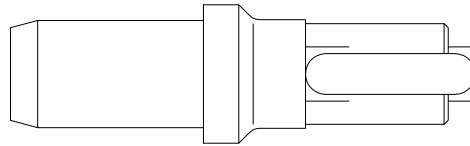


Tools/Equipment Required:

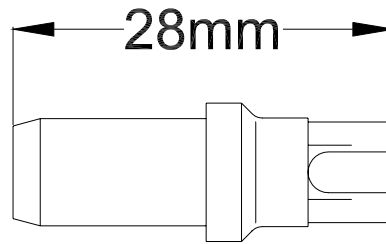
- 12mm Allen wrench
- torque wrench capable of setting 122 N-m (90 ft-lb)
- needle-nose pliers

Conversion Procedure:

1. Remove the *M22 Plug* with the 12mm Allen wrench.
2. Remove the *Spring* with the needle-nose pliers.
3. Remove the *Washer* and *Shuttle Spool* simultaneously with the needle-nose pliers.
4. Remove the *Washer* from the *Shuttle Spool*.



Standard Shuttle Spool



**Modified Shuttle Spool
(LHC P/N 8883031020)**

5. Replace the *Standard Shuttle Spool* with the *Modified Shuttle Spool* (illustrated above).

Note:

You can purchase the *Modified Shuttle Spool* from Linde by ordering part number 8883031020. Alternately, you can grind down the *Standard Shuttle Spool* to 28mm as illustrated above. If choosing the grinding method, be warned that this will permanently disable the case flushing feature until a new *Standard Shuttle Spool* is used.

6. Reinstall the *Washer* onto the *Modified Shuttle Spool*.
7. Reinstall the *Washer/Modified Shuttle Spool* assembly back into the *Shuttle Body*.
8. Reinstall the *Spring*.
9. Reinstall the *M22 Plug*. Torque the *M22 Plug* to 122 N-m (90 ft-lb).



*******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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