



#### ASSEMBLY PROCEDURE FOR GAS PISTON: (Use 17246 Assembly Tool)

WITH PISTON ROD HELD SECURELY AND EXTENDING 1/4" BEYOND THE END OF THE GAS BARREL, ASSEMBLE THE PARTS IN THE ORDER SHOWN USING THE FLAT END OF THE ASSEMBLY TOOL TO COMPACT THE SEALS. BE SURE THAT THE BELLEVILLE SPRINGS ARE ASSEMBLED IN SETS OF TWO, CUPPED ALTERNATIVELY IN OPPOSITE DIRECTIONS. USE THE OTHER END OF ASSEMBLY TOOL TO TORQUE THE NUT DOWN UNTIL SNUG AND THEN BACK OFF UNTIL A SLOT IN THE NUT LINES UP WITH THE HOLE IN THE ROD. INSERT AND SECURE THE COTTER PIN.

\*NOTE: WHEN PROPERLY TIGHTENED, THE 51364 NUT SHOULD SOLIDLY CONTACT THE 17937-1 ROD SHOULDER AND BE APPROXIMATELY FLUSH WITH THE ROD END. (IF NECESSARY, USE FEWER 16719-5 SPRINGS TO ACHIEVE THIS.)

#### ASSEMBLY PROCEDURE FOR GAS CHECK VALVES: (Use 16675 Assembly Tool)

1. PLACE OUTLET PORT IN THE UPRIGHT POSITION. INSERT SEAT, BALL, RING, SMALL SPRING, SHANK AND LARGE SPRING UNTIL SEATED PROPERLY. IT IS IMPORTANT THAT THESE PARTS ARE IN PROPER POSITION BEFORE CONTINUING. SLIDE ONE SET OF PACKINGS (BRONZE, THIN TFE BACK-UP, O-RING, THICK TFE BACK-UP) IN THE ORDER SHOWN ONTO SEAT FITTING THE THICK TFE BACK-UP WILL PROVIDE SUFFICIENT GRIP TO RETAIN THE PACKINGS DURING INSERTION. THEN, USING ASSEMBLY TOOL, SCREW SEAT IN UNTIL IT IS SNUG (APPROXIMATELY 5/8" BELOW END CAP FACE). USING A THIN ROD, DEPRESS BALL THROUGH INLET PORT TO VERIFY PROPER MOVEMENT.

2. PLACE INLET PORT IN UPRIGHT POSITION. INSERT LARGE SPRING, SHANK, RING, SMALL SPRING, BALL AND SEAT INTO PORT UNTIL SEATED. IT IS IMPORTANT THAT THE PARTS ARE IN PROPER POSITION BEFORE CONTINUING. SLIDE ONE SET OF PACKINGS (BRONZE, THIN TFE BACK-UP, O-RING, THICK TFE BACK-UP) IN THE ORDER SHOWN ONTO SEAT FITTING. THE THICK TFE BACK-UP WILL PROVIDE SUFFICIENT GRIP TO RETAIN THE PACKINGS DURING INSERTION. THEN, USING THE ASSEMBLY TOOL, SCREW THE SEAT IN UNTIL IT IS SNUG (APPROXIMATELY 5/8" BELOW END FACE). CHECK THAT THE BALL IS FREE TO MOVE BY DEPRESSING IT WITH A THIN ROD FROM THE INLET END.

Ⓐ INDICATES PARTS IN SEALS KIT 17325

Ⓑ INDICATES PARTS IN SEALS KIT 51544-30

Ⓒ INDICATES PARTS IN END CAP ASSEMBLY 53032-30

## -30 GAS BARREL

REV	DESCRIPTION	DATE CHG	BY	APPD
P	REMOVED FROM INLET FROM 17255, ECO 7350			
N	REMOVED SEAL KIT 17325 FROM 17255 SEAL KIT, ECO 6155			
M	SEAL KIT WAS 568012-22, 568117-31 WAS 568117-22, ECO 5485-1			
L	568117-31 WAS 568117-22 SEC ECM 1944-3			