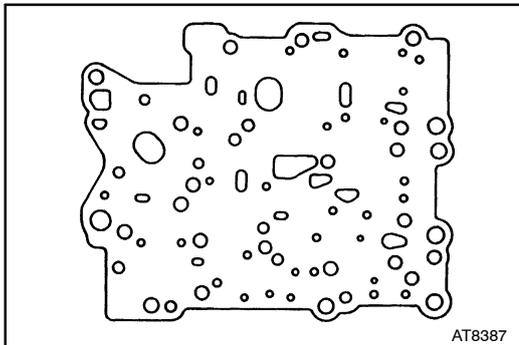


(Assembly of Transfer Valve Body)

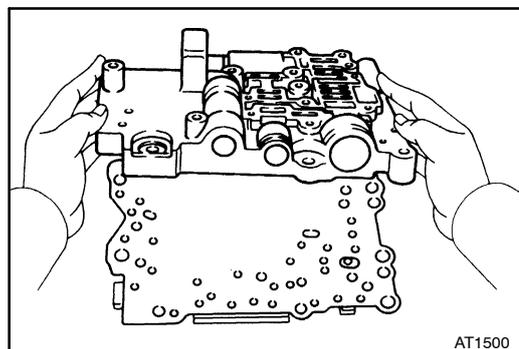
(See page AT-209)

1. POSITION NEW NO. 2 GASKET ON UPPER VALVE BODY
Align a new No. 2 gasket at each bolt hole.

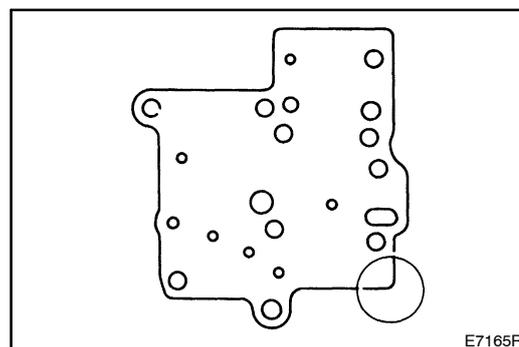
2. POSITION VALVE BODY PLATE ON NO. 2 GASKET
Align the plate at each bolt hole.



3. POSITION NEW NO. 1 GASKET ON PLATE
Align a new No. 1 gasket at each bolt hole.

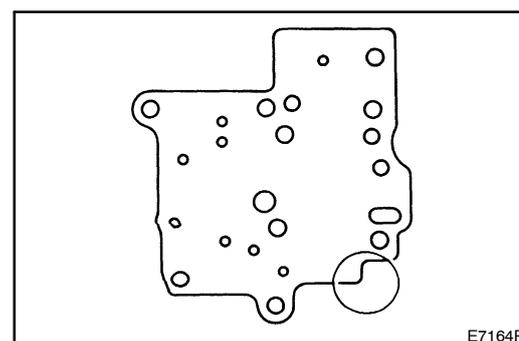


4. PLACE CENTER VALVE BODY ON TOP OF UPPER VALVE BODY

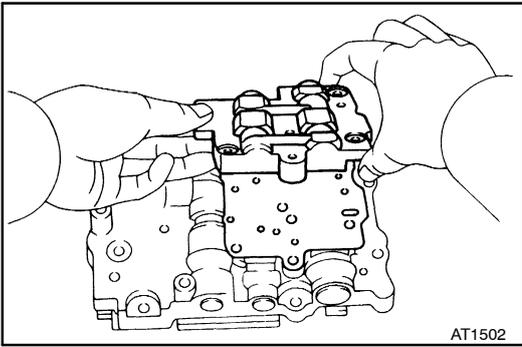


5. POSITION NEW NO. 2 GASKET ON CENTER VALVE BODY
Align a new No. 2 gasket at each bolt hole.

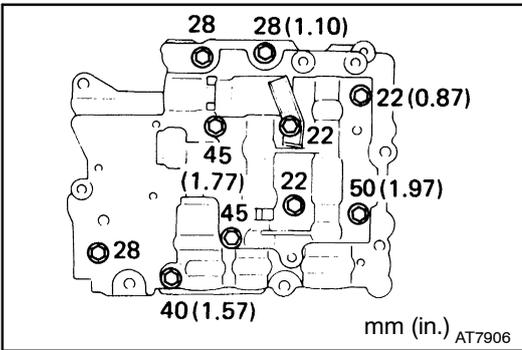
6. POSITION VALVE BODY PLATE ON NO. 2 GASKET
Align the plate at each bolt hole.



