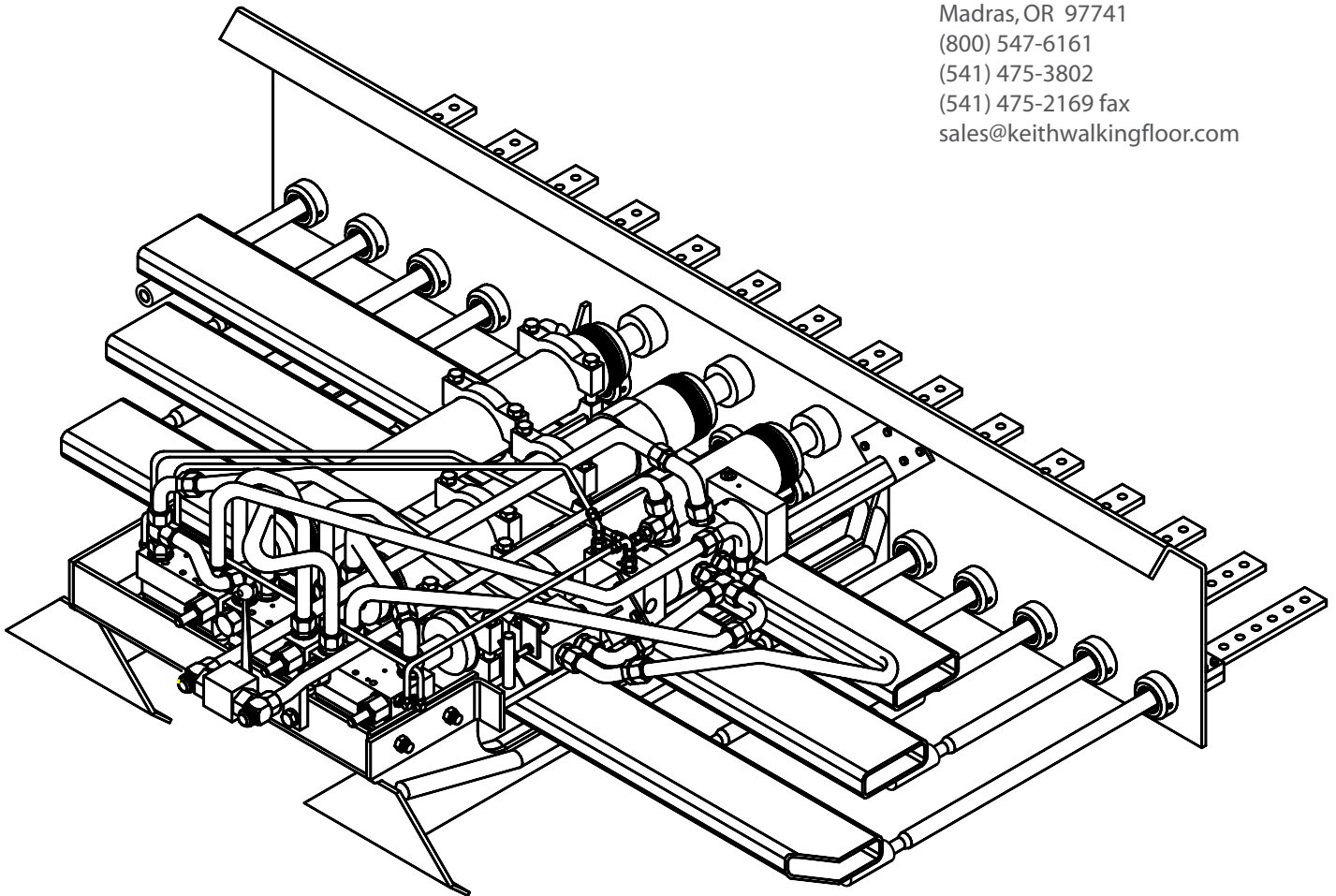


KEITH® **LEAKPROOF 94**

UNLOADING SYSTEM

KEITH Mfg. Co.
WORLD HEADQUARTERS
Madras, OR 97741
(800) 547-6161
(541) 475-3802
(541) 475-2169 fax
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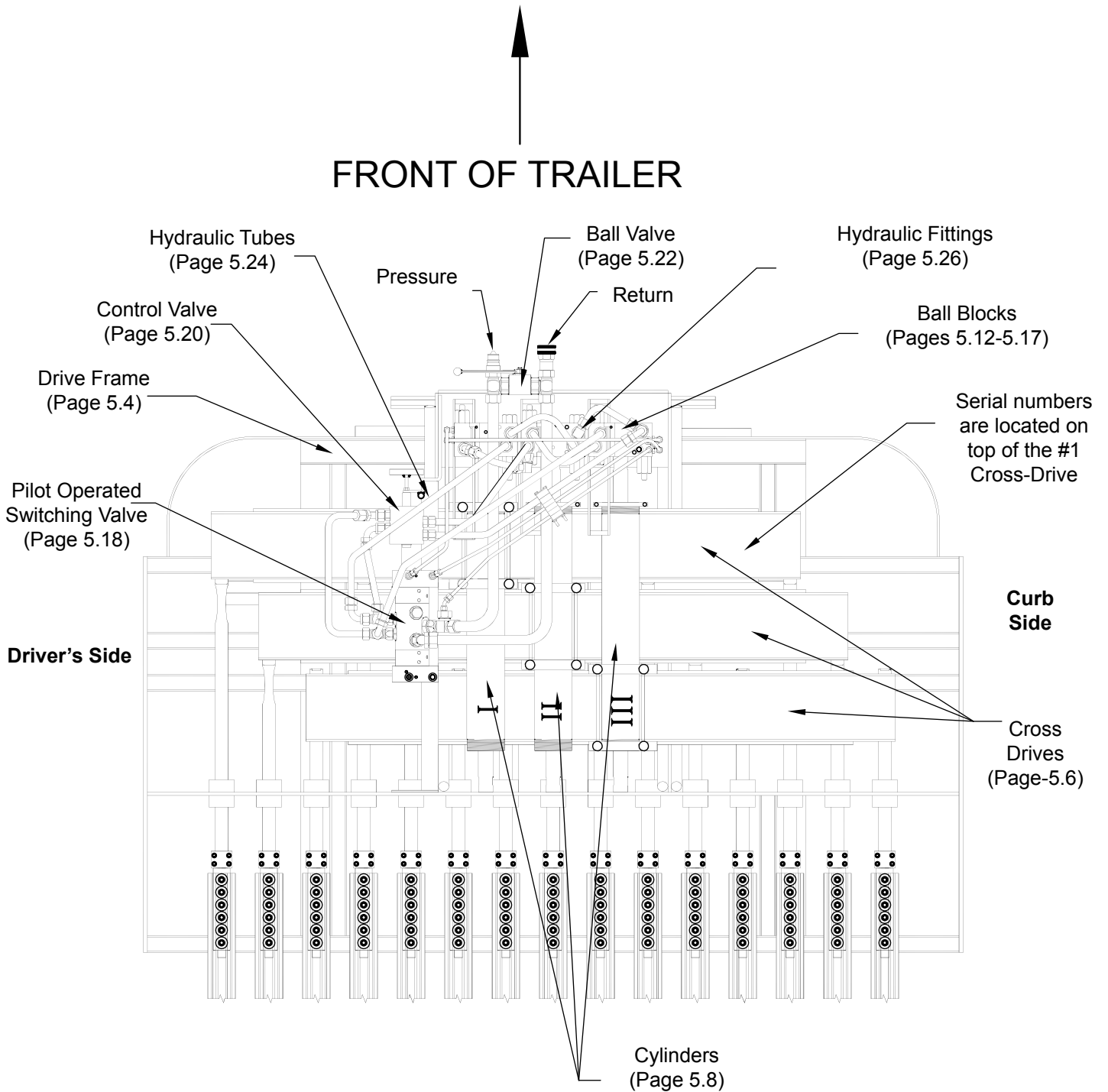
Updated 11.12.2018

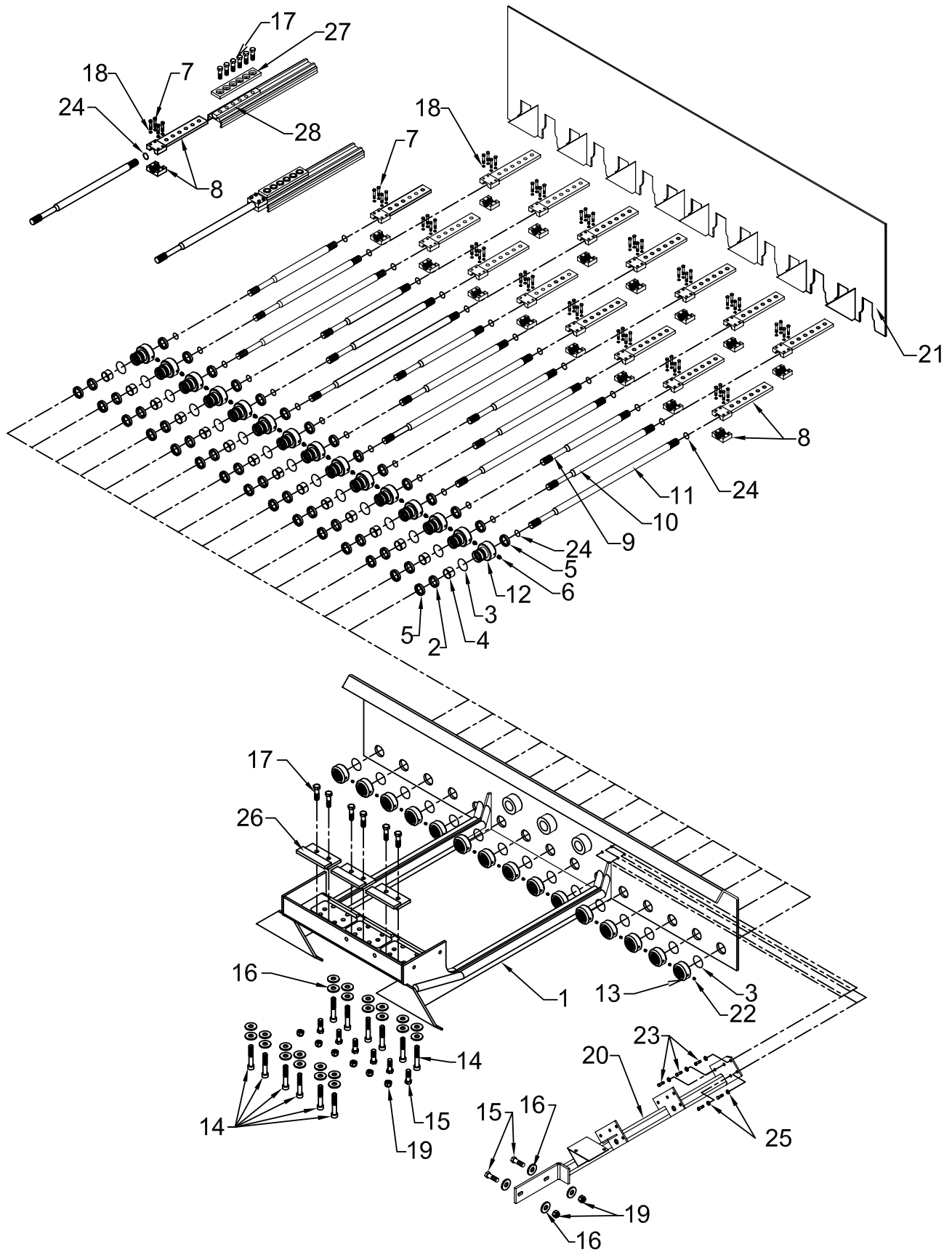
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Note: The following parts guide is for KEITH® LeakProof 94 15 slat systems. For all other systems please contact KEITH Mfg. Co. at 800-547-6161. KEITH & *WALKING FLOOR* are registered worldwide trademarks of KEITH Mfg. Co.

