REXPO
CUTTING & BLASTING SOLUTIONS

How to Repair an AccuStream High-Cycle On/Off Valve Using Kit #13683

These instructions will demonstrate how to replace components of an AccuStream High-Cycle On/Off Valve with kit #13683

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TOOLS:

- 13/16" wrench (1)
- 7/8" wrench (1)
- 1" wrench (1)

PARTS:

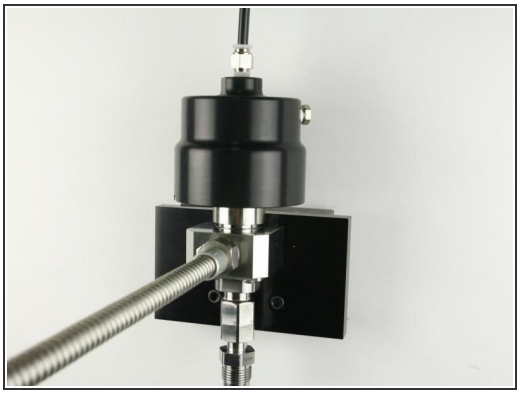
- Repair Kit #13683 (1)
- Needle Bearing #12178 (included in kit) (1)
- High-Pressure Valve Seal #11043 (included in kit) (1)
- Accu Seat #11010 (included in kit) (1)
- Actuator #12828 (1)
- Adapter #13841 (1)
- Valve Body #11033 (1)
- Blue Goop #11111 (1)
- Isopropyl Alcohol (1)

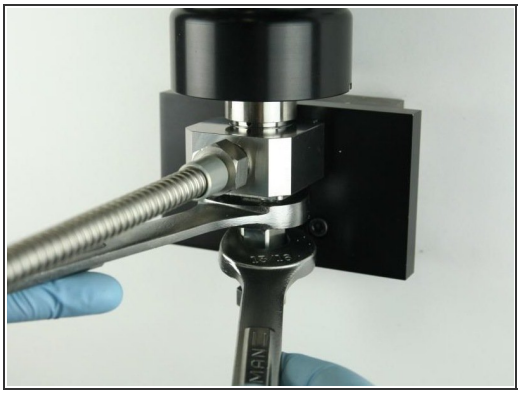
Step 1 — How to Repair an AccuStream High-Cycle On/Off Valve Using Kit #13683

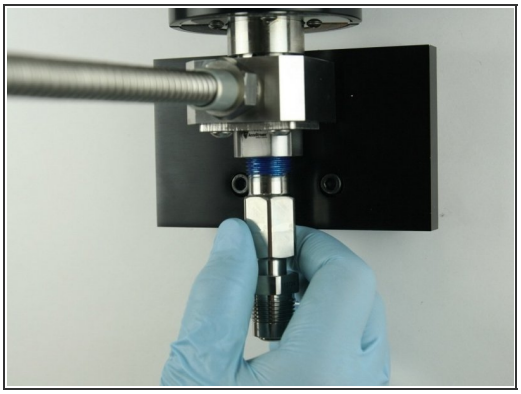
⚠ Always make sure all high-pressure water has been removed from valve by following machine manufacturers' safety instructions. Failure to do so can cause severe injury or death.

- Turn OFF all water pressure to the on/off valve.
- Turn the on/off valve ON to raise the needle from the accu seat.

Step 2

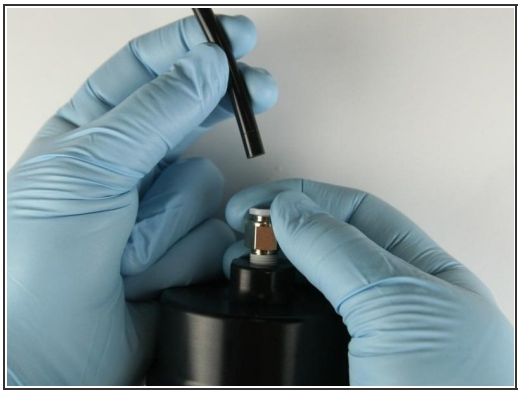
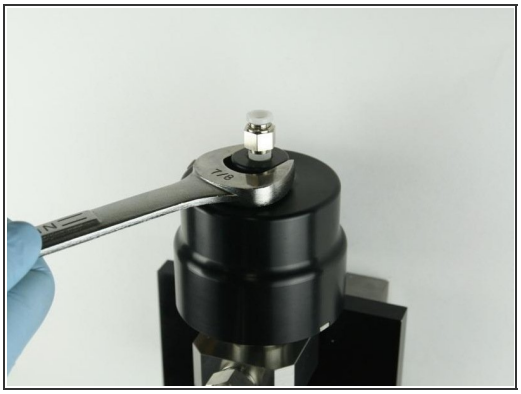






