

Repair Kit: General Seals

Kit part number VA001-651-79 contains all the general seals for all the control modules.

Instructions:

Pneumatic compartment seals (5, 6, 7, 8 and 9):

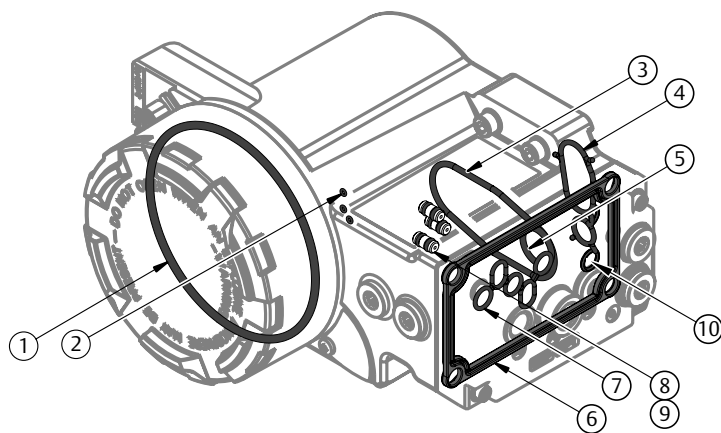
- 1 Remove cover of pneumatic compartment (4x allen key 3mm)
- 2 Remove booster block from cover (3x allen key 3mm)
- 3 Grease all the seals lightly with Lubriplate MAG-1 grease and assemble the seals back in place.
- 4 Mount the booster block to the cover:
 - 3x Allen key 3mm,
 - 1.0 Nm/8.85 lbf.in)

Main cover and pilot valve seals (1 and 2):

- 1 Unlock the lock screw (allen key 2mm) of the main round cover and remove the cover.
- 2 Remove the pilot valve assembly (3x philips head No 2)
- 3 Grease the seals (1 and 2) lightly with Lubriplate MAG-1 grease and assemble the seals back in place.
- 4 Mount the pilot valve assembly and fasten the screws.
 - 3x philips head No 2
 - 1.0 Nm/8.85 lbf.in)
- 5 Place back the main round cover and screw the lock screw hand tight

Actuator interface seals (3, 4 and 5):

- 1 Remove the seals (3, 4 and 5).
- 2 Grease the seals lightly with Lubriplate MAG-1 grease and assemble the seals back in place.



Pos.	Description	Dimensions (mm)	Qty.
1	O-ring Cover	101.2 X 3.53	1x
2	O-ring Pilot Assembly	1.78 X 1.02	4x*
3	O-ring Assembly Cover	55.25 X 2.62	1x
4	O-ring Seal to Actuator		1x
5	O-ring IPT	15.55 X 2.62	1x
6	Seal Pneumatic Cover		1x
7	O-ring Seal Amplifier		1x
8	Tube Connector		4x*
9	O-ring Tube Connector	2.9 X 1.78	8x*
10	O-ring Pneumatic Cover	7.65 X 1.78	2x

Note:

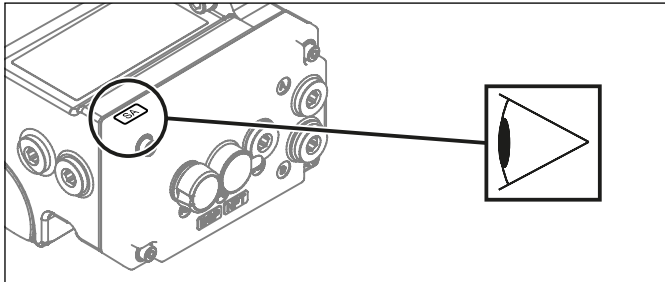
- * 3x for double-acting and single-acting.
- 4x for double-acting spring-return.

