



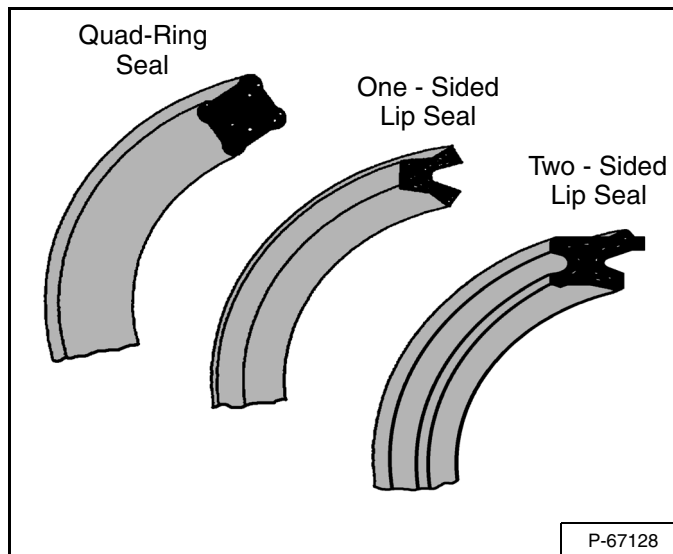
BOBCAT TECHNICAL INFORMATION BULLETIN

Bulletin #: 374
Date: 13 January 2006
Product: Loader
Subject: Hydraulic Control Valve Spool
Seal Replacement

MODEL
440, 443, 450, 540, 542, 543, 553, 641, 642, 643, 645, 741, 742, 743, 753, 763, 773, 7753, 843, 853, 1213, 1600, 2000, 2400, 2410

The spool seals (P/N's 6632204, 6632256, 6659554 and 6665846) are no longer available.

Figure 1



[Figure 1] Three types of seals are available for installation in hydraulic control valves, a quad-ring seal and two styles of lip seals. The seals are not interchangeable.

Early control valves must use the quad-ring seal. Later control valves and replacement control valves must use a lip seal. Replace the seal with the same type that was originally installed. If the correct seal type is in question, inspect the valve spool bore and refer to the drawings to determine the correct type.

DIRECT TO:

PARTS MANAGER
SERVICE MANAGER
SALES MANAGER

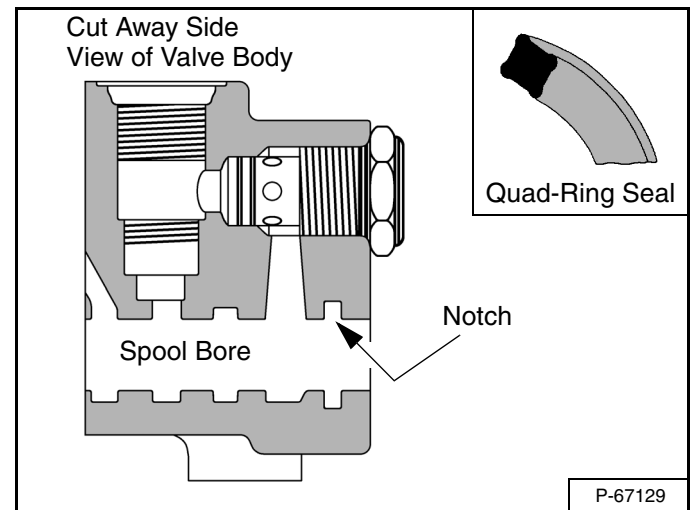


NOTE: Before installing any seal, de-burr any sharp edges that may contact the seal to prevent cutting the seal.

Parts

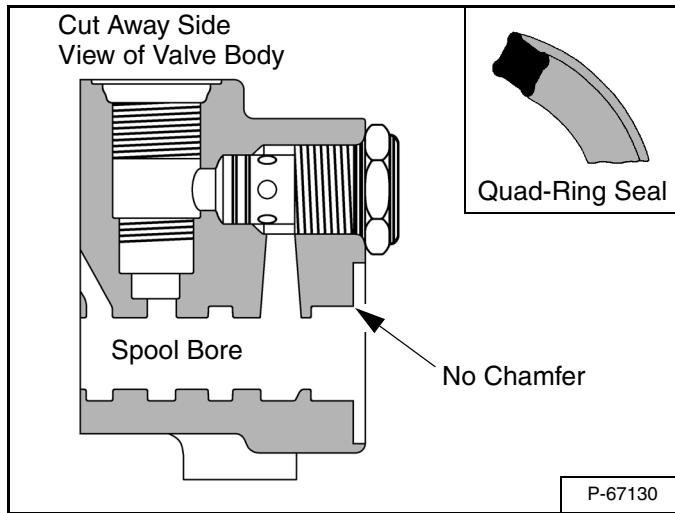
P/N	DESCRIPTION
6646372	Quad-Ring Seal
6665089	One - Sided Lip Seal
6683274	Two - Sided Lip Seal

