



Process:

# Dump Cylinder Valve Assembly Installation

## WORK INSTRUCTION

ME-PFC-003-F-001 Visual Work Instruction Template Rev 10  
12/3/2018

Department:	ALL	Doc. No.:	WI-A9-001	Author:	Zachery Mullally
Area:	ALL	Revision #:	Initial Release	Approved (Eng):	
Section:	ALL	Revision Date:	Draft	Approved (Qty):	Keith Borchers
Reference Doc:	Blank	Page:	1 of 12	Approved (OPS):	
	Blank			Approved (PM):	

### Quality Policy

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### PPE



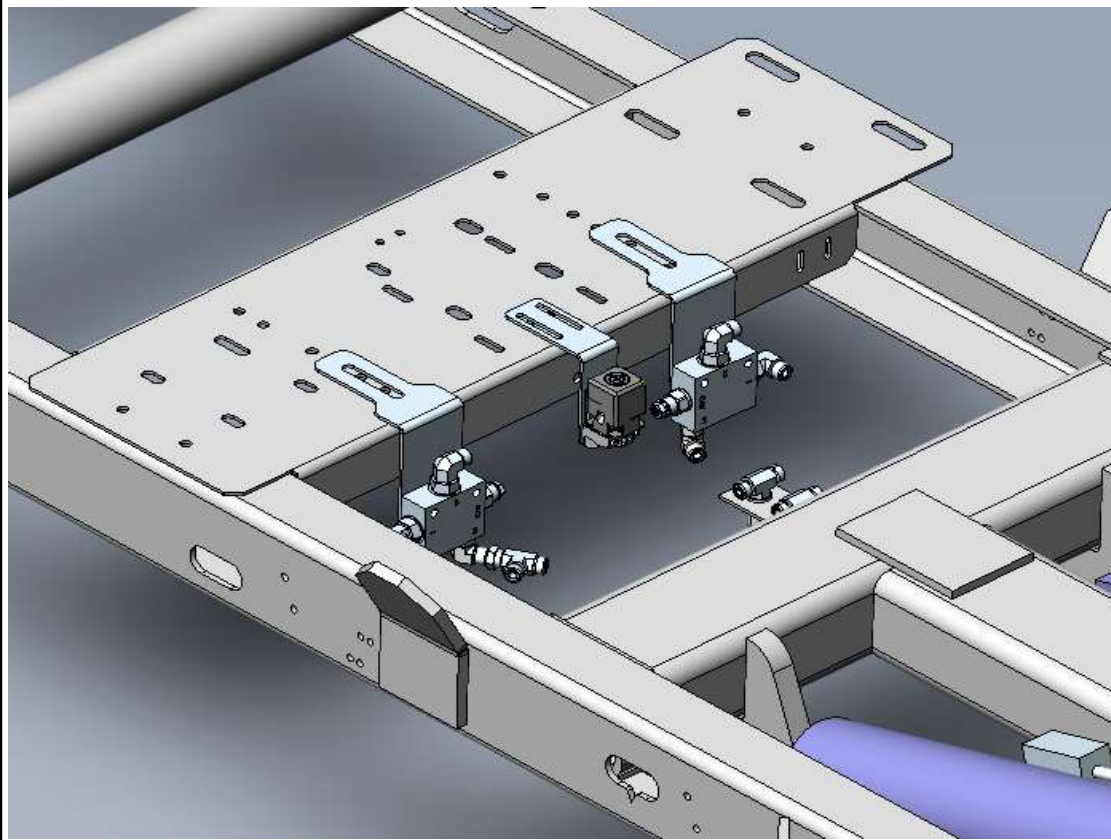
### Caution



### Equipment / Materials

Tools: 5/8" Socket/Wrench, 1/2" Socket/Wrench

### Illustration



### Instruction Details

Read the work order and this work instruction before beginning operation. If you have any questions, ask for direction from your Lead.







Source all parts and materials listed on the Work Order and Drawing **206D12** before the beginning this build.


