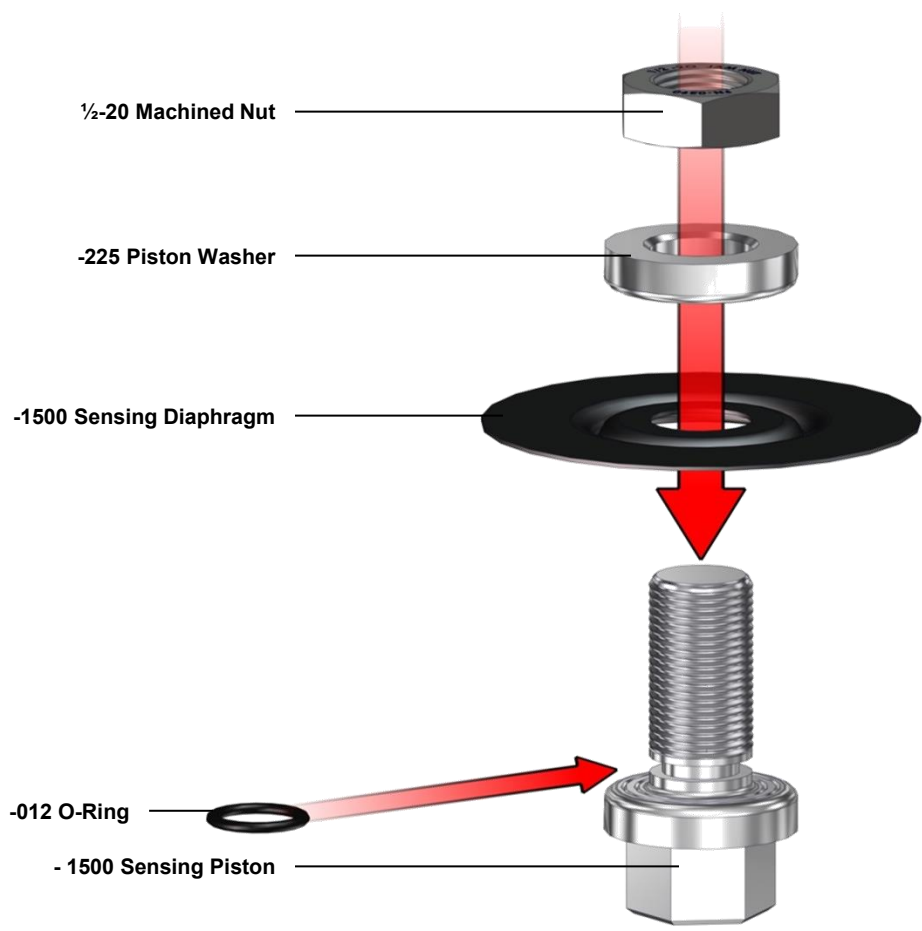




VPC-1500-DA-SN
Assembly
Instructions

Assemble -1500 Sensing Diaphragm Assembly

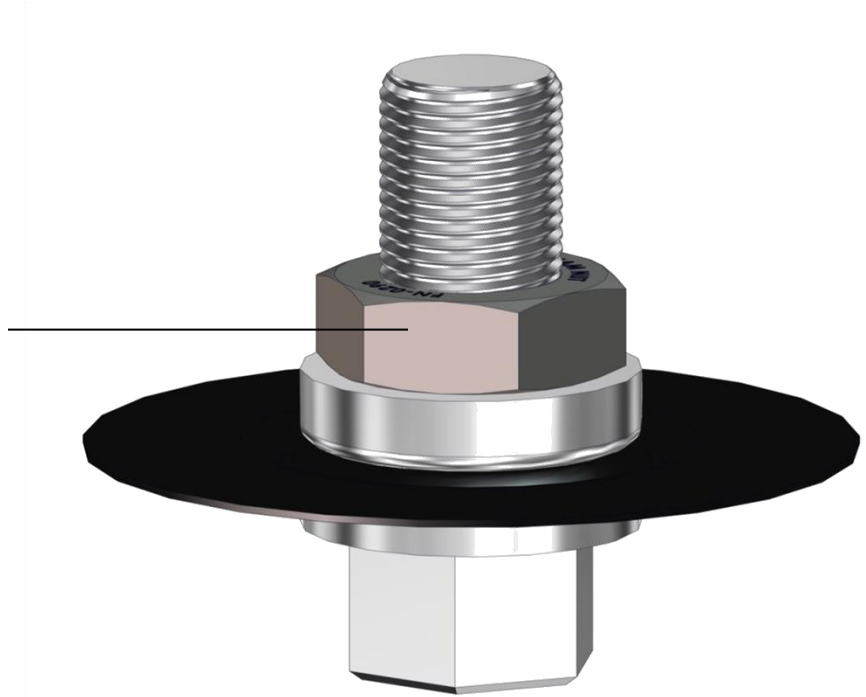


Instructions:

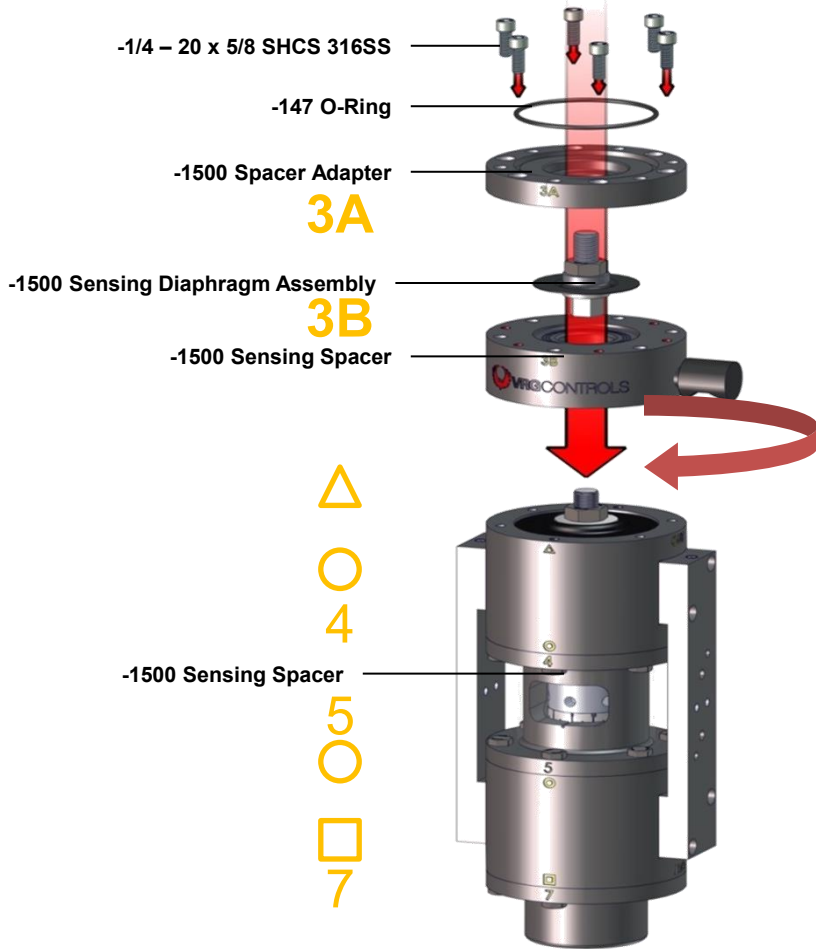
1. Lubricate -012 O-Ring and install onto -1500 Sensing Piston
2. Install -1500 Sensing Diaphragm onto -1500 Sensing Piston with Convolute facing DOWN
3. Install -1500 Piston Washer with Serrations facing downward toward -1500 Sensing Diaphragm
4. Thread 1/2 - 20 Machined Nut onto -1500 Sensing Piston and torque to 110 in-lbs.



