

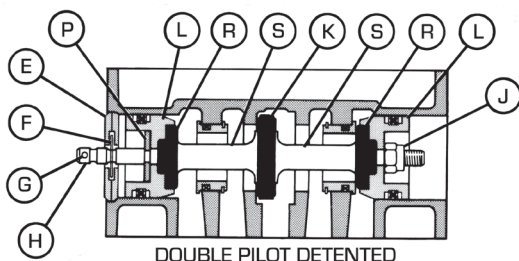
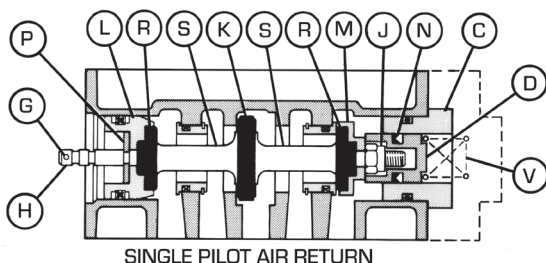
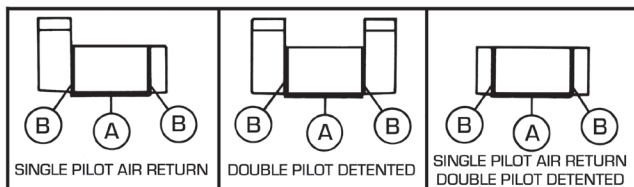
VALVE BODY SERVICE KIT

W74 SERIES ANSI VALVES

KIT NUMBER 615K77, 2607H77

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 valve from base and discard body-to-base gasket (A).
3. Remove pilot assemblies and/or end caps. Discard gaskets (B).
4. On single piloted valves remove guide (C), piston (D), and return spring (V).
5. On double piloted valves remove spacers (E) and spring detent (F).
6. Insert pin in .110 dia. hole (G) in spindle (H) to hold spindle while removing locknut (J).
7. Remove spindle allowing center poppet (K) to fallout.
8. On single piloted valves remove piston (L) and poppet (M). Discard piston (L) and seals (R).
9. On double piloted valves remove pistons (L). Discard pistons (L) and seals (R).
10. Clean and examine piston bores. If worn or damaged do not rebuild.
11. Replace U-cup (N) on piston (D). Lubricate before assembling into the valve.
12. Assemble retainer washer (P), piston (L), seal (R) and spacer (S) on spindle (H). Place center poppet (K) in valve body with chamfered hole facing end of valve body having a chamfered piston bore.
13. Lubricate chamfered piston bore and carefully insert spindle into bore and through center poppet (K).
14. On single piloted valves assemble poppet (M), seal (R) and spacer (S). Carefully install on threaded end of spindle (H).
15. On double piloted valves assemble piston (L), seal (R) and spacer (S). Lubricate piston bore and carefully install on threaded end of spindle (H).
16. Again using a pin in the spindle hole install and torque lock-nut (J) to 30-35 inch-lb.
17. On single piloted valves install guide (C) and piston (D).
18. Replace gaskets (A, B) according to chart (Z). Install return spring (V) on end piston (D). Install pilots and/or end caps. Attach valve to base.
19. Reconnect air and electric supply (if any) and check valve individually for correct operation (if possible) before integrating into the system.