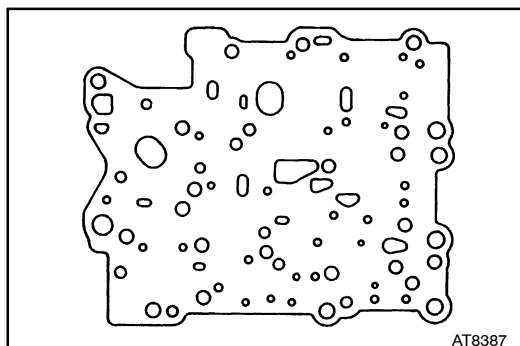


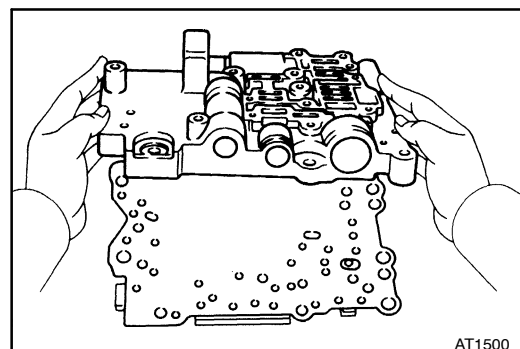
(Assembly of Transfer Valve Body)

(See page AT-209)

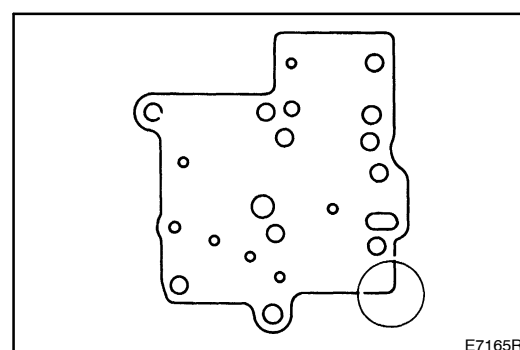
1. **POSITION NEW NO. 2 GASKET ON UPPER VALVE BODY**
Align a new No. 2 gasket at each bolt hole.
2. **POSITION VALVE BODY PLATE ON NO. 2 GASKET**
Align the plate at each bolt hole.



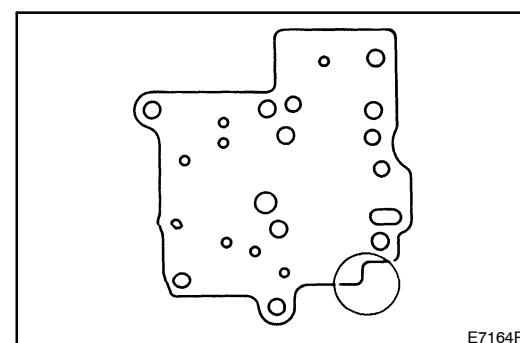
3. **POSITION NEW NO. 1 GASKET ON PLATE**
Align a new No. 1 gasket at each bolt hole.



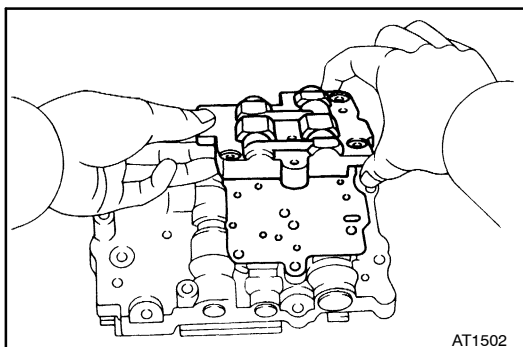
4. **PLACE CENTER VALVE BODY ON TOP OF UPPER VALVE BODY**



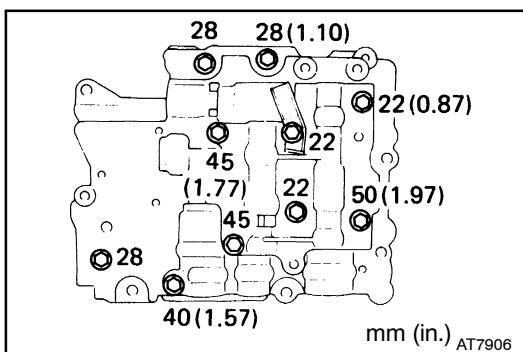
5. **POSITION NEW NO. 2 GASKET ON CENTER VALVE BODY**
Align a new No. 2 gasket at each bolt hole.
6. **POSITION VALVE BODY PLATE ON NO. 2 GASKET**
Align the plate at each bolt hole.



