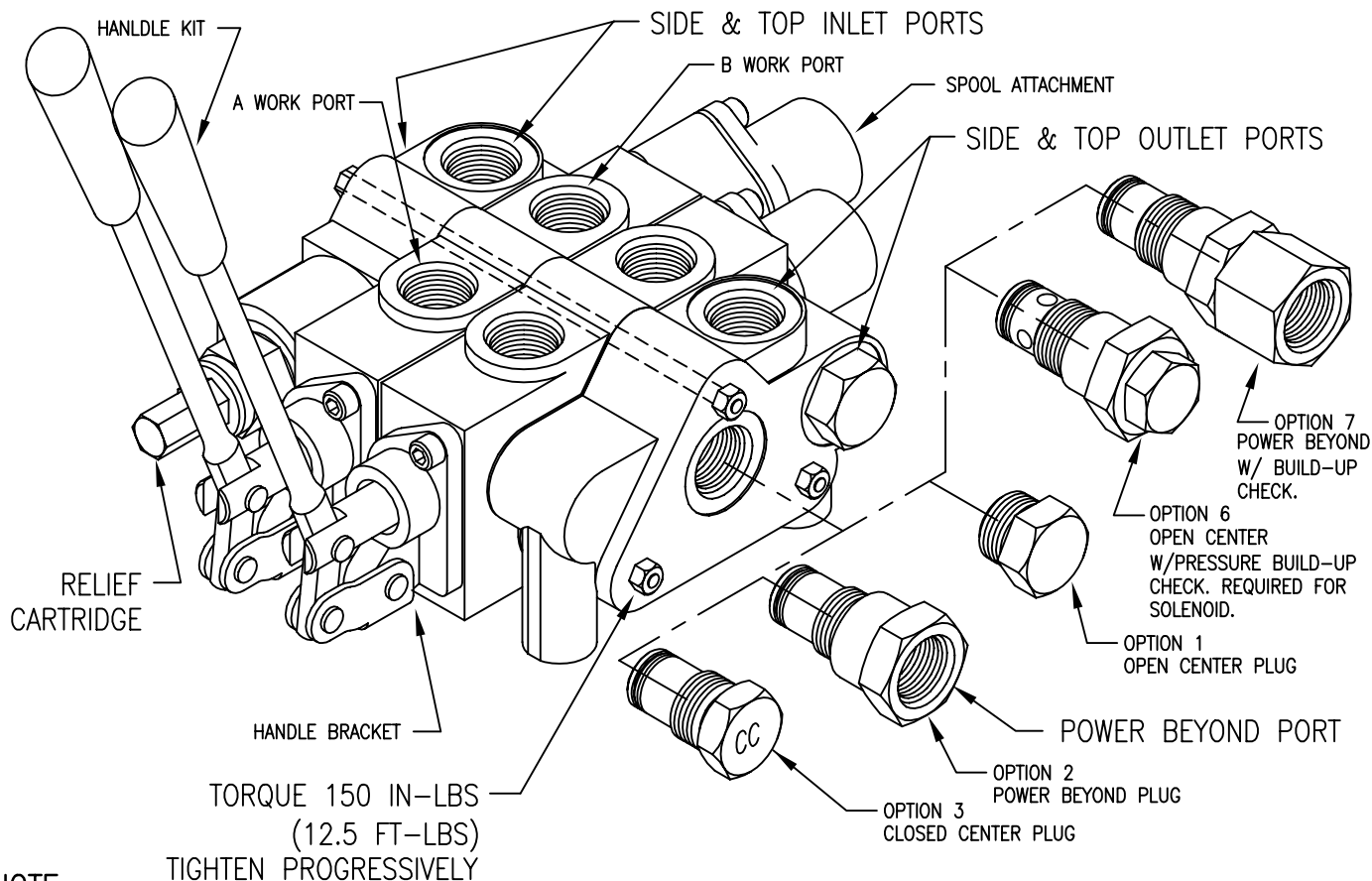


TYPICAL MODEL SV STACK VALVE ASSEMBLY



NOTE:
FEATURES MAY VARY WITH
MODEL NO. CONSULT CATALOG

STACK VALVE ASSEMBLY INSTRUCTIONS

1. INSTALL NUTS AND LOCKWASHERS ON ONE END OF EACH TIEROD.
2. INSERT TIERODS THROUGH HOLES IN THE INLET SECTION
3. POSITION THE INLET SECTION WITH TIERODS INSTALLED ON ITS SIDE SO TIERODS ARE VERTICAL. PLACE FOUR O-RINGS INTO FOUR GROOVES ON SIDE OF INLET.
4. SLIDE THE WORK SECTIONS DOWN THE TIERODS AND POSITION OVER THE INLET SECTION. PLACE FOUR O-RINGS INTO FOUR GROOVES ON SIDE OF WORK SECTION.
5. REPEAT FOR REMAINING WORK SECTIONS AND OUTLET. MAKE CERTAIN O-RINGS STAY IN GROOVES DURING ASSEMBLY.
6. INSTALL NUTS AND LOCKWASHERS. PROGRESSIVELY TIGHTEN TIERODS TO 150 IN-LBS \pm 6 IN-LBS (12.5 FT-LBS \pm 5 FT-LBS)
7. INSTALL HANDLES AND OPERATE SPOOLS. MAKE CERTAIN THAT SPOOLS DO NOT BIND AND THAT SPOOLS WITH SPRING CENTER RETURN TO NEUTRAL.
8. IF A SPOOL BINDS LOOSEN TIEROD NUTS. RETORQUE ALL NUTS TO 8 THEN 10 AND FINALLY 12.5 FT-LBS.
9. IF A SPOOL STILL BINDS CHECK FOR A SMASHED O-RING OR CONTAMINATION BETWEEN THE SECTIONS.

PLEASE NOTE:

