

## Instructions

### ICS 25-80

## Replacing the Teflon seat in the function module

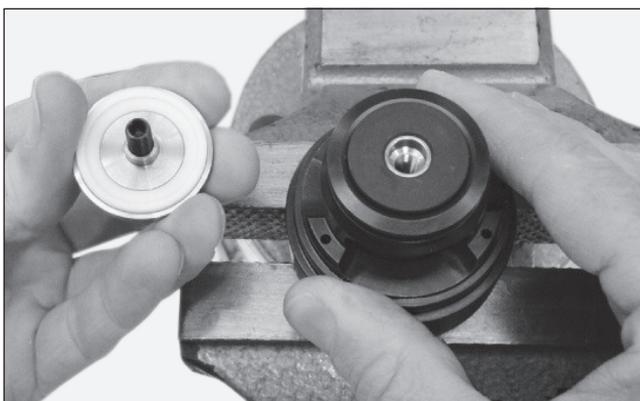
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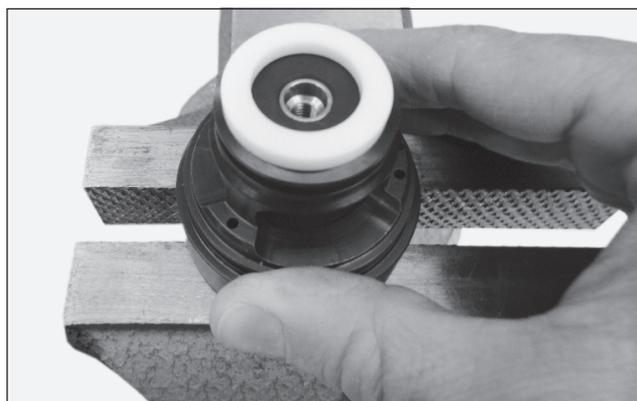
1. Turn the module upside down and secure in a screw vice, holding the module on the two flat sides (A).



2. Loosen the washer plate using a 13 mm (0.5 in.) spanner.



3. Unscrew the washer plate while holding on to the module (the spring force will force the module to detach from the piston).



4. Remove the old/worn Teflon seat from the washer plate. Mount the new Teflon seat on top of the regulating cone. Remember to place the Teflon seat with the flat surface facing up.



5. Screw the washer plate back on to the module by hand. It is recommended to add thread lock liquid prior to assembly.



6. Tighten the washer plate using a torque wrench.  
ICS 25, 32 and 40 = 17 Nm (12 lb/ft)  
ICS 50, 65 and 80 = 25 Nm (18 lb/ft)

#### NOTE!

**It is important to tighten the washer plate with the correct torque, otherwise the washer plate may become loose or get damaged!**

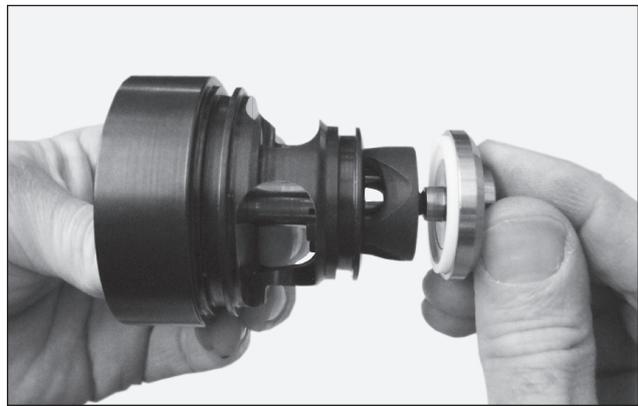
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If the insert becomes detached from the piston, follow the procedure below.



1. Place the spring in the module and insert the piston. Squeeze the piston ring while pressing the piston into the module.



2. Hold the piston in place while mounting the regulating cone, Teflon plate and washer plate. Tighten the washer plate using the correct torque:  
ICS 25, 32 and 40 = 17 Nm (12 lb/ft)  
ICS 50, 65 and 80 = 25 Nm (18 lb/ft)