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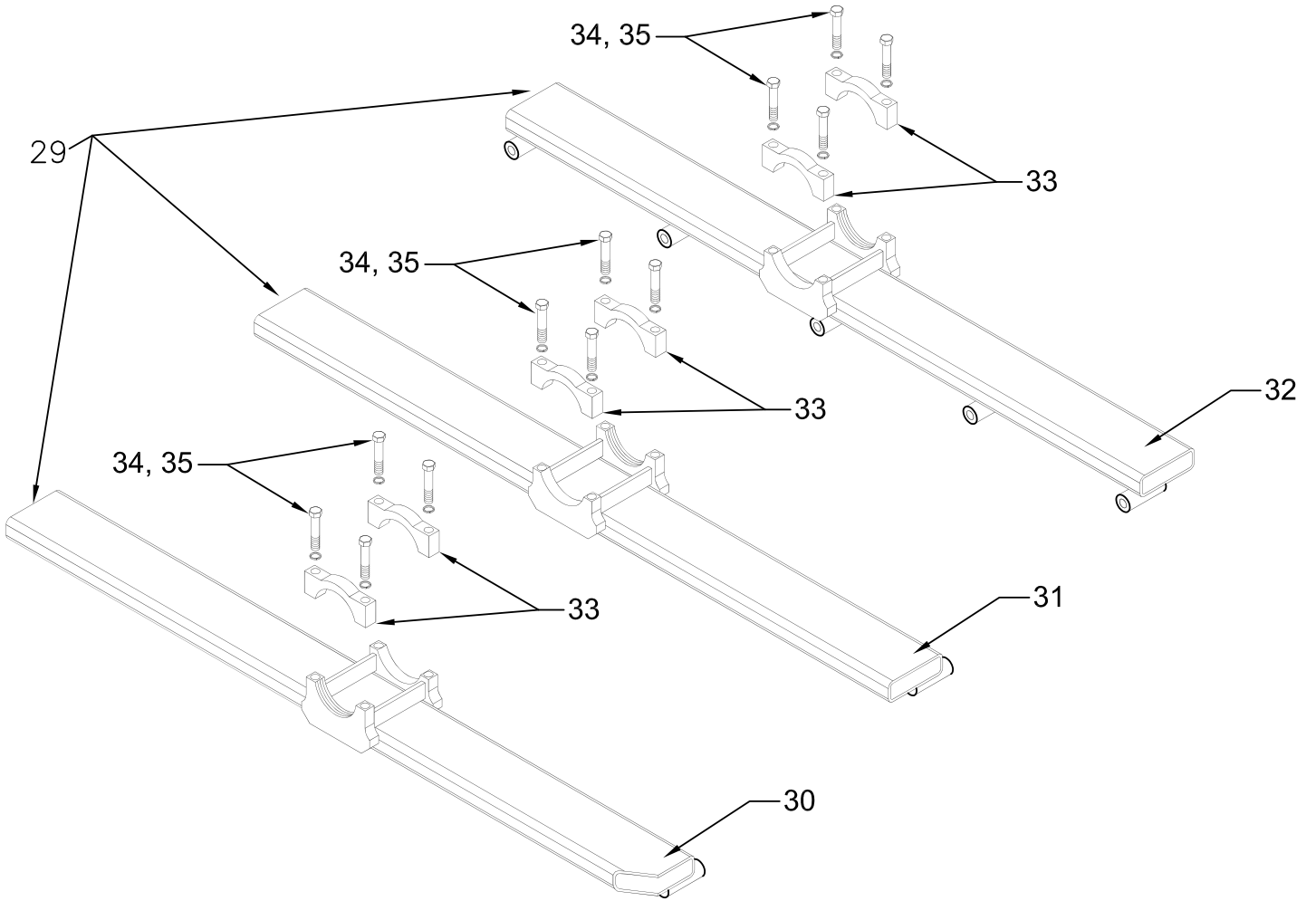




Parts List

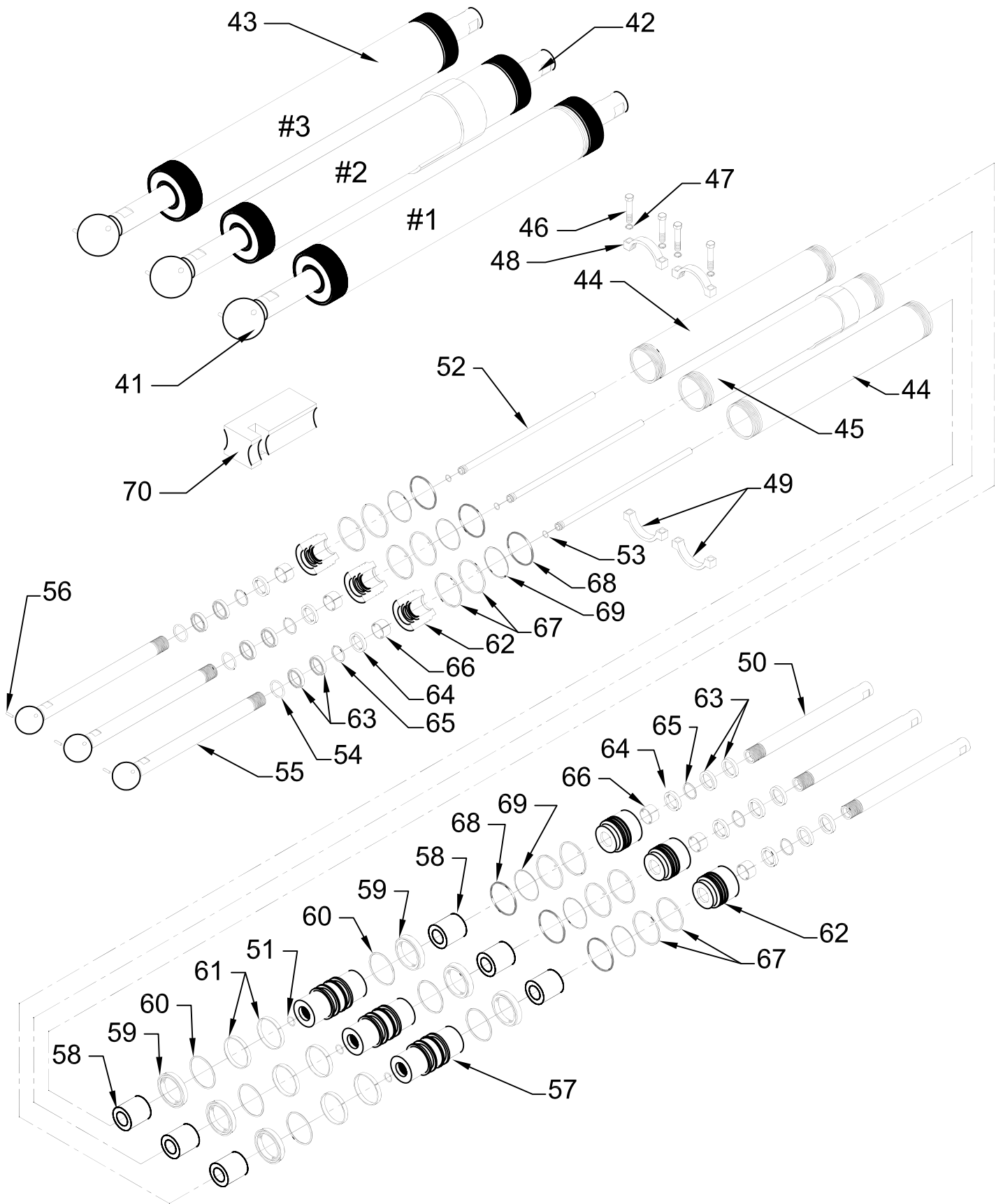
-	-	Drive Frame Assembly Steel	-
1 ⁽¹⁾	1	Drive Frame Steel	-
	15	Waterdam Bushing Assembly	01322901
		Includes items 2-6, 12,13, & 22	
2	15	Seal Rod O-Ring 216 90 Duro Urethane	84382400
3	30	O-Ring 330	84386200
4	15	Wear Ring Rod 1 1/8" WO62-1250-1500	84402000
5	30	Wiper Rod 1 1/8" J1125	84425850
6 ⁽¹⁾	15	Fitting Grease	varies
7	60	Bolt Hex GR5 3/8" x 13/4"	86439000
8	15	Clevis Bar Assembly	03094601
9	5	Rod Drive 19 5/8"	03383801
10	5	Rod Drive 24"	03383901
11	5	Rod Drive 33 5/8"	03384001
12	15	Bushing Drive Rod	03421201
13	15	Jam Nut Bushing Drive Rod	03421301
14	12	Bolt Socket Head GR8 5/8" x 4"	86470100
15	8	Bolt Hex GR8 5/8" x 2"	86464500
16	28	Washer Flat 1/2"	86558500
17	6	Bolt Hex GR8 1/2" x1 3/4	86450500
18	60	Washer Lock 3/8"	86555000
19	8	Nut Hex Nylock 5/8"	86631500
20	1	Mount Bar Assembly Switching Valve	04190401
21 ⁽¹⁾	1	Shield Lower 87" Assembly	03150201
22	15	Set Screw 3/8" x 1/2" Socket	86436000
23	5	Bolt Hex GR5 5/16" x 1"	86427000
24	30	O-Ring 314	84385800
25	5	Washer Lock 3/4"	86559500
26	3	Plate Stiffener Ball Block	04336301
27	15	Plate Counter-Bore LP94	04256801
28	15	Clevis Nut Bar Unc LP94	04324001

(1) Part numbers and descriptions vary based on drive configuration and application.



