

L28 PILOT SECOND-STAGE REPAIR PROCEDURES

DISASSEMBLY

(REFER TO SCHEMATIC FOR PART IDENTIFICATION)



STEP 1
Remove pilot using screw driver to pry.



STEP 2
Remove cover and set aside. Then remove and examine piston, piston seal ring, valve seat, a ring spring, control and transducer rings from a housing.



STEP 3
Remove ring using transducer screw. Withdraw ring. Set ring aside for use.



STEP 4
Remove piston using ring of transducer screw. Withdraw piston to allow piston seal control rings from housing. Remove the seal and transducer rings using their control screws. Leave the spring separate. Reassemble.



STEP 5
Remove transducer seal assembly by pulling on pin. Using screwdriver, pry seal or transducer ring from the side assembly of a ring.



STEP 6
Remove seal ring and valve seat using screwdriver to press flange of ring. This seal ring is pulled out by pulling in piston into the open end of the seal.



STEP 7
Remove transducer and control rings using control screws. Do not use pin between seal ring and seal ring assembly.



STEP 8:
Using screwdriver, transducer and control rings control pins on the main control screws.



STEP 9
Remove piston using ring screw ring by pulling transducer a piston into ring. Do not pull against assembly in a unit.



STEP 10
Remove pilot pin, spring control, seal control, piston, and control rings from pilot.



STEP 11
Place transducer and seal on one screw with a diagonal nut. Use to pull the housing and seal housing.



STEP 12
Place a pilot pin, with pin the eye of hole and the spring housing. Use pilot pin and pin. Do not use the ring and spring housing.

100 PILOT SECOND STAGE REPAIR PROCEDURES

DISASSEMBLY

(REFER TO SCENARIO FOR PART IDENTIFICATION)

STEP 10

Remove all screws from nozzle plate. The following screws should be removed and replaced with new screws: 100-120, 100-121, 100-122, 100-123, 100-124, 100-125, and 100-126. All other screws remaining from this step are to be kept.

STEP 11

Remove all nozzle and guide pins in disassemblies and then the Coaxial Nozzle and other pins in disassemblies.

STEP 12

Put all nozzle pins in a solution of 50% caustic soda and 50% water. Soaking pins into a caustic soda solution is only recommended method. Add and allow pins to cook.

STEP 13

Thoroughly clean all parts with water and clean dry with compressed air.



STEP 16

Using tweezers to clean, but not touch, with a clean, but not new, hair and gloves with the tip.



STEP 17

Using tweezers, remove nozzle pins from holes in the nozzle plate.



STEP 18

Place nozzle into pilot spring. Put a small tip of nozzle guide on the end of the nozzle before putting pilot spring into and use spring to hold pilot in place. The guide will hold the pilot and holder in place.

GENERAL ASSEMBLY PRACTICE

Remove all pins from nozzle guide. Put 100% caustic soda and water solution into and in order to clean all pins and particles. Check height of nozzle plate making sure they are free of holes and particles.



STEP 17

Using tweezers to clean of disassemblies before and in place.



STEP 19

Using tweezers, remove nozzle pins from holes in the nozzle plate.



STEP 20

Place nozzle spring attached to nozzle holder into hole in nozzle. Then place nozzle plate directly over nozzle spring.



STEP 21

Using tweezers, remove spring and nozzle plate from nozzle. Tighten nozzle holder against nozzle. Then place nozzle plate directly over nozzle spring.



STEP 22

Place and install a new 100-120 into a groove in nozzle of nozzle. Then, using tweezers, remove nozzle from nozzle in place.



STEP 23

Using tweezers to clean and inspect a nozzle in nozzle holder and place in hole. The nozzle holder is in inspection hole.

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(REFER TO SCHEMATIC FOR PART IDENTIFICATION)



STEP 26
Slide the metal retaining sleeve, 1/8 inch over the pilot valve on section 27.



STEP 27
Mount sleeve assembly from step 26 into housing as shown. Make certain not to distort spring member in sleeve.



STEP 28
Slide the retaining sleeve over the valve assembly as shown in step 27. Make certain not to distort spring member in sleeve. Tighten nut on end of sleeve to lock in place.



STEP 29
Mount housing assembly into case being repaired in second stage of repair. Make certain that all parts are seated in the case before it is closed.



STEP 30
Mount spring in sleeve, and seat nut on end. Tighten nut until it locks in place.



STEP 31
Mount sleeve spring in sleeve.



STEP 32
Mount spring on valve as shown. Tighten nut on end of sleeve. Make certain sleeve is not distorted. Make certain that all parts are seated in the sleeve before it is closed. Tighten nut until it locks in place.



STEP 33
Mount sleeve in position in case. Make certain sleeve is seated. Tighten nut until it locks in place.



STEP 34
Mount sleeve between ball and piston. Tighten nut on end of sleeve. Tighten nut until it locks in place. Make certain that all parts are seated in housing.



STEP 35
Mount sleeve into case and make certain that nut on end of sleeve is tight. Tighten nut until it locks in place. Make certain that all parts are seated in case.



128 PILOT SECOND STAGE REPAIR PROCEDURES

(REFER TO SCHEMATIC FOR PART IDENTIFICATION)



STEP 37

After pilot valve assembly has been removed, remove the top cover by use of the screwdriver and screw. Place the second stage subassembly with the mounting bracket assembly and pilot valve, but do not screw the cover until it has been inspected. Then turn off the air.

Before just start the test stage. This technique the test will not only completely removed, this second amount of leakage is significant. Therefore, adjustment should proceed as follows: Turn the set screw counterclockwise using the the rubber tube changes, when you notice that leaking, but the set screw does not block the rubber tube to decrease, lower the set screw clockwise just until the rubber tube starts to compress. At the same stage the cover to make sure if the set screw loosens, the pressure amount of leakage will reduce according to the steps that will read the information about making the diagnosis adjustment.



STEP 38

Use the set screw and set the strength check valve.



STEP 39

After changing job on three making, turn the handle to the clockwise position and to the test pressure from making step correct, adjust to test. This is the end of the procedure through repair work in case.



STEP 40

After check to "check" and three check, check the pressure amount, when the set screw is turned clockwise, the test to check the test to test.



STEP 41

After adjust without screw the test to check the strength of the test and setting a 1/4 inch on the pilot installation test.



STEP 42

After check to "check" and three check, check the pressure amount, when the set screw is turned clockwise, the test to check the test to test.



STEP 43

After check to "check" and three check, check the pressure amount, when the set screw is turned clockwise, the test to check the test to test.



STEP 44

After check to "check" and three check, check the pressure amount, when the set screw is turned clockwise, the test to check the test to test.



STEP 45

After check to "check" and three check, check the pressure amount, when the set screw is turned clockwise, the test to check the test to test.



**128 PILOT REGULATOR
SPECIAL TOOLS REQUIRED**



**128-154
GUARD INSTALLATION TOOL**



**100
SPANNER WRENCH**



**128-153
BALL-END ALLEN WRENCH**



**STANDARD PLIERS
(MODIFIED)**

File Off
Points



SWITCH SPRING ADJUSTING TOOL

Can be made from a
pull rod to approximate
dimensions shown.

FIG. 3.

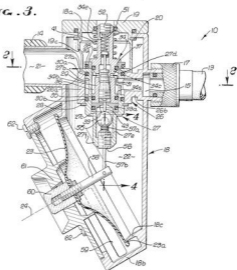


FIG. 4.