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

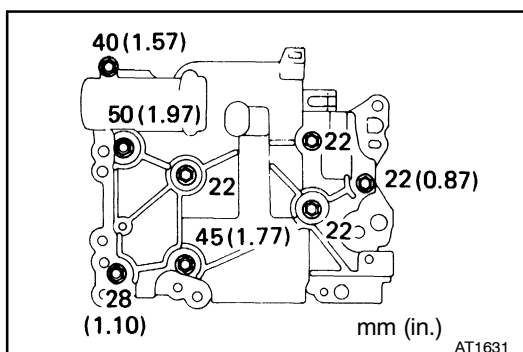


8. **PLACE LOWER VALVE BODY ON TOP OF CENTER VALVE BODY**



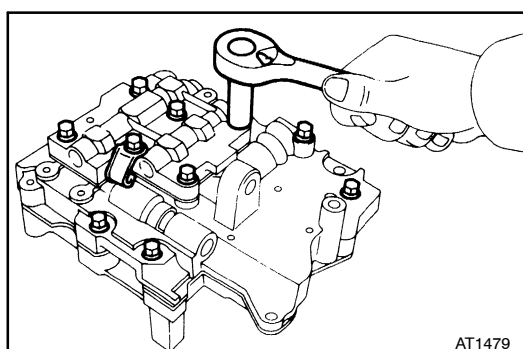
9. **INSTALL AND FINGER TIGHTEN TEN BOLTS IN LOWER AND CENTER VALVE BODIES TO SECURE UPPER VALVE BODY**

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

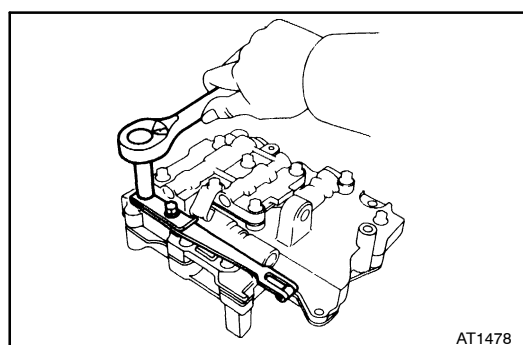


10. **TURN ASSEMBLY OVER, CHECK GASKET ALIGNMENT AND FINGER TIGHTEN EIGHT BOLTS IN UPPER VALVE BODY**

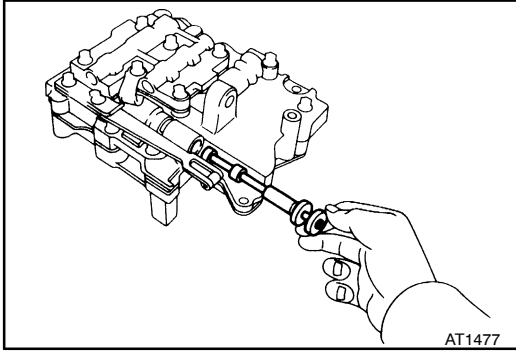
HINT: Each bolt length (mm, in.) is indicated in the figure.



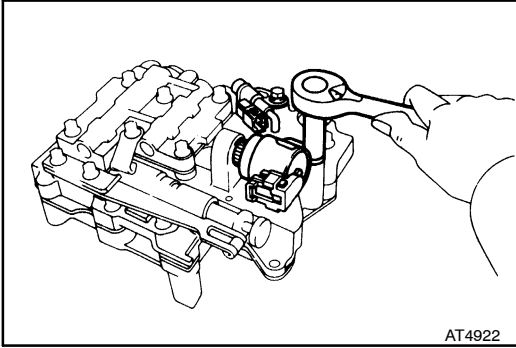
11. **TIGHTEN BOLTS ON BOTH SIDES**
Torque: 70 kg-cm (61 in.-lb, 6.9 N-m)



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)