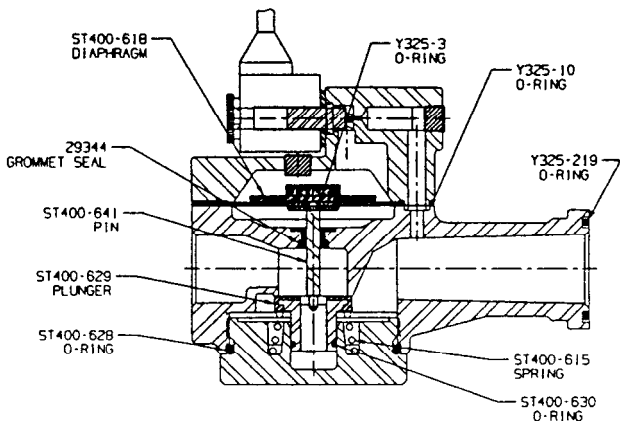


Genuine

Ingersoll-Rand Replacement Parts

ST400-K619 TUNE-UP KIT

This Tune-up Kit services the ST400-A339 and ST400-A339M Diaphragm Valve



(Dwg. TPA1517)

This GENUINE Ingersoll-Rand Tune-up Kit contains the following parts:

PART NUMBER	PART NAME (Description)	QUANTITY
ST400-618	Diaphragm	1
Y325-3	O-ring (Buna-N)	1
Y325-10	O-ring (Buna-N)	1
ST400-615	Spring	1
ST400-630	O-ring (Buna-N)	1
ST400-628	O-ring (Buna-N)	1
ST400-629	Plunger	1
ST400-641	Stem	1
29344	Grommet Seal (Buna-N)	1
Y325-219	O-ring (Buna-N)	1
SRV-GR55*	Grease	1

* Not Illustrated

For further information, refer to the following forms:

Model	ST400
Parts List	P7061

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(OVER)
Form K7061
Edition 1
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WARNING

Always wear eye protection when performing any maintenance on this valve. Always turn off the air supply and disconnect the air supply before installing or removing any component on this valve, before making any adjustments on this valve or before performing any maintenance on this valve.

DISASSEMBLY

General Information

1. Do not disassemble the valve any further than necessary to replace worn parts.
2. When grasping a part in a vise, always use leather-covered or copper-covered vise jaws to protect the surface of the part and help prevent distortion. This is particularly true of threaded members.
3. Do not remove any part which is a press fit in or on a subassembly unless the removal of that part is necessary for replacement or repairs.
4. Always have a complete set of seals and O-rings on hand before starting any overhaul valve. Never reuse old seals or gaskets.

Disassembly of the Valve

1. Remove the six cover Screws from the Cover and Valve Housing. Remove the Housing Cover from the Valve Assembly.
2. Remove the Diaphragm (ST400-618) from the Valve Housing and the O-ring (Y325-3) from the pocket in the Valve Housing.
3. Unscrew the Cap from the Valve Housing. Remove the O-ring (ST400-628) from the Cap. The Spring (ST400-615) and Plunger (ST400-629) should come out with the Cap. If not, remove them from the Valve Housing.
4. Remove the Grommet Seal (29344) from the Valve Housing.

ASSEMBLY

General Instructions

1. Whenever grasping a valve or part in a vise, always use leather-covered or copper-covered vise jaws. Take extra care with threaded parts or housings.
2. Apply a film of grease (SRV-GR55) to all O-rings before final assembly.

Assembly of the Valve

1. Insert the rounded end of the Grommet Seal (29344) in the top of the Valve Housing through the valve body hole. The top can be identified by the concentric raised rings.
2. Lubricate the O-rings on the Valve Stem (ST400-641) and Plunger (ST400-629) with grease (SRV-GR55). Push this assembly through the Grommet Seal from the bottom of the Valve so that the Plunger seals on the valve seat.
3. Turn the Valve Housing over and place the Spring (ST400-615) on the Plunger with the smaller diameter of the Spring seated on the plunger.
4. Place the large O-ring (ST400-628) on the Cap. Guide the Spring and Plunger into the Cap while screwing the Cap into the Valve Housing. Tighten the Cap until it seats snugly against the Valve Housing.
5. Place the O-ring (Y325-3) into the pocket of the Valve Housing.
6. Place the Diaphragm (ST400-618) on the Valve Housing, making sure that the punched hole of the Diaphragm is aligned over the O-ring and that the plastic disk of the Diaphragm is up.
7. Set the Housing Cover on the Valve Body so that the O-ring shoulder fits into the diaphragm hole.
8. Attach the six Cover Screws through the Cover and Diaphragm and into the Housing. Alternately tighten the Screws to 45-55 in-lb (5.1-6.1 Nm) torque.