Figure 2



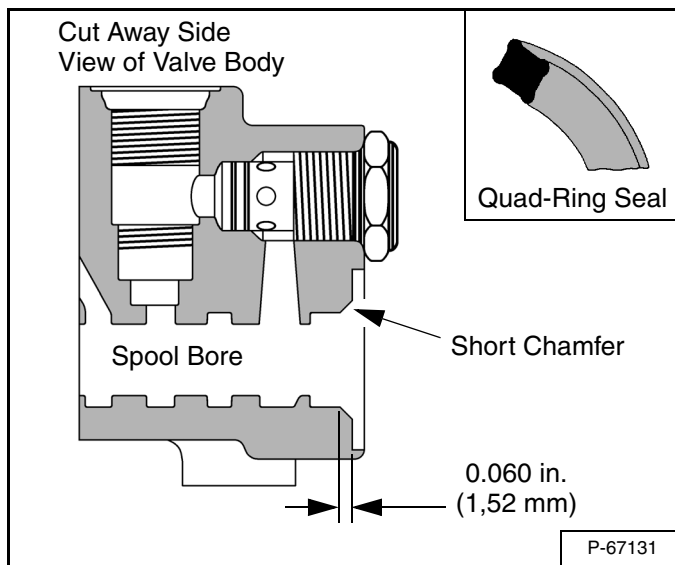
[Figure 2] Control valves with a notch in the spool bore require a quad-ring seal. Remove the control valve from the machine and install the quad-ring seal in the spool bore notch.

Figure 3



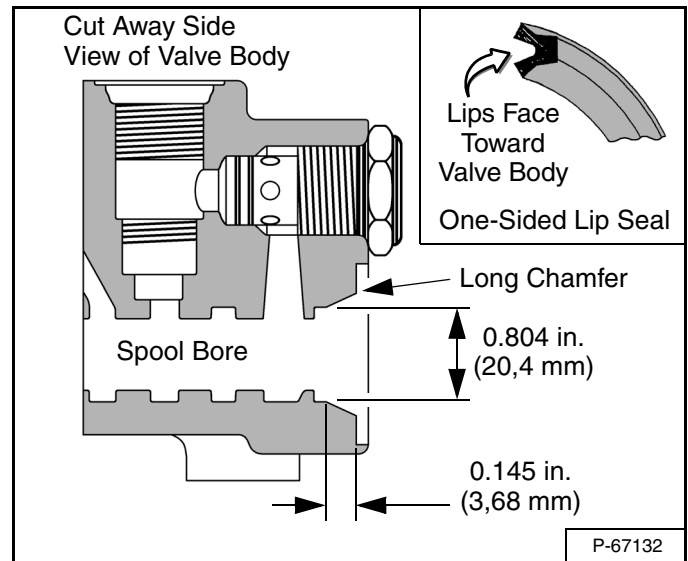
[Figure 3] Control valves that have a square opening (no chamfer) to the spool bore require a quad-ring seal. Install the quad-ring seal in the spool seal groove and install the spool into the control valve.

Figure 4



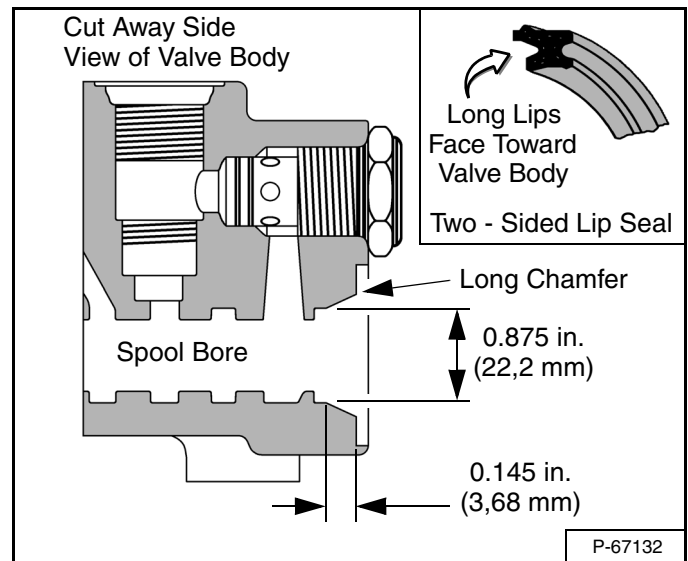
[Figure 4] Control valves that have a short chamfer located at the spool bore opening require a quad-ring seal. Install the quad-ring seal in the spool seal groove and install the spool into the control valve.

Figure 5



[Figure 5] Control valves that have a long chamfer and small diameter spool bore opening require a **one - sided lip seal**. Install the lip seal in the spool seal groove and install the spool into the control valve.

Figure 6



[Figure 6] Control valves that have a long chamfer and large diameter spool bore opening require a **two - sided lip seal**. Install the lip seal in the spool seal groove and install the spool into the control valve.