7. POSITION NEW NO. 1 GASKET ON PLATE
Align a new No. 1 gasket at each bolt hole.

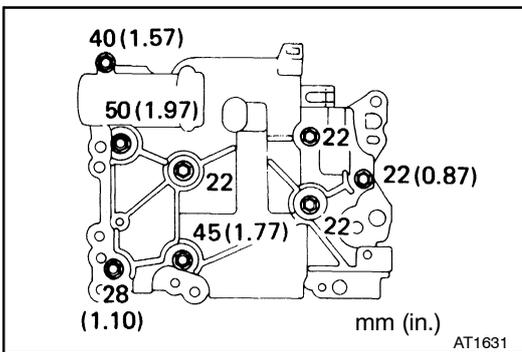


8. PLACE LOWER VALVE BODY ON TOP OF CENTER VALVE BODY



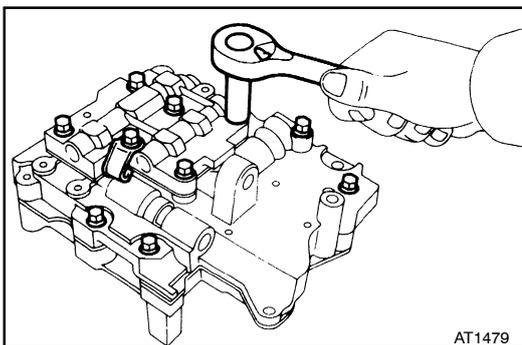
9. INSTALL AND FINGER TIGHTEN TEN BOLTS IN LOWER AND CENTER VALVE BODIES TO SECURE UPPER VALVE BODY

HINT: Each bolt length (mm, in.) is indicated in the figure.

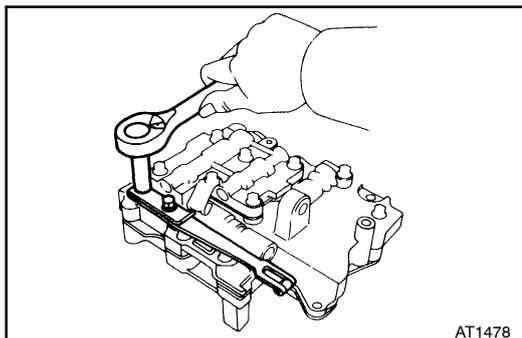


10. TURN ASSEMBLY OVER, CHECK GASKET ALIGNMENT AND FINGER TIGHTEN EIGHT BOLTS IN UPPER VALVE BODY

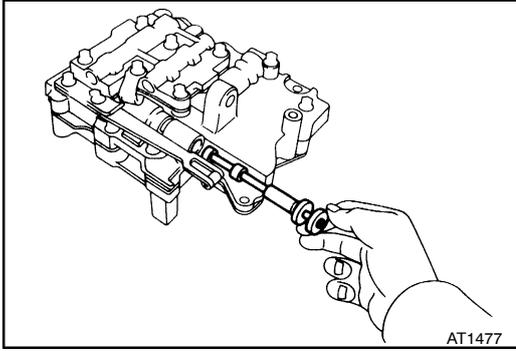
HINT: Each bolt length (mm, in.) is indicated in the figure.



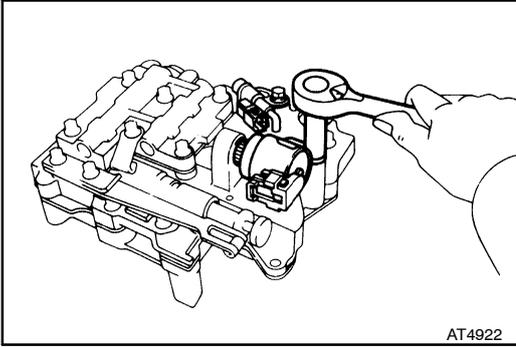
11. TIGHTEN BOLTS ON BOTH SIDES
Torque: 70 kg-cm (61 in.-lb, 6.9 N-m)



12. INSTALL DETENT SPRING
Torque: 70 kg-cm (61 in.-lb, 6.9 N-m)

**13. INSERT MANUAL VALVE**

HINT: Make sure the manual valve moves smoothly.

**14. INSTALL NO. 4 SOLENOID**

(a) Install a new O-ring to the solenoid.

(b) Install the solenoid and torque the bolt.

Torque: 100 kg-cm (7 ft-lb, 10 N-m)

15. (w/ A.D.D.)

INSTALL TRANSFER PRESSURE SWITCH

Torque: 70 kg-cm (61 in.-lb, 6.9 N-m)