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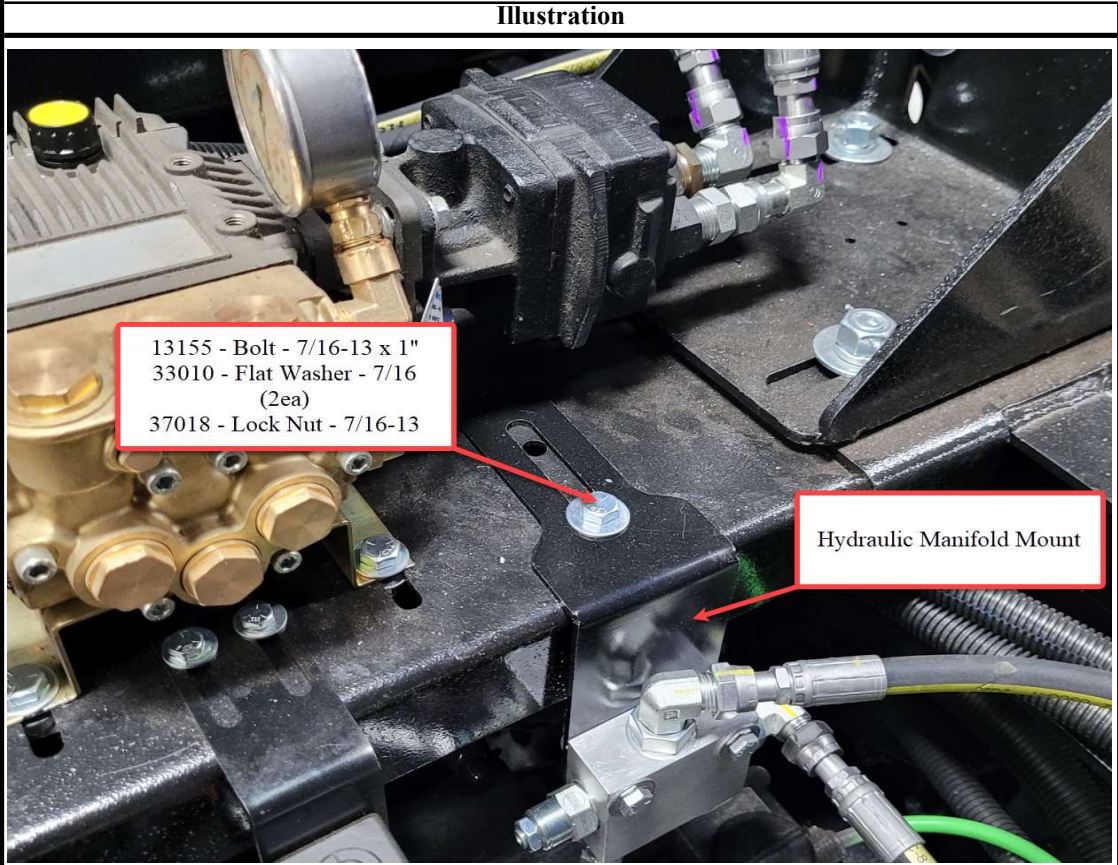
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<b>PPE</b>					<b>Caution</b>				
<b>Equipment / Materials</b>	Tools:								
<b>Illustration</b>				<b>Instruction Details</b>					
<p style="text-align: center;"><b><u>Hardware Required:</u></b></p> <p style="text-align: center;"><b>Bolts:</b></p> <p style="text-align: center;"><b>13155</b> – Bolt – 7/16"-13 x 1" (2ea)  <b>11061</b> – Bolt – 5/16"-18 x 2" (4ea)</p> <p style="text-align: center;"><b>Washers:</b></p> <p style="text-align: center;"><b>33010</b> – Flat Washer – 7/16" (4ea)  <b>115451557</b> – Flat Washer – 5/16" (8ea)</p> <p style="text-align: center;"><b>Nuts:</b></p> <p style="text-align: center;"><b>37018</b> – Lock Nut – 7/16"-13 (2ea)  <b>37021</b> – Lock Nut – 5/16"-18 (4ea)</p>									
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<b>PPE</b>					<b>Caution</b>				
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**Equipment / Materials** Tools: 5/8" Socket/Wrench




**Instruction Details**

Install **(5225566)** Manifold Mount onto Sub Frame, Secure Using:






**13155** - Bolt - 7/16"-13 x 1"  
**33010** - Flat Washer - 7/16" (2ea)  
**37018** - Lock Nut - 7/16"-13

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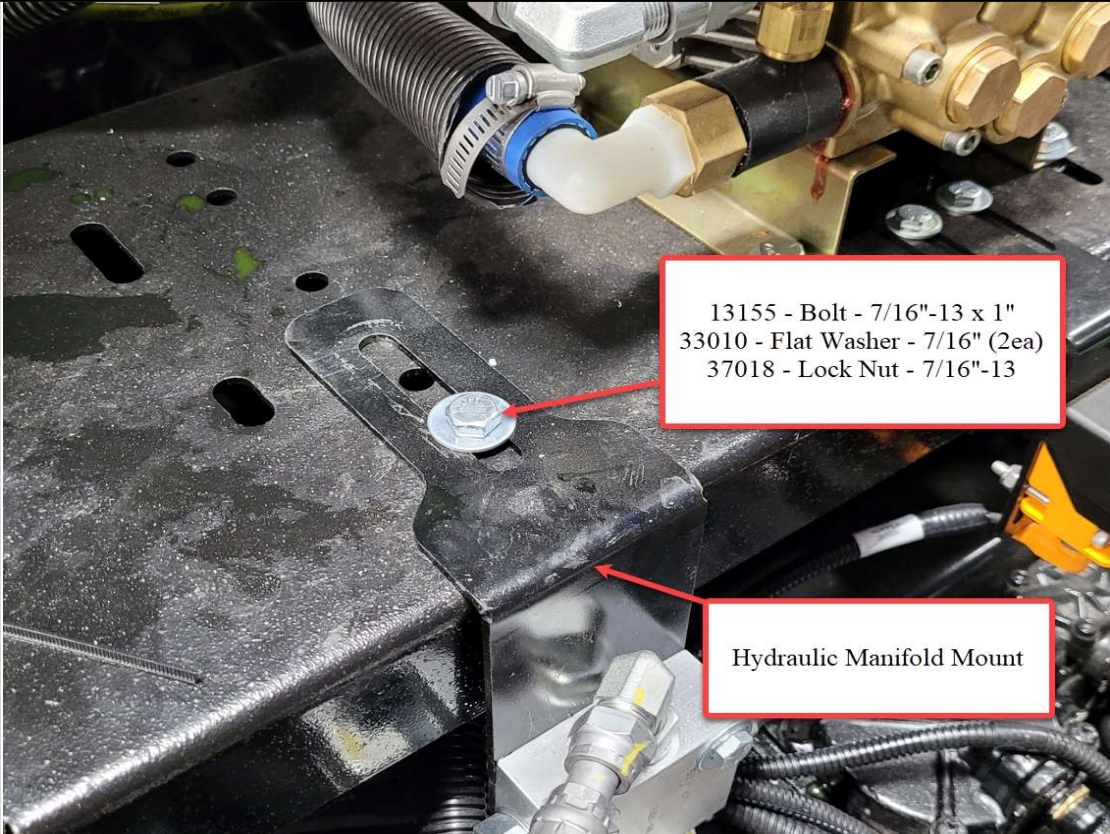
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**Equipment / Materials** Tools: 5/8" Socket/Wrench

Illustration	Instruction Details
 <div data-bbox="756 917 1155 1084" style="border: 1px solid red; padding: 5px; width: fit-content;"> <p>13155 - Bolt - 7/16"-13 x 1" 33010 - Flat Washer - 7/16" (2ea) 37018 - Lock Nut - 7/16"-13</p> </div> <div data-bbox="798 1258 1144 1372" style="border: 1px solid red; padding: 5px; width: fit-content;"> <p>Hydraulic Manifold Mount</p> </div>	<p>Install <b>(5225566)</b> Manifold Mount to Sub Frame, Secure Using:</p> <p><b>13155</b> - Bolt - 7/16"-13 x 1" <b>33010</b> - Flat Washer - 7/16" (2ea) <b>37018</b> - Lock Nut - 7/16"-13</p>