BE VERY CAREFUL NOT TO NICK OR SCRATCH THE PRECISION GROUND SURFACES ON THESECTIONS. ALSO TAKE CARE TO KEEP THESE SURFACES CLEAN DURING ASSEMBLY.

CLOSED CENTER PLUG OPTION 3

This option provides for closed center operation. This is typically used with a variable displacement pressure compensated pump or in a system with an unloading valve. When the spools are in neutral the inlet port is blocked. The power beyond plugs can be used for closed center conversion by plugging the power beyond port. PLEASE NOTE it may be necessary to increase relief pressure above pump compensator setting.

POWER BEYOND PLUG WITH #8 SAE ORB PORT OPTION 2

This option provides for a high pressure power beyond port. This would be used if a valve is to be added downstream. PLEASE NOTE The outlet must be connected to tank. When spools are in neutral the inlet is connected to power beyond port.

PRES. BUILD-UP CART OPTION 6/P.B. PLUG WITH #8 SAE OPTION 7

Open center pressure build-up valve, required for solenoid operated sections. Option 7 same as option 2 but w/pres. build-up

3 WAY SPOOLS OPTION 'A'

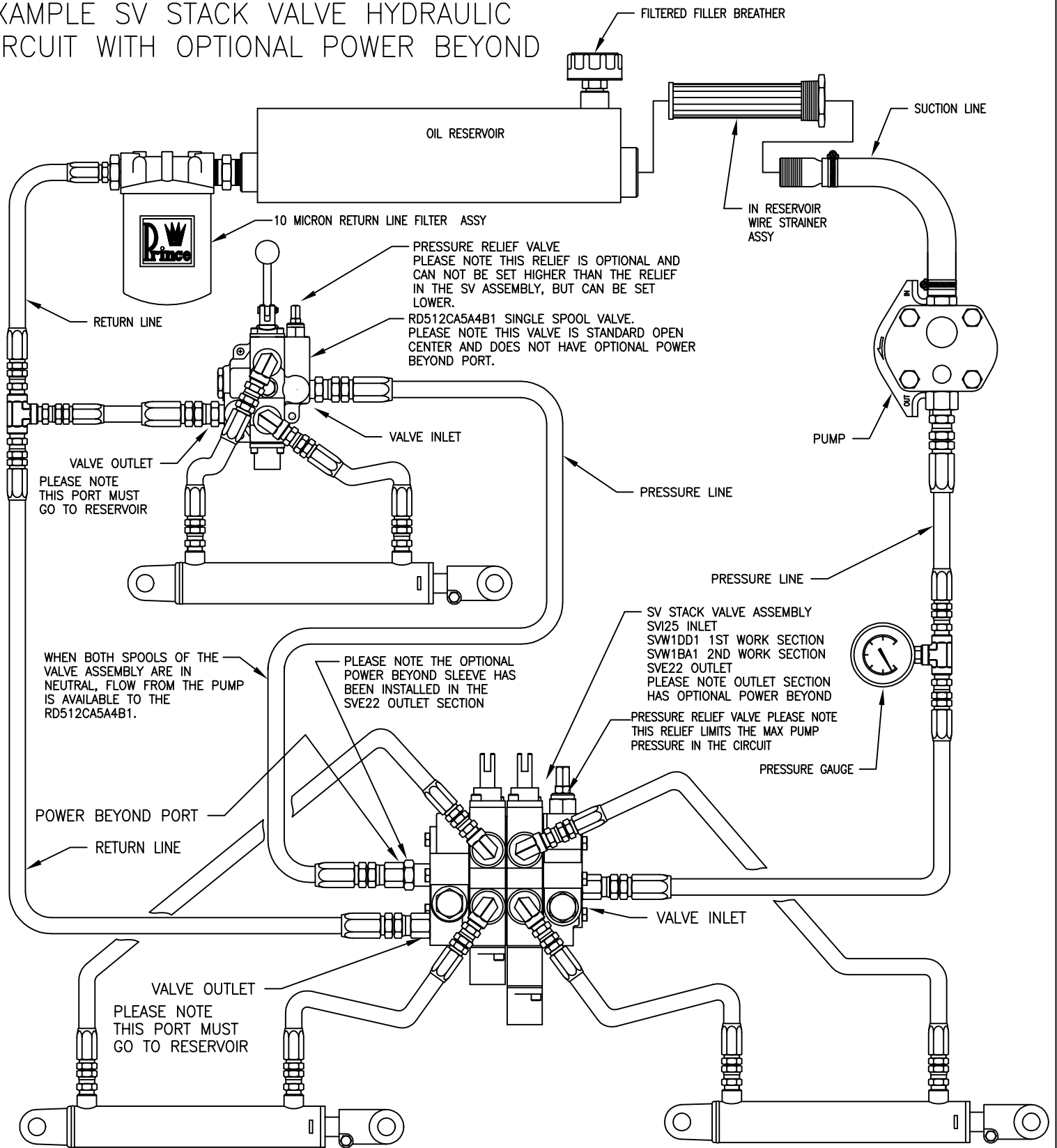
Have the 'A work port' plugged. Connect 'B work port' to cylinder.