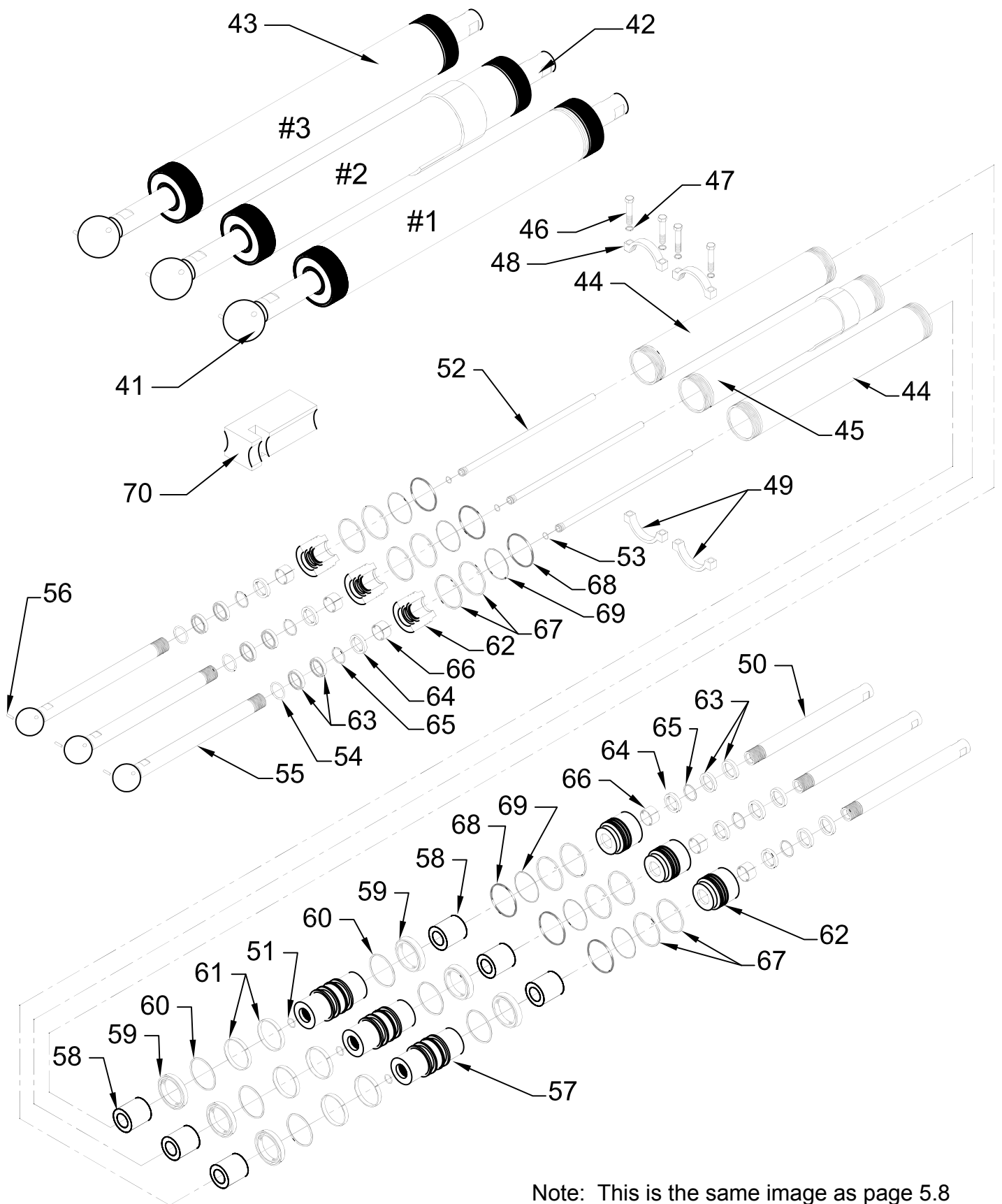
Parts List

ID#	QUANTITY	DESCRIPTION	PARTNUMBER
29	1	Cross-Drive 15 Slat 3 Cylinder Set	03094401
-	-	Includes Items 30-32	-
30	1	Cross-Drive 15 Slat 3 Cylinder #1	03094402
31	1	Cross-Drive 15 Slat 3 Cylinder #2	03094403
32	1	Cross-Drive 15 Slat 3 Cylinde r#3	03094404
33	6	Clamp Cross-Drive Upper 4.0"	01323601
34	12	Bolt Hex GR8 3/4"x4-1/2"	86474000
35	12	Washer Lock 3/4"	86559500



Parts List

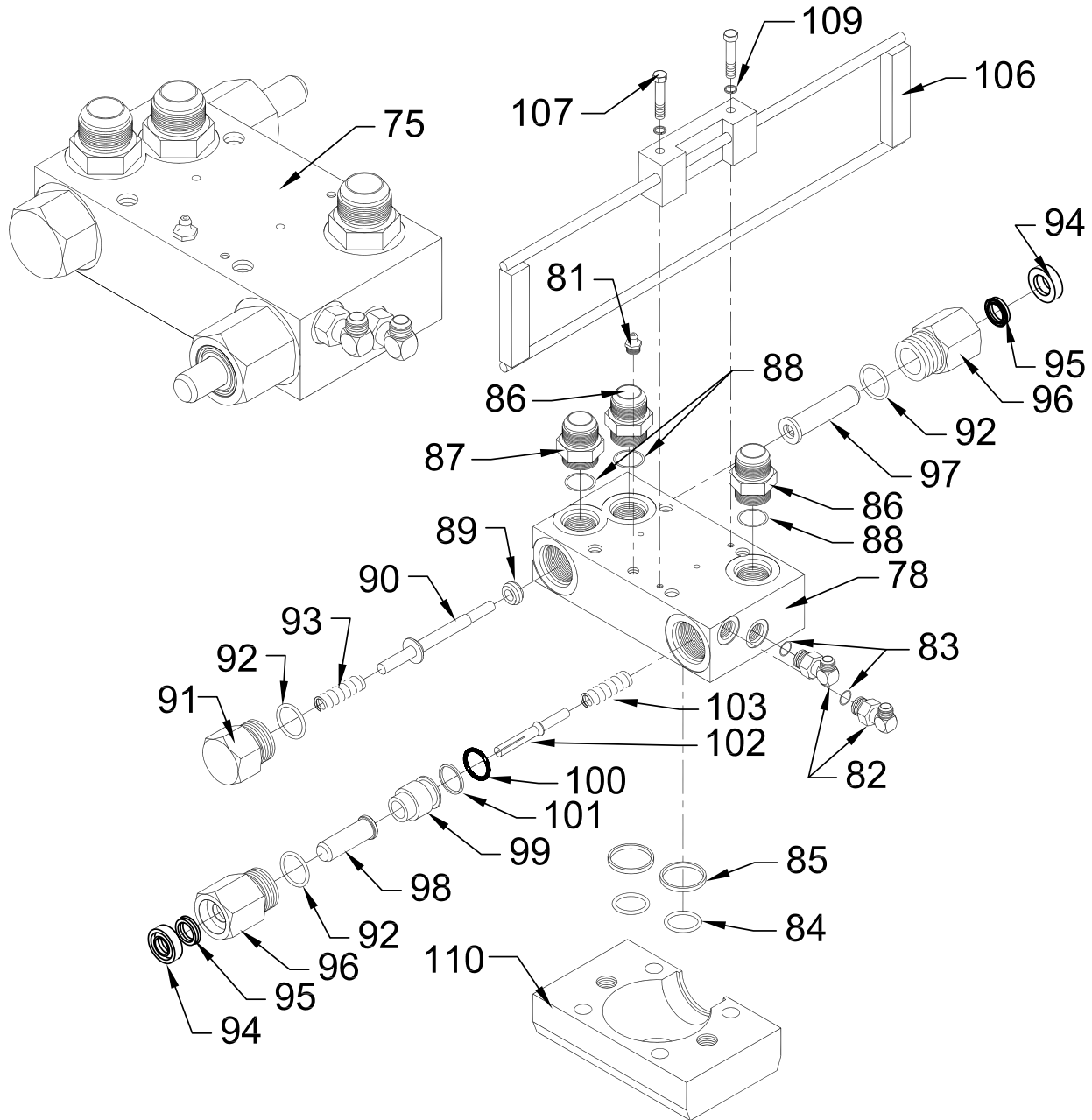
ID#	QUANTITY	DESCRIPTION	PART NUMBER
41	1	Cylinder Assembly in 3 Cylinder Drive #1	03203001
42	1	Cylinder Assembly in 3 Cylinder Drive #2	03203101
43	1	Cylinder Assembly in 3 Cylinder Drive #3	03203001
-	-	Includes Items 44-69	-
44	2	Barrel #1 & #3	01505301
45	1	Barrel #2 W/ Threaded Pad	04431001
46	4	Bolt Hex GR5 3/8" x 2- 1/4"	86440000
47	4	Washer Lock 3/8"	86555000
48	2	Clamp Shifting Threaded	01502002
49	2	Clamp Shifting Smooth	01502001
-	3	Rod W/ Piston & Head 4.0" Assembly	03795701
-	-	Includes Items 50-69	-
50	1	Rod Tail Weld Assembly	04651201
51	1	O-Ring 210 Urethane	84380400
52	1	Inner Tube Assembly	03794901
53	1	O-Ring 116	84376800
54	1	O-Ring 327	84386000
55	1	Rod Ball End	03794301
56	1	Dowel Pin Cylinder Ball 1/4" x 3/4"	04228801



Note: This is the same image as page 5.8

Parts List (cont.)

