



REXPO

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Pump Bleed-Down Valve Kit (004694-1)

The repair kit includes one of each of the following:

- Seal Hoop (11323)
- Needle (Stem)
- Bleed-Down Valve Assy (11321)
- Bushing
- B305 Lube (28339)
- Oil Seal, BDV (A-4241)
- HP Seat, BDV (11325)
- 12880-908 O-ring
- 12880-912 O-ring
- 11679-114 O-ring
- 11680-114 O-ring

-also needed is the Bleed-Down Valve Tool (12029) (not included)

Kit installation procedure:

1. Shut down the system.
2. Remove the hydraulic hose and gland nut connection from the water drain tubing to the bleed-down valve.
3. Remove the gland nut from the collar at the high-pressure inlet port of the bleed-down valve.
4. Disconnect the actuator housing from the high-pressure valve assembly.
5. Remove the hydraulic fitting from the actuator housing.
6. Push the piston out of the actuator housing through the oil port. Remove and discard the O-ring and backup ring from the piston. Check the piston for any damage. Should there be damage, install a new O-ring and backup ring on the replacement piston in the same order as the old piston.
7. Lubricate the O-ring and backup ring on the piston with standard O-ring lubricant.
8. Insert the piston assembly into the actuator housing. Apply blue goop to the hydraulic fitting and secure it to the end of the actuator housing.

Bleed-Down Valve Body

NOTE: Do not remove the oil seal unless it is damaged or worn.

1. Remove the outlet adaptor and flow reducer from the Bleed-Down Valve Body to gain access to the HP seat. Remove and discard the HP seat. The flow reducer is contained in the end of the outlet adaptor and may fall out during the adaptor



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removal.

2. With the pin end of the BDV tool, push the pin out from the oil seal end to remove the components from the valve body.
3. Inspect the oil seal for damage. If it appears damaged, remove with a pick and press in the replacement oil seal using a vise or small arbor press.
4. Clean the valve body before any new part is installed.
5. Lubricate the stem brushing, seal, and seal hoop with the lubricant from the grease packet.
6. Place the bushing, hoop, and seal on the stepped end of the BDV tool in the order shown to the right.
7. The inner diameter of the valve body has a small step which can pinch or strip the O-ring from the HP seal during installation. To help prevent the O-ring from binding, apply lubricant to the inside of the narrow opening (stepped area) inside the valve body.
8. Insert the tool and parts in the valve body until the tool reaches the bottom of the valve. Remove the tool and inspect the HP seal; look for any pinching or displacement of the O-ring.
9. Apply grease to the stem and insert the stem through the HP seal until it is flush with the oil seal on the other end.
10. Apply blue good to the bottom of the HP seat and install it into the bottom of the bleed-down valve body with the pointed end out.
11. Apply blue goop to the adaptor fitting threads and flow reducer, then thread the fitting into the valve body and torque to 35 ft-lb.
12. Connect the high-pressure valve assembly to the actuator body.
13. Reinstall the bleed-down valve in the machine by attaching the gland nut to the high-pressure collar at the high-pressure port of the valve. Torque the collar nut to 35 ft-lb.
14. Install the gland nut connecting the water drain tubing to the bleed-down valve.
15. Reattach the hydraulic hose to the oil port of the bleed-down valve.
16. Turn on the pump and check for any leakage.

