VALVE BODY SERVICE KIT

27 SERIES POPPET

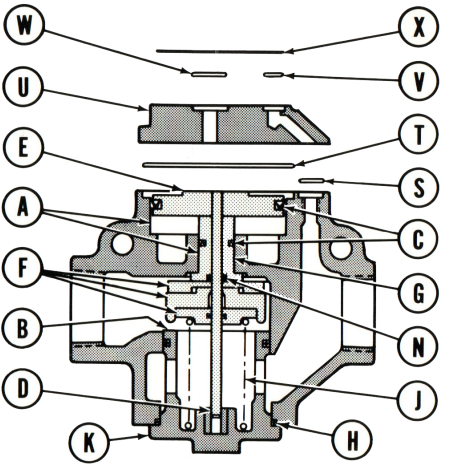
2-WAY – NORMALLY OPEN

Body Size 1¼

PIPE SIZE
1 - 1¼ - 1½

KIT NUMBER
506K87

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 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. Remove and discard all internal parts from valve body assembly. Discard all other O-rings. gaskets. and seals.
4. Thoroughly clean and dry the valve body. Inspect the piston and spacer bores (A) and poppet seats (B). Do not rebuild if any are worn or damaged.
5. Lightly lubricate bores (A). seals (C). rod end (D). and bearing in seat plug (K). Install piston assembly into valve body so that it is flush with top of valve body.
6. Push spacer (G) onto rod until it contacts piston.
7. Orient the pieces of poppet (F) as shown in the diagram. Push onto rod until spacer (G) is contacted. Verify that O-ring (N) is in spacer (G).
8. Install O-ring (H) and spring (J) on seat plug (K).
9. Install and fasten seat plug.
10. Depress piston several times. Parts must move and return freely.
11. Install O-rings (S. T) and attach adaptor (U).
12. Complete assembly with previously removed modules. Use gasket (X) or O-rings (V. W) as needed.
13. Connect air supply and electrical supply (if any) to the valve and check for correct operation before integrating into the system.