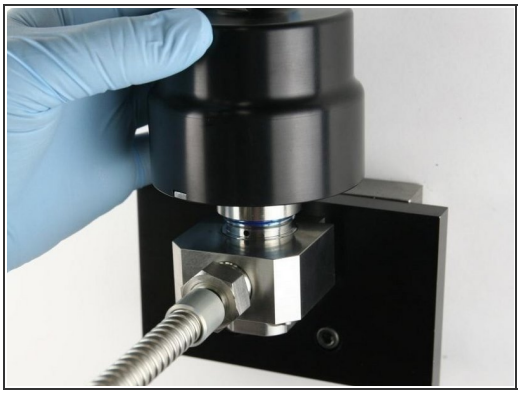
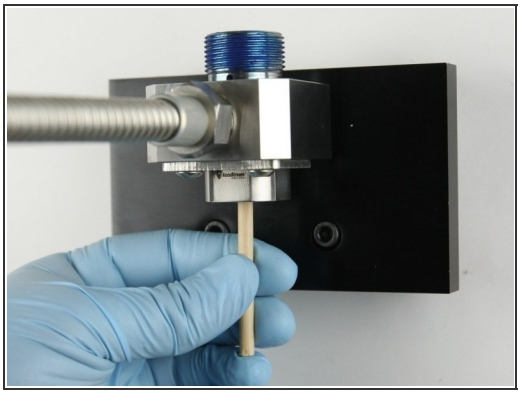
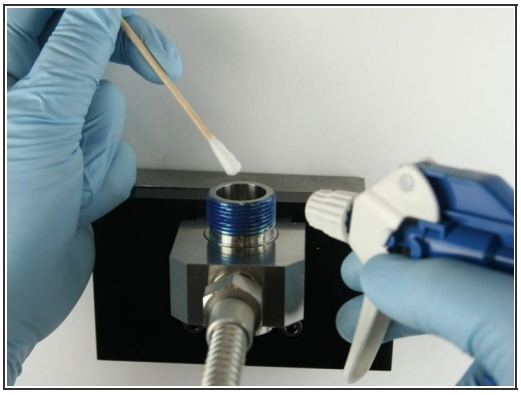
- Components can be replaced with the valve body in the mounting collar.
- Loosen the adapter from the valve body using 1" and 13/16" wrench.
- Unthread the adapter from the valve body.

Step 3

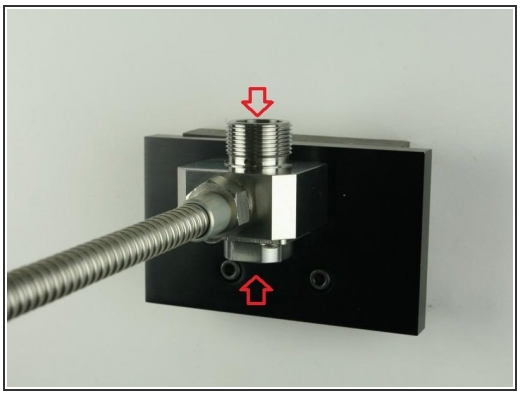
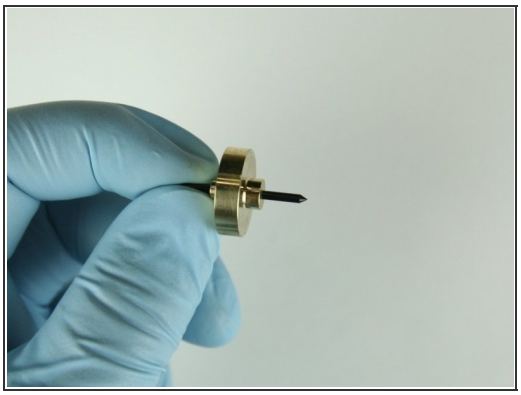
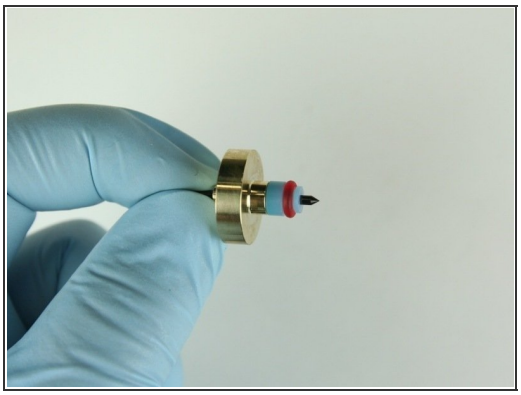
- Turn the air to the actuator OFF.
- Disconnect the air line from the actuator.
- Loosen the actuator from the valve body using a 7/8" wrench.