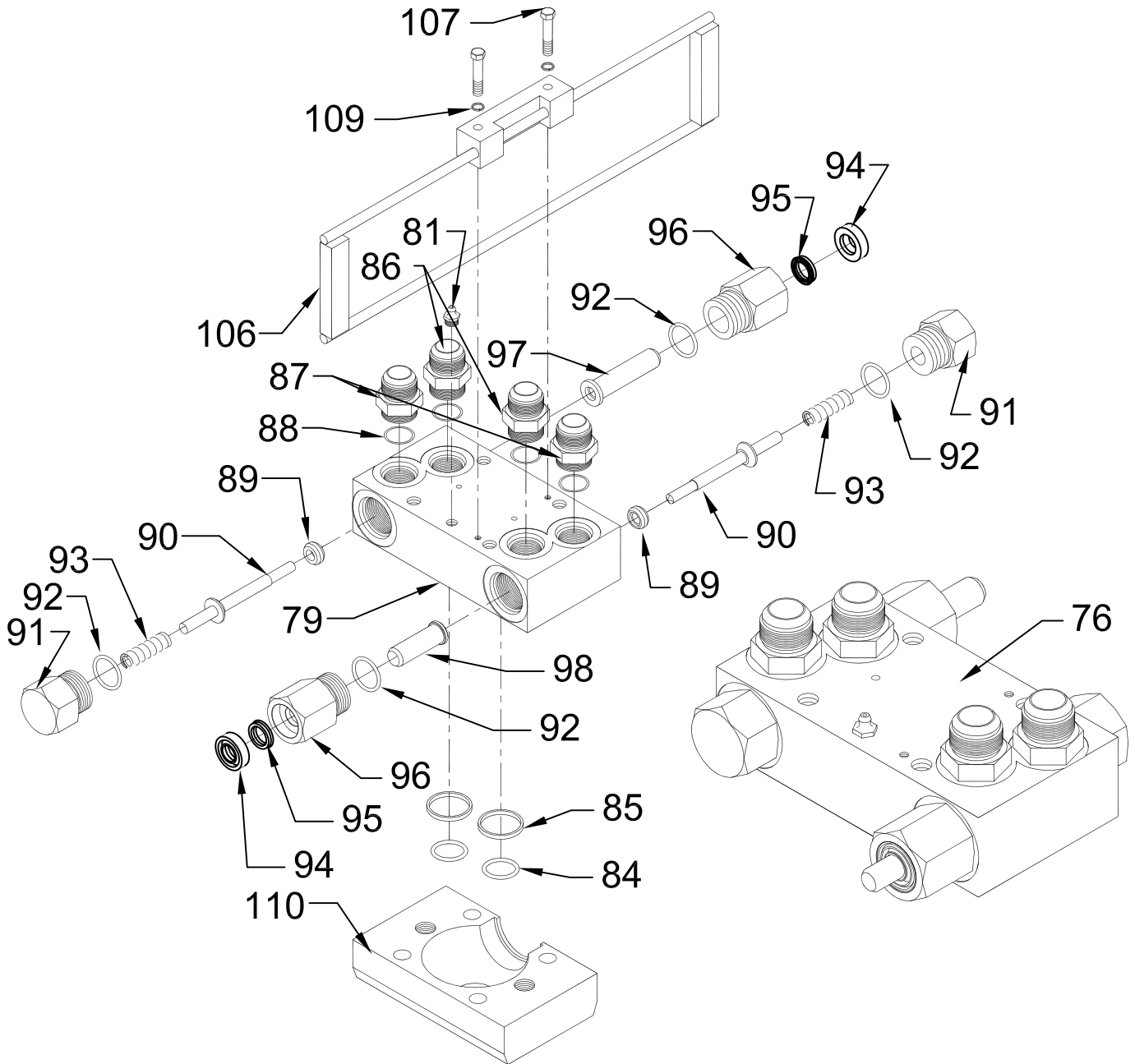
ID#	QUANTITY	DESCRIPTION	PARTNUMBER
-	1	Piston Ported Assembly	03795601
-	-	Includes Items 57-61	-
57	1	Piston Ported	03794001
58	2	Spacer Aluminum Piston Rod	03793901
59	2	Seal Piston Cylinder 4.0"	84352400
60	2	Seal Backup Piston Cylinder 4.0"	w/seal
61	2	Wear Ring Piston Cylinder 4.0"	84405400
-	2	Head 4.0 Assembly W/ Lockwire & Seals	04170801
-	-	Includes Items 62-69	-
62	1	Head 4.0" Cylinder	01500801
63	2	Wiper Rod 45mm Canned	84426600
64	1	Seal Rod Cylinder 45mm	84354200
65	1	Seal Backup Rod Cylinder 45mm	w/seal
66	1	Wear Ring Rod Cylinder 45mm	84401200
67	2	Lock Wire 4.0" & 100 mm Head Cylinder	03812106
68	1	O-Ring 240	84385000
69	1	O-Ring Backup 8-240	84393200
70	2	UHMW Cylinder Spacer Block	04589401
71	1	UHMW Spacer Block	04589501
-	1	Seal Kit 4.0" Cylinder	04227301
-	-	Includes Items 51, 53, 54, 59-61 & 63-69	-



ID#	QUANTITY	DESCRIPTION	PARTNUMBER
75	1	Ball Block Assembly Upper #1 POSWV	04431101
-	-	Includes Items 78&81-103	-
78	1	Ball Block#1 Upper	03096301
81	1	Fitting Grease 1/8" Pipe 1610B	84704300
82	2	6801-06-0690°	84691100
83	2	O-Ring 906	84386800

Parts List (cont.)

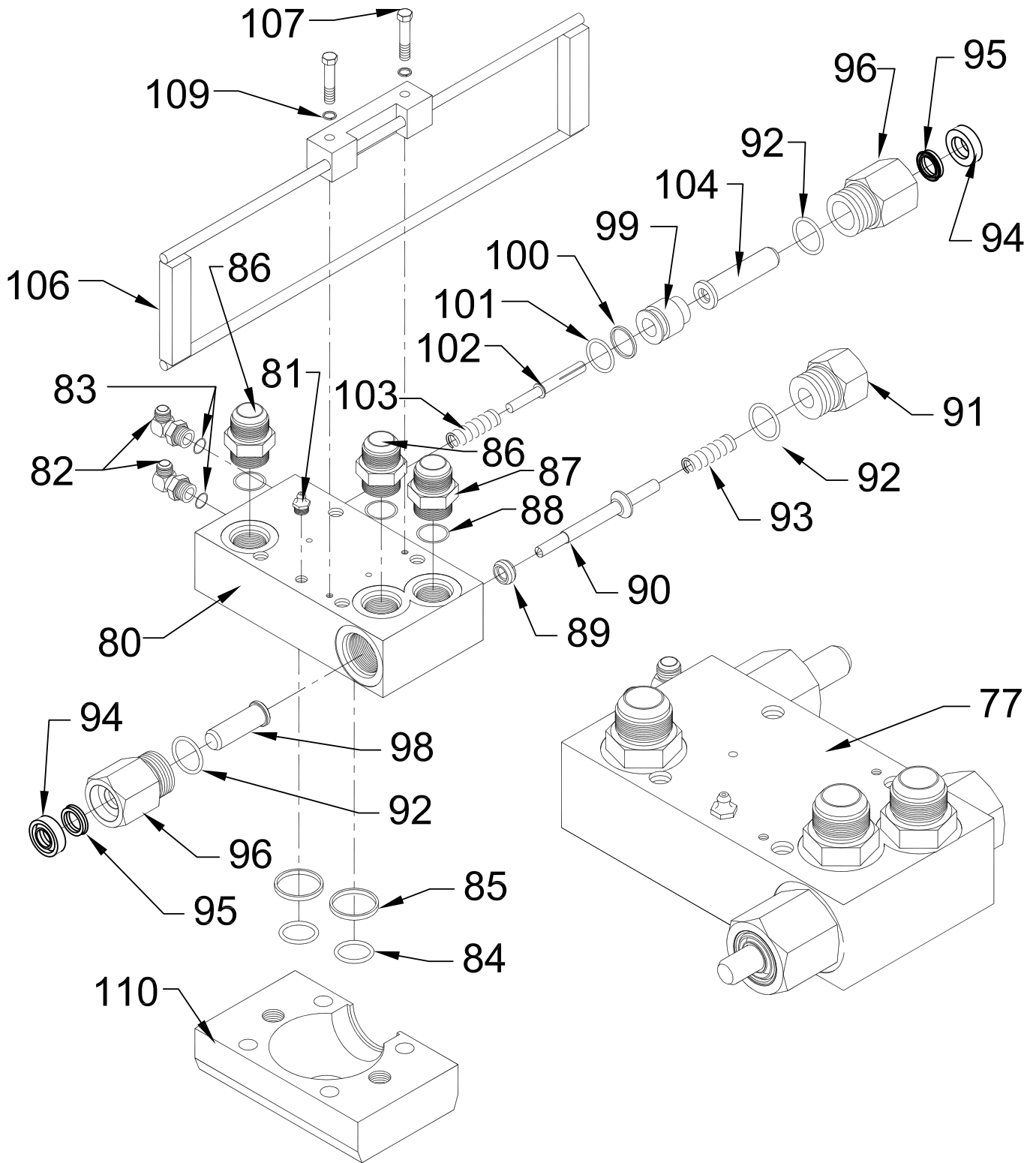
ID#	QUANTITY	DESCRIPTION	PART NUMBER
81	1	Fitting Grease 1/8" Pipe 1610B	84704300
84	2	O-Ring 214 Urethane	84382000
85	2	O-Ring Backup 8-214 Ball Block	02100301
86	2	6400-12-12 Straight	84685000
87	2	6400-12-12 Straight Modified	01509701
88	4	O-Ring 912	84387400
-	1	Check Valve Push Long Assembly	04564301
-	-	Includes Items 89-97	-
89	1	Restrictor Collar Check Valve	01328401
90	1	Rod Check Valve	01206101
91	1	End Cap Check Valve	03097001
92	2	O-Ring 916	84387800
93	1	Spring 9-1010-11	84455200
94	1	Wiper Canned 5/8" Rod	84427200
95	1	Seal Rod 5/8"	84352200
96	1	Nose Cap Push Check Valve	03312501
97	1	Plunger Long Check Valve	03294101
-	1	Pilot Push Check Valve Assembly	03421101
-	-	Includes Items 92, 94-96, 98-103	-
92	1	O-Ring 916	84387800
94	1	Wiper Canned 5/8" Rod	84427200
95	1	Seal Rod 5/8"	84352200
96	1	Nose Cap Push Check Valve	03312501
98	1	Plunger Short Check Valve	03294001
99	1	Seat Check Valve Pilot	03126201
100	1	O-Ring 211	84380600
101	1	O-Ring Back Up 211	84390800
102	1	Check Valve Pilot	03126101
103	1	Spring 9-0808-36	84455000
106	1	Shift Yoke Assembly Check Valve Actuator #2 & #3 Cyl	01331701
107	2	Bolt Hex GR5 1/4" x 1-1/2"	86416500
109	2	Washer Lock 1/4"	86551500
110	1	Ball Block Lower	01508001