-1500 Sensing Diaphragm Assembly



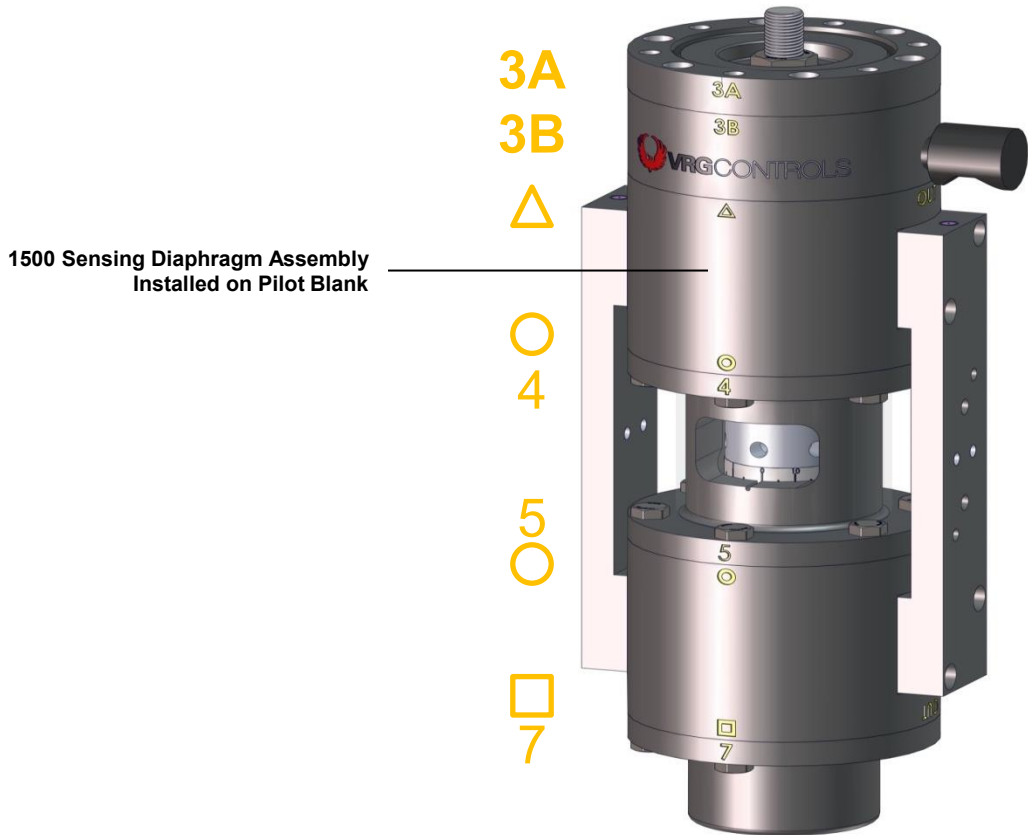
-Install & Lock 1500 Sensing Diaphragm Assembly



