

PM - part	Check for :	Pos. number on the drawing	Kit to be used				Remark
			A	B	C	D	
Piston	Scoring	1A			Heavy		
	Rust	1B	Clean		Heavy		
	Blockage of bleed hole	1C	Clean				
Piston ring	Breakage	2A		X	X		
	Scoring	2B	Light-increase inspections	Heavy	Heavy		
Cylinder wall	Scoring	3A	Light-increase inspections			Heavy	Do not use sandpaper or similar
	Rust	3B	Light-clean carefully			Heavy	
Valve seat	Marks	4A				Heavy	
	Cavitation	4B	Light-increase inspections			Heavy	
Valve plate	Marks	5A	Machine using lathe	Heavy	Heavy		Results in leakage over seat
	Chips & particles	5B	Machine using lathe	Heavy	Heavy		Results in leakage over seat
	Fractures	5C		X	X		
	Deforming	5D		X	X		
Cone	Wear	6A	Light-increase inspections		Heavy		Looks like sand-blasting
	Cavitation	6B	Light-increase inspections		Heavy		Looks like very small holes - barely visible
Spindle (pushrod)	Wear	7A			Heavy		Looks like sand-blasting
	Cavitation	7B	Light-increase inspections		Heavy		Looks like very small holes - barely visible
	Bending	7C			Change		Measure using lathe
	Damage to thread	7D			Change		Bolt could also be damaged
Filter	Particles	8A	Clean				
	Deforming	8B			Change		
	Rust	8C	Clean		Heavy		
Pilot holes	Blockage	9A	Clean				
	Rust	9B	Clean				
Spring	Breakage	10A				X	
	Corrosion	10B	Clean			Heavy	
Intermediate plate	Rust	11A	Clean		Heavy		
Bottom plate	Particles	12A	Clean incl. house inside				
	Wear of guide hole	12B	Light-increase inspections			Heavy	

Inspection set A:

Consist of:	Size	Code no.
Top gasket (13)		Both cone types
Bottom gasket (14)		
Flange gaskets	5	027F3241
	10	
	15	
	20	
	25	
	32	027F3242
	40	027F3243
	50	027F3244
	65	027F3245
	80	027F3246
	100	027F3247
125	027F3248	

Maintenance set B:

Consist of:	Size	Code no.
Top gasket (13)		Both cone types
Bottom gasket (14)		
Flange gaskets	5	027F3250
	10	
	15	
	20	
	25	
	32	027F3251
	40	027F3252
	50	027F3253
	65	027F3254
	80	027F3255
	100	027F3256
125	027F3257	

Overhaul set C:










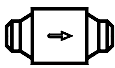



Consist of:	Size	Code no.	Code no.
Top gasket (13)		Standard cone	V-cone
Bottom gasket (14)			
Flange gaskets	5	-	027F3259
	10	-	027F3260
	15	-	027F3261
	20	027F3262	-
	25	027F3263	-
	32	027F3264	027F3271
	40	027F3265	027F3272
	50	027F3266	027F3273
	65	027F3267	027F3274
	80	027F3268	027F3275
	100	027F3269	027F3276
125	027F3270	-	

The set of o-rings (027F1004) for the pilot valves is not included in to kits A and B and should be ordered separately.

Replacement Valve set D:

Set "D"	Size	Code no.	Code no.	Code no.	Code no.
Consist of:		PM 1, std cone	PM 1, V-cone	PM 3, std cone	PM 3, V-cone
Valve complete	5	-	027F3001	-	027F3010
Flange gaskets	10	-	027F3002	-	027F3011
	15	-	027F3003	-	027F3012
	20	027F3004	-	027F3013	-
	25	027F3005	-	027F3014	-
	32	027F3006	027F1936	027F3015	027F1945
	40	027F3007	-	027F3016	027F1946
	50	027F3008	-	027F3017	027F1947
	65	027F3009	-	027F3018	027F1948
	80	-	-	027F1271	027F1930
	100	-	-	027F1276	027F1931
	125	-	-	027F1281	-

Spare parts and accessories
Main valves, type PM 1 and PM 3

Accessories for PMC	Description	Qty	Code no.
	External pilot connector Weld, PM 5 to 65, ID 12.7 mm/OD 18 mm Weld, PM 80 to 125, ID 12.7 mm/OD 18 mm 1/4 NPT, PM 5 to 65 1/4 NPT, PM 80 to 125 Nipple assembly Damping orifice, dia. 1.0 mm O-ring Gasket	 1 1 1 1	 027F1048 027F1049 027B2065 027B2066
	Seal kit for external pilot connector Alu gasket Gasket O-ring	 4 4 4	 027F1004
	Blanking plug Plug Stop plug O-ring Gasket	 1 1 1 1	 027F1046
	Pressure gauge connector, solder/weld Nipple assembly Alu gasket	 1 1	 027F2035
	Seal kit for solder/weld pressure gauge connector Alu gasket Alu gasket	 10 10	 027B2029
	Pressure gauge connector cutting ring connector 6 mm 10 mm	 1 1	 027B2063 027B2064
	Pressure gauge connector, 1/4 NPT	1	027B2062
	Pressure gauge connector, flare (Must not be used in ammonia systems!) Nipple Schraeder valve Cap Alu gasket	 1 1 1 1	 027B2041
	Function indicator for PM/PMC 1 and 3, sizes 5 to 65 Function indicator assembly Gasket	 1 1	 027F0085
	CVH pilot valve body weld ID 12.7 mm/OD 18 mm	1	027F1047
	CVH pilot valve body G 1/4 (ISO 228-1)	1	027F1160
	CVH pilot valve body G 1/4 (USAS B2.1-1960)	1	027F1159
	„Strong“ spring for PM 1 and 3, sizes 5 to 25, approx. 45% more closing force	1	027F0662
	Manual opening device for PM 5-65 and ICS25-65 (stainless steel, square), including cap	1	027F2130
	Manual opening device for PM 80-125 (stainless steel, square), including cap	1	027F2134