Parts List

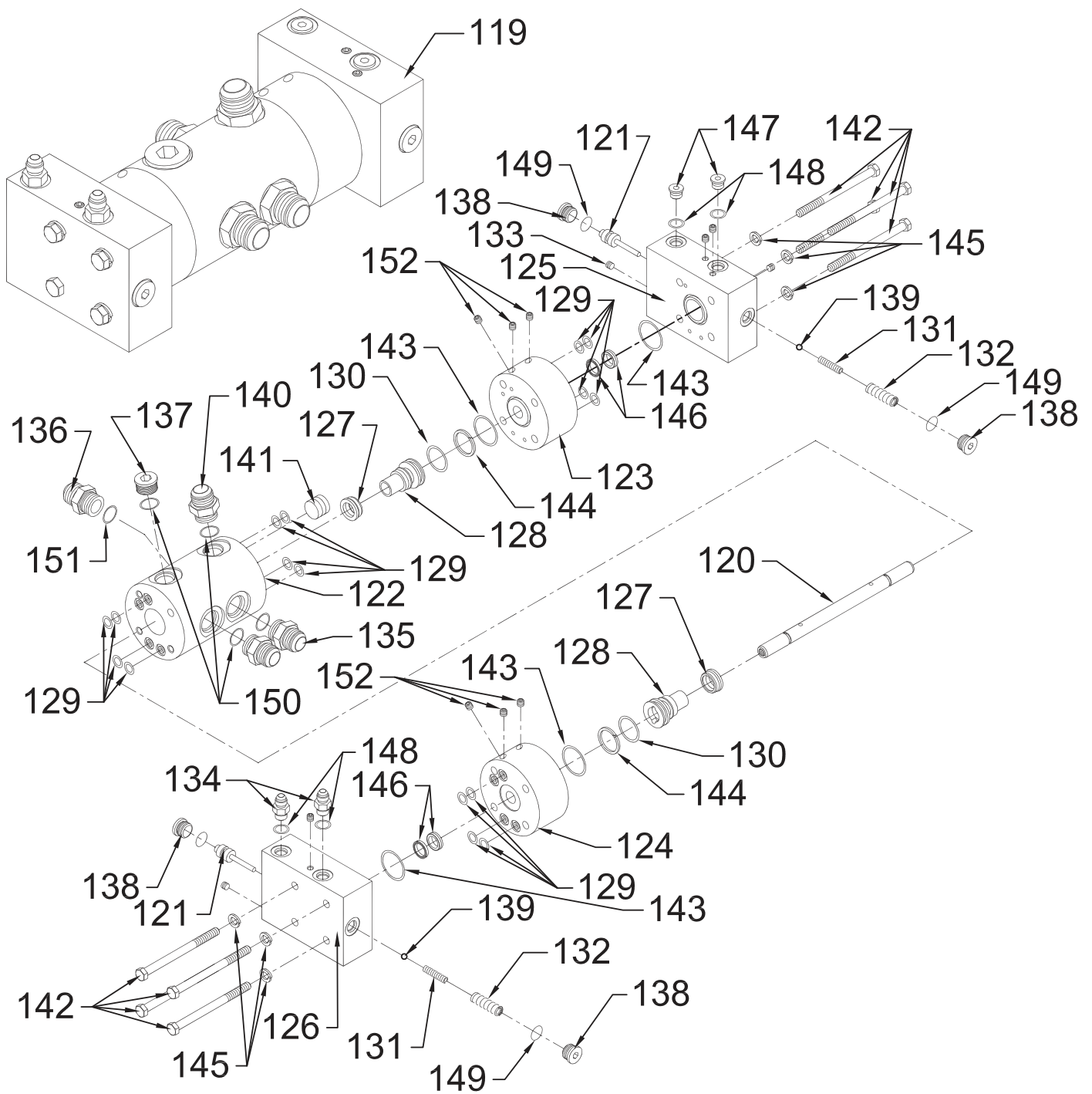
ID#	QUANTITY	DESCRIPTION	PART NUMBER
76	1	Ball Block Assembly Upper #2 POSWV	04556201
-	-	Includes Items 79,81,84-98	-
79	1	Ball Block #2 Upper	03096401

ID#	QUANTITY	DESCRIPTION	PARTNUMBER
81	1	Fitting Grease 1/8" Pipe 1610B	84704300
84	2	O-Ring 214 Urethane	84382000
85	2	O-Ring Backup 8-214 Ball Block	02100301
86	2	6400-12-12 Straight	84685000
87	2	6400-12-12 Straight Modified	01509701
88	4	O-Ring 912	84387400
-	1	Check Valve Push Long Assembly	04564301
-	-	Includes Items 89-97	-
89	1	Restrictor Collar Check Valve	01328401
90	1	Rod Check Valve	01206101
91	1	End Cap Check Valve	03097001
92	2	O-Ring 916	84387800
93	1	Spring 9-1010-11	84455200
94	1	Wiper Canned 5/8" Rod	84427200
95	1	Seal Rod 5/8"	84352200
96	1	Nose Cap Push Check Valve	03312501
97	1	Plunger Long Check Valve	03294101
-	1	Check Valve Push Short Assembly	04564302
-	-	Includes Items 89-96 & 98	-
89	1	Restrictor Collar Check Valve	01328401
90	1	Rod Check Valve	01206101
91	1	End Cap Check Valve	03097001
92	2	O-Ring 916	84387800
93	1	Spring 9-10 10-11	84455200
94	1	Wiper Canned 5/8" Rod	84427200
95	1	Seal Rod 5/8"	84352200
96	1	Nose Cap Push Check Valve	03312501
98	1	Plunger Short Check Valve	03294001
106	1	Shift Yoke Assembly Check Valve Actuator #2 & #3 Cyl	01331701
107	2	Bolt Hex GR5 1/4" x 1-1/2"	86416500
109	2	Washer Lock 1/4"	86551500
110	1	Ball Block Lower	01508001



Parts List

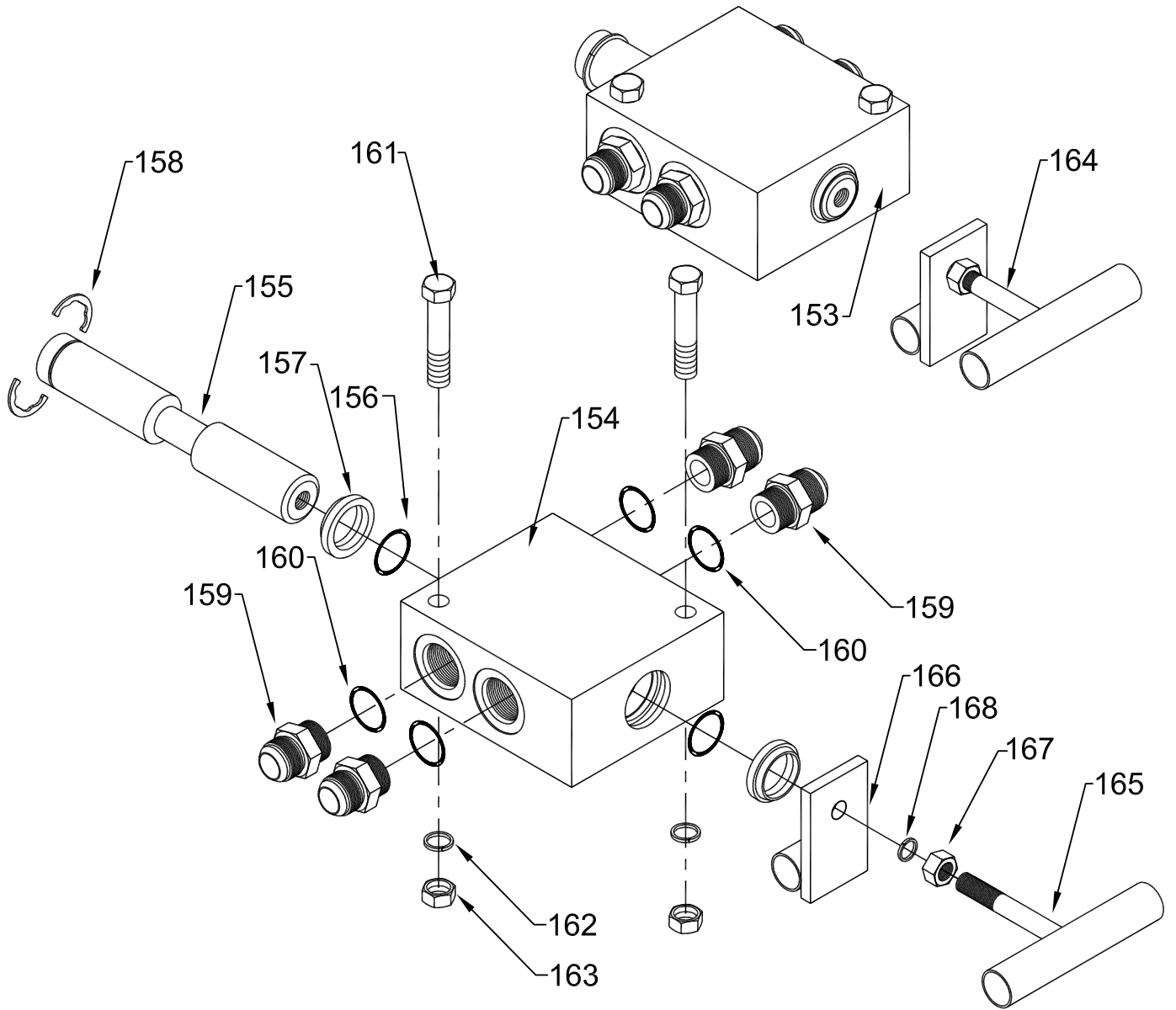
ID#	QUANTITY	DESCRIPTION	PARTNUMBER
77	1	Ball Block Assembly Upper #3 POSWV	04431301
-	-	Includes Items 80-96 & 98-104	-
80	1	Ball Block #3 Upper	03096501
81	1	Fitting Grease 1/8" Pipe 1610B	84704300
82	2	6801-06-0690°	84691100
83	2	O-Ring 906	84386800
84	2	O-Ring 214 Urethane	84382000
85	2	O-Ring Backup 8-2 14 Ball Block	2100301
86	2	6400-12-12 Straight	84685000
87	1	6400-12-12 Straight Modified	1509701
88	3	O-Ring 912	03097001
-	1	Check Valve Push Short Assembly	04564302
-	-	Includes Items 89-96 & 98	-
89	1	Restrictor Collar Check Valve	01328401
90	1	Rod Check Valve	01206101
91	1	End Cap Check Valve	03097001
92	2	O-Ring 916	84387800
93	1	Spring 9-10 10-11	84455200
94	1	Wiper Canned 5/8" Rod	84427200
95	1	Seal Rod 5/8"	84352200
96	1	Nose Cap Push Check Valve	03312501
98	1	Plunger Short Check Valve	03294001
-	1	Check Valve Pilot Signal Push SWV	03421103
-	-	Includes Items 92,94-96,99-104	-
92	1	O-Ring 916	84387800
94	1	Wiper Canned 5/8" Rod	84427200
95	1	Seal Rod 5/8"	84352200
96	1	Nose Cap Push Check Valve	03312501
99	1	Seat Check Valve Pilot	03126201
100	1	O-Ring 211	84380600
101	1	O-Ring Backup 8-211	84390800
102	1	Check Valve Pilot	03126101
103	1	Spring 9-0808-36	84455000
104	1	Plunger Check Valve	01507401
106	1	Shift Yoke Assembly Check Valve Actuator #2 & #3 Cyl	01331701
107	2	Bolt Hex GR5 1/4"x1-1/2"	86416500
109	2	Washer Lock 1/4"	86551500
110	1	Ball Block Lower	01508001



