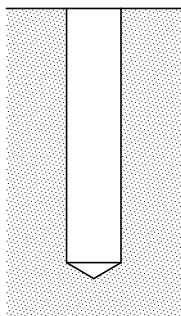


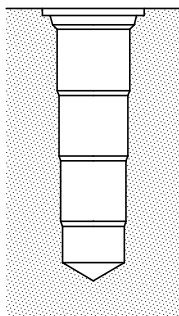
## USE OF FORMING TOOLS :

Here are showed the four working phases in order to obtain an unified cavity. We recommend to respect concentricity marked in schedules n. 17.000 – 17.001 – 17.002.

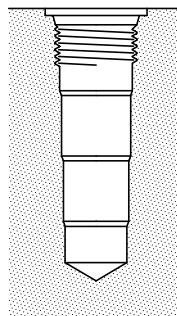
In the under mentioned code-table are marked the cavities code and pre-drilled diameters.



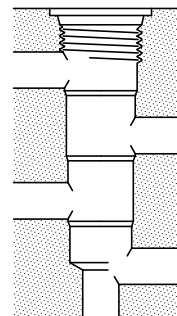
Pre-drilled hole



Forming tool



Tapping



Radial holes

| Cavity type | Cavity code | Pre-drilled hole | Forming tool code | Tap type   |
|-------------|-------------|------------------|-------------------|------------|
| 20 2 way    | S 20/2      | ∅ max. 14        | 89 328 101        | M 18x1.5   |
| 20 3 way    | S 20/3      | ∅ max. 13        | 89 328 102        |            |
| 20 4 way    | S 20/4      | ∅ max. 12        | 89 328 103        |            |
| 29 2 way    | S 29/2      | ∅ max. 14        | 89 328 140        | 3/4-16 UNF |
| 28 2 way    | S 28/2      | ∅ max. 11        | 89 328 113        |            |
| 28 3 way    | S 28/3      | ∅ max. 13        | 89 328 141        |            |
| 28 4 way    | S 28/4      | ∅ max. 11        | 89 328 142        |            |
| 30 2 way    | S 30/2      | ∅ max. 18        | 89 328 104        | M 22x1.5   |
| 30 3 way    | S 30/3      | ∅ max. 17        | 89 328 105        |            |
| 30 4 way    | S 30/4      | ∅ max. 16        | 89 328 106        |            |
| 50 2 way    | S 50/2      | ∅ max. 27        | 89 328 107        | M 33x2     |
| 50 3 way    | S 50/3      | ∅ max. 26        | 89 328 108        |            |
| 50 4 way    | S 50/4      | ∅ max. 25        | 89 328 109        |            |
| 70 2 way    | S 70/2      | ∅ max. 37        | 89 328 110        | M 42x2     |
| 70 3 way    | S 70/3      | ∅ max. 35        | 89 328 111        |            |
| 70 4 way    | S 70/4      | ∅ max. 33        | 89 328 112        |            |

## SEALS :

On all standard valves are used special polyurethane seals which do not require back-up rings and grant an effective seal till static pressure of 600 bar.

Seals used on thread are in accordance with ISO 6149 and are manufactured with compounding Buna N 70 or 90 Shore A. Standard seals bear a temperature range from -35 °C to +110 °C.

On request seals with different compounding may be assembled; please ask our Technical Department.

## FLUIDS AND FILTRATION :

Standard seals are suitable for being used with usual hydraulic oils with mineral base type HM and HV according to ISO 6074. On technical schedules of each valve are showed the beared viscosity range as well as the required filtration level.

We recommend to respect these limits in order to obtain an high reliability and a long lasting life of components.