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INSTALLATION INSTRUCTIONS

RPI PART #AMP211 - PM PACK (STEAM)

• PM PACK INCLUDES:

S1: (1) RPI PART #AMK219 - SOLENOID VALVE REPAIR KIT

S2 & S9: (2) RPI PART #AMK220 - SOLENOID VALVE REPAIR KIT

S35: (1) RPI PART #AMK221 - SOLENOID VALVE REPAIR KIT

• ALSO AVAILABLE:

RPI PART #AMK215 - SEAT KIT (STEAM)

WARNING: Turn off electrical power, bleed pressure from the manifold assembly and safely vent fluid prior to servicing the valve manifold assembly! When maintenance is complete, verify that the valve manifold assembly is operating properly before returning to service. Failure to do so could result in property damage, serious injury, or death!

CAUTION: Take care to not damage sealing surfaces, leakage may result.

RPI PART #AMK219

SOLENOID VALVE REPAIR KIT *(Shown in Green in Figure 1 on next page)*

REBUILD INSTRUCTIONS FOR S1 VALVE

1. Disassemble the solenoid coil.
2. Unscrew the solenoid bonnet and remove the plunger assembly, core guide, bonnet o-ring and washer. *Note: If replacing the valve seat, use a 9/16" deep socket wrench for valve seat removal. Clean the manifold cavity. **NEW STYLE VS. OLD STYLE VALVE SEATS:** The new style .375" orifice valve seat is manufactured with a flange to accommodate a seat o-ring. When replacing one flanged valve seat for another, lubricate the o-ring and install the valve seat; it is not necessary to use any thread sealant. When replacing the old style valve seat (no flange) with a new flanged valve seat, lubricate the o-ring and apply Pipe Sealant 567 (RPI Part #RPA459) to the threads. Torque to 19 ft/lbs (225 +/- 25 in/lbs). Let the sealant cure for 4 to 8 hours before running the machine when sealant is used on the valve seat threads.*
3. Clean the manifold and manifold cavities. Install the washer, lubricate and install the bonnet o-ring into the manifold.
4. Holding the solenoid bonnet horizontally, load the core guide and the plunger assembly. thread the solenoid bonnet into the manifold and torque to 21 ft/lbs (250 +/- 25 in/lbs).
5. Reassemble the solenoid coil.

RPI PART #AMK220

SOLENOID VALVE REPAIR KIT *(Shown in Purple in Figure 1 on next page)*

REBUILD INSTRUCTIONS FOR S2 AND S9 VALVES

1. Disassemble the solenoid coil.
2. Unscrew the solenoid bonnet from the bonnet manifold. Remove the punger assembly and the bonnet o-ring.
3. Remove the bonnet manifold. Remove the piston assembly, Lip seal, support and the inner & outer manifold gaskets. *Note: If replacing the valve seat, use a 1" deep socket wrench for valve seat removal. Clean the manifold cavity and apply High Temp Lubricant (RPI Part #RPL090) or equivalent to the seat o-ring. Install and torque to 15 ft/lbs (175 +/- 25 in/lbs).*
4. Clean the manifold and manifold cavities. Lubricate gaskets with High Temp Lubricant (RPI Part #RPL090). Install the inner and outer manifold gaskets into the manifold. A little extra lube will help hold the gaskets in place while installing the remainder of the parts.
5. Use High Temp Lubricant (RPI Part #RPL090) or equivalent to lubricate the surface of the piston assembly that comes in contact with the lip seal.
6. Assemble the lip seal onto the support and insert the piston assembly into the lip seal. Install the assembly into the bonnet manifold.
7. Mount the bonnet manifold assembly (now loaded with the piston assembly, lip seal and support) to the manifold. Insert the mounting screws finger tight and tighten in a criss-cross manner. Final torque to 8 ft/lbs (95 +/- 10 in/lbs).
8. Use High Temp Lubricant (RPI Part #RPL090) or equivalent to lubricate the bonnet o-ring and install into the bonnet manifold.
9. Holding the solenoid bonnet horizontally, load the plunger assembly and thread the solenoid bonnet assembly into the bonnet manifold. Torque to 15 ft/lbs (175 +/- 25 in/lbs).
10. Reassemble the solenoid coil.

RPI PART #AMK221

SOLENOID VALVE REPAIR KIT *(Shown in Dark Blue in Figure 1 on next page)*

REBUILD INSTRUCTIONS FOR S35 VALVE

1. Disassemble the solenoid coil.
2. Unscrew the solenoid bonnet. Remove the plunger assembly and the bonnet o-ring. *Note: If replacing the valve seat, use a 7/16" deep socket wrench for seat removal. Clean manifold cavity and coat the threads of the valve seat (.218" orifice) with Pipe Sealant 567 (RPI Part #RPA459) or equivalent thread sealer. Install and torque to 6 ft/lbs (75 +/- 10 in/lbs).*
3. Clean the manifold and all manifold cavities.
4. Lubricate the bonnet o-ring with High Temp Lubricant (RPI #RPL090) and insert into the manifold. A little extra lube will help hold the o-ring in place while installing the remainder of the parts.
5. Holding the solenoid bonnet horizontally, insert the plunger assembly.
6. Install the solenoid bonnet assembly into the manifold. Torque to 15 ft/lbs (175 +/- 25 in/lbs).
7. Reassemble solenoid coil.

FIGURE 1 - Exploded View of Steam Manifold

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- S35: (1) RPI PART #AMK221 - SOLENOID VALVE REPAIR KIT

• ALSO AVAILABLE:

- RPI PART #AMK215 - SEAT KIT (STEAM)