ID #	QUANTITY	DESCRIPTION	PART NUMBER
119	1	Switching Valve Assembly Pilot Operated	04126401
-	-	Includes Items 120-152	-
120	1	Rod Control Switching Valve	01335501
121	2	Plunger Pilot Operated Switching Valve	02528901

Parts List (cont.)

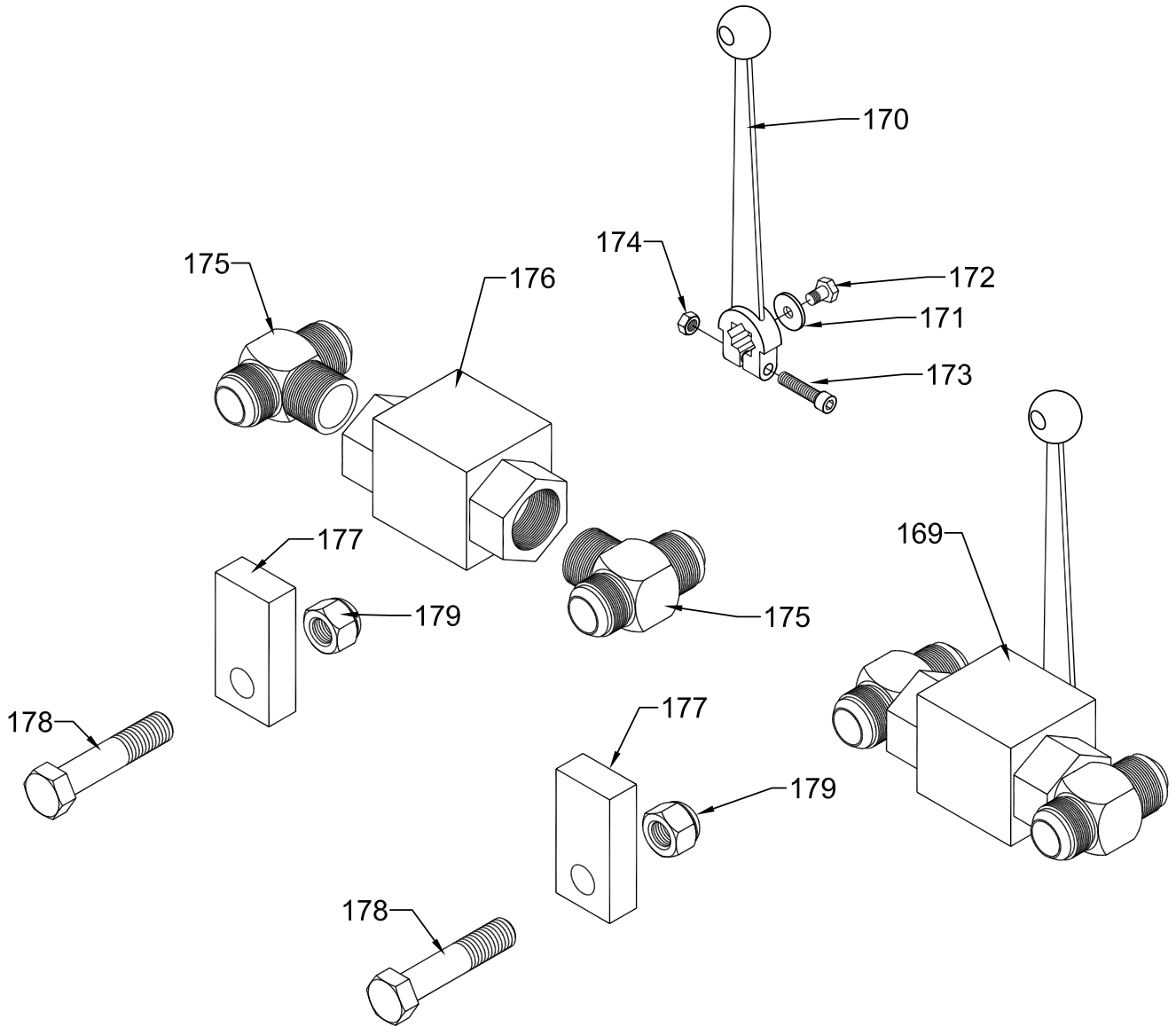
ID #	QUANTITY	DESCRIPTION	PART NUMBER
122	1	Switching Valve Body	03126801
123	1	End Cap Right Pilot Operated Switching Valve	03126901
124	1	End Cap Left Operated Switching Valve	03127001
125	1	End Cap Right Outer Pilot Operated Switching Valve	03127101
126	1	End Cap Left Outer Pilot Operated Switching Valve	03127201
127	2	Ring Poppet Switching Valve	03718801
128	2	Poppet Switching Valve	03718901
129	16	O-Ring 111	84376200
130	2	O-Ring Backup 8-216	84391600
131	2	Spring Check Valve External Small #B-18272	84453200
132	2	Spring Check Valve External Large #B-18273	84453400
133	5	1/16" Pipe Plug Socket 7/8" Taper	84680770
134	2	6400-06-06 Straight	84684000
135	2	6400-12-12 Straight	84685000
136	1	6408-16-16 Straight	84685400
137	1	6408-H-12 Hollow Hex Plug	84687700
138	4	6408-H-08 Hollow Hex Plug	84687500
139	2	Ball 5/16" Chrome Steel	84800500
140	1	6400-16-12 Straight	84685300
141	1	1/2" Pipe Plug Socket 7/8" Taper	84680790
142	8	Bolt Hex GR5 3/8" x 5"	86445500
143	4	O-Ring 126	84378200
144	2	O-Ring 216	84382200
145	6	Washer Lock 3/8"	86555000
146	4	Steel Rod 5/8"	84352200
147	2	6408-H-06 Hollow Hex Plug	84687400
148	4	O-Ring 906	84386800
149	4	O-Ring 908	84387000
150	4	O-Ring 912	84387400
151	1	O-Ring 916	84387800
152	6	1/8" Pipe Plug Socket 7/8" Taper	84687250
-	1	Seal Kit Pilot Operated Switching Valve	04227401
-	-	Includes Items 129, 130, 143, 144, 146 & 148-151	-



Parts List

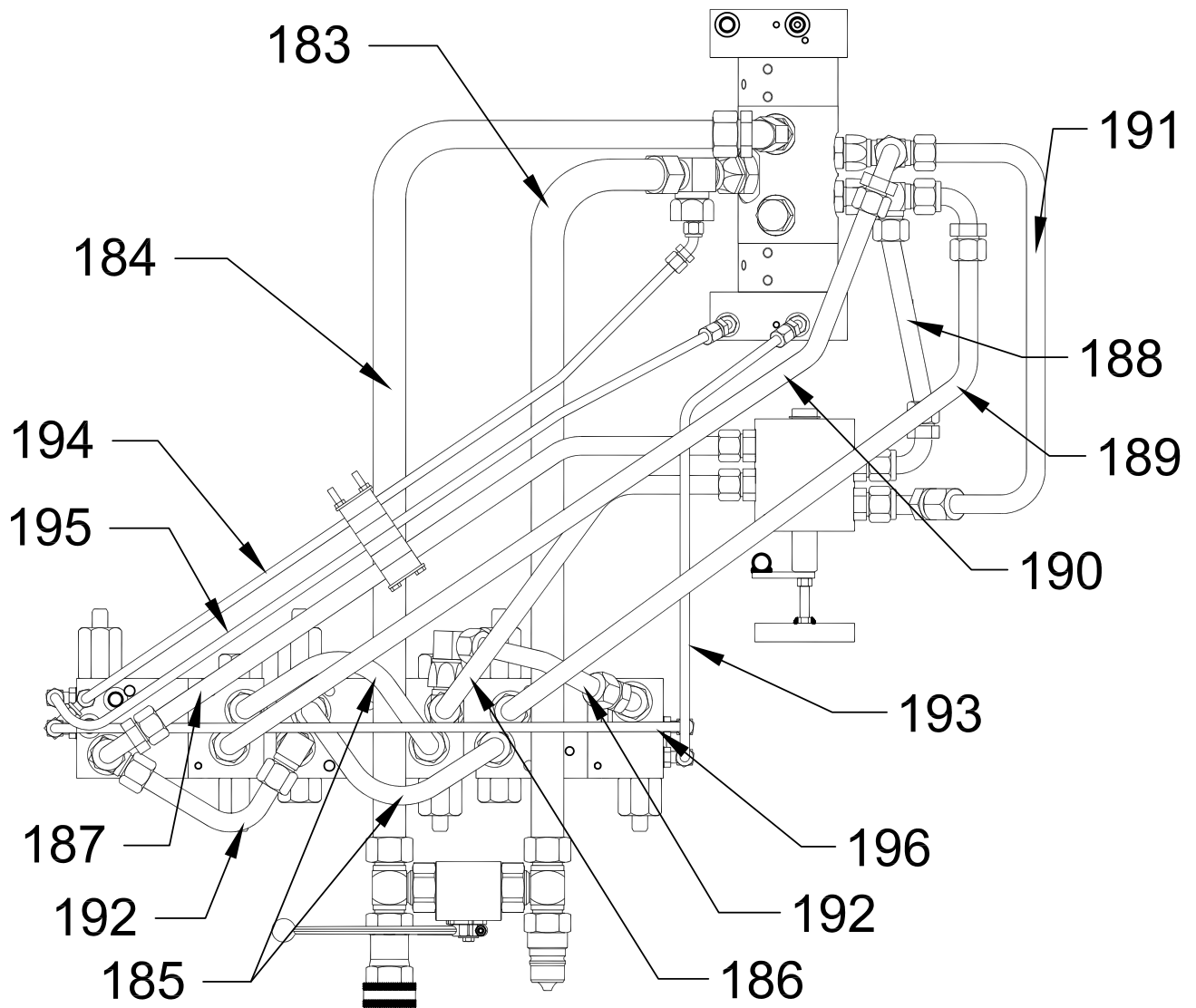
ID#	QUANTITY	DESCRIPTION	PART NUMBER
153	1	Control Valve Load/Unload Assembly	02552701
-	-	Includes items 154-160	-
154	1	Body Control Valve	01049501
155	1	Spool Control Valve	03423201
-	1	Seal Kit Control Valve Load/Unload	03877901
-	-	Includes items 156-158	-
156	2	O-Ring 214B-70	84381800
157	2	Wiper 1" Rod	84427000
158	1	Snap Ring 2-Piece For Spool	84801000
159	4	6400-12-10 Straight	84684900
160	4	O-Ring 910	84387200
161	2	Bolt Hex GR5 3/8"x3"	86442000
162	2	Washer Lock 3/8"	86555000
163	2	Nu Hex 3/8"	86628500
164	1	Handle Assembly Control Valve Load/Unload	02552601
-	-	Includes items 165-168	-
165 ⁽¹⁾	1	"T" Handle	-
166 ⁽¹⁾	1	"T" Handle Plate	-
167	1	Nut Hex 3/8"	86628500
168	1	Washer Lock 3/8"	86555000

