

NOTE

The repair kit is used to service various models in this relay valve series which may not require the use of all repair kit components.

RELAY VALVE

Service Instructions

For Brake Valves: 593675

DISASSEMBLY

1. Remove plug (1), retainer (3) and spring (4) from housing (7). Remove o-ring (2) from plug (1).
2. Separate housings (7 & 11) by removing cap screws (5) and washers (6). Remove o-rings (9 & 10) from housings (7 & 11).
3. Carefully remove spool (8) from housing (7).
NOTE: Be careful not to damage spool or housing bore.

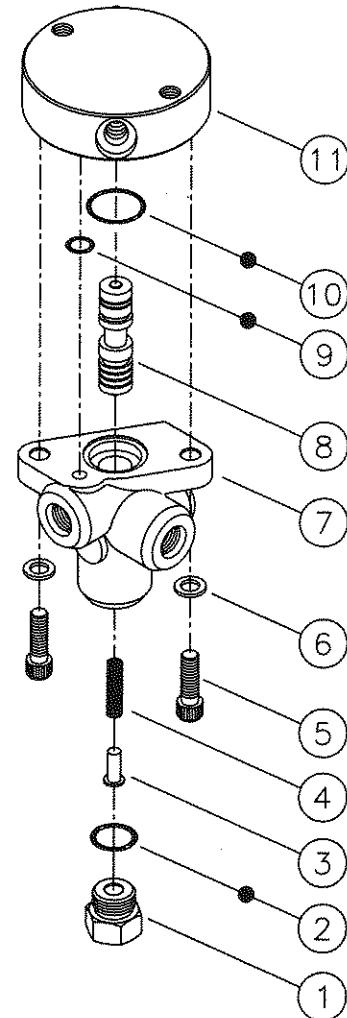
CAUTION

Do not intermix spools and housings. Spool (8) and housing (7) are manufactured as a matched set.

ASSEMBLY

LUBRICATE ALL RUBBER COMPONENTS FROM REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM.

1. Clean all parts thoroughly before assembling.
2. Lubricate spool (8) with clean system fluid and carefully slide into top end of housing (7) bore. Note direction of spool (8). **NOTE: Spool must slide freely into bore. If either part is damaged, a new valve assembly may be required.**
3. Install new o-rings (10 & 9) in proper o-ring pockets on housings (7 & 11).
4. Reassemble housings (7 & 11) using cap screws (5) and washers (6). Use Loctite 242 on cap screws and torque 27.1-32.5 N·m (20-24 lb·ft).
5. Install new o-ring (2) on plug (1).
6. Install spring (4), retainer (3) and plug (1) in housing (7). Torque plug (1) 47.5-54.2 N·m (35-40 lb·ft).



● Items included in Repair Kit