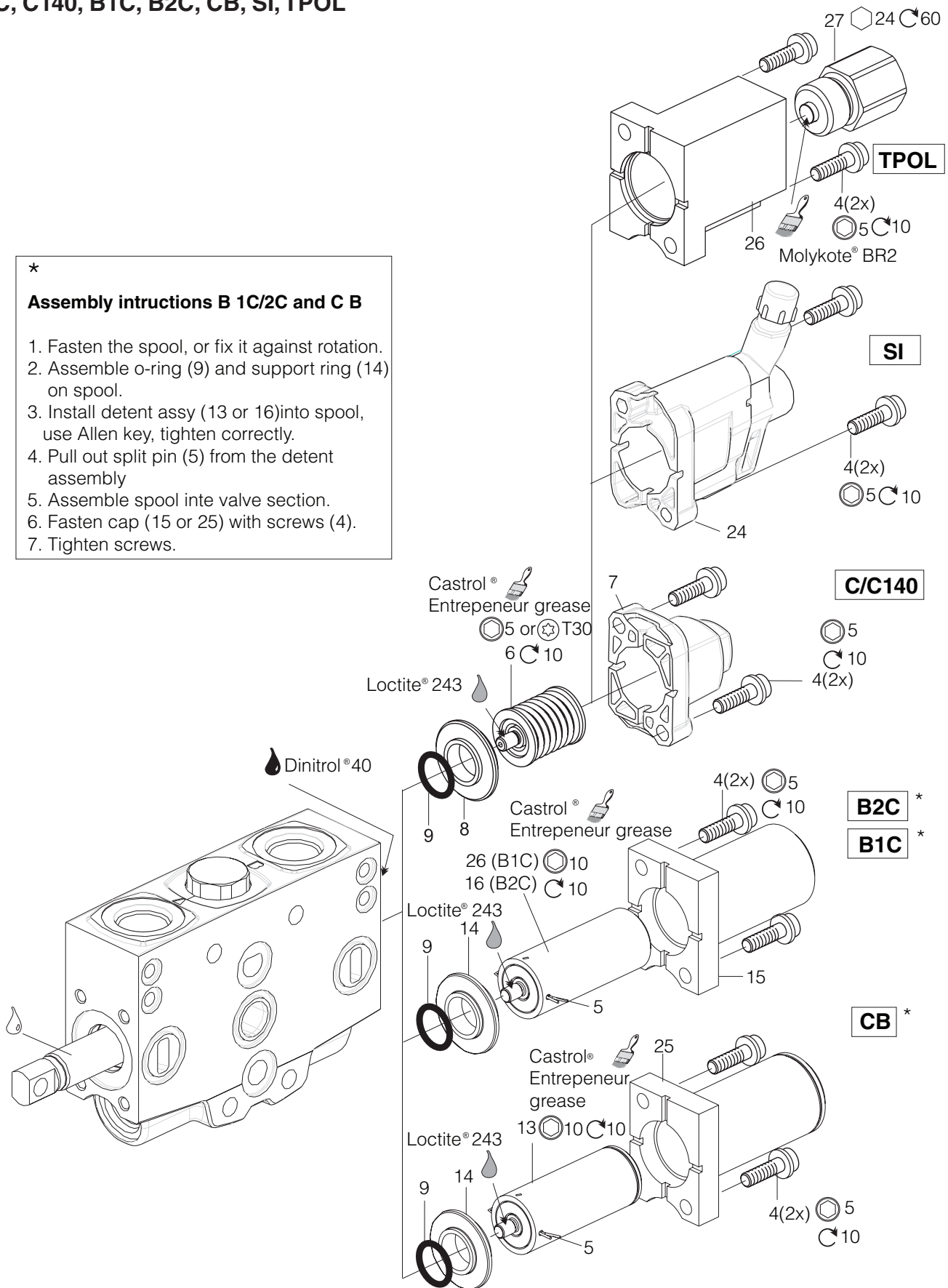


C, C140, B1C, B2C, CB, SI, TPOL

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Assembly instructions B 1C/2C and C B

1. Fasten the spool, or fix it against rotation.
2. Assemble o-ring (9) and support ring (14) on spool.
3. Install detent assy (13 or 16) into spool, use Allen key, tighten correctly.
4. Pull out split pin (5) from the detent assembly
5. Assemble spool into valve section.
6. Fasten cap (15 or 25) with screws (4).
7. Tighten screws.



See Customer Specification				
Code	Pos	Part	Description	Remarks / Items
C, C140	50	398000K008	Cap kit C, C140	4(2x), 7, 8, 9
C, C140; TPOL, SI	50; 52	6760041	Spring pack, STD, centering force 80 N	6
C+A020	50 + 59	398000K484	Spring pack, C+A020	6 (Valid also for TPOL and SI in pos. 52)
C140	50	6760042	Spring pack, C140, centering force 140 N	6
C140+A020	50 + 59	6760470	Spring pack, C140+A020	6 (Valid also for TPOL and SI in pos. 52)
C, C140; TPOL, SI	50; 52	6760544	Support washer multipack	8(100x)
B1C	50	6764253	Spool actuator B1C	4(2x), 9, 14, 15, 26 [5]
B1C	50	398000K159	Cap kit B1C/B2C	4(2x), 9, 14, 15
B1C	50	6764254	Spring/detent pack, B1C	26 [5]
B2C	50	398000K059	Spool actuator B2C	4(2x), 9, 14, 15, 16 [5]
B2C	50	398000K159	Cap kit B1C/B2C	4(2x), 9, 14, 15
B2C	50	398000K259	Spring/detent pack	16 [5]
CB	50	398000K060	Spool actuator CB	4(2x), 9, 13 [5], 14, 25
CB	50	398000K160	Cap kit CB	4(2x), 9, 14, 25
CB	50	398000K260	Spring/detent pack	13 [5]
C, C140, B2C, CB	50	398000K805	Seal kit C, C140, B2C, CB (A- and B- side)	3, 9(2x), 11 (See page 12)
TPOL	52	398000K420	Cap kit, TPOL	4(2x), 8, 9, 26
TPOL	52	6760044	Cylinder assembly, TPOL	27
SI	52	398000K404	Spool position sensor kit	4(2x), 8, 9, 24