

(Assembly of Valve Body)

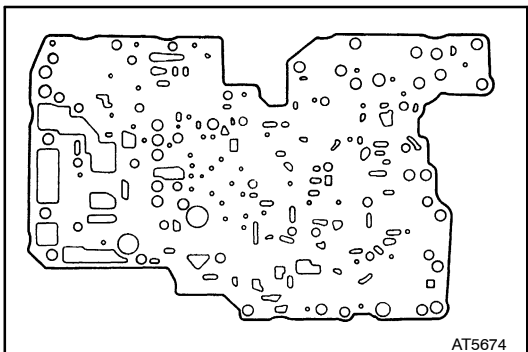
(See page AT-92)

1. **POSITION NEW NO. 1 GASKET ON UPPER VALVE BODY**

Align a new No. 1 gasket at each bolt hole.

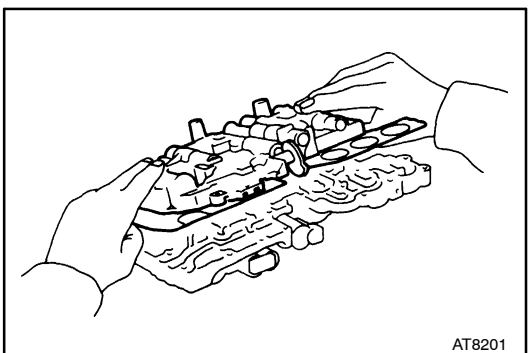
2. **POSITION VALVE BODY PLATE ON NO. 1 GASKET**

Align the plate at each bolt hole.



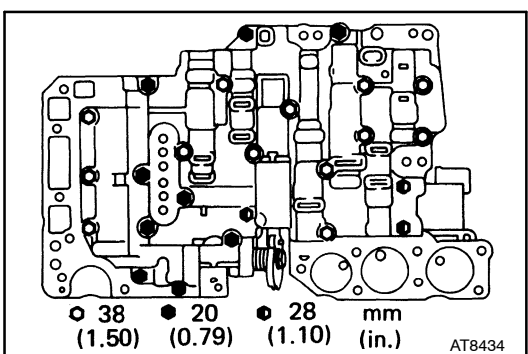
3. **POSITION NEW NO. 2 GASKET ON PLATE**

Align a new No. 2 gasket at each bolt hole.



4. **PLACE UPPER VALVE BODY WITH PLATE AND GASKETS ON TOP OF LOWER VALVE BODY**

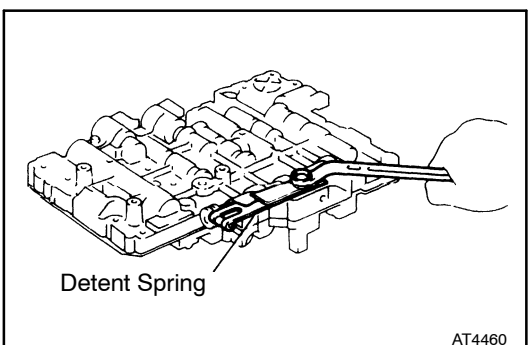
Align each bolt hole and gasket in the valve body.



5. **INSTALL THE TWENTY-FIVE BOLTS TO UPPER VALVE BODY**

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

Torque: 65 kg-cm (56 in.-lb, 6.4 N-m)



6. **INSTALL MANUAL VALVE**

7. **INSTALL DETENT SPRING**

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

8. **MAKE SURE MANUAL VALVE MOVES SMOOTHLY**