

# Supplement Sheet FOR MODEL SS5 VALVE GASKET KIT 20100277 FOR MODEL SS10 VALVE GASKET KIT 20102745

GENERAL

This publication provides instructions and details for installing a replacement valve plate assembly on a SS5 or SS10 bare pump.

PARTS LIST

	Bolts (27 ft. lbs.) 1-4 M8 X 65mm 96729348	WARNING HAZARDOUS VOLTAGE AND HIGH PRESSURE AIR. Can cause serious injury or death. Disconnect power and bleed pressure from the tank before servicing.				
	Head	HEAD AND VALVE REMOVAL:				
	1-2 Gasket Head 54571617	<ol> <li>Remove the inlet filter assembly from the head.</li> <li>Ensure all air pressure has been released from the compressor before disconnecting any tube connections or loosening the head screws. Disconnect all tubing attached to the air head</li> </ol>				
	1-1 Ass'y Valve Plate 54701081	<ul> <li>assembly.</li> <li>Remove the air head capscrews and discard. Carefully lift the head and then the valve assembly off the cylinder.</li> <li>Observe the assembly direction of the valve plate before removing from the air head. Make note</li> </ul>				
and the second	1-3 Gasket, Valve Plate 54429600	<ul><li>of this direction in order to reassemble the air head and new valve assembly to the cylinder.</li><li>5. Remove the valve plate gasket from the cylinder. Remove the head gasket from the head. If scrapping is necessary, do so lightly to prevent marring or scratching the sealing surface.</li></ul>				

REF. NO.	Ref. Part d No. Number	DESCRIPTION	SS5 QTY	SS10 QTY		<b>NOTICE:</b> There has been a design change on the head capscrews, torque values and torquing sequence for the SS5 and SS10 bare. The
1-1	54701081	VALVE PLATE ASSY	1	2	-	
1-2	54571617	571617 GASKET, HEAD 429600 GASKET, VALVE PLATE/CYLINDER	1	2		capscrew strength has been increased to 10.9 allowing for higher
1-3	54429600		1	2		torque (27 Ft lbs – 36.6 N-M). This kit includes new grade 10.9
1-4	96729348	BOLT, M8X65MM	6	12	10	capcrews to permit upgrading to the new design.

## SPECIAL NOTICE:

There has been a design change on the SS5 and SS10 valve plate. Early valve plate components were assembled with M3 diameter hardware. Current valve plate components are assembled using M4 diameter hardware. This kit contains a valve plate assembled with M4 hardware. This valve plate will not fit the cylinder of those units originally supplied with an M3 valve plate.

If your unit has a cylinder designed for M3 valve plates you will need to modify it before installing the new M4 valve plate. It will be necessary to perform a simple inspection to determine which cylinder you have.

### **INSPECTION:**

Locate the (4) valve hardware relief holes on top of the cylinder.
 Measure the diameter of the relief holes.

$$.315$$
 inches = M4



### MODIFICATION:

- 1. Mask the cylinder bores and the head bolt holes to prevent metal chips from entering.
- 2. Using a suitable tool (bit, reamer, grinder, etc.), carefully enlarge the diameter of the holes to .315 inches and increase the depth to .22 inches. Be sure to deburr all sharp edges.
- 3. Check for interference by trial fitting the new valve plate assy.



#### VALVE AND HEAD INSTALLATION:

- 1. Position a new valve gasket on the cylinder.
- 2. Carefully install the valve plate on the cylinder with the discharge side facing up.
- 3. Align the new head gasket on the valve assembly.
- 4. Carefully install the head on the valve plate.
- Install the new capscrews finger tight. Cold torque in three –step process, using prescribed criss-cross pattern as shown. Snug capscrews using 15 Ft Lb (20.3N-M) torque setting, Full torque to 27 Ft-Lbs (36.6 N-M). Repeat 27 Ft-Lbs (36.6 N-M) torque.
- 6. After reassembly and testing for leaks, retorque head capscrews to 27 Ft-Lbs (36.6 N-M) using the prescribed criss-cross pattern. Do this while the compressor is still hot (hot torque).



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