



### Tools/Equipment Required:

- 3mm Allen wrench
- torque wrench capable of setting 3.8 N-m (2.8 ft-lb)

**Procedure to Exchange a Displacement Override (DOR) Block:**

1. Remove the four *S.H.C.S.* from the existing DOR block with the 3mm Allen wrench. Keep the *S.H.C.S.* with the DOR being removed - Do NOT reused them with the new DOR block.
2. Remove the existing DOR block from the motor control. Make sure that the *O-Ring* is removed with the DOR block.

**Note:**

For the *High-Pressure Hydraulic DOR* configuration, there is a *Spool* in the DOR housing. This *Spool* should be kept with this DOR block.

For the *Pneumatic DOR* configuration, there will be a *Spool* and a *Spring* in the DOR housing. This *Spool* and *Spring* should be kept with this DOR block.

3. Prior to installing the new DOR block, check the following:
  - a. Make sure that the *O-Ring* is in good condition (i.e. not damaged) and is resting properly in the o-ring groove.
  - b. If the new DOR block is the *High-Pressure Hydraulic DOR* configuration, make sure that the *Spool* is there.
  - c. If the new DOR block is the *Pneumatic DOR* configuration, make sure that the *Spool* and *Spring* are there.
4. Install the new DOR block and fasten it with the four new *S.H.C.S.* Tighten the *S.H.C.S.* with the 3mm Allen wrench and torque each one to:
  - 3.8 N-m (2.8 ft-lb)...[For the *Low-Pressure Hydraulic, High-Pressure Hydraulic, and Pneumatic DOR*]
  - 2.7 N-m (2.0 ft-lb)...[For the *Electric DOR*]



**\*\*\*\*\*ATTENTION\*\*\*\*\***

You have been provided information on conversion, repair and/or service of Linde components. Proper application of the information requires specific training and may require use of specialized tooling and equipment. If you choose to proceed with the conversion, repair and/or service of the Linde component(s) absent the necessary training and/or these specialized tools, you do so at your risk.

Linde Hydraulics Corporation will accept no claim for warranty or other consideration resulting from deficiencies in the conversion, repair and/or service done in accordance with the guidance offered herein when the necessary training has not been conducted and/or required specialized tooling and equipment has not been utilized.

All requests for training must be coordinated through your Linde Account Manager. He can also provide you price and availability of any specialized tooling.

Questions regarding the information provided or this disclaimer should be addressed to the Warranty & Service Department, Linde Hydraulics Corporation.

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