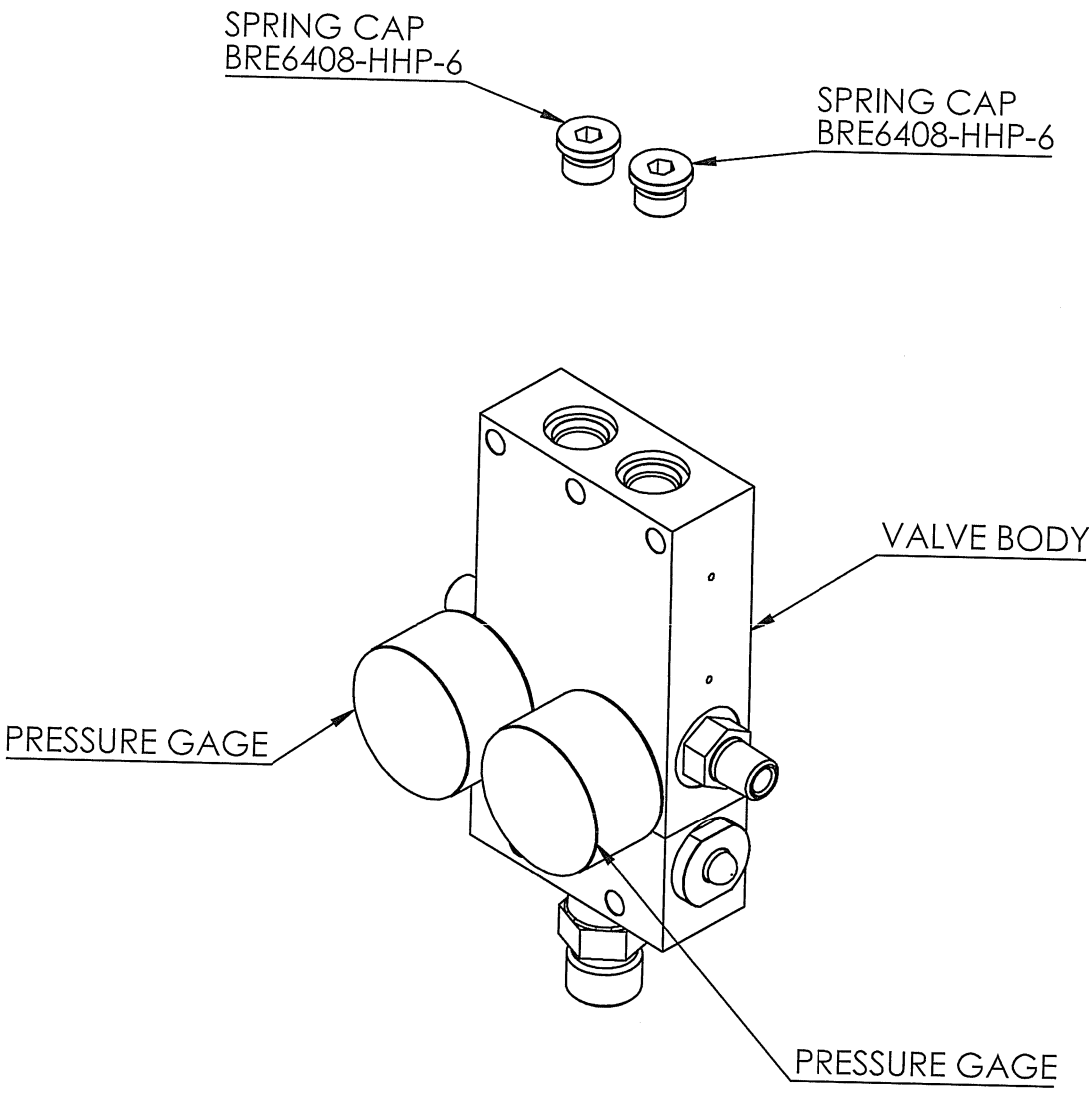
Disassembly Instructions

Note this kit is just to cover if O-rings have failed if there are other problems with the valve such as heavy corrosion or debris in bores just the O-rings may not fix the problem. The Spool bores must be clean and smooth with a mirror like finish and the right size.

