

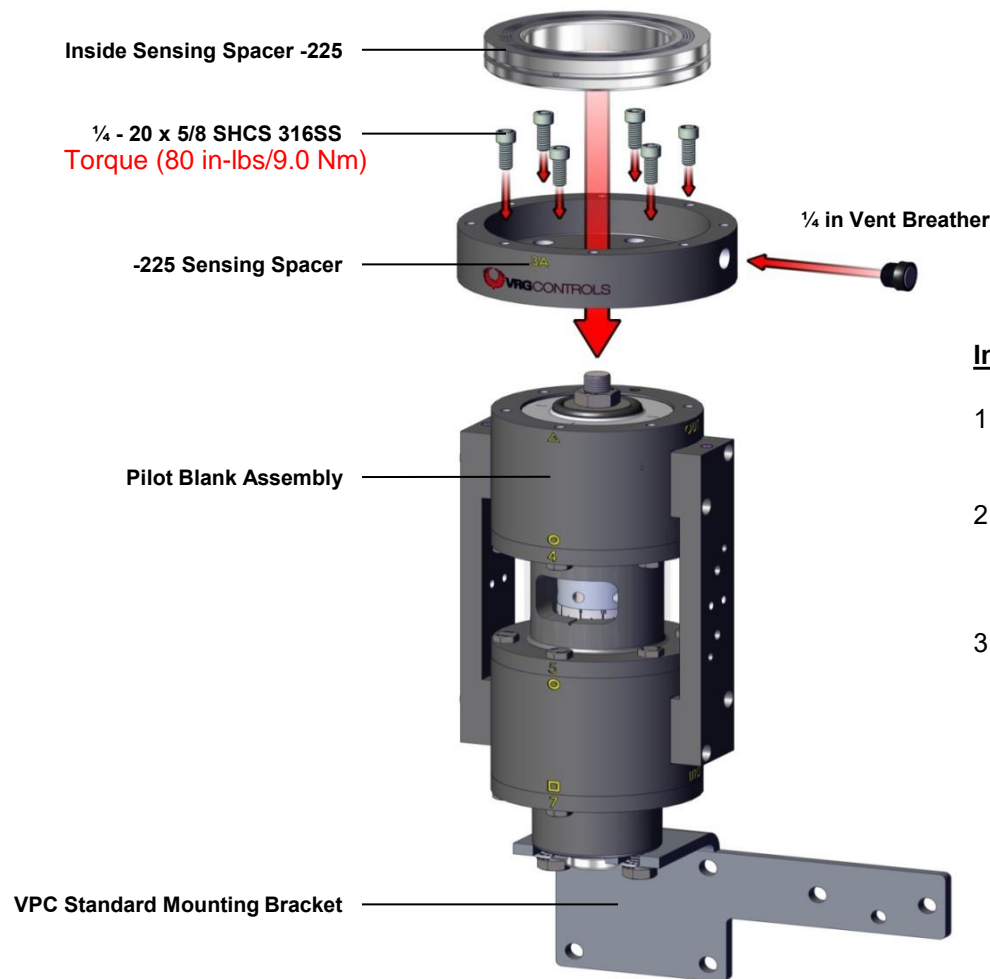


VPC-225-DA-SN

Assembly Instructions

REV 120325 - UPDATE FASTENER TORQUE SPECS

Install -225 Sensing Assembly onto Pilot Blank Assembly

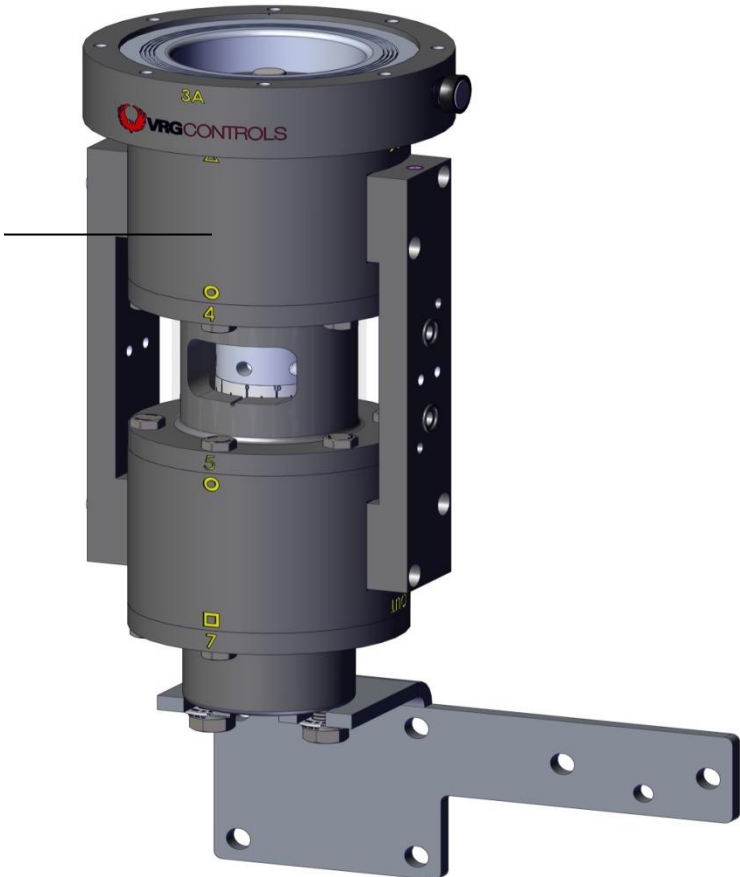


Instructions:

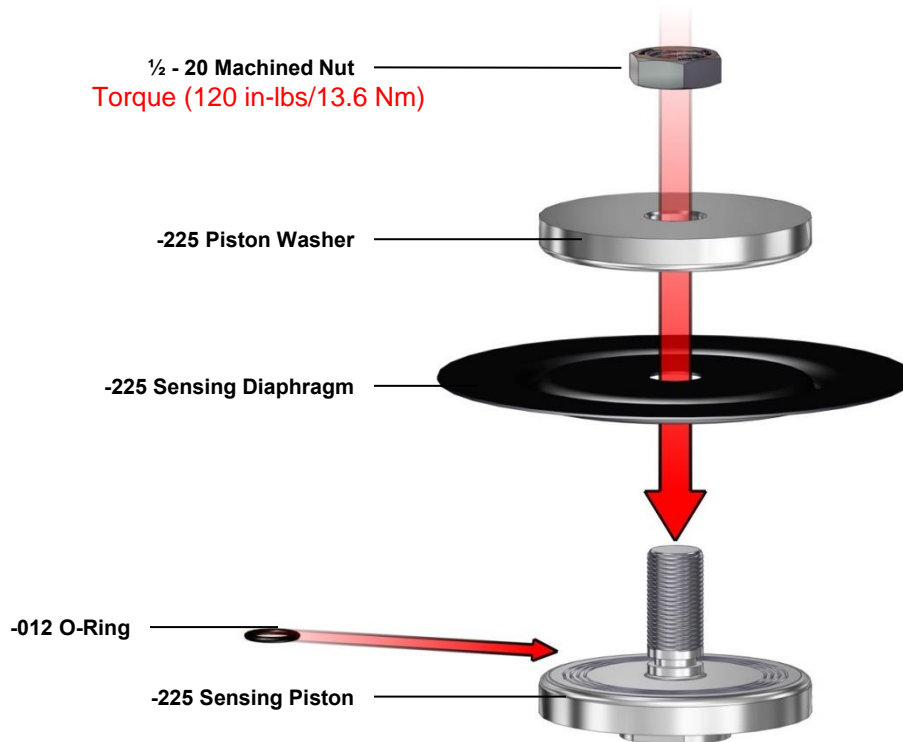
1. Install 1/4 in Vent Breather into vent port on -225 Sensing Spacer
2. Insert Inside Sensing Spacer -225 into -225 Sensing Spacer. Ensure that components are aligned and do not bind during assembly.
3. Install -225 Sensing Spacer Assembly onto top of Pilot Blank Assembly and tighten using 1/4 - 20 x 5/8 SHCS 316SS in star pattern.