(1) Not sold separately. Included only with Control Valve Handle Assembly.

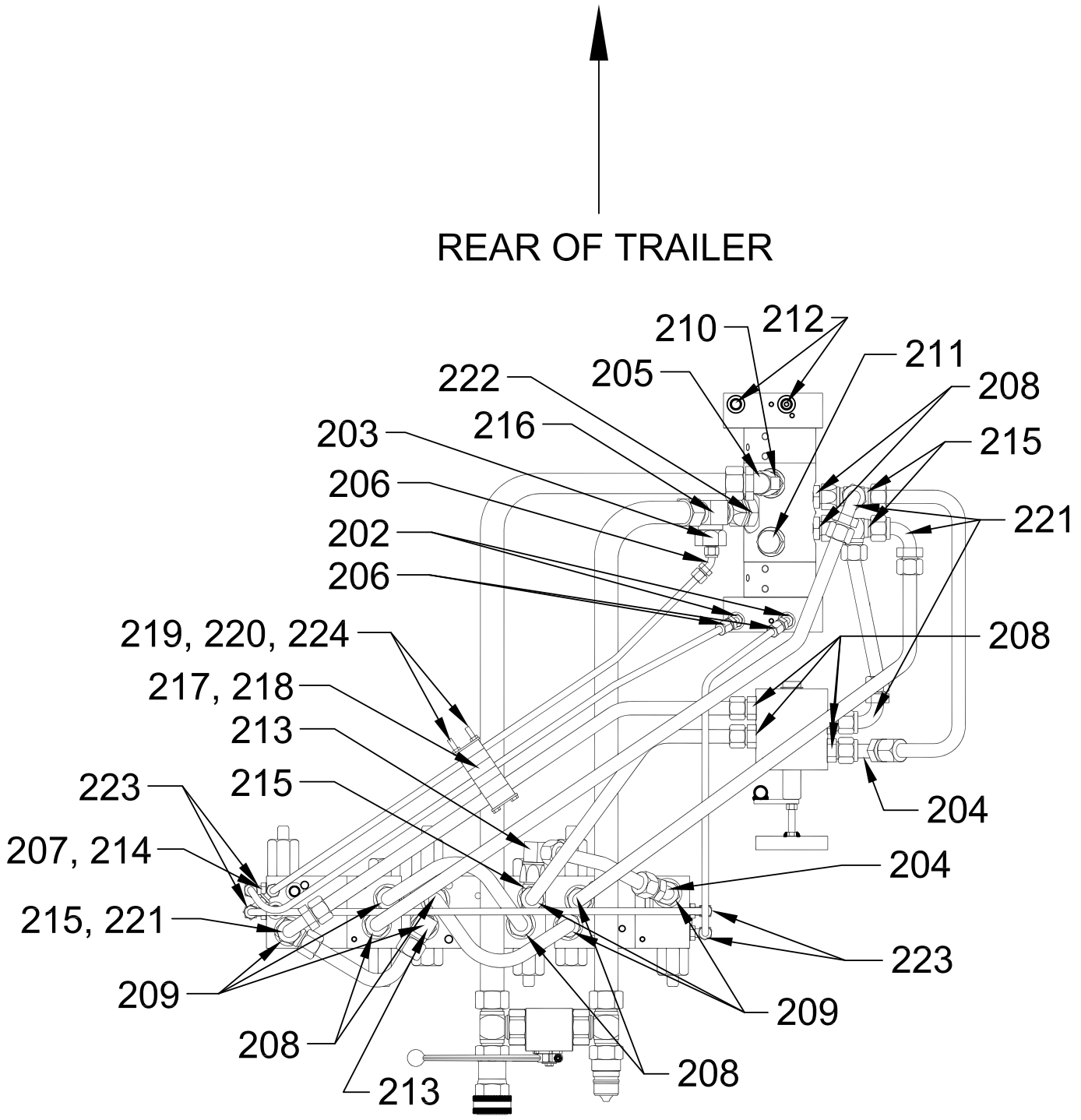


ID #	QUANTITY	DESCRIPTION	PART NUMBER
169	1	Ball Valve 1" w/ Tees & Handle	84802600
-	-	Includes Items 170-176	-
170	1	Handle Ball Valve	84802903
171	1	Washer Flat 6 mm	w/ ball valve
172	1	Bolt Hex GR 86mm x 1mm x 10mm	w/ballvalve
173	1	Bolt Socket Head GR 86mm x 1mm x 30mm	w/handle
174	1	Nut Hex 6mm x 1mm	w/handle
175	2	260716-16-16Tee	84678400
176	1	Ball Valve Assembly 1"	84802800
177	2	Plate Mount Ball Valve	03156401
178	2	Bolt Hex GR 8 5/8" x 2"	86464500
179	2	Nut Hex Nylock 5/8"	86631500

