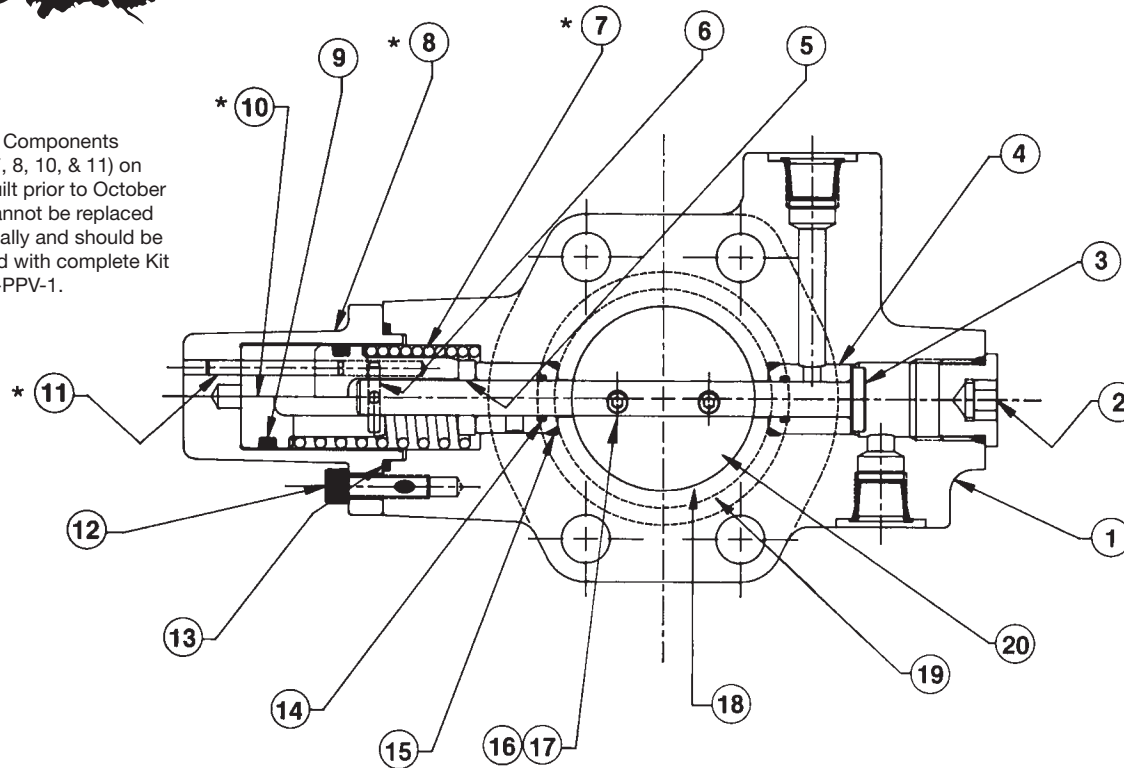




POWR-PRO SERVICE PARTS

Air Cap Components (items 7, 8, 10, & 11) on units built prior to October 1994 cannot be replaced individually and should be replaced with complete Kit No. AK-PPV-1.



Part Numbers shown are for units built AFTER October 1994. Older units are not serviceable except for Air Components.

ASSEMBLY AND DISASSEMBLY NOTES:

1. Removal of the Insert Bushings is not recommended.
2. A light coating of grease should be applied to the Valve Spool before pushing thru O-Rings.
3. The Spool and Lockcollar surfaces must be completely degreased before pressing together. Upon assembly the total spool end play should be between .002-.005 inches (.05-.127 mm).
4. The Throttle Plate should be installed from the front side (Muncie name is cast into this side) in such a way that when

- rotated to the closed position the edge makes contact with the Dowel Pin. Also be sure that the crossdrilled hole in the Spool lines up with the "P" Port, upon final assembly. Lightly tap the Throttle Plate to allow unit to center itself. Torque Nuts and Screws to 18 in.-lbs. (.2 kg-meters).
5. The Air Cylinder should be positioned so that a slight preload of Throttle Plate, in the closed position, is seen. Torque screws to 105 in.-lbs. (1.21 kg-meters).

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1		VALVE BODY
		N.A.	2 inch (50.8 mm)
		N.A.	1-1/2 inch (38.1 mm)
2	1	25T35516	Plug
3	1		SPOOL
		N.A.	2 inch (50.8 mm)
		N.A.	1-1/2 inch (38.1 mm)
4	2	49T35501	Insert Bushing
5	1	N.A.	Locking Collar
6	1	26T35514	Dowel Pin (Short)
7	1	27T36238	Spring
8	1	28T36236	Air Cup
9	1	12T35304	O-Ring (Piston)
10	1	49T36237	Piston
11	1	26T35594	Dowel Pin (Long)
12	2	19T35595	Screw (Air Cup)
13	1	12T36877	O-Ring (Air Cup)
14	2	N.A.	O-Ring (Spool)
15	2	N.A.	O-Ring (Insert)
16	2	19T35518	Screw
17	2	22T35519	Locknut
18	1		RACE
		28T35294	2 inch (50.8 mm)
		28T35287	1-1/2 inch (38.1 mm)
19	1		O-RING (FLANGE)
		12T36867	2 inch (50.8 mm)
		12T36868	1-1/2 inch (38.1 mm)
20	1		THROTTLE PLATE
		49T36066	2 inch (50.8 mm)
		49T36067	1-1/2 inch (38.1 mm)
N.S.	1	N.A.	Dowel Pin (Throttle Plate Stop)
N.S.	1		SEAL KIT
		GSK PPV-32	2 inch (50.8 mm)*
		GSK PPV-24	1-1/2 inch (38.1 mm)*
			*Includes Items 9, 13, 19
N.S.	1	AK-PPV-1	Air Cap Kit Includes Items 7, 8, 9, 10, 11, 13



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