1) You may want to put the valve body into a vise for these procedures. Use plastic or a smooth jaw vise so as not to scratch the unit.
2) Remove the two Spring Caps (BRE6408-HHP-6).
    a. **Caution there is spring pressure against this plug so be careful removing. Plug will not fly off if it is held. See figure A-1**
3) Using a wrench remove pressure gages.
4) Turn valve over in vise for access to Cap (20-102).
    a. When turning valve body over springs will slide out of bores on Spring Cap end.
5) As shown in figure A-2 remove the 2 Glands (20-105) with a 22MM wrench.
6) Push out Indicator Spool (20-104) with a plastic or wood dowel or small screw driver handle. See figure A-2.
    a. **Caution do not scratch bore**
7) Remove outlet see Fig A-3.
8) Remove the 6 Cap Screws see Fig A-3.
    a. Cap (20-102) can now be removed.
9) Remove Main Spools (20-103) a shown in Figure A-4.
    a. **Caution push Spool out from Cap side only.**
10) Inspect bores in the Main Body (20-101) and the Cap (20-102) for corrosion, pitting, or heavy scratches.
    a. Any of these issues must be removed to prevent premature failure of O-rings.
    b. If scratches are too deep or pitting has to be removed Body or Cap my need replacement.
    c. If this is the case for failure of valve, the valve in not in a good environment and future failure of the O-ring seals will continue.
11) Remove O-rings from Spools (20-103) and (20-104).
    a. Be careful not to scratch or ding up the Spools.
12) Remove O-rings from Glands (20-105).
13) Put new O-rings on Main Spools (20-103). Requires 6 568-012 5778-90 O-rings from kit in bag marked Main Spool (20-103).
14) Put one O-ring in each groove shown in Figure A-5. Repeat for 2nd Main Spool.
15) Put new O-rings on Indicator Spool (20-104). Requires 1 568-012 5778-90 O-ring and 2 568-010 5611-80 O-rings from kit in bag marked Indicator Spool (20-104).
16) Add O-rings to Indicator Spool (20-104) shown in Figure A-6
17) Add MS-111 grease to each O-ring and use finger to push grease into groove around O-ring.
18) Put new O-rings 568-906 onto Glands (20-105).
    a. Note be careful not to tear O-ring on threads while installing.

Re-assembly

1) With Main Body (20-101) in vise.
2) Push Main Spools (20-103) into bores of Main Body (20-101) from Cap end as shown in Figure A-7
    a. Note this is the end with O-ring grooves.
3) Push Main Spools (20-103) so they are flush with top of Main Body.
4) Add 2 O-rings 568-0016 into grooves on Main Body.
5) The Cap (20-102) is now ready to be placed on Main Body. Use the 6 Cap Screws to bolt Cap down. Shown in Figure A-8
    a. **Make sure both faces of the Cap and Main Body are clean and free of debris.**
    b. **Cap Screws need to be tight.**
    c. **Note make sure to tighten evenly so that Cap is flush with Body.**
6) Now take Indicator Spool (20-104) and put Gland (20-105) on one end. Then put Indicator Spool into bore of Cap and push in until Gland can be threaded into Cap. See Figure A-8.
7) Now thread other Gland into Cap and turn until O-ring touches.
8) Using the 22MM wrench tighten the Glands snug.
    a. **Caution to not over tighten as threads could strip.**
9) Flip over Valve Body in vise, install springs into bores. See Figure A-9
10) Using a ratchet and Allen Key Hex socket push down on Spring Plug (BRE6408-HHP-6) and turn to engage threads and tighten. See Figure A-9
11) Repeat for second Spring Plug.
12) Use thread tape on gage threads and install in Body.
13) With fingers make sure that Indicator Spool will move back and forth.
    a. Note may be tight at first but with a couple of cycles back and forth will loosen up as grease spread out in bore.
14) Now you are ready to hook hoses back on and ready to run.