Repair Kit: Booster block

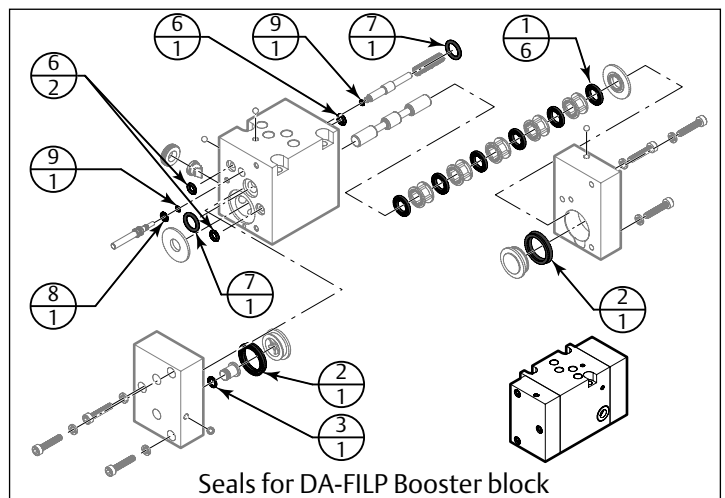
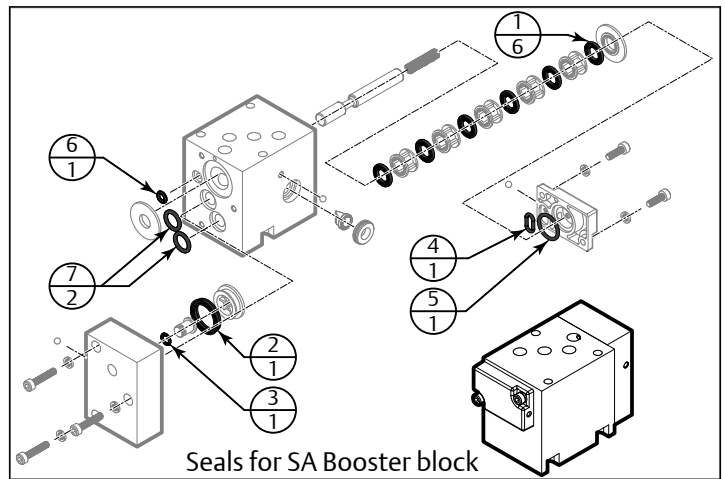
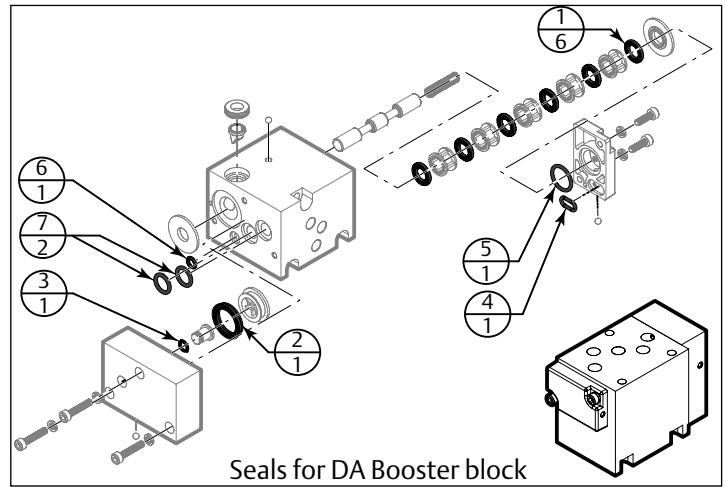
Kit part number VA001-651-81 contains all the seals for Spring Return, Double Acting and Double Acting-FILP booster block.

Instructions:

- 1 Check if the type label reads SA, DA or FILP and replace the seals as indicated in the table.



- 2 Remove cover of pneumatic compartment (4x allen key 3mm)
- 3 Remove booster block from cover (3x allen key 3mm)
- 4 Disassemble the booster block completely (allen key 2.5mm) and remove and discard all the seals.
- 5 Grease all the seals lightly with Lubriplate MAG-1 grease and assemble the seals back in place.
- 6 Reassemble the booster block:
 - Allen key 2.5mm;
 - 0.7-1.0Nm / 6.2-8.85 lbf.in,
- 7 Mount the booster block to the cover:
 - 3x Allen key 3mm,
 - 1.0 Nm/8.85 lbf.in)
- 8 Mount the complete assembly back into the control module.
 - 4x Allen key 3mm
 - Torque: 1.0 Nm/8.85 lbf.in



Pos.	Part # - Description	Qty	Notes
1	Seal NBR 6500-series	6	
2	Plunger seal 6500-series	2	SA&DA need only 1x
3	O-ring NBR70 4,0x1,2	1	
4	O-ring NBR70 6,5x1,5	1	SA&DA only
5	O-ring NBR70 11,5x1,5	1	SA&DA only
6	O-ring NBR70 3,5x1,5	3	SA&DA need only 1x
7	O-ring NBR70 7,65x1,78	2	
8	O-ring NBR70 3,0x1,2	1	FILP only
9	O-ring NBR70 1,3x1,0	2	FILP only