Step 4

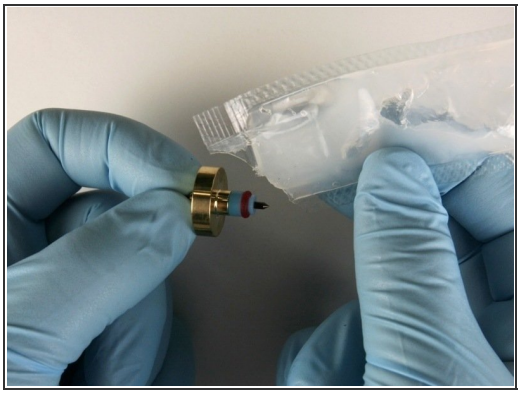
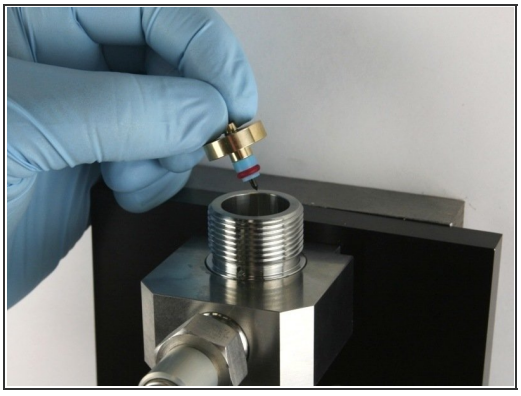
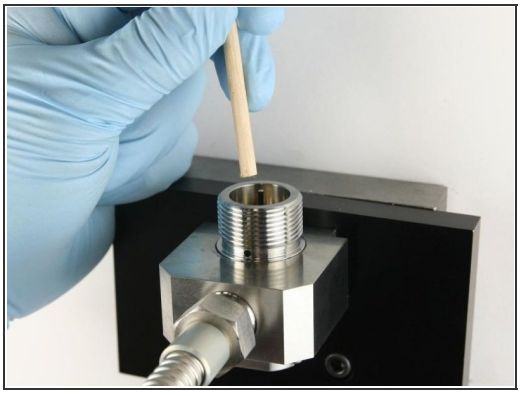
- Unthread the actuator from the valve body.
- Remove all the valve components from the valve body using the included dowel.
- Thoroughly clean the interior/exterior of the valve body with isopropyl alcohol before replacing the components.

Step 5

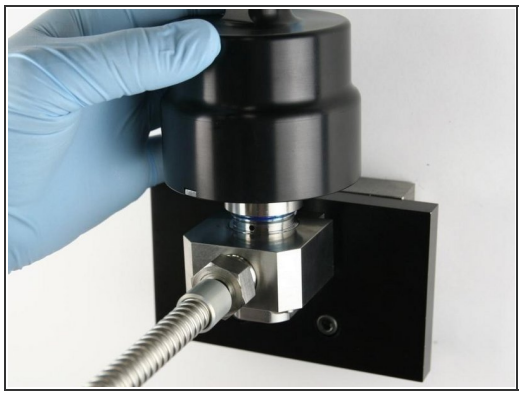
- Check the top and bottom of the bore for cracks/blemishes. If excessive wear or cracks are visible, replace the valve body.
- Slide the needle bearing onto the needle point with the smaller step away from the needle point.
- Slide the high-pressure valve seal onto the needle point with the O-ring away from the needle bearing.

