



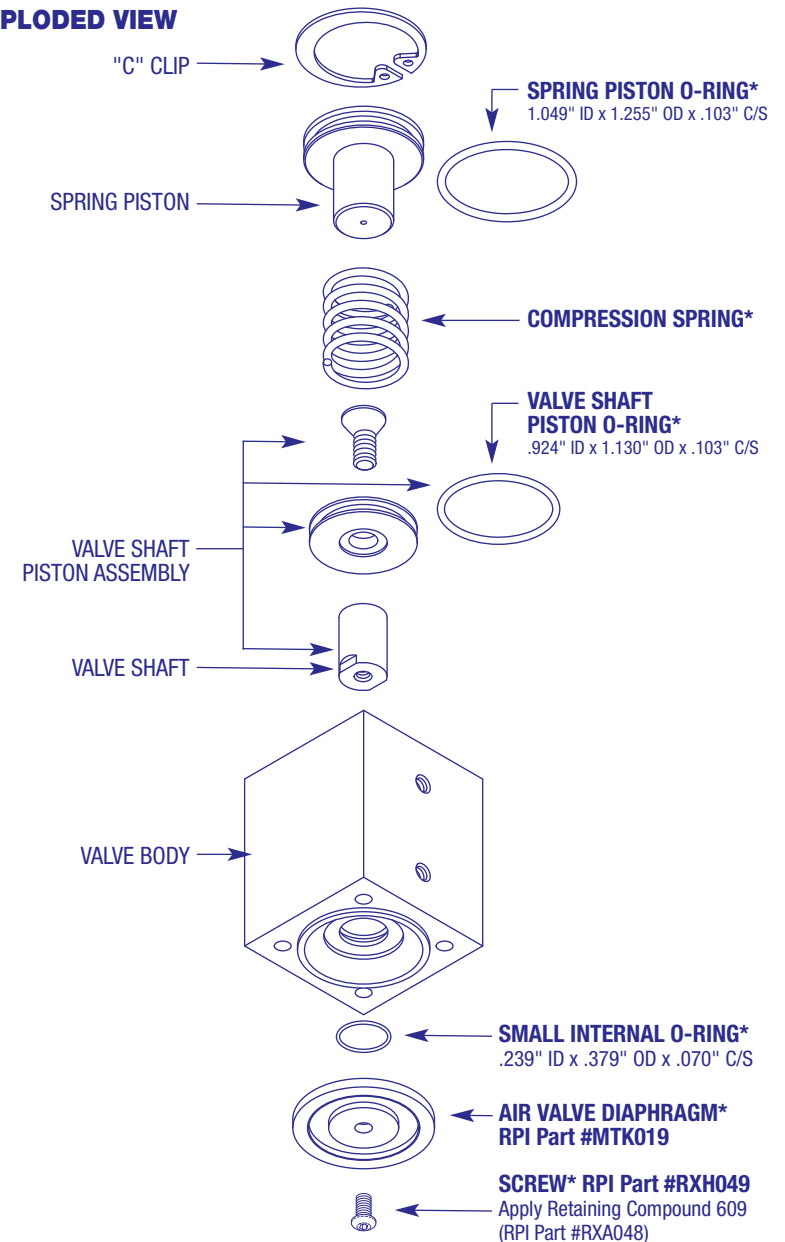
replacement parts industries, inc.

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MTK055 VALVE BLOCK REBUILD KIT INSTALLATION INSTRUCTIONS

- 1) Remove the pneumatic valve from its corresponding manifold. Save the four (4) mounting screws for re-installation.
- 2) If available use the Low Profile Wrench (RPI Part #RXT003) to slide under the air valve diaphragm and hold the valve shaft in place. **NOTE:** To allow for a better visual, it may be easier to pull the old air valve diaphragm off the retaining screw. Use a 3/32" hex key while holding the valve shaft in place to break the center screw loose. If the screw is difficult to loosen, a pair of vice grips may be used on the side of the head of the screw to break the screw free. Do not worry about damage to the screw as a new screw is provided in this kit.
- 3) Once the old screw and air valve diaphragm are removed, clean the valve assembly of any excess Loctite® or debris.
- 4) Turn the pneumatic valve over and remove the "C" clip with a pair of retaining ring pliers. Save the "C" clip for re-assembly.
- 5) Turn the pneumatic valve over again and press the shaft and piston assemblies through the valve body until it is completely out of the valve.
- 6) Remove the small internal o-ring from the pneumatic valve body, which is located internally under the diaphragm and discard.
- 7) Remove the old spring piston o-ring and the valve shaft piston o-ring from the piston and shaft assemblies and discard.
- 8) Using a lint free cloth or foam Q-Tips™, carefully clean all of the o-ring grooves.
- 9) Replace the compression spring and apply a thin coat of Magnalube® (RPI Part #RXL124) to the three (3) new o-rings included in this kit and reinstall in the corresponding locations.
- 10) Apply a generous amount of Magnalube® (RPI Part #RXL124), included in this kit, to the inner diameter bore of the housing.
- 11) Reinstall the shaft and piston assemblies by carefully pressing them back through the pneumatic valve body in the order shown. Reinstall the "C" clip with retaining ring pliers.
- 12) Place the new diaphragm on the pneumatic valve block with the grooved side facing outward. Sparingly apply Retaining Compound 609 (RPI Part #RXA048) to the tip of the Screw (RPI Part #RXH049). Install the screw and tighten until snug. **Caution:** Avoid using a large amount of retaining compound to make removing the screw at the next PM easier. **Do not over tighten** the retaining screw as this may cause the diaphragm to bow or deform and leak.
- 13) Place the pneumatic valve block on the manifold and hold it down while tightening the four (4) mounting screws uniformly in a diagonal pattern. **Do not over tighten** the screws. This may cause the threads in the manifold to strip out or the inserts to come loose.
- 14) Reinstall the pneumatic valve assembly back onto its corresponding manifold.
- 15) Reinstall the manifold assembly and run a test cycle to ensure it is functioning properly.

PNEUMATIC VALVE BLOCK EXPLODED VIEW



* The Valve Block Rebuild Kit (RPI Part #MTK055) includes all of the parts identified in bold type above including the Air Valve Diaphragm, Screw (RPI Part #RXH049), Small Internal O-ring, Valve Shaft O-ring, Spring Piston O-ring, Compression Spring, and the Retaining Compound 609 (RPI Part #RXA048) and Magnalube® (RPI Part #RXL124), which are not shown.