

	*Blocks 351 981 R1, 354 383 R1 thru R4	*Block 360 719 R1
Regulator valve check valve spring		
Free length - inches	—	1-15/32
Test length - inches	—	1-1/8
Test load - pounds	—	6.22 ± 5%
Regulator valve ball rider spring		
Free length - inches	1-7/16	—
Test length - inches	1-1/32	—
Test load - pounds	16.7 ± 5%	—
Safety valve piston diameter - inch2495 to .2500	.3120 to .3125
Orifice plug opening - inch024	.024
Connecting rod bushing (after installation) - inch6868 to .6878	.6868 to .6878

*The cylinder block number is cast on the side of the block.

GENERAL Cleaning

Strict cleanliness is necessary when servicing the hydraulic Touch-Control system. Use only clean solvent. Keep the bench clean. Keep all tools clean.

Before proceeding with removal of any parts from the hydraulic cylinder block or pump unit, remove all oil and dirt from the outside surfaces. Then use fresh solvent to clean the dismantled parts.

Clean the passages in the block with a round bristle brush, petroleum solvent, and air pressure. Be very careful when handling the hydraulic system parts. Careless handling will damage the finished surfaces, producing nicks and abrasions which will affect the sealing

ability and the life of the seal rings and gaskets.

After parts are cleaned, dry them with air pressure. Do not use old rags or cotton waste to clean internal surfaces or internal parts of the system. Small particles of lint from such material may adhere to the metal and prevent the various valves from seating.

When installing O-rings, use a good grade of light cup grease as a lubricant. Light cup grease is helpful, too, in retaining valves and springs during assembly. Cup grease also provides needed initial lubrication — before the IH Hy-Tran fluid is circulating normally.