Step 6

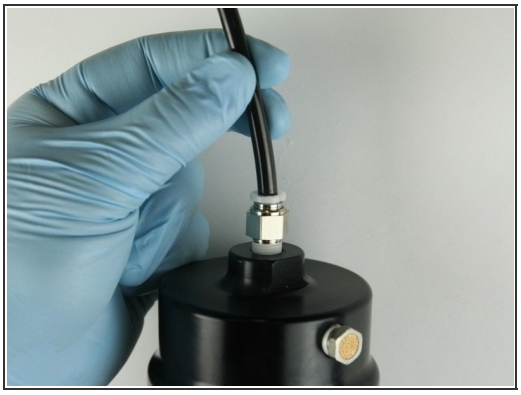
- Apply a high-pressure lubricant to the outside diameter of the high-pressure valve seal.
- Put the needle point at the top of the valve body.
- Use the dowel to push the needle in the valve body until the needle bearing bottoms out.

Step 7


- Apply Blue Goop to the top threads of the valve body.
- Thread the actuator onto the valve body.
- Tighten the actuator to the valve body using a 7/8" wrench.

Step 8



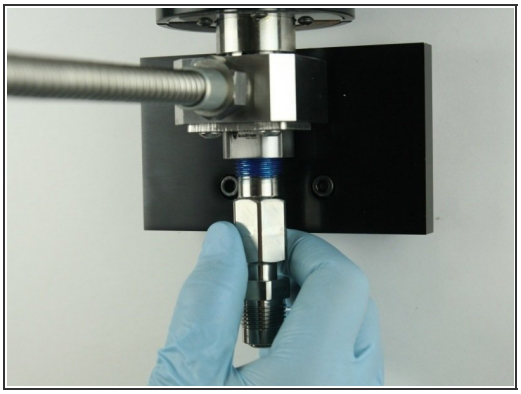
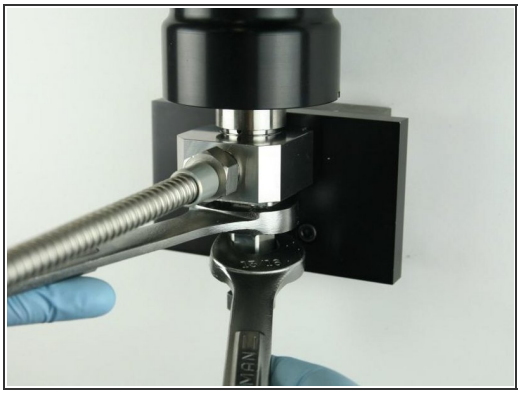
- Reconnect the air line to the top of the actuator.
- Clean the adapter of all blue goop with isopropyl alcohol or similar cleaning agent.
- Reapply Blue Goop to the top threads and to the top of the adapter.

Step 9



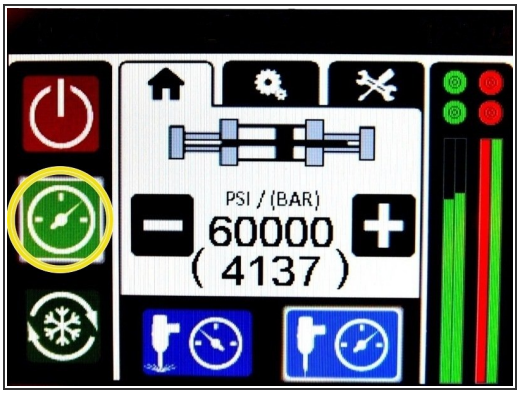
- Put the accu seat at the top of the adapter with the flat side towards the adapter.
- Apply Blue Goop to the top of the accu seat.
- Turn the air to the actuator On.

Step 10


- Thread the adapter into the valve body.
- Tighten the adapter into the valve body using a 1" and 13/16" wrench.
- Turn the air to the actuator OFF.

Step 11



- Apply water pressure to the valve assembly to verify there are no leaks
- Quickly cycle the valve on and off a few times to purge the system of all contaminants before installing cutting head
- Reinstall cutting head and continue the cutting process.