LOAD CHECK:

The load check feature is standard on all SV series valves. Each spool has a separate load check. The load check will prevent the fall of a cylinder as the spool is shifted. It also prevents the backflow of oil from the work port to the inlet. The pump must build up enough pressure to overcome the pressure on the work port caused by the weight of the load before the cylinder can move.

PLEASE NOTE: The load check has nothing to do with how well the valve will hold up a cylinder with the spool in neutral. The load check is functional only when the spool is shifted.

EXAMPLE SV STACK VALVE HYDRAULIC CIRCUIT WITH OPTIONAL POWER BEYOND



MODEL SV KITS AND CARTRIDGES

PART NO.	DESCRIPTION	PART NO.	DESCRIPTION	PART NO.	DESCRIPTION
660580001	SVW SEAL KIT	660180037	SPRING CENTER W/DETENT OUT	660180007	ADJUSTABLE HANDLE KIT
660580010	SVH SEAL KIT	660180051	SPRING CENTER FLOAT KIT	660250006	INLET RELIEF (OPT. 1) NO RELIEF PLUG
660580009	SVL SEAL KIT	660180036	SPRING CENTER W/ DETENT IN	RV-0L	INLET RELIEF (OPT. 4) ADJ. RELIEF CART 500-1500 PSI
660580011	SVS SEAL KIT	660180037	SPRING CENTER W/DETENT OUT	RV-0H	INLET RELIEF (OPT. 5) ADJ. RELIEF CART 1500-3000 PSI
660180052	LOAD CHECK KIT	660180015	SPRING CENTER W/MICROSWITCH BRACKET	200400030	OPEN CENTER PLUG
660580004	BETWEEN SECTION SEAL KIT	660180033	BENT JOYSTICK HANDLE KIT	660280001	POWER BEYOND PLUG #8 SAE PORT (OPTION 2)
660180001	SPRING CENTER KIT	660180017	STRAIGHT JOYSTICK HANDLE KIT	660280002	CLOSED CENTER PLUG (OPTION 3)
660180002	3 POSITION DETENT KIT	660180018	OFFSET JOYSTICK HANDLE KIT	660280019	POWER BEYOND PRESSURE BUILD-UP CART (OPTION 7)
660180003	1 POSITION DETENT KIT	660180005	COMPLETE STANDARD HANDLE KIT	660280018	OPEN CENTER PRESSURE BUILD-UP CART (OPTION 6)
660180051	SPRING CENTER FLOAT KIT	660180011	HANDLE KIT (HANDLE, KNOB & PINS)		RELIEF: STANDARD SETTING OPTION 5 2000 PSI
660180036	SPRING CENTER W/ DETENT IN	660180031	PIN KIT (FOR STD. HANDLE)		STANDARD SETTING OPTION 4 1000 PSI