

Legacy Air Valve and Pilot Valve Repair Kit 220656 for 400, 1200, and 2500 Series Glutton Pumps

405829E

EN

To upgrade existing Glutton pumps to the latest air valve technology, Graco highly recommends using conversion kit 17W667.



IMPORTANT SAFETY INSTRUCTIONS

For complete warnings, refer to the Air-Powered Glutton Pump instruction manual 307843.

NOTE: Parts included in the kit are identified with a part number. Use all the parts in the kit for the best results.



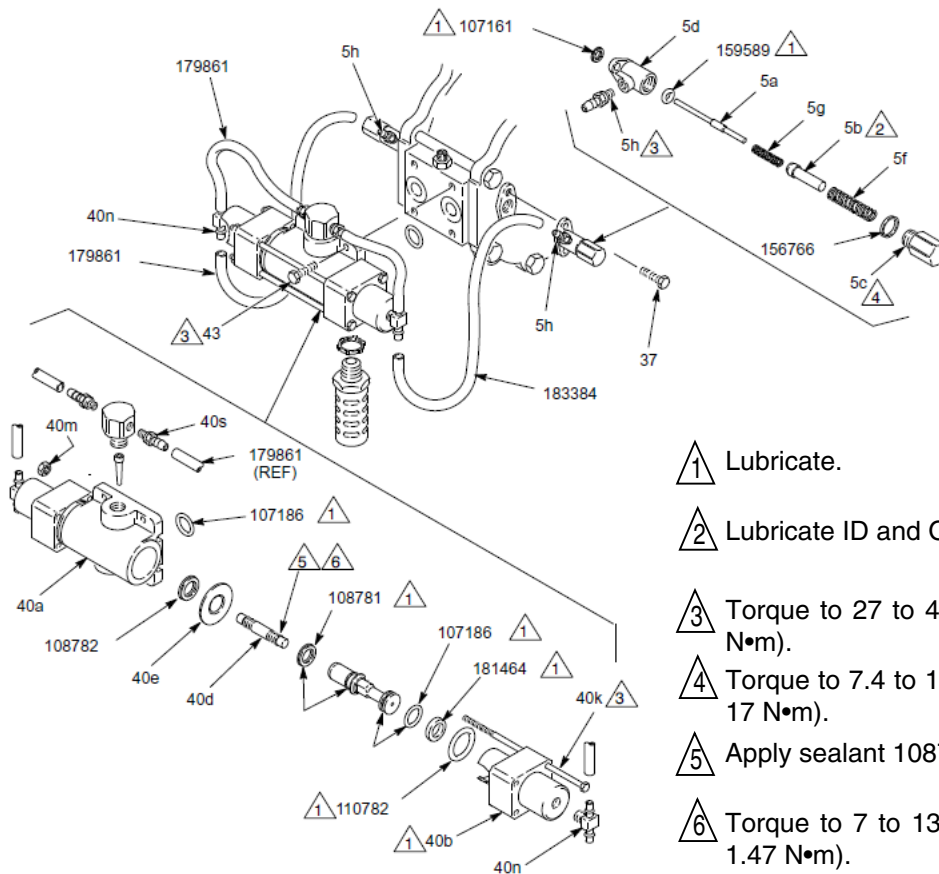
This equipment stays pressurized until pressure is manually relieved. To help prevent serious injury, including skin injection or splashing in the eyes or on the skin, follow the **Pressure Relief Procedure** when you stop pumping and before you clean, check, or service the equipment.

1. Shut off the air supply to the pump.
 2. Hold a metal part of the gun (if used) to a grounded metal pail. Trigger the gun to relieve the pressure.
 3. Open all fluid valves in the system, having a waste container ready to catch the drainage. Leave the drain valves open until you are ready to return to operation.
1. Follow the **Pressure Relief Procedure** above.
 2. Cut a small slit in the tube ends (179861 & 183384) and disconnect them from the pilot valve fittings (5h), air valve tees (40n), and barb fittings (40s).
 3. Unscrew the cap screws (37). Remove the pilot valve housings (5d).
 4. Grease the rod seals (107161). Install one on each side of the pump. Secure the pilot valve housings (5d) to the pump with the cap screws (37).
 5. Unscrew the valve cap (5c) from each valve housing (5d) and remove the parts.
 6. Apply lithium base grease to the inside and outside of the air valve (5b), and to the o-rings and seals.
 7. Install the o-ring (159589). Completely seat the o-ring on the flat in the valve housing (5d). Install the long end of the valve stem (5a) into housing.
 8. Install the small spring (5g) over the valve stem (5a), the air valve (5b) over the spring, and the larger spring (5f) over the air valve.
 9. With the copper gasket (156766) in place on the valve cap (5c), screw the cap onto each of the valve housings (5d). Torque the cap to 7.4 to 12.5 ft-lb (10 to 17 N•m).
 10. Remove the valve end housings (40b) by unscrewing the screws (40k) and nuts (40m).
 11. Center the valve spools in the housing (40a). Remove the spools and stem (40d) by applying opposing force with wrenches on the spool flats.
 12. Apply lithium base grease to all o-rings, u-cups, and gaskets. Complete the spool assembly before installing them.

13. Remove the seal retainers (40e) from each side of the center housing (40a). Replace the u-cup (108782), with lips facing into the housing. Install the retainers with the flat side facing into the housing.
14. Replace spools if they are damaged. Replace the o-ring (107186) and u-cup (108781) on each spool and seat them in the grooves. Install the u-cup with lips facing towards the housing (40a).
15. Apply anaerobic sealant (108754) to the spool stem (40d) threads. Remove excess sealant.
16. Thread one spool onto the stem (40d) and insert it into the center housing (40a). Be careful not to dislodge the u-cups (108782) and retainers (40e). Thread the other spool onto the stem. With wrenches on flats of spools, apply opposing force and tighten until snug, 7 to 13 in-lb (0.79 to 1.47 N•m).

17. Replace the gasket (181464) in each end housing (40b) and the o-ring (110782) on each end housing shoulder.
18. With the mufflers facing down, install the end housings (40b), onto the center housing (40a). Be careful not to move the spool and dislodge the u-cups (108782) and retainers (40e). Secure the end housings with four screws (40k) and nuts (40m), torquing them to 27 to 45 in-lb (3 to 5 N•m).
19. Replace the two o-rings (107186) in the center housing (40a).
20. Install the air valve on pump with four cap screws (43) and torque alternately and evenly to 27 to 45 in-lb (3 to 5 N•m).
21. Connect the new tubes (179861 & 183384) to the pilot valve fittings (5h), air valve tees (40n), and barb fittings (40s).

NOTE: Do not overtighten the spools, as this can shear the spool threads.



- 1 Lubricate.
- 2 Lubricate ID and OD.
- 3 Torque to 27 to 45 in-lb (3 to 5 N•m).
- 4 Torque to 7.4 to 12.5 ft-lb (10 to 17 N•m).
- 5 Apply sealant 108754.
- 6 Torque to 7 to 13 in-lb (0.79 to 1.47 N•m).

All written and visual data contained in this document reflects the latest product information available at the time of publication. Graco reserves the right to make changes at any time without notice. This manual contains English. MM 405829

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