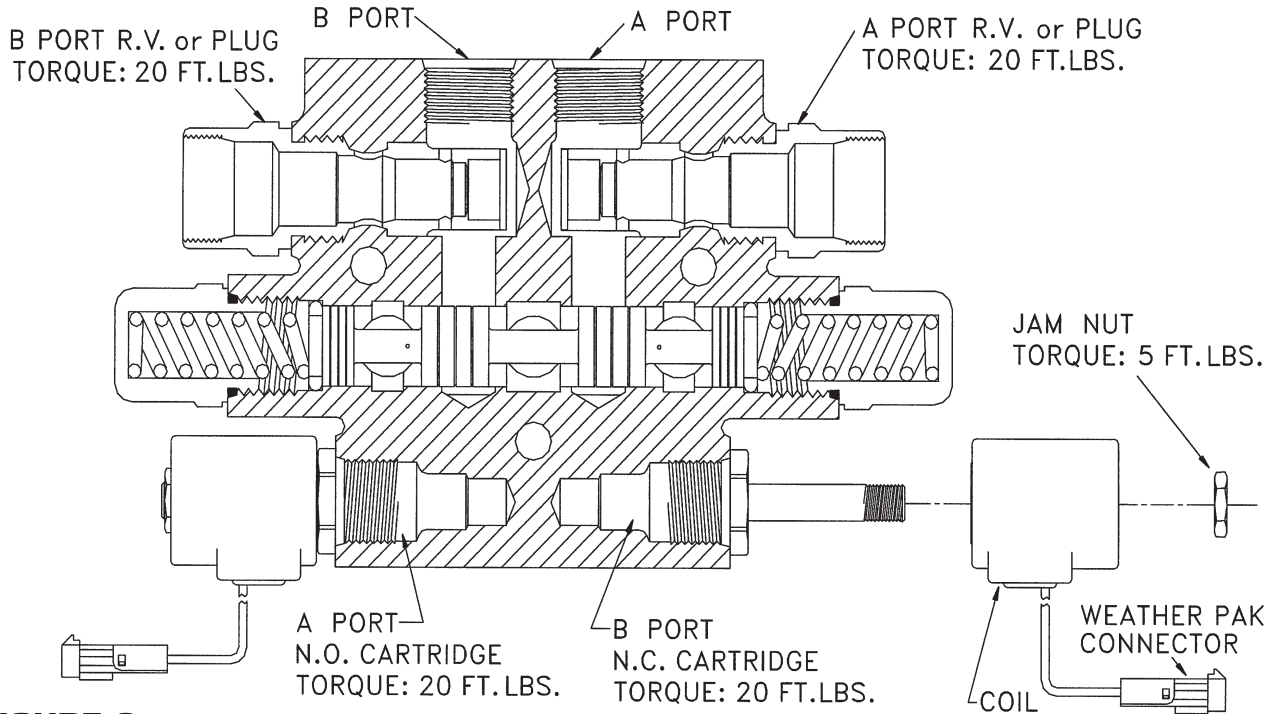


FIGURE 2

REFERENCE FIGURE 2

Port and Cavity Accessories Shown in Figure 2.

O-ring goes on the nose end groove of the relief valve or blanking plug.

Relief Valve Port Options

- Work port relief cavity plug (-10 ODT)
- Port R.V. cartridge set @ 750 PSI, adj. Range 500-1,000 PSI
- Port R.V. cartridge set @ 1,800 PSI, adj. Range 1,000-2,500 PSI
- Work port relief short plug (-10 ODT)

Solenoid Cartridge Port Options

- Solenoid cartridge cavity plug (-8)
- N.C. cartridge & coil with weatherpak connector (work section)
- N.C. cartridge only (work section)
- 12-Volt coil assembly (weatherpak connector)
- N.O. cartridge & coil with weatherpak connector (unloader section)
- N.O. cartridge only (unloader section)
- 12-Volt coil assembly (weatherpak connector)

Other Accessories

- Manual override/stroke control
- Work port plug (-8 ODT)

Part Number

- 17V-34CP
- 17V-34R075
- 17V-34R18
- HHBP-10

- 25T37436
- 35M37547MTN
- 35M37547CN
- 35M35874BMT
- 35M35874MTN
- 35M35874CN
- 35M35874BMT

- 17V-36M
- 25T35999 or HHBP-8



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