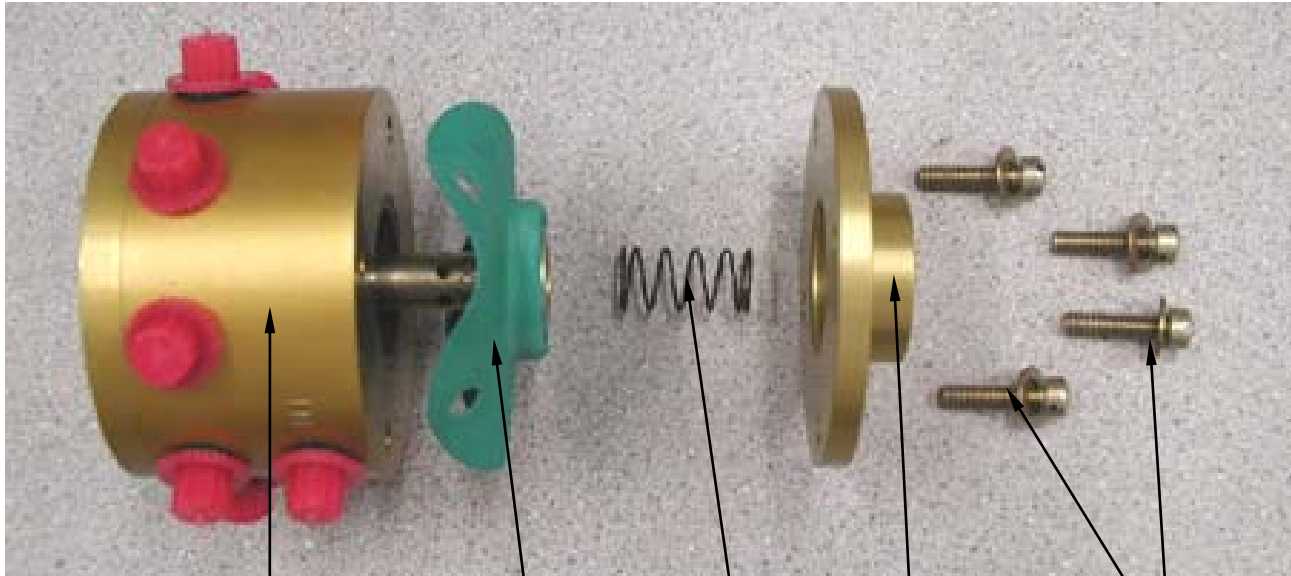


FOR REFERENCE ONLY



Flow Divider
Body Assy.

Diaphragm/Spool
Valve Assy.
Torque 4-40 nut 4
to 6 in-lbs, 12 in-
lbs. max. Use
Loctite on screw
and nut. Clean
assembly after
Loctite sets up.

Spring

Cover

Cover Screws
Torque 20-25 in-lbs

Assemble Flow Divider: Spray diaphragm screw and Lock Nut threads with Loctite Primer T and let stand 3 minutes minimum. Apply Loctite Hydraulic Sealant 569 to screw shank. Assemble Flow Divider Valve and Diaphragm per print. Torque Lock Nut to 4-6 in-lbs.(Note: Valve should not spin after torque is applied, if diaphragm spins relative to valve after 6 in lbs of torque is applied, it is permissible to increase torque up to 12 in lbs max. to compensate for running torque of lock nut) Allow Loctite to cure for 8 hours minimum, and then clean parts with solvent and blow dry. Assemble diaphragm assembly, Spring and Flow Divider Cover. Torque screws to 15-25 in-lbs. Assemble Flow Divider Base. Torque screws to 15-25 in-lbs.

!!!!!!!!!!!!!!!!!!!!!!!!!!!! RE-LOCKWIRE ALL SCREWS!!!!!!!!!!!!!!!!!!!!!!!!!!!!