

**62TE
Remanufactured
Valve Body**

(Without Solenoid Pack)

Part No.

CHR412

Solenoid Pack Installation

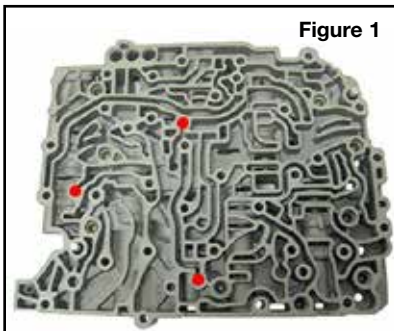


Figure 1

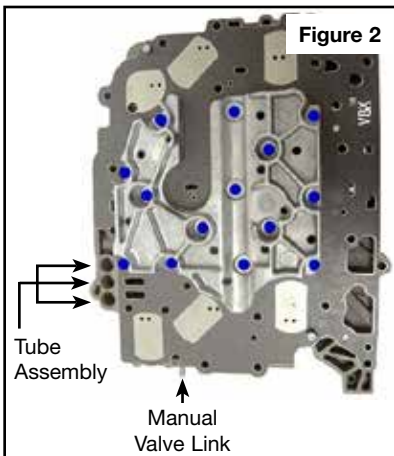


Figure 2

1. Before Installing onto Case

- a. Remove and save the two bolts with nylon nuts. Remove U-shaped plate and rear separator plate.
- b. Install plastic screen/gasket onto solenoid pack and install assembly onto the aluminum plate, aligning the dowels.

NOTE: The plastic screen/gasket will be damaged if cleaned with solvents or other harsh chemicals. Clean it with dish liquid and water.

- c. Place valve body on bench with the solenoid pack electric connector facing down.
- d. Install checkballs in locations indicated in by the circles (**Figure 1**).
- e. Install separator plate, separator plate gasket and U-shaped housing onto valve body (**Figure 2**). Use a little assembly lube on the separator plate to hold the separator plate gasket in place so it does not move and get damaged.
- f. Install fourteen valve body bolts as indicated by the circles (**Figure 2**). Torque bolts to 50 in/lbs starting in the center and working around the outside in circular pattern.
- g. Make sure accumulator springs and pistons are installed correctly and the 2-4 oil feed tube is installed and seated onto case.

2. Case Installation

- a. Install the valve body onto case aligning manual valve and the three tubes in the tube assembly with the valve body (**Figure 2**). The dowels should drop into the holes on the case.
- b. Install valve body to case bolts. Torque bolts to 50 in-lbs.

NOTE: Install flat detent spring with roller and make sure all internal wiring is routed correctly to avoid pinched wires.