

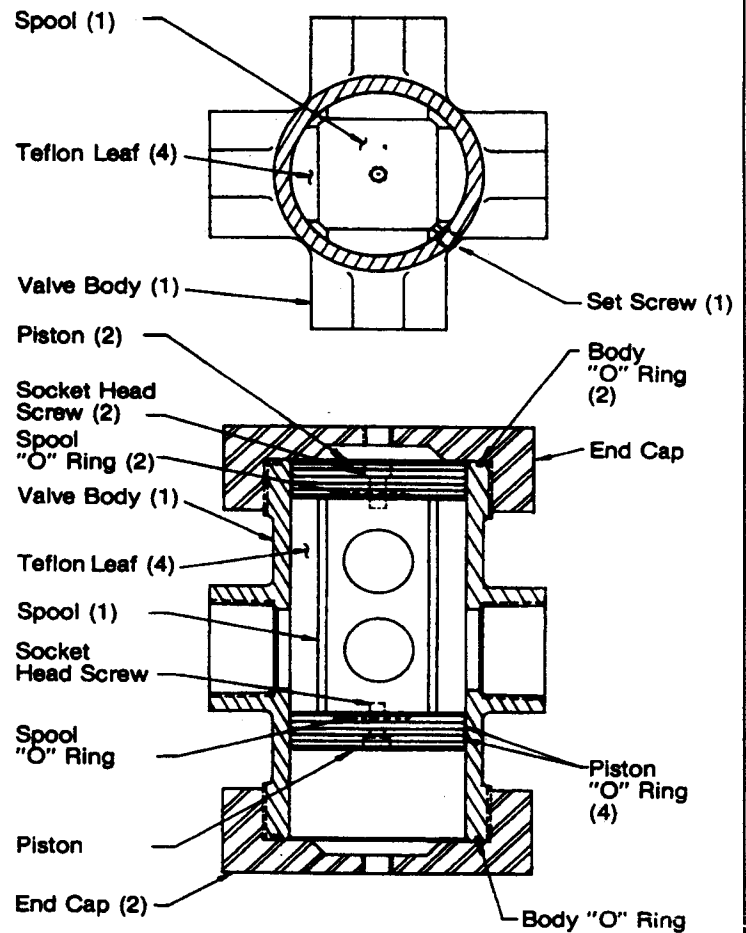
10.0 INSTALLATION INSTRUCTIONS- 4-WAY SLIDING VALVE

VALVE DISASSEMBLY

1. Shut off air supply and bleed air out of all lines connected to the valve.
Caution: All ports must be bled (not pressurized) before repairs are started to prevent damage or personal injury.
2. Remove Pilot Lines from both End Caps.
3. Remove both End Caps.
4. Remove Spool locating Set Screw in side of Body.
5. Remove Socket Head Screw from center of Top Piston. Using low pressure air, place hose nozzle in screw hole of Piston and apply air to remove Piston.
Caution: When air is applied, the Piston will be forced out against the nozzle. Slowly back the Piston out until it is flush with the valve opening. Place hand on Piston and continue to ease it out with air pressure. **DO NOT USE HIGH PRESSURE AIR.**
 Remove two (2) Piston "O" Rings and one (1) Spool "O" Ring from Piston and discard.
6. With marking pen, mark Spool end and Piston because Spool must be reassembled exactly with the same end up.
7. Using wood block (approx. 1 1/2" sq. X 10" long) tap with rawhide hammer against Spool to remove remainder of assembly. Discard four (4) Teflon leaves and eight (8) Leaf "O" Rings. Remove other Piston, discard two (2) Piston "O" Rings and one (1) Spool "O" Ring.
8. Clean and inspect all parts.

VALVE ASSEMBLY

1. Ensure valve body/parts are clean and free from contaminants, dirt and oil.
2. Place two (2) Leaf "O" Rings under each Teflon leaf. Then place the four (4) leaves around the Spool using a rubber band to hold them in place.
3. Place two (2) new Piston "O" Rings, coated with a light lubricant, and one (1) Spool "O" Ring onto marked Piston. Place marked Piston onto the marked end of the Spool. Place a drop of Loc-tite # 222 on Socket Head Screw thread and tighten Piston onto Spool.
4. Place a ring compression tool over Teflon leaves opposite Piston, approximately 1/2" from edge of Teflon and tighten.
5. Start Teflon leaf end of Spool in top of Valve Body with ports in-line and flat on Spool lining up with Spool Locating Set Screw hole in side of Valve Body. With block of wood and rawhide hammer, tap Piston (remove rubber bands while tapping in) until Spool slides into Valve Body and Piston is flush with the top of Valve Body.
6. Place two (2) new Piston "O" Rings, coated with a light lubricant, and one (1) Spool "O" Ring on remaining Piston. Place Piston into Valve Body on Spool. Place drop of Loc-tite #222 on screw thread and tighten Piston on Spool.



7. With Spool ports in line with Valve Body ports, apply drop of Loc-tite #222 to set screw - screw in Valve Body tight against Spool and back out 1/4 turn.
8. Place Body "O" Ring on end of Valve Body - apply Loc-tite #222 to threads on Body-screw on End Cap and tighten.
9. Place Body "O" Ring on other end of Valve Body - apply Loc-tite #222 to threads on Body-screw on End Cap and tighten. Allow fifteen (15) minutes before pressurizing valve.
10. It is recommended that the valve be leak checked. Install air line into one End Cap. Slowly pressurize to dryer's rated operating pressure and spray soap solution on end cap connection. Repeat procedure for remaining end.
11. Reconnect all air piping and install Pilot Lines.