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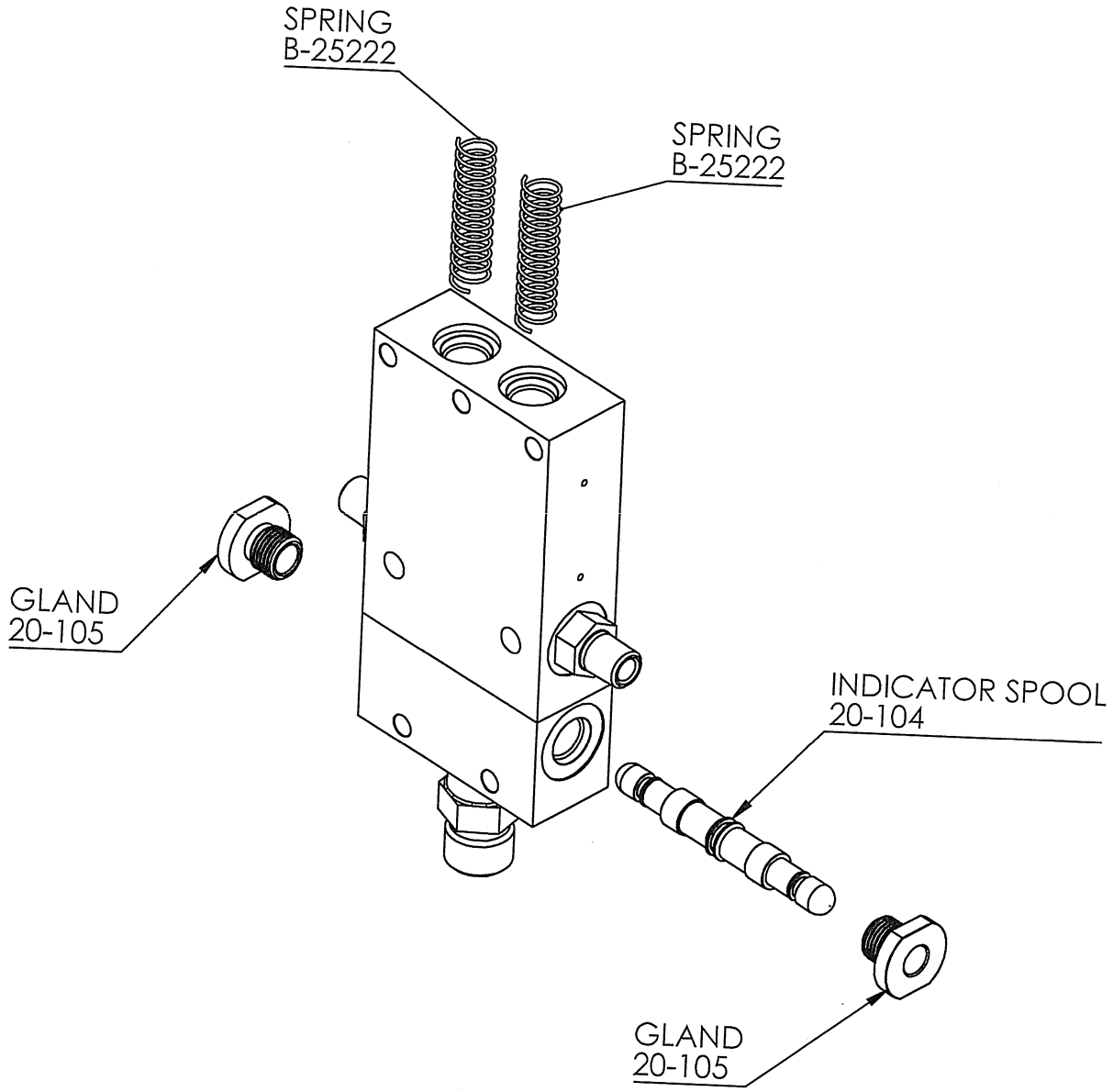
			DRAWN	KEW	1/2020
			CHECKED	KEW	1/2020
			ENG APPR.	KEW	1/2020
			MFG APPR.		
		MATERIAL	Q.A.		
NEXT ASSY	USED ON	FINISH	COMMENTS:		
APPLICATION		DO NOT SCALE DRAWING			

