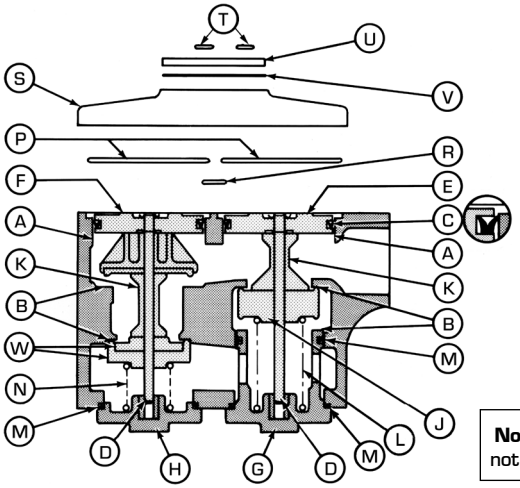
VALVE BODY SERVICE KIT
27 SERIES POPPET – 4-WAY
BASIC SIZE 3/4 & 1¼

PIPE SIZE	KIT NUMBER
1/2, 3/4, 1	493K87
1, 1¼, 1½	494K87

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. Turn off electrical supply (if any) to the valve. Shut off and exhaust the air supply.
2. Remove pilot assembly or air head and adaptor (U).
3. Disassemble the valve body assembly. Discard all internal parts.
4. Thoroughly clean and dry the valve body.
5. Inspect piston bores (A) and poppet seats (B). Do not rebuild the valve if any are worn or damaged.
6. Lightly lubricate piston bores (A), piston seals (C), rod ends (D) of piston assemblies (E and F), and bearings in seat plug (G) and end plug (H).
7. Install piston assembly (E) and piston poppet assembly (F) into the appropriate bores so that they are flush with the top of the valve body.
8. Push double poppet (J) onto rod of piston assembly (E) until it contacts spacer (K). Push two-piece poppet (W) onto rod of piston poppet assembly (F) until it contacts spacer (K).
9. Replace O-rings (M) on seat plug (G). Install longer spring (L). Install and fasten seat plug.
10. Replace O-rings (M) on end plug (H). Install shorter spring (N). Install and fasten end plug.
11. Depress piston assemblies (E and F) several times. They must move and return freely.
12. Install O-rings (P and R) and attach adaptors (S).
13. Complete assembly with previously removed modules. On a solenoid valve use gasket (V), adaptor (U), and O-rings (T). On a pressure controlled valve use only gasket (V).
14. Connect air supply and electrical supply (if any) to the valve and check for correct operation before integrating into the system.