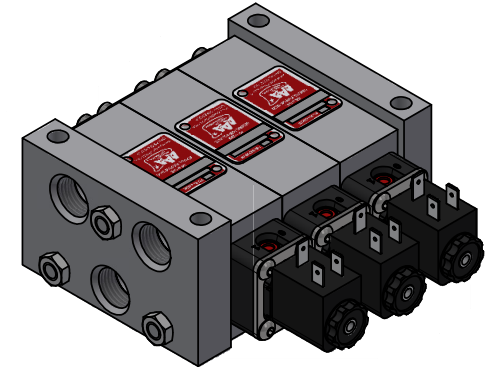
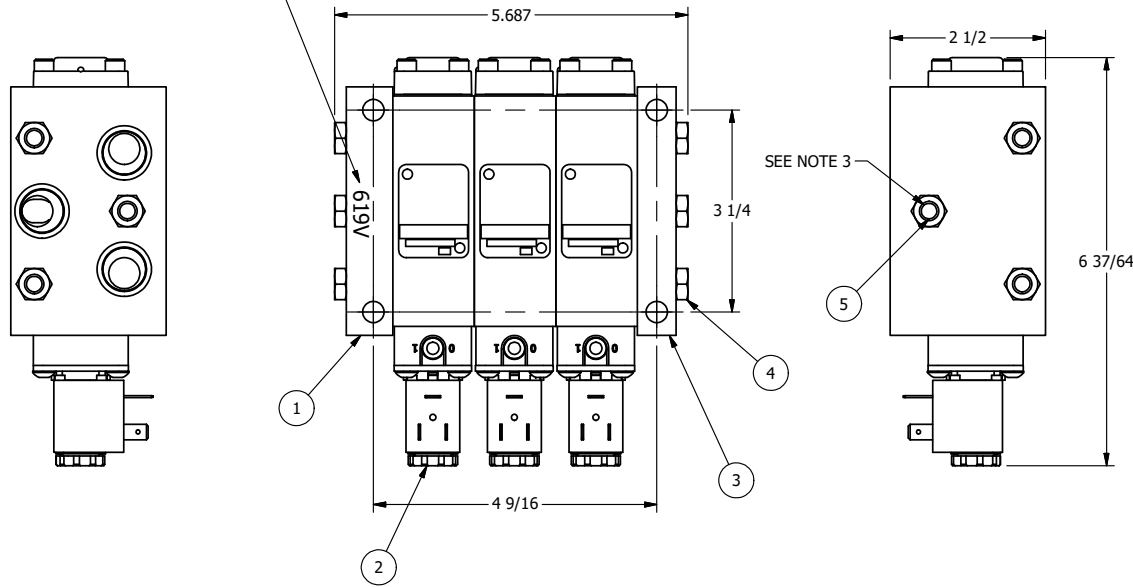


4 3 2 1

MARK PORTED PLATE WITH STACK NUMBER USING 1/4" LETTERS



NOTES:

- 1) CUT TIE RODS TO 5.69. MINIMUM CHAMFER ON ENDS.
- 2) PRE-ASSEMBLE USING CLAMPS, THEN USE TIE RODS.
- 3) USE LOCTITE ON NUTS, ONE END ONLY.
- 4) TIE RODS MUST BE FLUSH WITH NUTS. USE CLAMP TO HOLD STACK TOGETHER DURING ASSEMBLY.

THE FOLLOWING PARTS ARE INCLUDED WITH INDIVIDUAL VALVES, SECTIONS OR PLATES AND ARE USED TO ASSEMBLE.

QTY	PART NO	DESCRIPTION
12	V-110	O-RING, BUNA-N, 70 DURO, AS-114, (REF 5/8 X 13/16 X 3/32), 1/4" SLEEVE, 1/2" SUB, STACK

5	1	V-635	ALL THREAD, STAINLESS, 5/16"-24, FOR TIE RODS, 'B' SERIES
4	6	V-636	NUT, 5/16-24, HEX, JAM, 316 STAINLESS
3	1	BEP-4	PLATE, BLIND END, 1/4" & 3/8" STACK VALVE
2	3	618VG	1/4" STACK, SNGL SOL, 2-POS, SPRING RTRN, 24 VDC, BUNA O-RINGS, EXT PILOT, G SPOOL, SS HDWR,
1	1	PEP-4T	PORTED END PLATE, .75 THICK, SHALLOW PORTS, 1/4" & 3/8" STACKING VALVE
FLG	QTY	PART NO	DESCRIPTION

LIMITS ON DIMENSIONS
UNLESS
OTHERWISE SPECIFIED

2-PL DECIMAL ± .01
3-PL DECIMAL ± .005
FRACTIONAL ± 1/64
ANGULAR ± 1/2°



DRAWN: RMckenna	DATE: 10/8/2009	CHECKED: KWaite	DATE: 10/16/2013
SCALE: 1 / 2	SHEET: 1 OF 1	RELEASED: HWomack	DATE: 10/16/2013

TITLE: ASSEMBLY, B-STACK VALVES, 3 618VG 24VDC, PEP-4T, BEP-4, STAINLESS HARDWARE	PART NO.: 619V	REV.: A
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A	NO.	DATE	REVISION
	12/15/09		REPLACED 618V WITH 618VG.

4 3 2 1

THE INFORMATION CONTAINED WITHIN THIS DOCUMENT IS PROPRIETARY TO AAA PRODUCTS AND MAY NOT BE DISCLOSED WITHOUT PRIOR WRITTEN CONSENT

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