ASSURANCE VALVE SYSTEMS

FIGURE A-1

SIZE	DWG. NO.	REV.
A	ELIMINATOR ASSYEMBLY	1
SCALE:1:5	WEIGHT:	SHEET 1 OF 1



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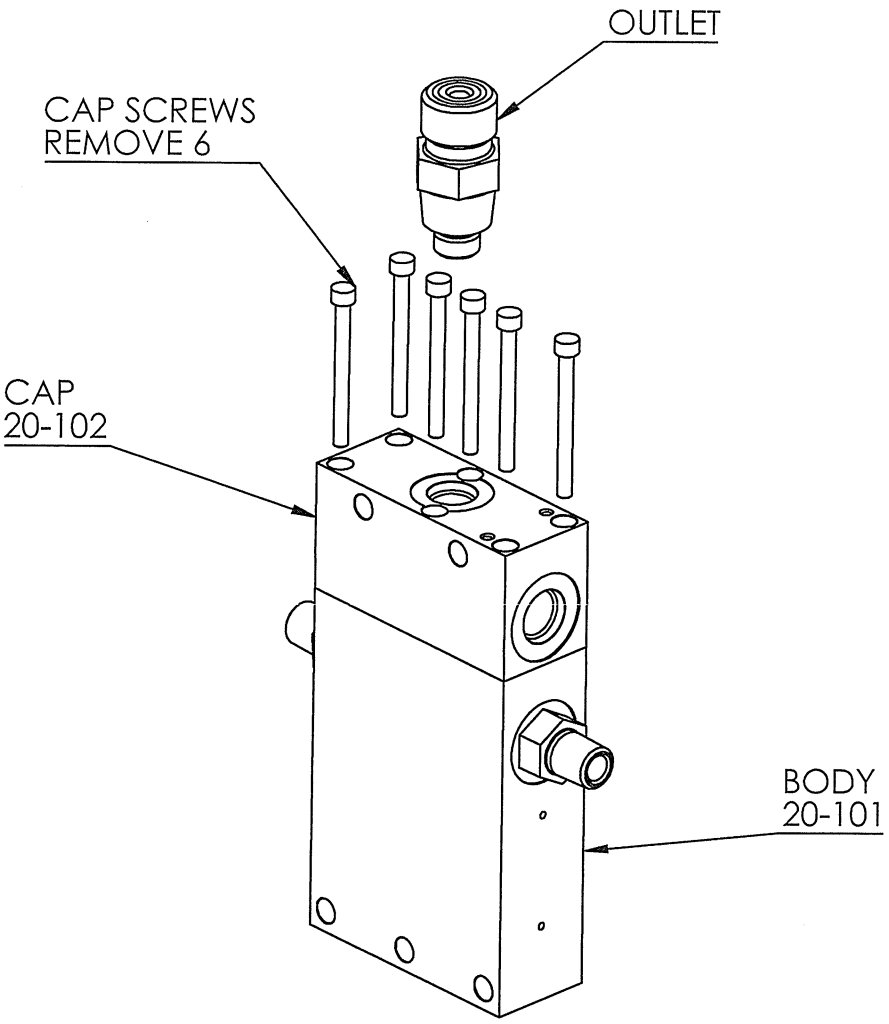
			CHECKED	KEW	1/2020
			ENG APPR.	KEW	1/2020
			MFG APPR.		
		MATERIAL	Q.A.		
NEXT ASSY	USED ON	FINISH	COMMENTS:		
APPLICATION		DO NOT SCALE DRAWING			

ASSURANCE VALVE SYSTEMS

FIGURE A-2

SIZE	DWG. NO.	REV.
A	ELIMINATOR ASSY	1
SCALE:1:5	WEIGHT:	SHEET 1 OF 1



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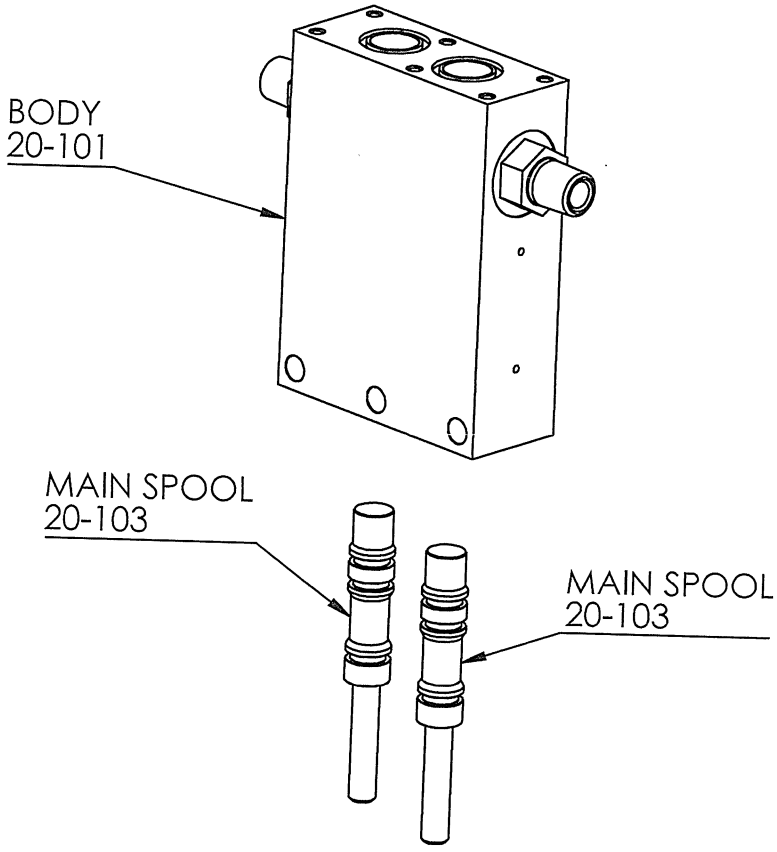
			CHECKED	KEW	1/2020
			ENG APPR.	KEW	1/2020
			MFG APPR.		
		MATERIAL	Q.A.		
			COMMENTS:		
NEXT ASSY	USED ON	FINISH			
APPLICATION		DO NOT SCALE DRAWING			