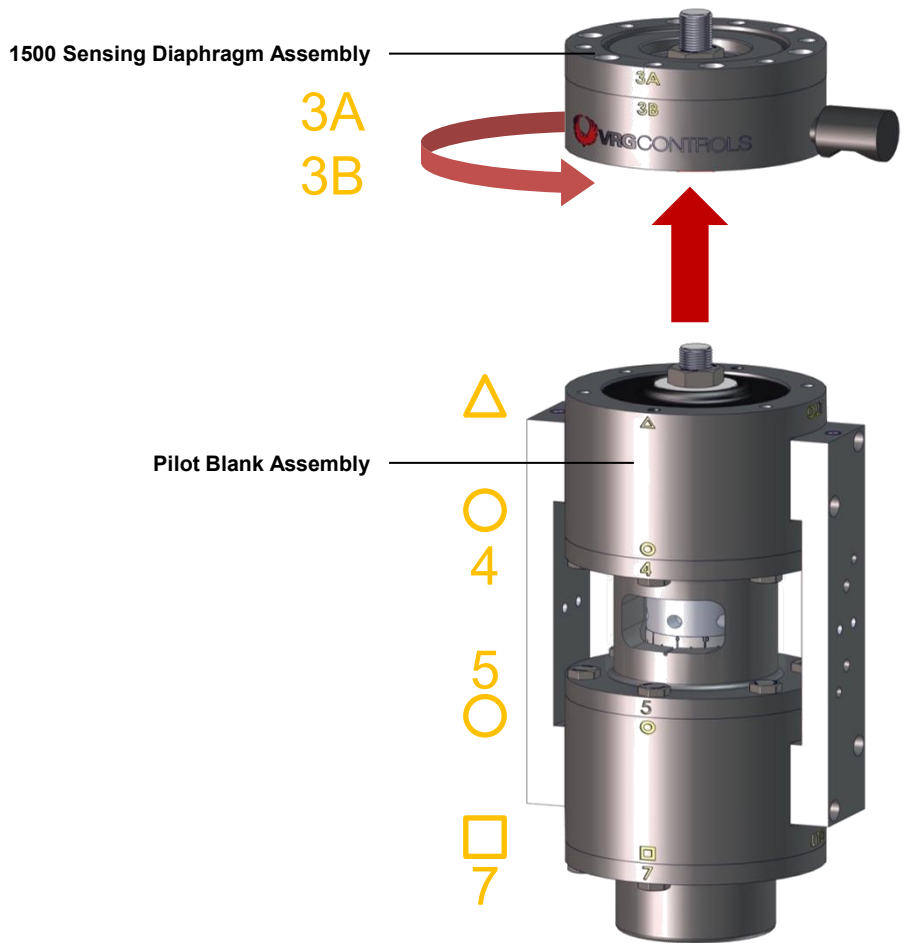
Instructions:

1. Install 1/4 NPT Vent Breather into NPT port on vent port on -1500 Sensing Spacer
2. Align -1500 Sensing Spacer with logo facing front of assembly (in-line with Adjusting Drum Window)
3. Push -1500 Sensing Spacer onto Pilot Blank Assembly
4. Thread 1500 Sensing Diaphragm Assembly onto Seat & Nozzle Piston on top of Pilot Blank Assembly until it is fully engaged. **DO NOT TIGHTEN BEYOND FINGER TIGHT.**
5. Lubricate and install -147 O-Ring into top of -1500 Spacer Adapter.
6. Install -1500 Spacer Adapter. Tighten with 1/4 - 20 x 5/8 SHCS 316SS and tighten firmly in star pattern (QTY 6).
7. -1500 Sensing Diaphragm is now locked into -1500 Sensing Assembly.

