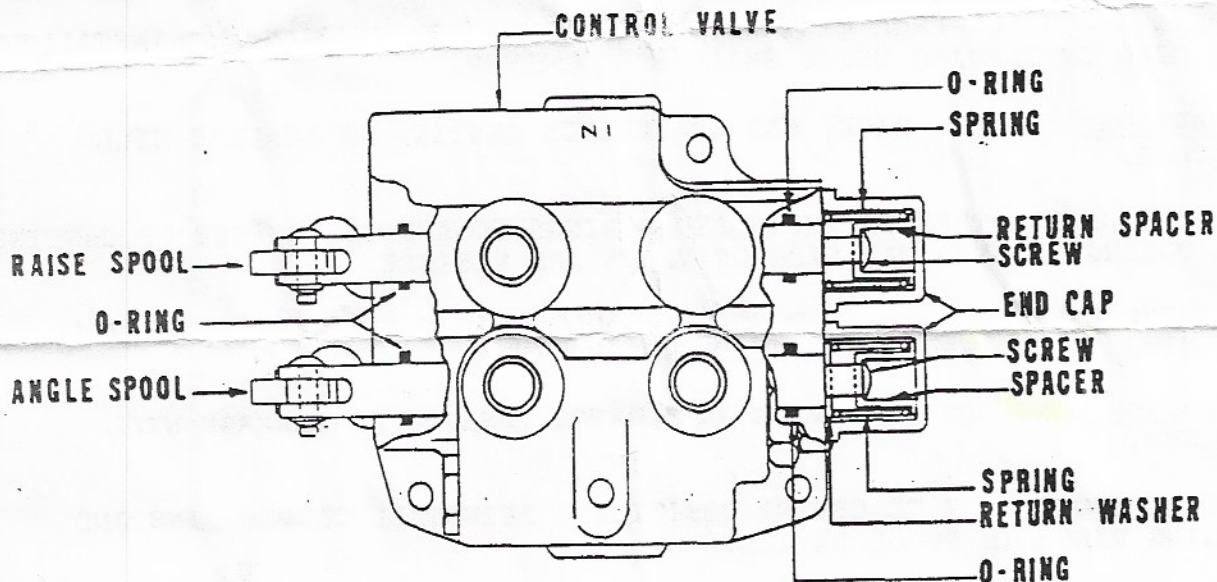


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DUKE HYDRAULICS/VICTOR FLUID  
POWER CONTROL VALVE

SPOOL SEAL  
REPLACEMENT

A3412-40



### SERVICE INSTRUCTIONS

**TOOLS REQUIRED:** MEDIUM PHILLIPS SCREWDRIVER  
SMALL SCREWDRIVER  
COTTER KEY EXTRACTOR  
BENCH VISE

**REPAIR TIME:** 30 MINUTES (APPROXIMATE)

**PARTS REQUIRED:** FOUR O-RINGS - PN 4271 (SEAL KIT - PN 4272)  
TWO GASKETS - PN 3707

**NOTE:** SPOOL SEALS/O-RINGS ARE IN CASTING FOR DUKE HYDRAULIC AND VICTOR FLUID POWER VALVES WITH SERIAL NUMBERS 31000 OR GREATER.

1. HOLDING CONTROL VALVE IN BENCH VISE, REMOVE END CAPS FROM SPOOLS USING MEDIUM PHILLIPS SCREWDRIVER.

**CAUTION:** RAISE SPOOL IS SPRING LOADED SO HOLD END CAP WHILE REMOVING SCREWS.

2. DISASSEMBLE RAISE SPOOL SPRING ASSEMBLY BY REMOVING SCREW FROM RETURN SPACER USING PHILLIPS SCREWDRIVER. PLACE SCREW, RETURN SPACER, AND SPRING IN RAISE SPOOL END CAP.

3. DISASSEMBLE ANGLE SPOOL SPRING ASSEMBLY BY REMOVING SCREW FROM SPACER. PLACE RETURN WASHER, SCREW, SPACER AND SPRING IN ANGLE SPOOL END CAP.

**CAUTION:** SPRING ASSEMBLY IS SPRING LOADED, SO CAREFULLY REMOVE SCREW FROM SPACER.

4. REMOVE RETAINING RING AND CLEVIS PINS FROM LEVERS AND SLIDE SPOOLS TOWARD END CAP SIDE OF VALVE UNTIL O-RINGS IN LEVER SIDE OF VALVE ARE VISIBLE.



5. REMOVE O-RINGS FROM CASTING USING COTTER KEY EXTRACTOR. INSTALL NEW O-RING IN CASTING USING SMALL SCREWDRIVER.

**CAUTION:** DO NOT NICK, MAR OR SCRATCH CASTING AS LEAKAGE WILL OCCUR.

6. SLIDE SPOOLS THROUGH INSTALLED O-RINGS TOWARD LEVER SIDE OF CASTING UNTIL O-RINGS IN END CAP SIDE OF VALVE ARE VISIBLE.

7. REMOVE O-RINGS FROM CASTING USING COTTER KEY EXTRACTOR. INSTALL NEW O-RING IN CASTING USING SMALL SCREWDRIVER.

**CAUTION:** DO NOT MAR, NICK OR SCRATCH CASTING AS LEAKAGE WILL OCCUR.

8. SLIDE SPOOL BACK TO CENTER POSITION. REINSTALL CLEVIS PINS AND RETAINING RINGS IN SPOOL LEVERS.

9. REASSEMBLE RAISE SPOOL SPRING ASSEMBLY - SPRING, RETURN SPACER, AND SCREW - USING PHILLIPS SCREWDRIVER.

10. REASSEMBLE ANGLE SPOOL SPRING ASSEMBLY - RETURN WASHER, SPRING, SPACER, AND SCREW - USING PHILLIPS SCREWDRIVER.

11. REINSTALL END CAPS WITH NEW GASKETS USING PHILLIPS SCREWDRIVER.