ASSURANCE VALVE SYSTEMS

FIGURE A-3

SIZE	DWG. NO.	REV.
A	ELIMINATOR ASSY	1
SCALE:1:2	WEIGHT:	SHEET 1 OF 1



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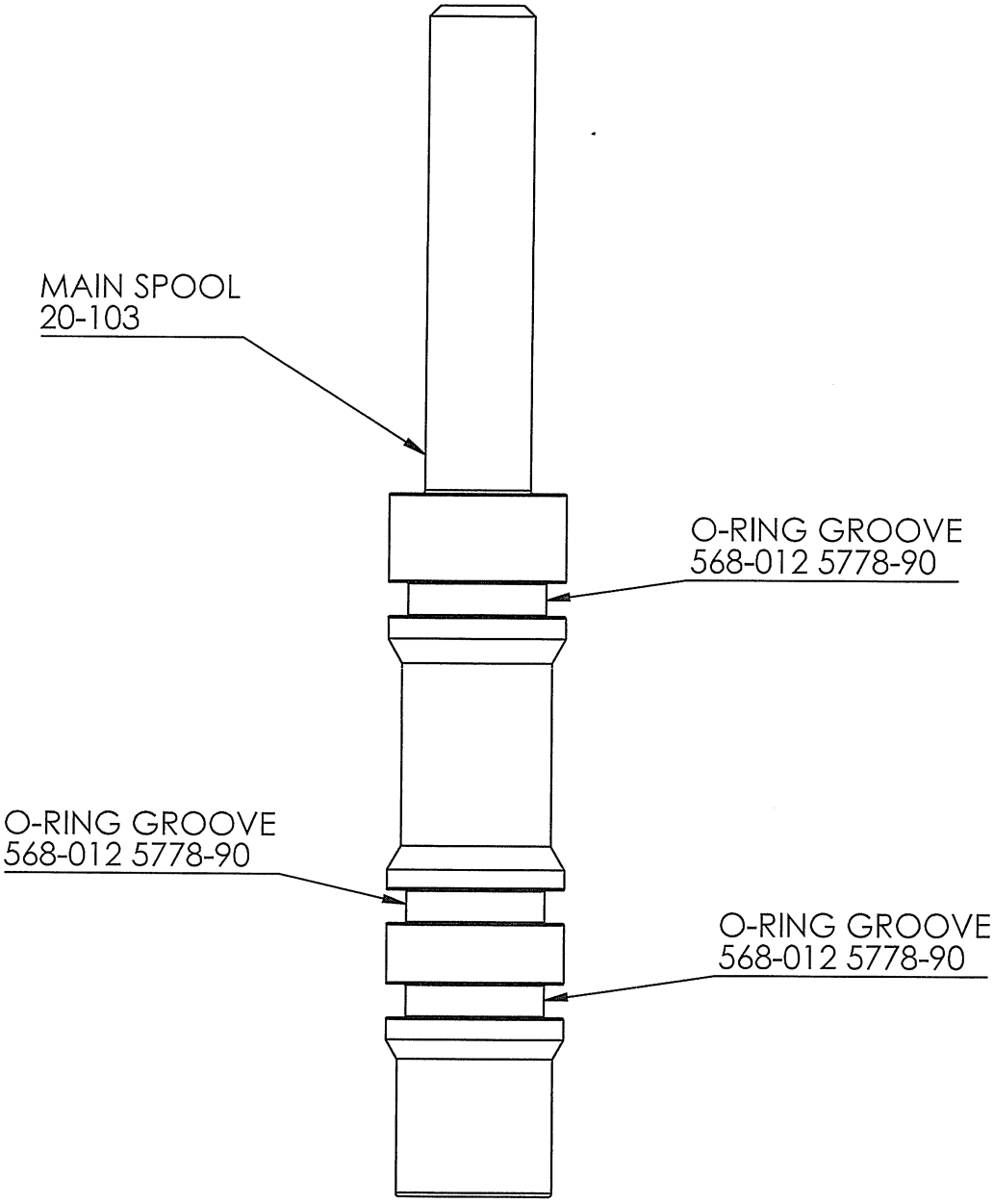
			CHECKED	KEW	1/2020
			ENG APPR.	KEW	1/2020
			MFG APPR.		
		MATERIAL	Q.A.		
NEXT ASSY	USED ON	FINISH	COMMENTS:		
APPLICATION		DO NOT SCALE DRAWING			