1500 Sensing Diaphragm Assembly Installed on Pilot Blank



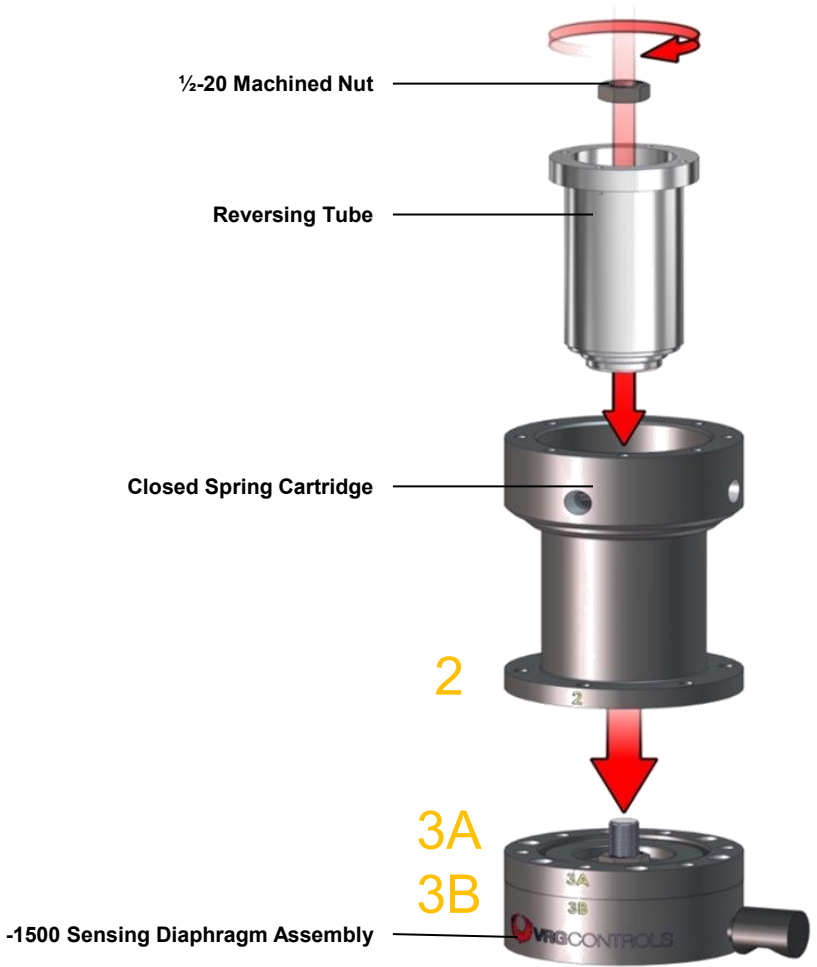
Remove 1500 Sensing Diaphragm Assembly



Instructions:

1. Unscrew entire -1500 Sensing Diaphragm Assembly from Pilot Blank Assembly

Assemble -1500 Sensing Diaphragm Assembly onto Closed Spring Cartridge



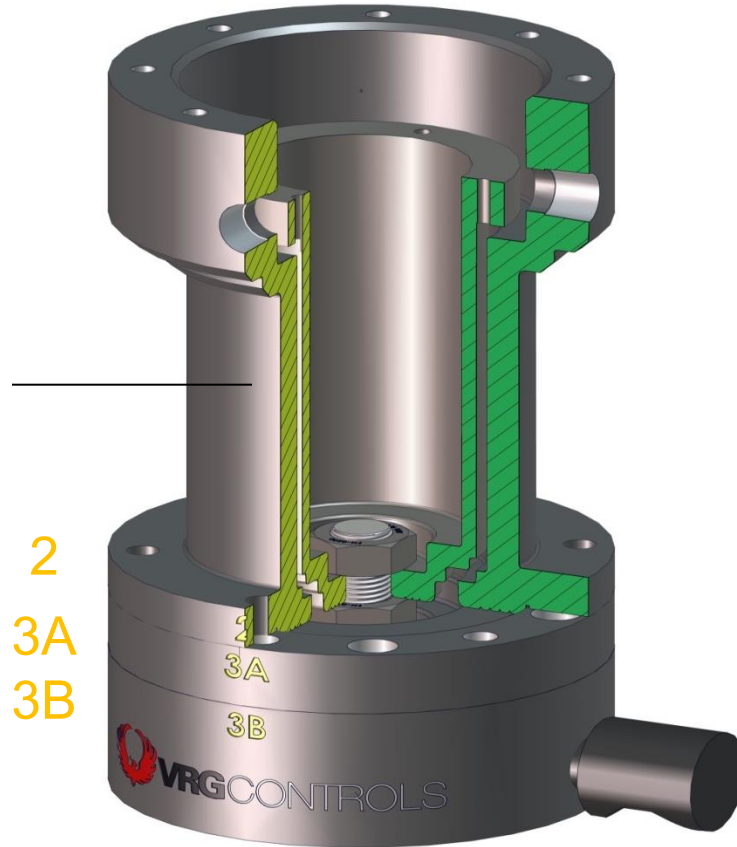
Instructions:

1. Install -1500 Sensing Diaphragm Assembly into Closed Spring Cartridge
2. Drop Reversing Tube through Closed Spring Cartridge and engage -1500 Sensing Diaphragm Assembly
3. Thread 1/2 - 20 Machined Nut onto -1500 Sensing Diaphragm Assembly and torque to 110 in-lbs. using 3/4 in Deep Well Socket wrench.