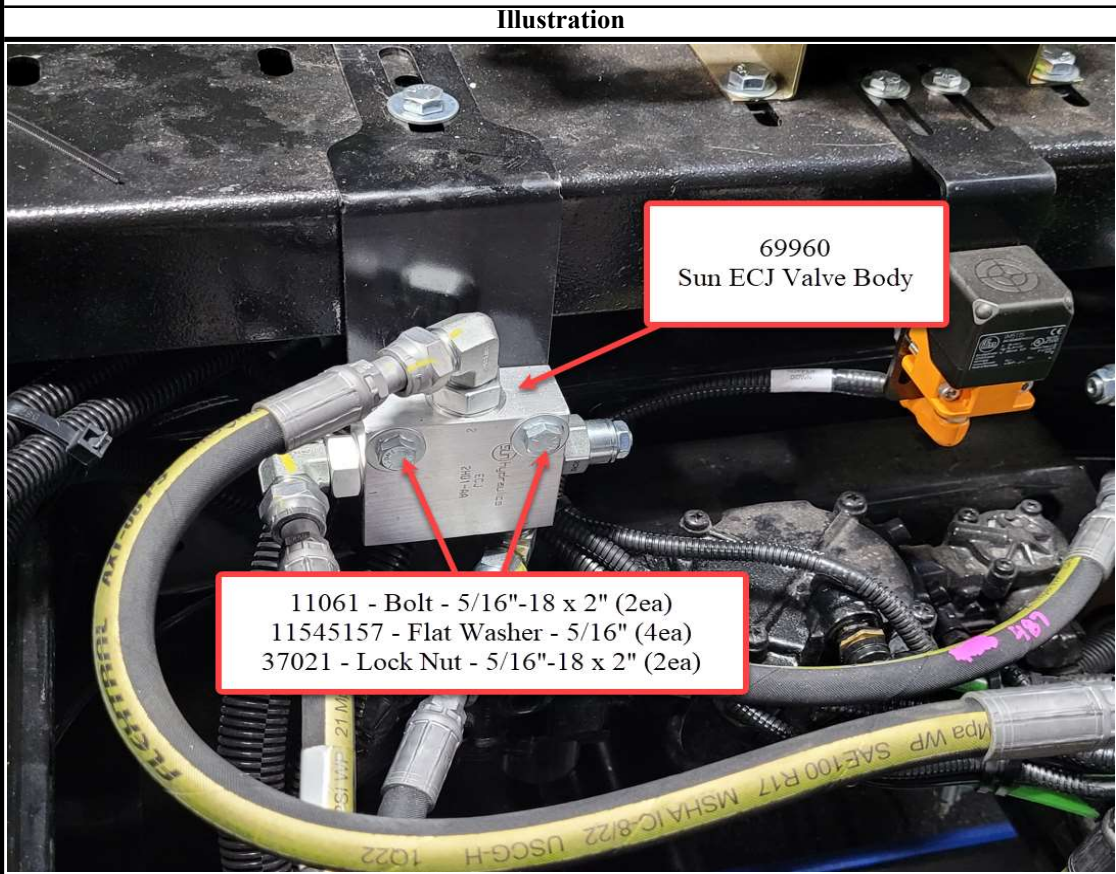
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<b>PPE</b>					<b>Caution</b>				
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**Equipment / Materials** Tools: 1/2" Socket/Wrench




**Instruction Details**

Install (69660) Sun ECJ Valve Body onto (5225566) Dump Cylinder Mount Bracket, Secure Using:






**11061** - Bolt - 5/16"-18 x 2" (2ea)  
**11545157** - Flat Washer - 5/16" (4ea)  
**37021** - Lock Nut - 5/16"-18 x 2" (2ea)

