



Gast Compressor Head Rebuild Kit [ACA86075]

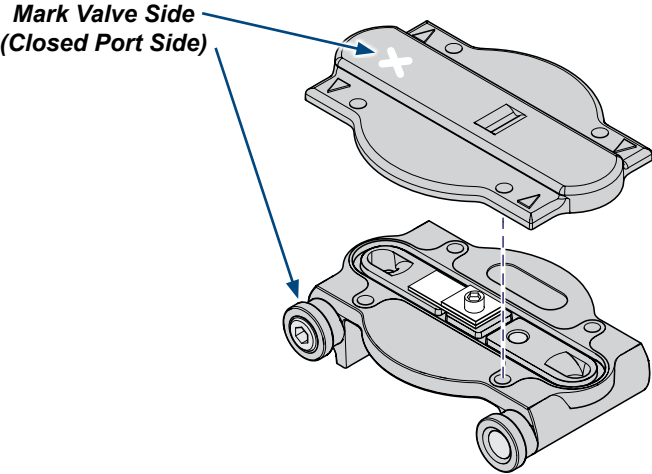
Applies to Models:
AOCRR42DQ, AOCRT22D
AOCRT22DQ, AOCRS11
AOCRS12, AOCRT21Q,
AOCRT21DQ, AOCRT22Q
R22, R42, P21, P22, P32
(with Gast Heads)

Language of origin: English

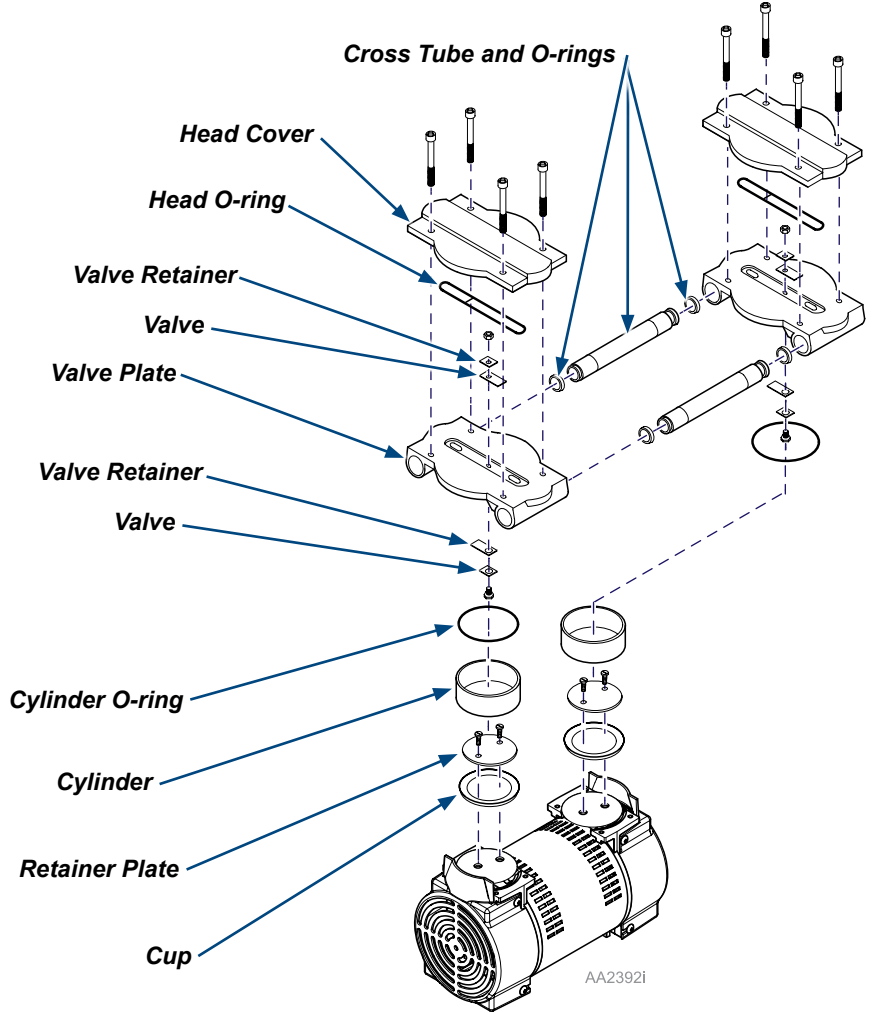
Restrictions:
Rebuild kit for Midmark compressors with Gast head.

WARNING
Disconnect pump at electrical power. Vent air lines to the compressor to remove pressure.

Step 1: Disassemble head...
A) Disconnect supply power. Vent air lines to remove pressure.
B) Remove the head bolts and head covers.
C) Remove and discard valves and valve retainers.
D) Remove cross tubes from valve plates.
E) Remove the cylinders, retainer plates, and cups.
F) Discard cups, cylinder O-rings, head O-rings, and cross tube O-rings.
G) Clean all parts with water based solvent cleaner.