1500 Sensing Diaphragm Assembly onto Closed Spring Cartridge



1500 Sensing Diaphragm Assembly
onto Closed Spring Cartridge



1500 Sensing Diaphragm Assembly onto Closed Spring Cartridge



1500 Sensing Diaphragm Assembly
onto Closed Spring Cartridge

2
3A
3B
Δ

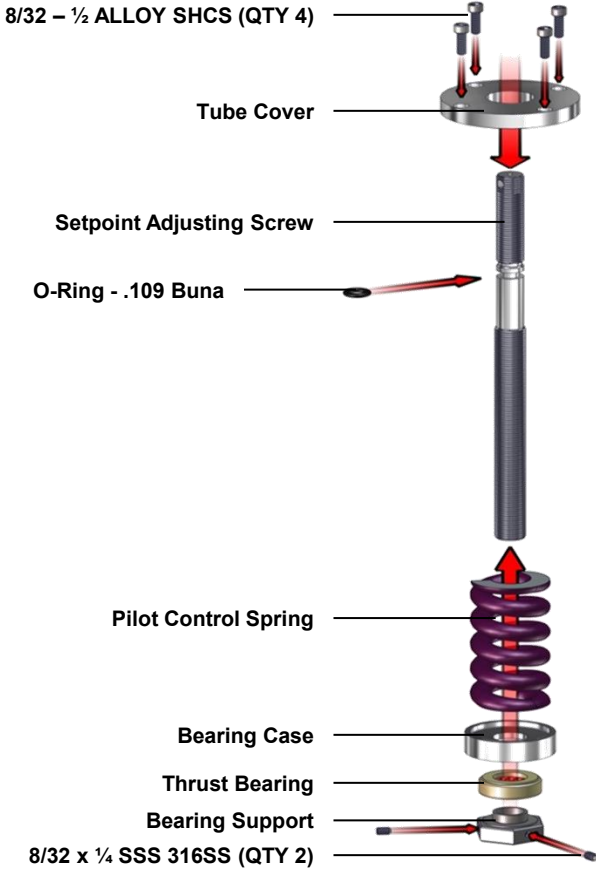
Pilot Blank Assembly



Instructions:

1. Engage -1500 Sensing Diaphragm & Closed Spring Cartridge onto Seat & Nozzle Piston on top of Pilot Blank Assembly until hand tight. Do not over tighten.
2. Disengage by rotating CCW just enough to ensure proper alignment with Pilot Blank Assembly.
3. "2" & "3A" & "3B" & "Δ" should be aligned on front of Pilot Blank Assembly.

