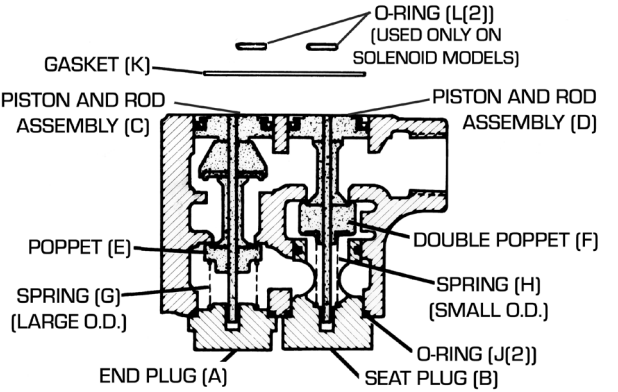
VALVE BODY SERVICE KIT
27 SERIES POPPET – 4-WAY
BASIC SIZE 3/8

PIPE SIZE
1/4, 3/8, 1/2

KIT NUMBER
492K87

Please read and make sure you understand all required instructions before proceeding with the valve service.
If you need additional information or have any questions about servicing your valve, please call ROSS Technical Services at: 1-888-TEK-ROSS (835-7677) or visit www.rosscontrols.com for additional contact information.



Note: This kit may contain parts not required to service your valve.

1. Open the electric supply (if any) to the valve. Shut off and exhaust the air supply.
2. Disassemble valve body assembly, discard all internal parts, and thoroughly clean and dry body.
3. Lightly lubricate piston bores and bearings in end cap (A) and seat plug (B). Lubricate rods and seals on piston and rod assemblies (C and D).
4. Insert piston and rod assembly (C) and piston and rod assembly (D) into appropriate bore.
5. Push poppet (E) onto piston rod and double poppet (F) onto piston rod.
6. Insert springs (G and H).
7. Place O-rings (J) into position - insert and fasten end plug (A) and seat plug (B).
8. Depress both pistons several times - parts must move and return freely.
9. Complete assembly by installing gasket (K) (or O-ring (L) on solenoid model) and attach prior removed module(s).
10. Reconnect air and electric supply and check for correct operation.