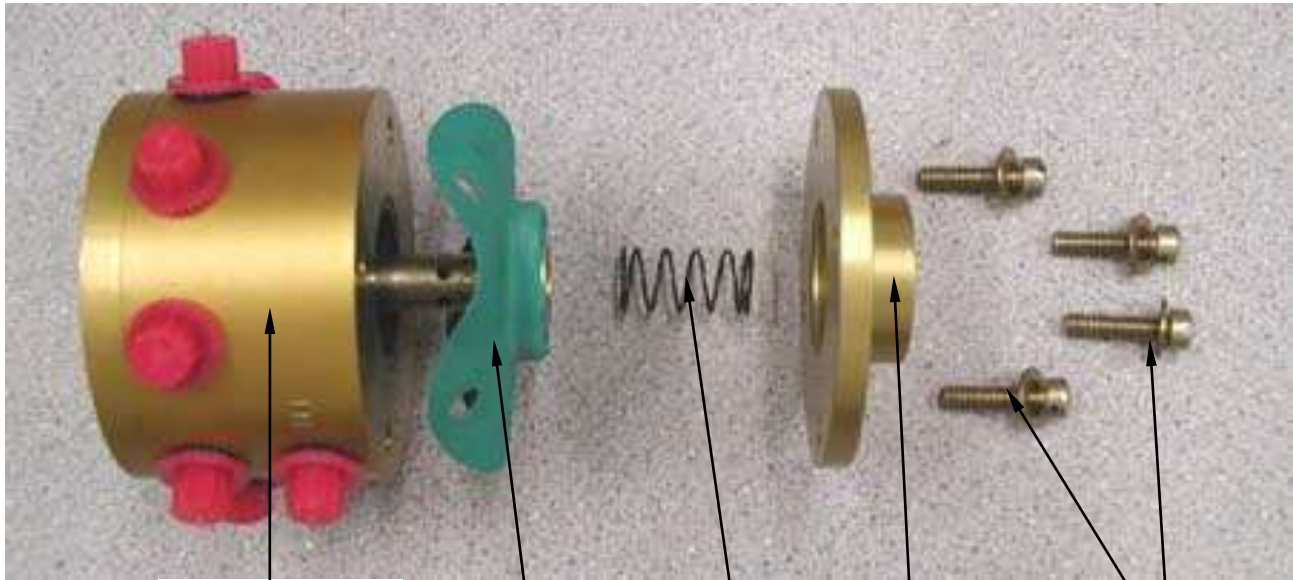


FOR REFERENCE ONLY

FLOW DIVIDER CLEANING INSTRUCTIONS

6-10. The following procedure is approved for cleaning the flow divider in the field. Should a malfunction in the flow test occur after cleaning, the flow divider should be returned for repair.

1. Remove the flow divider from the engine.
2. Remove the four 10-24 screws from the cover, then remove the cover. There is a spring under the cover. Remove the flow divider spool valve and diaphragm as one assembly. **Do not remove the diaphragm from the spool valve.**
3. Remove the four 10-24 flat head screws from the base of the flow divider. Remove the base noting the position of the base relative to the flow divider body. The bottom of the flow divider body and base are lapped surfaces. **DO NOT nick or scratch these surfaces.** Remove the O-ring from the base.
4. Clean the flow divider body in non-etching parts cleaner, Acetone or MEK. Do not submerge the spool and diaphragm in any cleaner. Wash the spool valve and diaphragm with Stoddard solvent. Blow off all parts with compressed air. Sonic cleaning is also an approved method for cleaning the flow divider body.
5. Insure that all the flow divider port slots are clean. A .006" feeler gauge is useful for this task. The flow divider spool valve needs to slide smoothly in the bore. This is a matched fitted part. **DO NOT USE ABRASIVE MATERIAL FOR CLEANING THE SPOOL VALVE.**
6. Reassemble the flow divider in the reverse order. Replace the flow divider base O-ring if damaged. O-Ring P/N OR-027.7.
7. Repeat the flow test as described in section 6-9.
8. Reinstall the flow divider on the engine as described in section 3-26 and 3-27.



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

If the flow divider requires replacement of the diaphragm, see instructions below.

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 Flow Divider Base. Torque screws to 15-25 in-lbs. Install Diaphragm/Spool Valve assembly (valve must slide smoothly in bore), Spring and Flow Divider Cover. Torque screws to 15-25 in-lbs.

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