



replacement parts industries, inc.

A Healthcare Components Group Company

CALL 800-221-9723 or 818-882-8611 • FAX 818-882-7028
E-MAIL: techsupport@rpiparts.com • WEBSITE: www.rpiparts.com

VPM198 MUFFLER INSTALLATION INSTRUCTIONS



WARNING: Remove power from the Bison® vacuum unit and move vacuum unit into an open area to give yourself enough room to work.

Top Lid Removal

1. Confirm that power has been removed from the vacuum unit.
2. Loosen the exhaust outlet coupling and separate it from the power unit. If the power unit is equipped with an S-Type Filter, loosen the S-Type Filter exhaust inlet coupling and remove it from the top lid.
3. Remove the oil reservoir fill cap and then the end cap of the drain line. Insert the drain line into your Disposal Bag (RPI Part #RPB838). Open the drain valve and let the oil reservoir drain completely. Close the drain valve and return the end cap to the drain line. If oil cleanup is needed, use the RPI Absorbent Pad (RPI Part #RPP958). Secure the cap on the Disposal Bag and dispose of the used oil per local City, County or State regulations.
4. Remove the (14) lid screws and save for replacement in future steps.
5. **Note:** Check the exhaust outlet and oil fill orientation before lifting the lid off. **Tech Tip:** Place a piece of tape on the top deck and fold it over to the reservoir side to remind you of the proper orientation of the lid and reservoir before you lift the lid off.
6. Use a utility knife to cut the sealant bond between the lid and the oil reservoir. **Caution:** Do not pry the lid off, until you have cut through the sealant completely on all four sides. **Note:** You will also cut through the piece of tape you used to mark the proper orientation of the lid and reservoir.
7. Remove all sealant from the underside of the lid and the reservoir lip. This is very important for a tight oil seal upon reassembly.
8. Clean out all debris and wipe down the inside of the oil reservoir.

Muffler (RPI Part #VPM198) Replacement

(For the Bison 7 & 9, the following steps apply to both mufflers)

9. Remove the hose clamp from the exhaust elbow and muffler shroud. Note the orientation of the muffler shroud for proper installation later.
10. Remove the muffler shroud screw and then remove the muffler shroud. Save both parts to reinstall later.
11. Using two pipe wrenches, one to remove the muffler, the other wrench is to counter the force of the first wrench to avoid breaking any welds.
12. Remove any RTV from the exhaust elbow and muffler shroud. Clean out any debris from the oil reservoir.
13. Install the new muffler into the exhaust elbow hand tight. **Do not use thread sealant.**
14. Apply Threadlocker 242 (RPI Part #RPA032) to the muffler shroud screw and attach the shroud to the muffler, maintaining a slightly tipped orientation. **See Figure 1 for models with 1 muffler (Bison 3 & 5) and see Figure 2 for models with 2 mufflers (Bison 7 & 9).**

15. Install the hose clamp over the muffler shroud and the exhaust elbow. Tighten securely.

Top Lid Replacement

16. Using an oil resistant sealant, such as the RPI Instant Gasket Sealant (RPI Part #RXS087), carefully apply a 1/8" bead of the gasket sealant to the reservoir lip with a generous bead around the screw holes.
17. Properly orient the top lid down onto the oil reservoir. Match up the tape you applied in **Step 5**.
18. Reinstall the (14) screws removed in **Step 4** and tighten down completely. Be careful not to strip out the mounting holes.
19. Trim and remove any excess instant gasket sealant that might have oozed out between the top lid and the oil reservoir.
20. Make sure the oil drain valve is still closed and fill the oil reservoir to the proper level, approximately 5 quarts of Synthetic Oil (Mobil 1®) (RPI Part #VPL131).
21. Return the vacuum unit to its original location. Reattach the exhaust outlet or the S-Type Filter and restore power to the vacuum unit.
22. Check for proper operation and check for any oil leaks.

Figure 1 - Bison 3 & 5 Vacuum Units

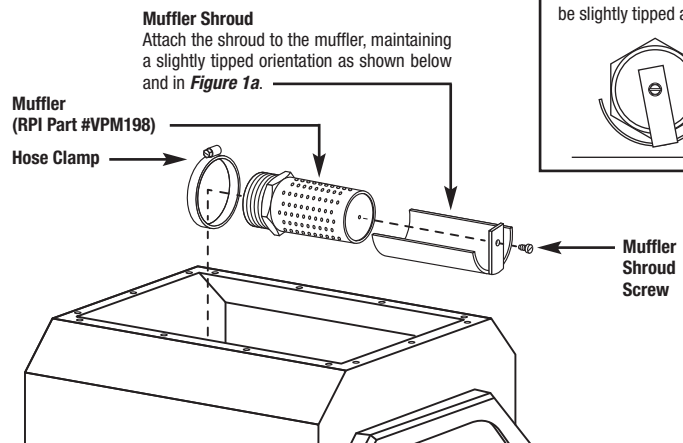


Figure 2 - Bison 7 & 9 Vacuum Units

