

## Service Kit Instructions

# Series 45 Servo and Gain Control Orifices

## Orifice replacement procedure



Series 45 Electric Proportional Control kits for frames E, F, J, and K2 come from the factory with a 1.2mm gain orifice and 0.8mm servo control orifice installed in the control assembly. A 1.0mm servo control orifice is included in this kit in the event it is required. Also, included in this kit is a 1.0mm and 0.8mm gain control orifice in the event it is required.

If the control orifices require replacement, please refer to the instructions below.

### Servo control orifice replacement

1. Remove servo control orifice.
2. Install required servo control orifice, and torque to 2-3.4 N•m [18-30 lbf•in].

### Gain control orifice replacement

1. Remove solenoid coil nut.
2. Slide solenoid coil off.
3. Remove control solenoid actuator.
2. Remove plug.
3. Remove gain control orifice.
4. Install required gain control orifice, and torque to 2-3.4 N•m [18-30 lbf•in].