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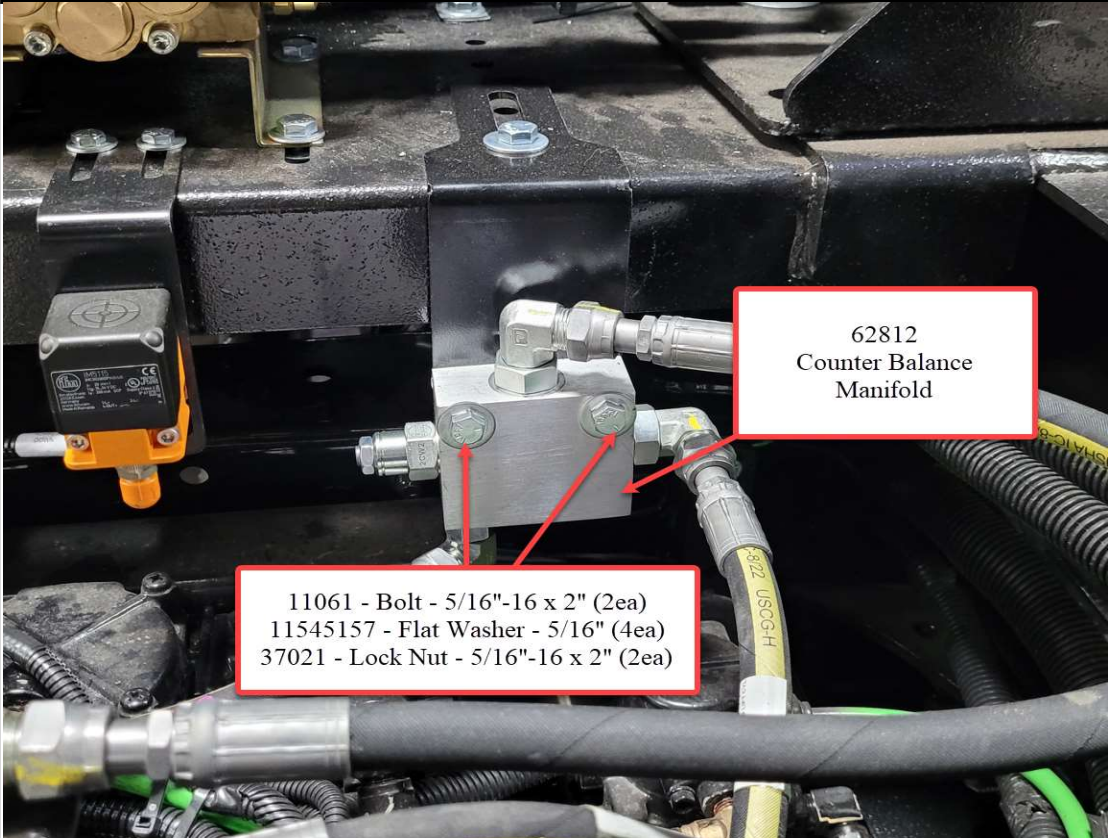
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**Equipment / Materials** Tools: 1/2" Socket/Wrench






Illustration	Instruction Details
	<p>Install <b>(69660)</b> Sun ECJ Valve Body onto <b>(5225566)</b> Dump Cylinder Mount Bracket, Secure Using:</p> <ul style="list-style-type: none"> <li><b>11061</b> - Bolt - 5/16"-18 x 2" (2ea)</li> <li><b>11545157</b> - Flat Washer - 5/16" (4ea)</li> <li><b>37021</b> - Lock Nut - 5/16"-18 x 2" (2ea)</li> </ul>