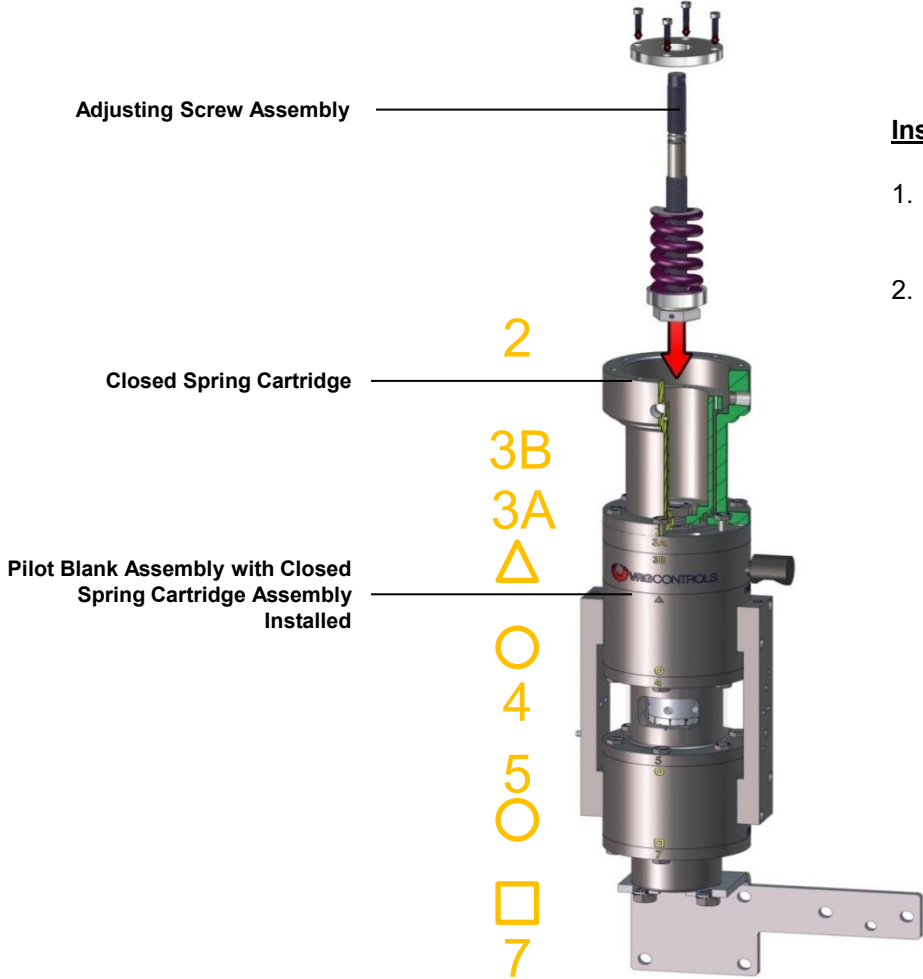
Assemble Setpoint Screw Assembly



Instructions:

1. Mount bearing support onto Setpoint Adjusting Screw with 8/32 x 1/4 SSS (Self-Locking).
2. Press Thrust Bearing into Bearing Support with stamped letters side first. Thrust Bearing should fit snugly inside Bearing Support and bearing surface should face outward and rotate freely.
3. Install Bearing Support/Bearing Assembly onto Setpoint Adjusting Screw
4. Thoroughly lubricate and Install Pilot Control Spring onto Adjusting Screw
5. Lubricate -109 O-Ring and install in groove at top end of Adjusting Screw
6. Place 8/32 - 1/2 ALLOY SHCS in through holes of Tube Cover and slip over top of Setpoint Adjusting Screw

Install Setpoint Adjusting Screw Assembly



Instructions:

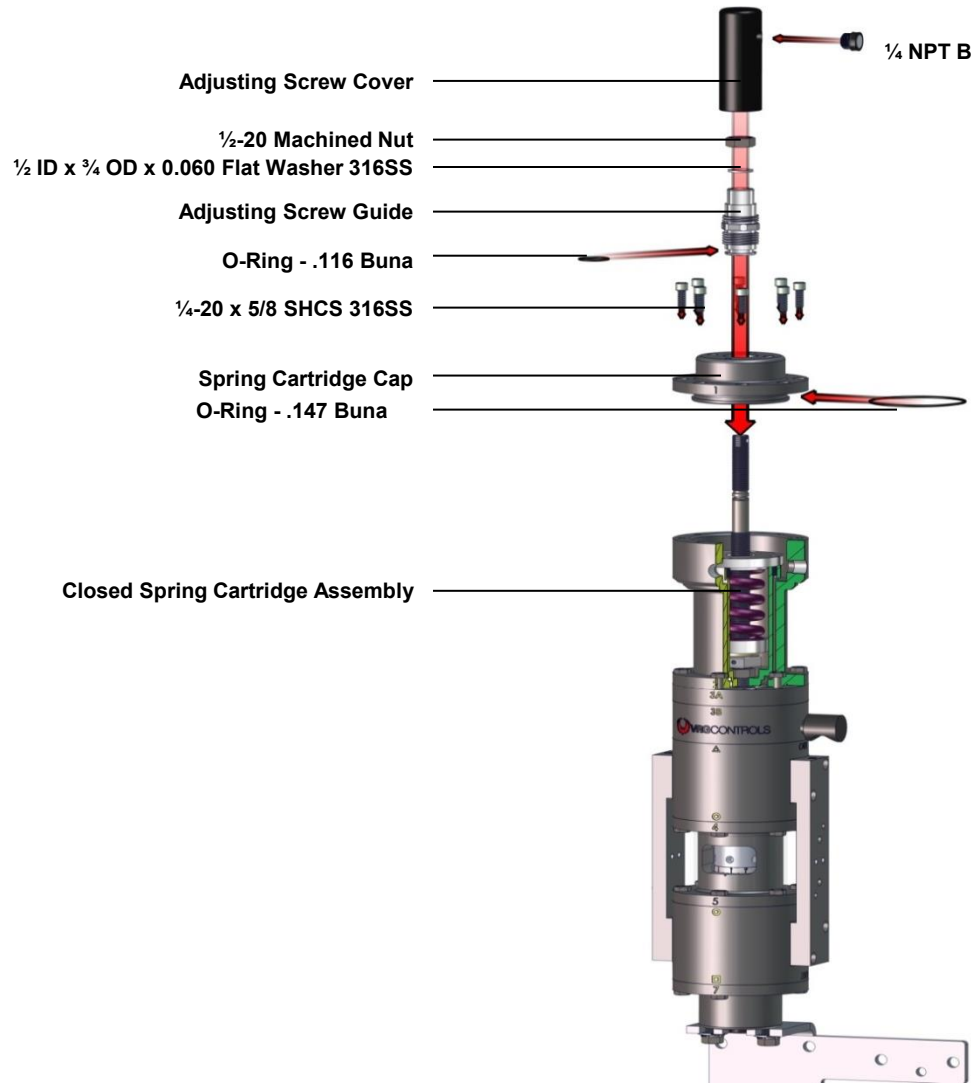
1. Slip entire Setpoint Adjusting Screw Assembly into Reversing Tube (inside Closed Spring Cartridge)
2. Tighten 8/32 – 1/2 ALLOY SHCS in star pattern. Hold opposing side of Tube Cover down when tightening first screw to ensure proper alignment when tightening



Pilot Blank Assembly with Setpoint Adjusting Screw Assembly Installed



Install Spring Cartridge Cap Assembly



1/4 NPT Breather Vent

Adjusting Screw Cover

1/2-20 Machined Nut

1/2 ID x 3/4 OD x 0.060 Flat Washer 316SS

Adjusting Screw Guide

O-Ring - .116 Buna

1/4-20 x 5/8 SHCS 316SS

Spring Cartridge Cap

O-Ring - .147 Buna

Closed Spring Cartridge Assembly

Instructions:

1. Lubricate -116 O-Ring and Install on Adjusting Screw Guide
2. Lubricate -147 O-Ring and Install on Spring Cartridge Cap
3. Thread Adjusting Screw Guide into Spring Cartridge Cap and Tighten
4. Drop Spring Cartridge Cap/Adjusting Screw Guide Assembly onto Setpoint Adjusting Screw and push over O-Ring.
5. Continue to install Spring Cartridge Cap Assembly by threading onto Setpoint Adjusting Screw. NOTE REVERSE THREADS.
6. Insert all 1/4-20 x 5/8 SHCS 316SS into Spring Cartridge Cap and tighten in star pattern until fully engaged. Tighten fully in star pattern.
7. Install Flat Washer and 1/2 - 20 Machined Nut
8. Install 1/4 NPT Breather Vent into Adjusting Screw Cover and thread assembly onto Setpoint Adjusting Screw.



Pilot Blank Assembly with Spring Cartridge Cap Assembly Installed

- 1
- 2
- 3A
- 3B
- △
-
- 4
- 5
-
-
- 7