ASSURANCE VALVE SYSTEMS

FIGURE A-4

SIZE	DWG. NO.	REV.
A	ELIMINATOR ASSY	1
SCALE:1:2	WEIGHT:	SHEET 1 OF 1



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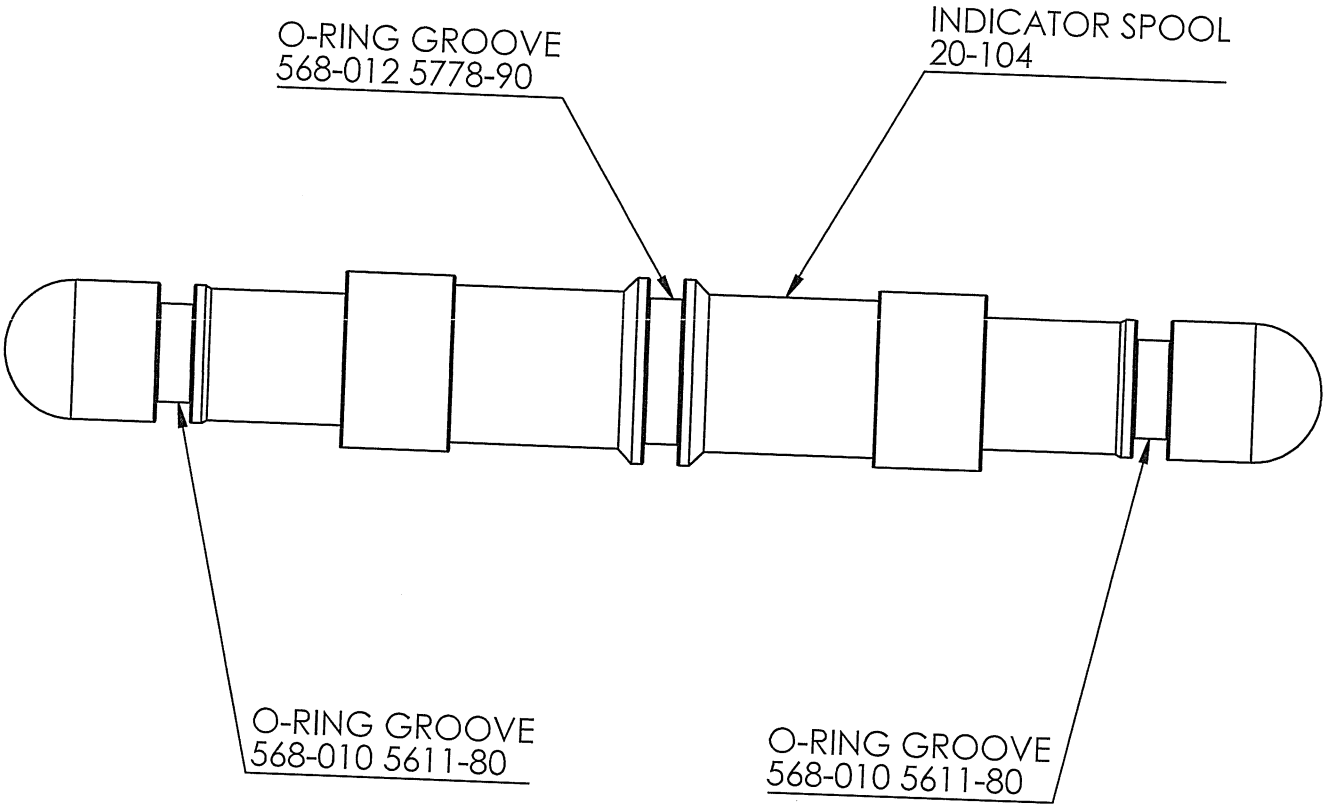
			CHECKED	KEW	1/2020
			ENG APPR.	KEW	1/2020
			MFG APPR.		
		MATERIAL	Q.A.		
NEXT ASSY	USED ON	FINISH	COMMENTS:		
APPLICATION		DO NOT SCALE DRAWING			

ASSURANCE VALVE SYSTEMS

FIGURE A-5

SIZE	DWG. NO.	REV.
A	20-103 O-RING	1
SCALE:1:1	WEIGHT:	SHEET 1 OF 1



NEXT ASSY	USED ON	
APPLICATION		

DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ±
ANGULAR: MACH ± BEND ±
TWO PLACE DECIMAL ±
THREE PLACE DECIMAL ±

MATERIAL

FINISH

DO NOT SCALE DRAWING

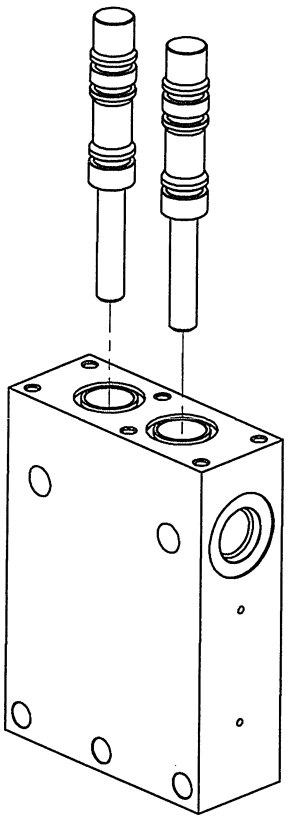
	NAME	DATE
DRAWN	KEW	1/2020
CHECKED	KEW	1/2020
ENG APPR.	KEW	1/2020
MFG APPR.		
Q.A.		