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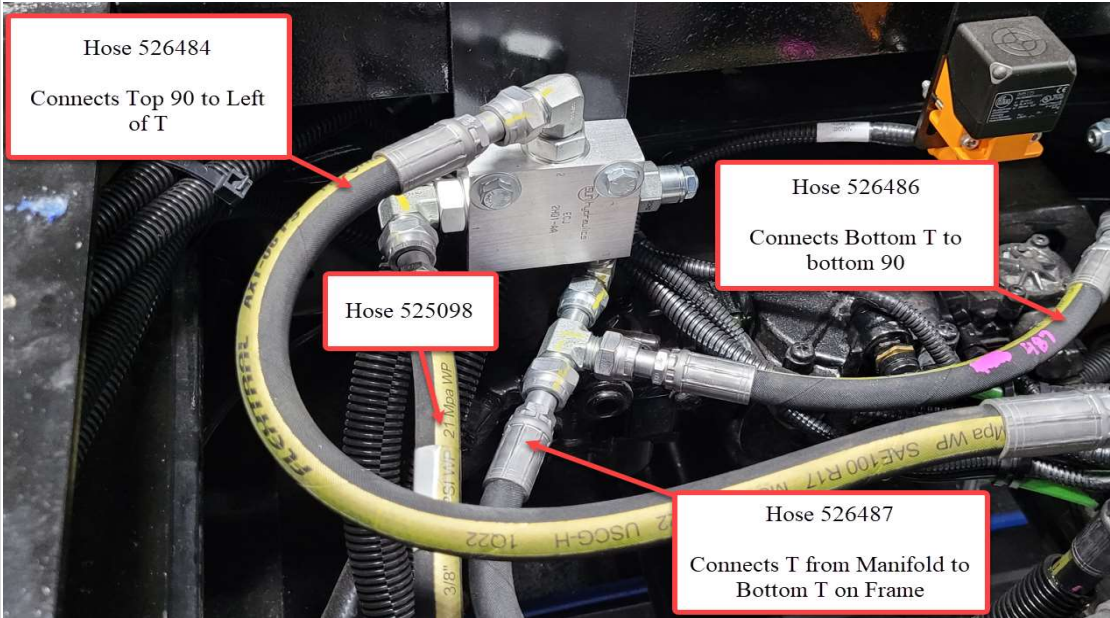
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**Equipment / Materials** Tools:

Illustration	Instruction Details
 <p>Hose 526484 Connects Top 90 to Left of T</p> <p>Hose 525098</p> <p>Hose 526486 Connects Bottom T to bottom 90</p> <p>Hose 526487 Connects T from Manifold to Bottom T on Frame</p>	<p>Connect Hose (526484) from Top 90° Fitting to Left Fitting on Front T.</p> <p>Connect Hose (525098) to Left 90° Fitting.</p> <p>Connect Hose (526487) from T on Bottom 90° to Bottom T on Rear Fitting</p> <p>Connect Hose (526486) from T on Bottom 90° to 90° on Right Manifold</p> <p><b>WARNING:</b> All Hoses are to be CAPPED until COMPLETE INSTALLATION. Failure to comply may result in FOD Contamination and Damage to Hydraulic System.</p>

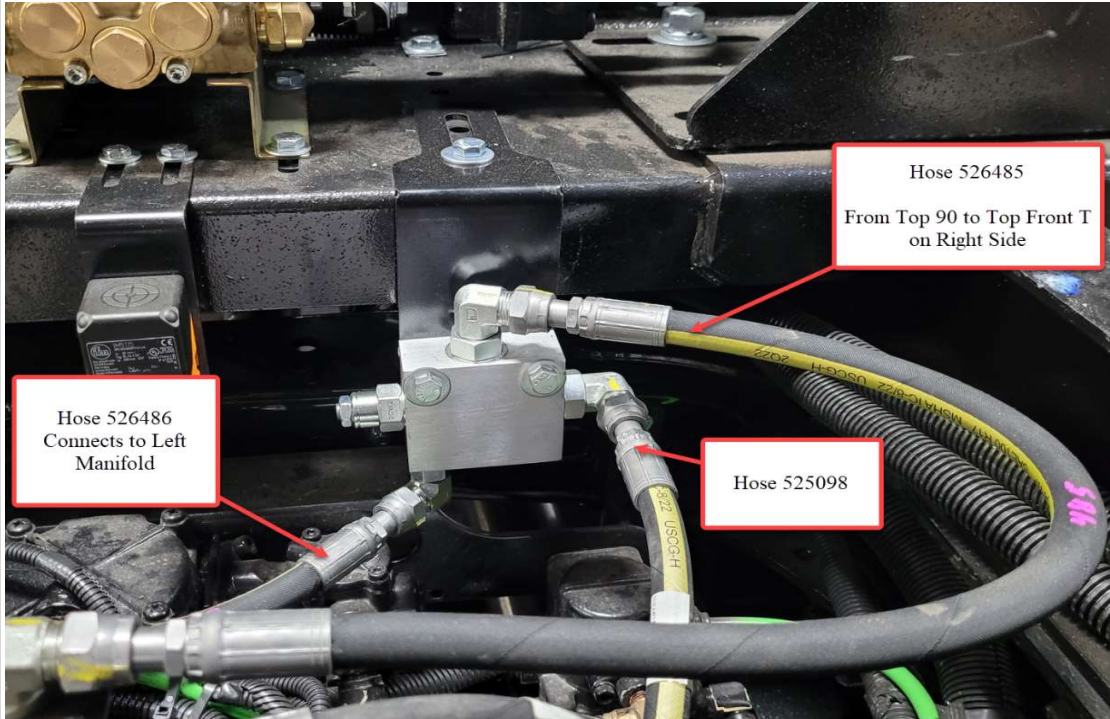
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<b>PPE</b>					<b>Caution</b>				
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**Equipment / Materials** Tools:






Illustration	Instruction Details
 <p>Hose 526485 From Top 90 to Top Front T on Right Side</p> <p>Hose 526486 Connects to Left Manifold</p> <p>Hose 525098</p>	<p>Connect Hose <b>(526485)</b> from Top 90° Fitting to Right Fitting on Front T.</p> <p>Connect Hose <b>(525098)</b> to Right 90° Fitting.</p> <p>Connect Hose <b>(526486)</b> from T on Bottom 90° to Bottom T on Rear Fitting</p> <p><b>WARNING:</b> All Hoses are to be <b>CAPPED</b> until <b>COMPLETE INSTALLATION</b>. Failure to comply may result in FOD Contamination and Damage to Hydraulic System.</p>

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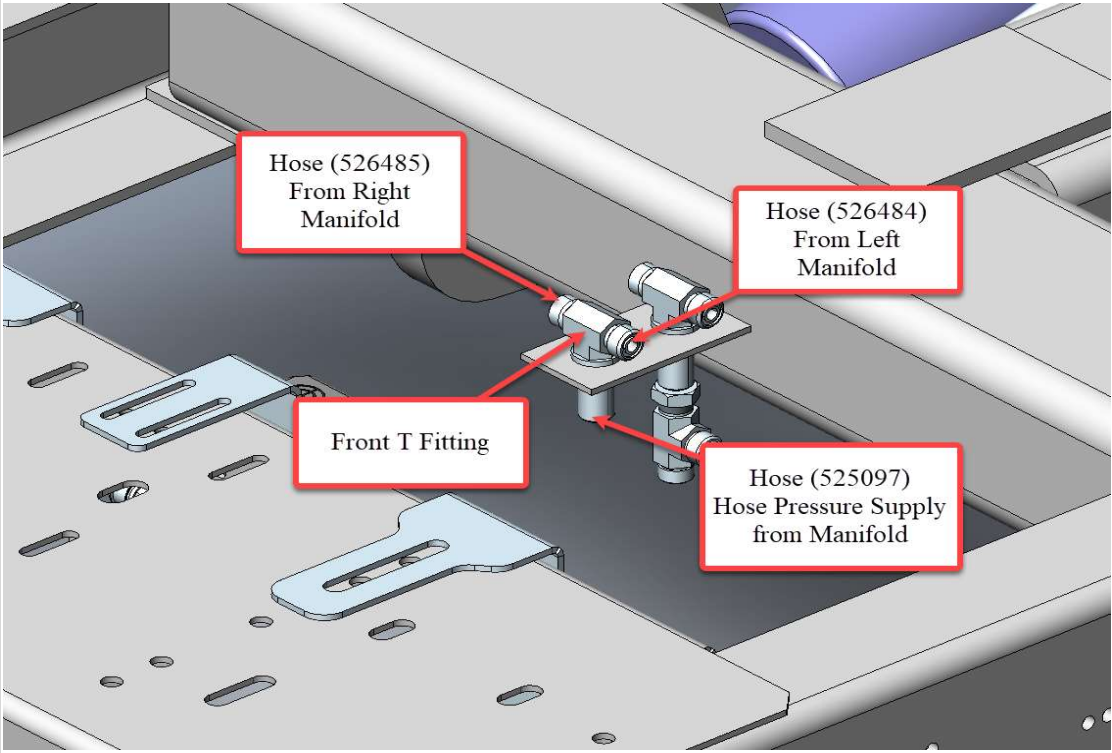


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**Equipment / Materials** Tools:

Illustration	Instruction Details
	<p>Connect Hose <b>(526485)</b> From Right Manifold Top 90° fitting to Front T.</p> <p>Connect Hose <b>(526484)</b> From Left Manifold Top 90° fitting to Front T.</p> <p>Connect Hose <b>(525097)</b> Hose Pressure Supply from Main Manifold to Bottom of Front T.</p>

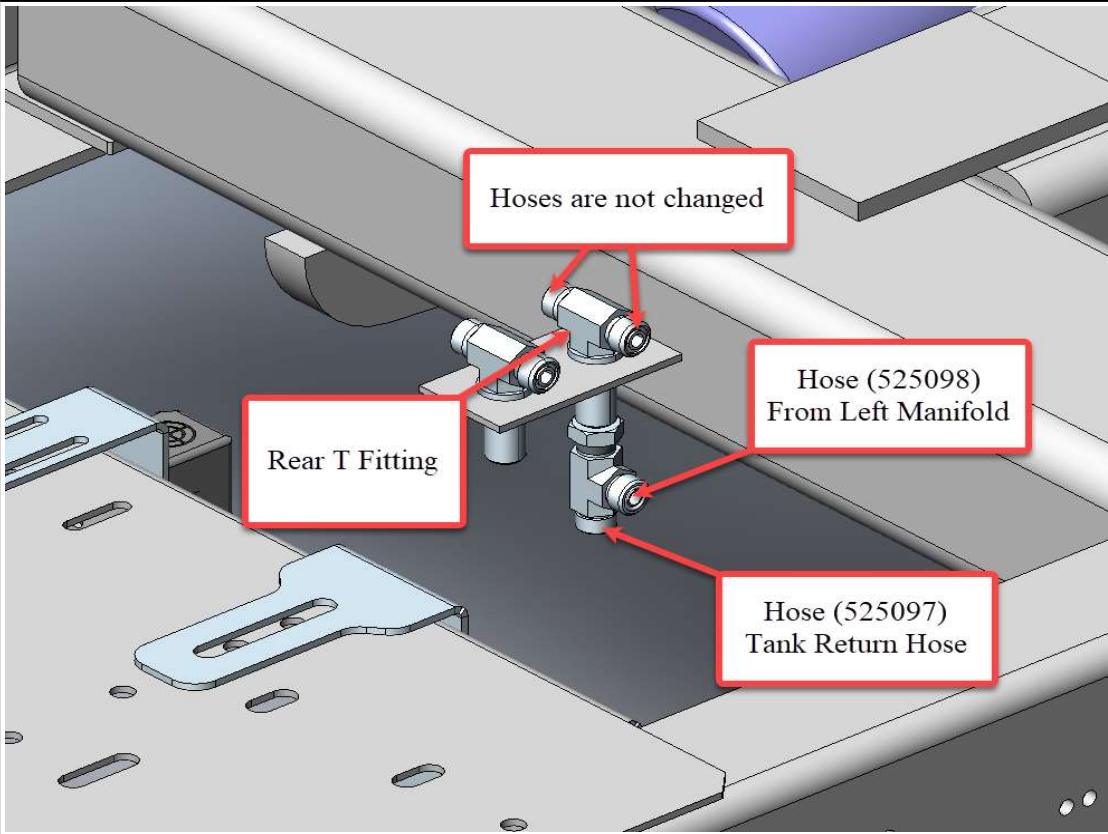
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**Equipment / Materials** Tools:

Illustration	Instruction Details
	<p>Hoses for Top of T are not changed.</p> <p>Connect Hose <b>(525098)</b> from Left Manifold to Side of Bottom T on Rear T Fitting.</p> <p>Connect Hose <b>(525097)</b> from Return Tank to Bottom of Bottom T on Rear T Fitting.</p>

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<b>Equipment / Materials</b>	Tools:								
<b>Illustration</b>				<b>Instruction Details</b>					
<p>Foreign Object Debris (FOD) includes any object found in an inappropriate location that, as a result of being in that location, can damage equipment or injure personnel. FOD includes a wide range of material, including loose hardware, discarded zip-ties, cut cotterpins, rocks, sand, shop aids, tools, oil and hydraulic spills.</p> <p>Ensure maintenance bay is swept, and all tools are accounted for at the end of every task.</p>									
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