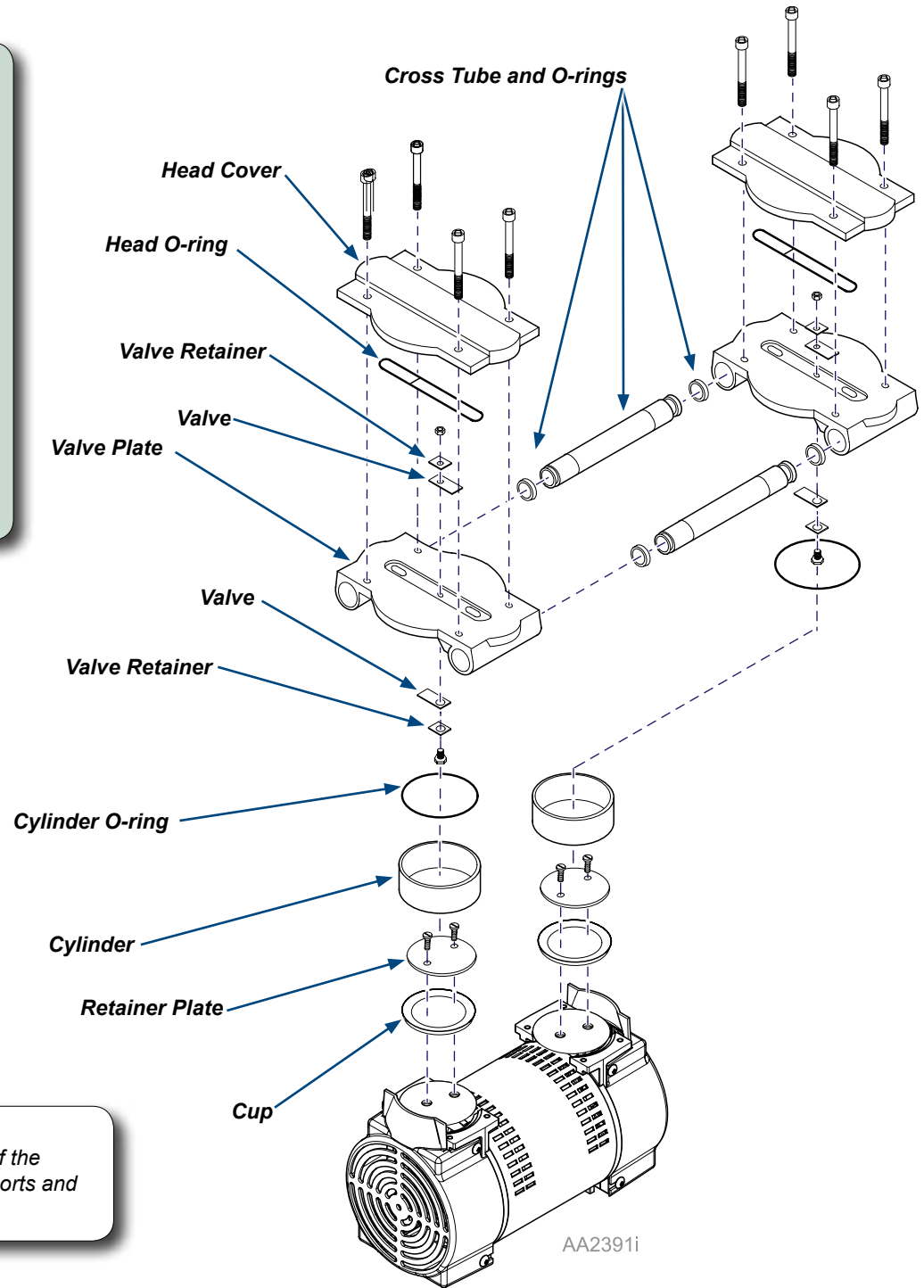
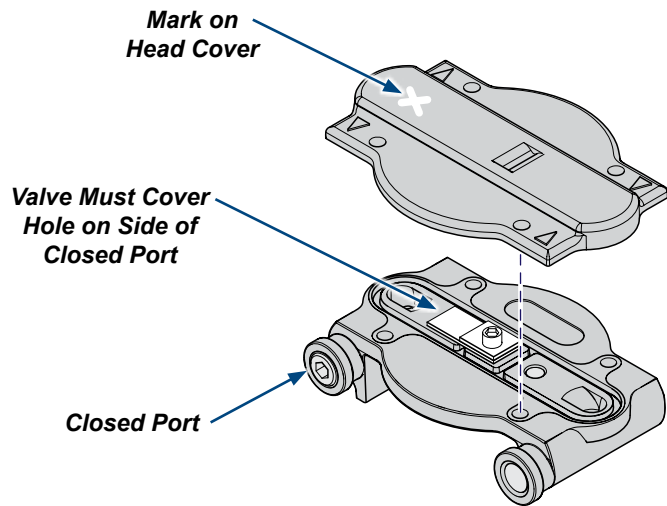
Equipment Alert
Mark the orientation of the head cover before disassembly so it is reassembled correctly later.



TP200 Rev. A

To reassemble head..

- A) Place cups on retainer plates, facing up.
- B) Apply loctite 222 on retainer screws and install retainer plates. Torque to 34-38 in. lbs.
- C) Place cylinders over cups at an angle to avoid damaging.
- D) Clean valves with water based solvent.
- E) Install valves and valve retainers. Torque screw at 11-13 in. lbs. Be careful not to scratch valves.
- F) Install O-rings on tubes and install into valve plates.
- G) Install cylinder O-rings in bottom of valve plates and position the valve plates over the cylinders. Check to ensure the cylinders are aligned with O-ring groove.
- H) Place head O-rings in groove on top of valve plates.
- I) Place the heads over the valve plates. Verify orientation of the ports and torque to 50 in. lbs.
- J) Connect supply power to compressor and check unit for air leaks.



Equipment Alert

Check to ensure proper orientation of the ports. Incorrect placement of the head cover on the valve plate will result in misalignment of the valve ports and valve damage. Damaged valves must be replaced before the pump will operate.