COMMENTS:

ASSURANCE VALVE SYSTEMS

FIGURE A-6

SIZE	DWG. NO.	REV.
A	20-104 O-RING	1
SCALE:1:1	WEIGHT:	SHEET 1 OF 1



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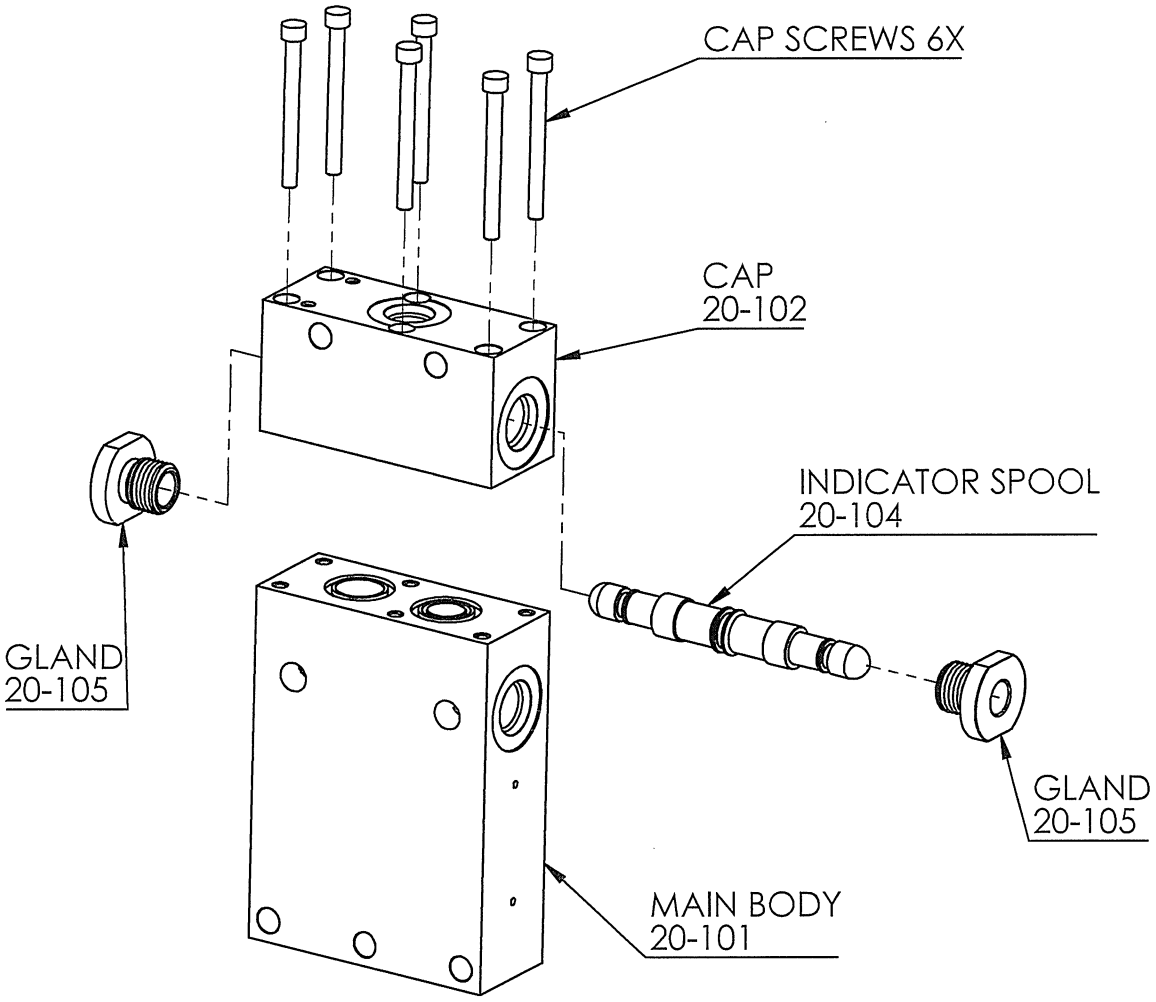
			CHECKED	KEW	1/2020
			ENG APPR.	KEW	1/2020
			MFG APPR.		
		MATERIAL	Q.A.		
			COMMENTS:		
NEXT ASSY	USED ON	FINISH			
APPLICATION		DO NOT SCALE DRAWING			

