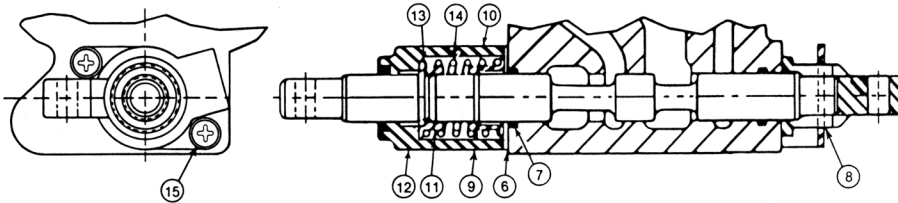


S2 Series Dump Pump

Spool Conversion Instructions

Kit No. DCK-S2
From Spring Return to Detent

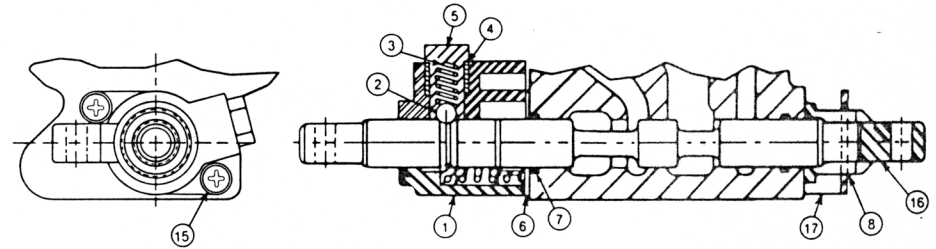
SPRING RETURN REMOVAL



NOTES

1. Remove spool pin, Item 8, from spool and spool end cap. Retain for re-use.
2. Remove two capscrews, Item 15, and slide spring-return end cap, Item 12, off the spool and spring-return assembly.
3. Remove spool with spring-return assembly from valve body. Cover plate, Item 6, and quad seal, Item 7, will come off with the spool. Once the spool is removed from the valve body, remove the cover plate and quad seal from the spool. Retain for re-use.
4. Compress the spring by pushing against spring guide, Item 11, to expose retaining ring, Item 13. (This may require the use of an arbor press. Force to compress spring is 50-55 lbs.) Remove retaining ring.
5. Remove spring, Item 14, spring guide, Item 9, and retaining ring, Item 10.
6. Clean mounting face of valve body and spool to remove dirt, grease, and paint.

DETENT INSTALLATION



NOTES

1. Lightly oil spool and slide into valve body.
2. Align hole in spool with slotted hole in spool end cap, Item 16, and install spool pin, Item 8. Spirol pin should not interfere with bracket, Item 17, when spool is operated.
3. Slide quad seal, Item 7, over spool and locate in counterbore in valve body.
4. Slide cover plate, Item 6, and detent end cap, Item 1, over spool and locate tightly against valve body.
NOTE: Detent end cap has a threaded hole for the detent assembly.
5. Align cover plate with end cap and insert two capscrews, Item 15, finger tight. Shift spool to assure centering of end cap.
6. Tighten capscrews to 30 In.-Lbs.
7. Insert steel ball, Item 2, in threaded hole of end cap. Place spring, Item 3, on top of ball. Slide detent retainer, Item 5, with lockwasher, Item 4, over spring and thread into end cap..
8. Tighten detent retainer to 120 In.-Lbs.



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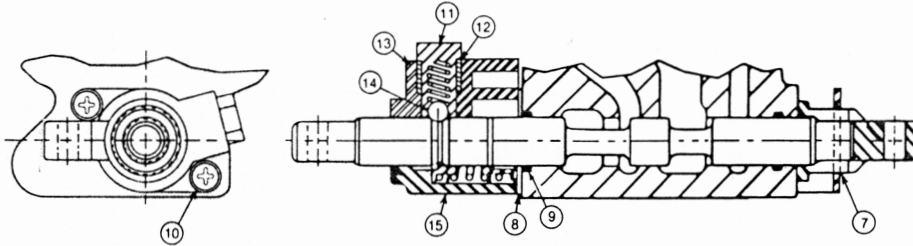
Item	Description	Qty.	Part Number
1	Detent end cap	1	PS-1425V
2	Detent ball	1	PS-1227V
3	Detent spring	1	PS-1228V
4	Lockwasher	1	PS-1229V
5	Detent retainer	1	PS-1230V

S2 Series Dump Pump

Spool Conversion Instructions

Kit No. SCK-S2
From Detent to Spring Return

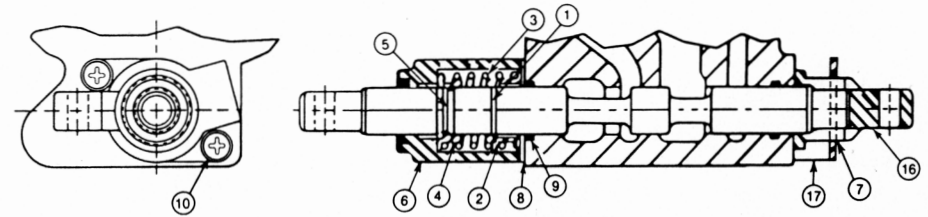
DETENT REMOVAL



NOTES

1. Remove detent cap, Item 11; lockwasher, Item 12; spring, Item 13; and ball, Item 14.
2. Remove two cap screws, Item 10; and slide detent end cap, Item 15, off the spool.
3. Remove spool, Item 7 from spool end cap. Retain for re-use.
4. Remove spool from valve body. Cover plate, Item 9, and quad seal, Item 9, will come off when spool is removed. Retain for re-use.
5. Clean mounting face of valve body and spool to remove dirt, grease, and paint.

SPRING RETURN INSTALLATION



NOTES

1. Attach narrower retaining ring, Item 1, to spool in narrow groove.
2. Slide longer spring guide, Item 2, onto spool and against retaining ring.
3. Install spring, Item 3, and shorter spring guide, Item 4, onto spool.
4. Compress spring by pushing against spring guide, Item 4, until the detent groove is visible. (This may require use of an arbor press. Force with spring compressed is 50-55 lbs.) Install retaining ring, Item 5, in detent groove.
5. Slide cover plate, Item 8, and quad seal, Item 9, onto spool and locate them against spring guide.
6. Lightly oil spool and slide spool with spring return assembly into valve body. Quad seal should enter counterbore in valve body.
7. Align hole in spool with slotted hole in spool end cap Item 16, and install spool pin, Item 7. Spool pin should not interfere with bracket, Item 17, when spool is operated.
8. Slide spring return end cap, Item 6, over the assembly and locate tight against cover plate and valve body. Cover plate must be aligned with end cap.
NOTE: Spring return end cap does not have a threaded hole in its side.
9. Insert two cap screws, Item 10, finger tight. Shift spool to assure centering of end cap.
10. Tighten cap screws to 30 In.-Lbs.

<u>Item</u>	<u>Description</u>	<u>Qty.</u>	<u>Part Number</u>
1	Snap ring	1	PS-1420V
2	Spring retainer	1	PS-1421V
3	Spring	1	PS-1422V
4	Spring retainer	1	PS-1423V
5	Snap ring	1	PS-1424V
6	Spring end cap	1	PS-1425VS