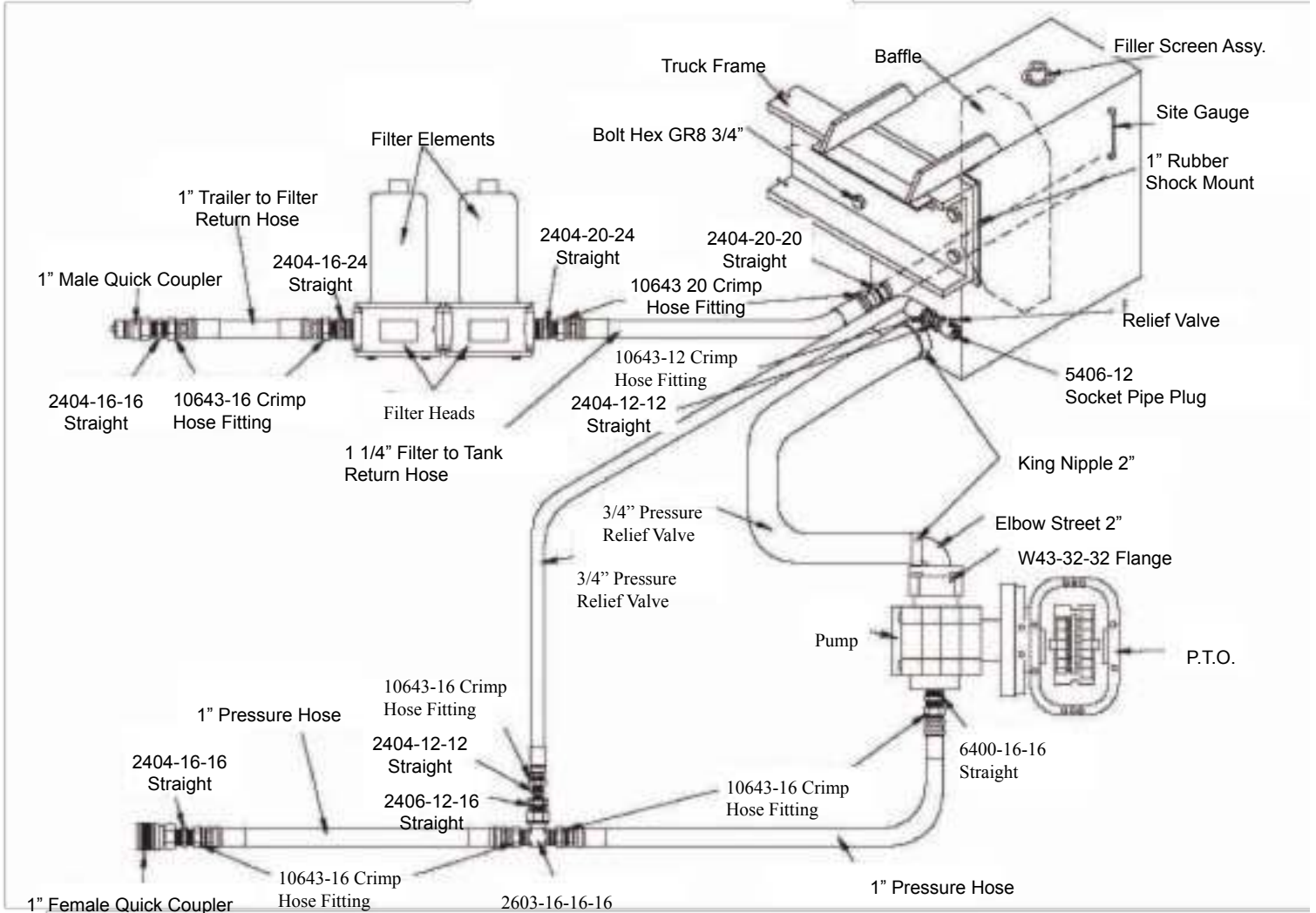
↑
REAR OF TRAILER



ID #	QUANTITY	DESCRIPTION	PART NUMBER
-	-	Hydraulic Tubes	-
-	-	Includes Items 183-196	-
183	1	Tube 1" Switching Valve Pressure	03010301
184	1	Tube 1" Switching Valve Return	03010302
185	2	Tube 3/4" #2 Ball Block to #1 or #3 Ball Block	04207301
186	1	Tube 3/4" #2 Bal Block to Control Valve	04207401
187	1	Tube 3/4" #3 Ball Block to Control Valve	04207501
188	1	Tube 3/4" Switching Valve To Control Valve Long	04207601
189	1	Tube 3/4" Switching Valve To #1 Ball Block	04207701
190	1	Tube 3/4" Switching Valve To #3 Ball Block	04207801
191	1	Tube 3/4" Switching Valve To Control Valve Short	04207901
192	2	Tube 3/4" #1 or #3 Ball Block to #2 Ball Block	04208001
193	1	Tube 3/8" #1 Ball Block to Switching Valve	04208101
194	1	Tube 3/8" #3 Ball Block to Switching Valve	04208201
195	1	Tube 3/8" #3 Ball Block to Pressure Line	04208301
196	1	Tube 3/8" #3 Ball Block to #1 Ball Block	04208401



ID#	QUANTITY	DESCRIPTION	PARTNUMBER
-	-	Hydraulic Fittings	-
-	-	Includes Items 202-224	-
202	2	2403-06-06 Straight	84672400
203	1	2406-16-06 Straight	84676200
204	2	63TA-12-12 Bent Stem 45°	84682600
205	1	63TA-16-16 Bent Stem 45°	84682700
206	3	63TA-06-06 Bent Stem 45°	84682300
207	1	63UA-06-06 Bent Stem 90°	84682800
208	10	6400-12-10 Straight	84684900
209	6	6400-12-12 Straight Modified	01509701
210	1	6400-16-12 Straight	84685300
211	1	6409-12MO-Ring Socket Plug	84687700
212	2	6409-06MO-Ring Socket Plug	84687400
213	2	6500-12-1290°	84688600
214	1	6602-06-06-06 Tee	84690100
215	4	6602-12-12-12 Tee	84690300
216	1	6602-16-16-16 Tee	84690400
217	2	Clamp Hydraulic Tube 3/8" 3095-PP	84750100
218	1	Clamp Hydraulic Tube 1" Set	84750300
219	2	Bolt Hex GR5 1/4"x5"	86424500
220	2	Nut Hex Nylock 1/4"	86626000
221	4	63UA-12-12 Bent Stem 90°	84683100
222	1	6400-16-16 Straight	84685400
223	4	6801-06-0690°	84691100
224	2	Plate Clamp TubeT op COP-3	84751200



Speed of Floor in Relation to Unload RPM

With a Fuller 13 or 15 speed transmission, a bottom mount 118% series 442/489 Chelsea power take off and a Commercial P-51 pump with a 2 1/2" gear, the floor movement in relation to pump output is as follows*:

TRUCK RPM	PUMP OUTPUT	FLOORMOVEMENT*
950RPM	30gallon	7.7ft./minute
1270RPM	40gallon	10.2ft./minute
1430RPM	45gallon	11.5ft./minute
1750RPM	55gallon	14.0ft./minute
1900RPM	60gallon	15.3ft./minute

*Above specifications are for a KEITH® LeakProof 94 drive unit with 4.0" bore cylinders. These area approximate feet per minute only and should be used strictly as a guide.

Note: Drive unit is not designed to exceed 60 GPM.

Transmission:	This wet kit is designed for a Fuller 13 or 15 speed transmission. All of the following information applies to this transmission. (P.T.O. specifications may vary with other transmissions. Please check with KEITH Mfg. Co. for specifications.)
Oil:	Chevron AW46 hydraulic oil or equivalent.
PTO: over	Chelsea series 442 489 bottom mount (6 or 8bolt) 118% power take off (electric speed is highly recommended), or Muncie P.C.65 with electric over speed.
Pump:	Commercial P-51A297BE (Spl.) 25-25 (2" four bolt suction) with Anchor W43-32-32 flange.
Filter:	Filter should be 10 to 30 micron on the return line. Filter should be a double element Zinga (or equivalent). Filterhead # DF-15-25. MF2215-25-0-2-0 Filter element #LE-10 or LE-30 (The filter element should be changed after 6 hours initially, and then every 6 months thereafter. This may vary with the operating environment.)
Hydraulic Reservoir:	Should hold approximately 1 gallon for every gallon per minute you plan to pump, i.e. 40 GPM = 40 gallon reservoir. Reservoir should hold a minimum of 40 gallons of oil.
SuctionLine:	Suction line from the tank to the pump should be no more than 5 in length and a minimum of 2" in side diameter. Example: SAE-100R4 (This type of line has a spiral wire to keep the hose from collapsing under suction.)
Pressureline:	Hose from truck to trailer should be 1" 16SAE-100R2.
Return Line:	Hose from trailer to filtershouldbe1"16SAE-100R1. Hosefromfiltertotankshouldbe1-1/4"20SAE-100R1.
Pressure Relief Valve:	Example: Cross #RD12D

Note: It is critical that this relief valve is set at no less than 2800 PSI and no more than 3000 PSI.

Unloading

Problem: Floor does not run at all.

Check: **All items on START-UP checklist:**

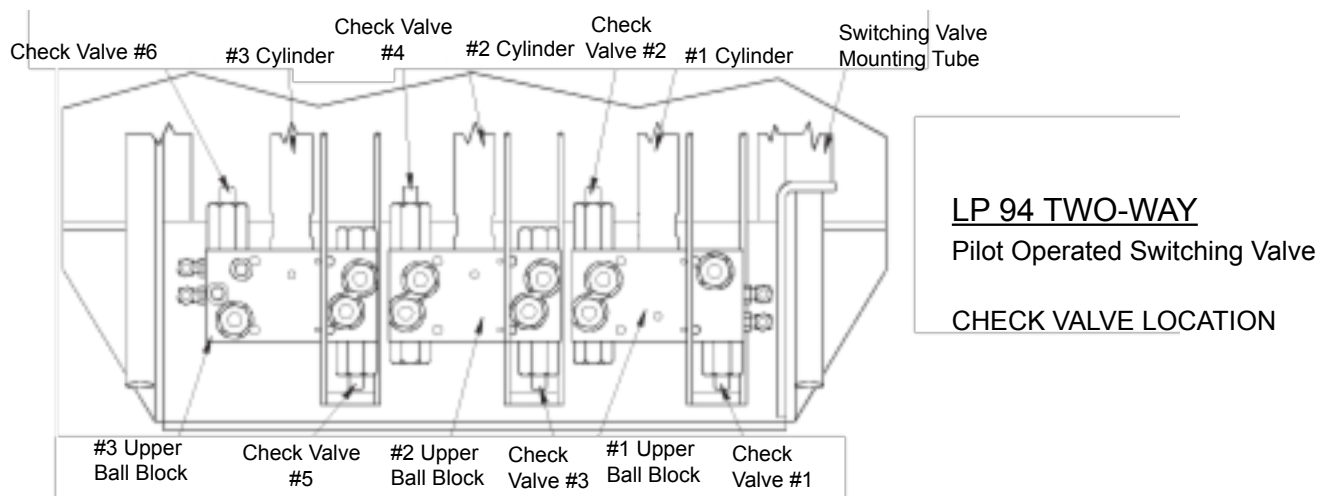
1. Is your entire system plumbed to the plumbing diagram?
2. Pump: Will it pump 30-35 GPM at pressure?
3. Relief Valve: Is it set at 2800-3000 PSI?
4. Oil: Have you filled the reservoir?
5. P.T.O.: Is it engaged?
6. Quick Disconnects: Are they completely engaged?
7. Ball Valve: Is the ball valve on the drive unit closed?
8. Is the pressure line on the trailer attached to the pressure line on the tractor and the return line attached to the return line?

The pressure and return lines must attach to their proper ports on the switching valve.

Problem: Cycle starts then floor stops.

1. Specific trouble: Drivers side cylinder (#1) moves toward the front of the trailer, center cylinder (#2) moves toward the front of the trailer, passenger side cylinder (#3) moves toward the front of trailer; then the system stops.
Solution: The (#6) check valve has malfunctioned. Replace the check valve.
2. Specific trouble: All three cylinders move toward the rear of the trailer; then the system stops.
Solution: The (#1) check valve has malfunctioned. Replace the check valve. (See note)

Note: If floor stops in the full rear position and the switching valve has switched, you may not have enough oil pressure. Less pressure is required to move the load than to pull the slats 1/3 at a time under the load.



Unloading

Problem: Does not cycle correctly

1. Specific trouble: Cylinders (#1) and (#2) extend together toward the front of the trailer while unloading.
Solution: The (#2) check valve has malfunctioned. Replace the check valve.
2. Specific trouble: Cylinders (#2) and (#3) extend together toward the front while unloading.
Solution: The (#4) check valve has malfunctioned. Replace the check valve.
3. Specific trouble: All cylinders extend together toward the front of the trailer while unloading.
Solution: The control valve is bypassing or the (#2) & (#4) check valves have malfunctioned. First replace the control valve. Then if the problem persists, replace the check valves.

Loading

Problem: Does not cycle correctly

1. Specific trouble: Cylinders (#2) and (#3) extend together toward the rear of the trailer while loading.
Solution: The (#5) check valve has malfunctioned. Replace the check valve.
2. Specific trouble: Cylinders (#1) and (#2) extend together toward the rear while loading.
Solution: The (#3) check valve has malfunctioned. Replace the check valve.
3. Specific trouble: All cylinders extend together toward the rear of the trailer while loading.
Solution: The control valve is bypassing or the (#3) & (#5) check valves have malfunctioned. First replace the control valve. Then if the problem persists, replace the check valves.

Note: When empty, some trailers will cycle in sequence forward 1-2-3, then back 3-2-1, (instead of all slats moving back together.) This is not a malfunction; no repairs are needed. When a load is put on a trailer, the drag will cause the floor to sequence properly.