ASSURANCE VALVE SYSTEMS

FIGURE A-7

SIZE	DWG. NO.	REV.
A	ELIMINATOR ASSY	1
SCALE:1:2	WEIGHT:	SHEET 1 OF 1



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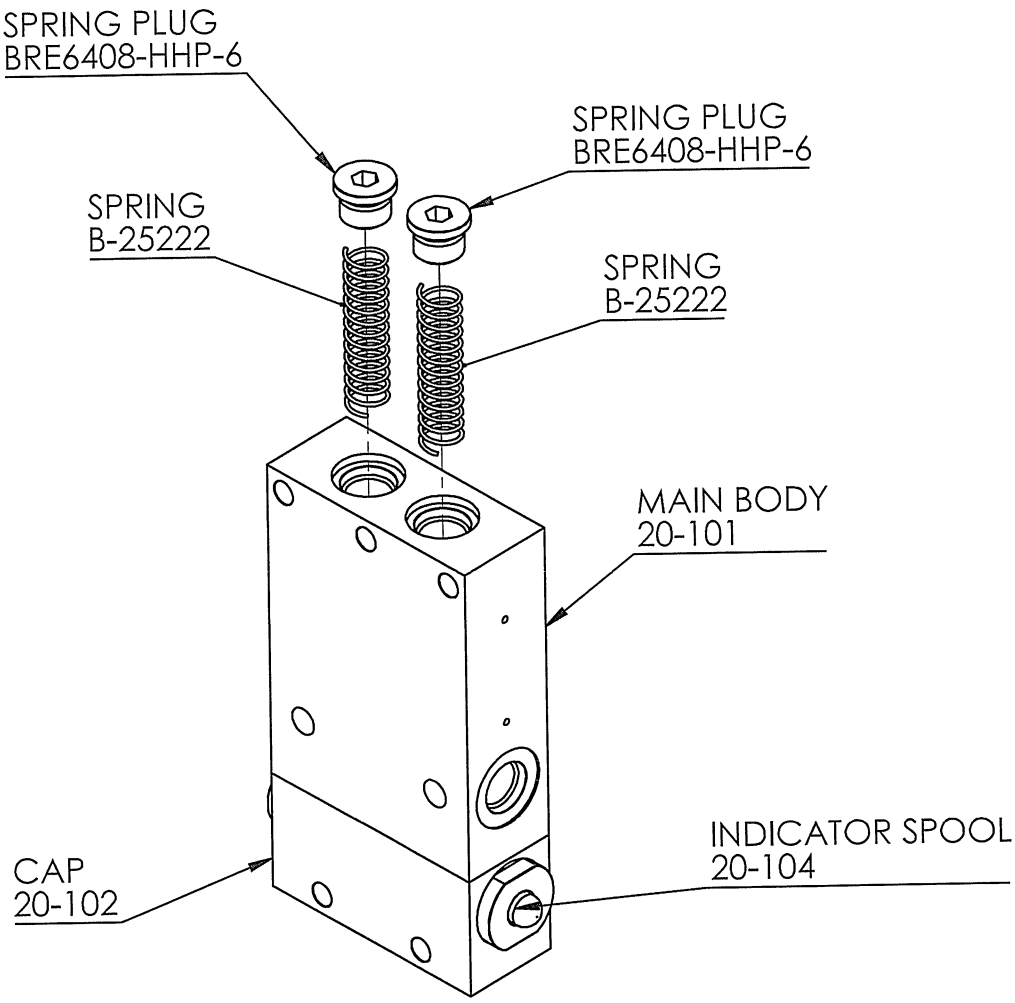
		FRACTIONAL ±	CHECKED	KEW	1/2020
		ANGULAR: MACH ± BEND ±	ENG APPR.	KEW	1/2020
		TWO PLACE DECIMAL ±	MFG APPR.		
		THREE PLACE DECIMAL ±	Q.A.		
		MATERIAL	COMMENTS:		
NEXT ASSY	USED ON	FINISH			
APPLICATION		DO NOT SCALE DRAWING			

ASSURANCE VALVE SYSTEMS

FIGURE A-8

SIZE	DWG. NO.	REV.
A	ELIMINATOR ASSY	1
SCALE:1:5	WEIGHT:	SHEET 1 OF 1



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			CHECKED	KEW	1/2020
			ENG APPR.	KEW	1/2020
			MFG APPR.		
		MATERIAL	Q.A.		
NEXT ASSY	USED ON	FINISH	COMMENTS:		
APPLICATION		DO NOT SCALE DRAWING			

ASSURANCE VALVE SYSTEMS

FIGURE A-9

SIZE	DWG. NO.	REV.
A	ELIMINATOR ASSY	1
SCALE:1:2	WEIGHT:	SHEET 1 OF 1