

# Valve Kit 4089554

## For all Twin Cylinder compressors with a 85mm Dia. Piston

Kit contains two unloader valves, two intake valves, two exhaust valves and four exhaust valves screws.  
This kit does not come with the gaskets and bolts needed to reassemble the head.

### Disassembly

1. Remove the six M8 (13mm across hex flats) head bolts, the seven M6 screws and the four M5 exhaust valve screws. **Discard the original bolts.**

### Cleaning

1. Remove gaskets from head and cover. Carefully remove any remaining gasket material and deposits from machined surfaces.
2. Remove any accumulated carbon and varnish by carefully scraping and with light applications of solvents. **Do not scratch or nick the machined areas of the valve sealing surfaces. Avoid** getting debris and solvents into the unloader piston. **The unloaders can not be cleaned or serviced. Avoid** the use of abrasive products similar to "Scotch Brite" because any abrasive grit left after cleaning will shorten the life of **your** compressor.

### Reassembly

1. Torque the exhaust valve screws to **5 Nm  $\pm$ 0.5 Nm** and **Rotate 90° +15° -5°**.
2. Place the head upside down on a Bench to begin the head assembly operation. Place both unloader valves into the recesses so that the unloader pin engages the valve and the valve pivots around the stationary pin near the center of the head. A small amount of Lubriplate grease can be used under the valves to insure they stay in place. **Lubriplate grease is not included in this kit.**
3. Lay the head gasket in place insuring that it fits over the guide bushings and the unloader hole allows communication from the head to the crankcase.
4. Place the inlet valves over the guide pins provided, insuring the pads are up and the valves will lie flat against the head openings. A small amount of Lubriplate grease can be used to insure they remain in place for the remainder of the assembly.
5. Turn the crankcase upside down with the rear (accessory drive end) in the same direction as the inlet air port and carefully place it on the head assembly. As the guide bushings find the counterbores in the crankcase, it will drop into position.
6. Holding the head on the crankcase, turn the assembly right side up. Place the crankcase into an appropriate fixture to begin the head bolt assembly.
7. Follow the instructions in the Head Bolt Kit for proper bolt torque.