Pilot Blank Assembly with -225 Sensing Assembly Installed



Assemble -225 Sensing Diaphragm Assembly

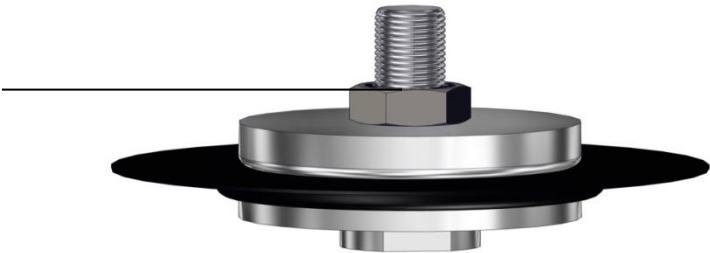


Instructions:

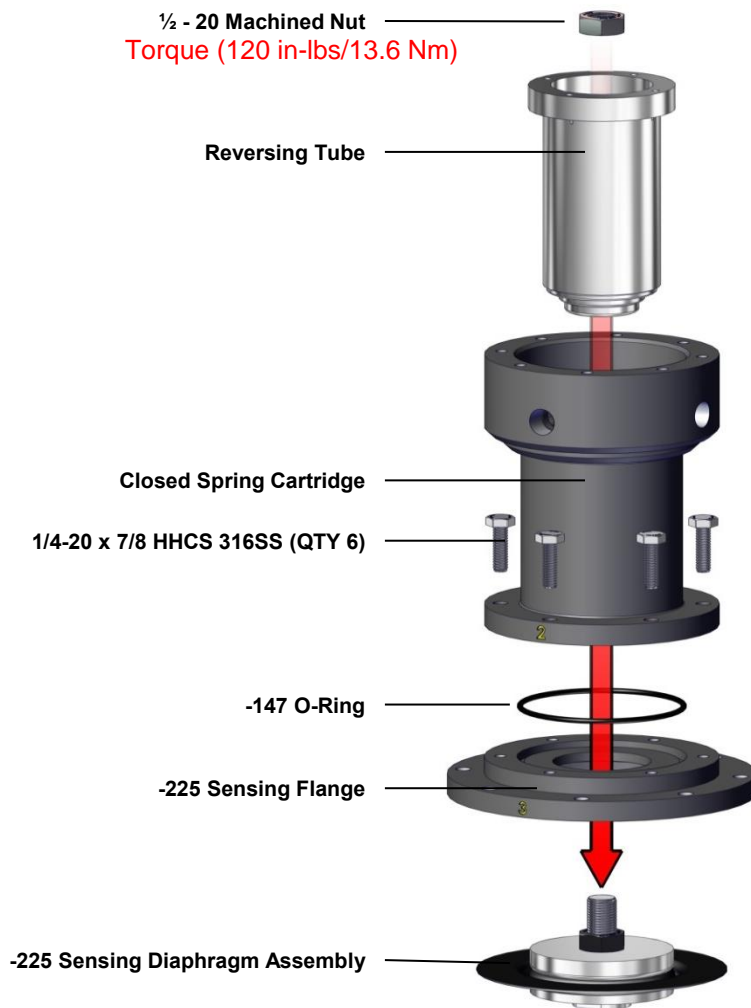
1. Lubricate -012 O-Ring and install onto -225 Sensing Piston
2. Install -225 Sensing Diaphragm onto -225 Sensing Piston with Convolute facing DOWN
3. Install -225 Piston Washer with Serrations facing downward toward -225 Sensing Diaphragm
4. Thread 1/2 - 20 Machined Nut onto -225 Sensing Piston and torque to 120 in-lbs.



-225 Sensing Diaphragm Assembly



Assemble -225 Sensing Diaphragm Assembly

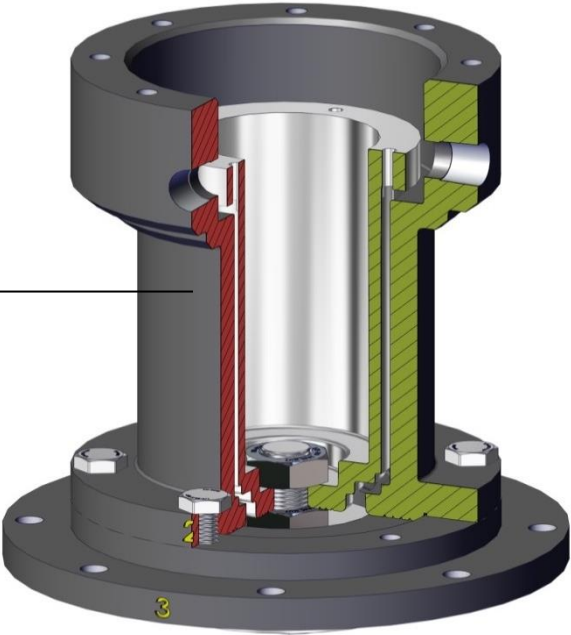


Instructions:

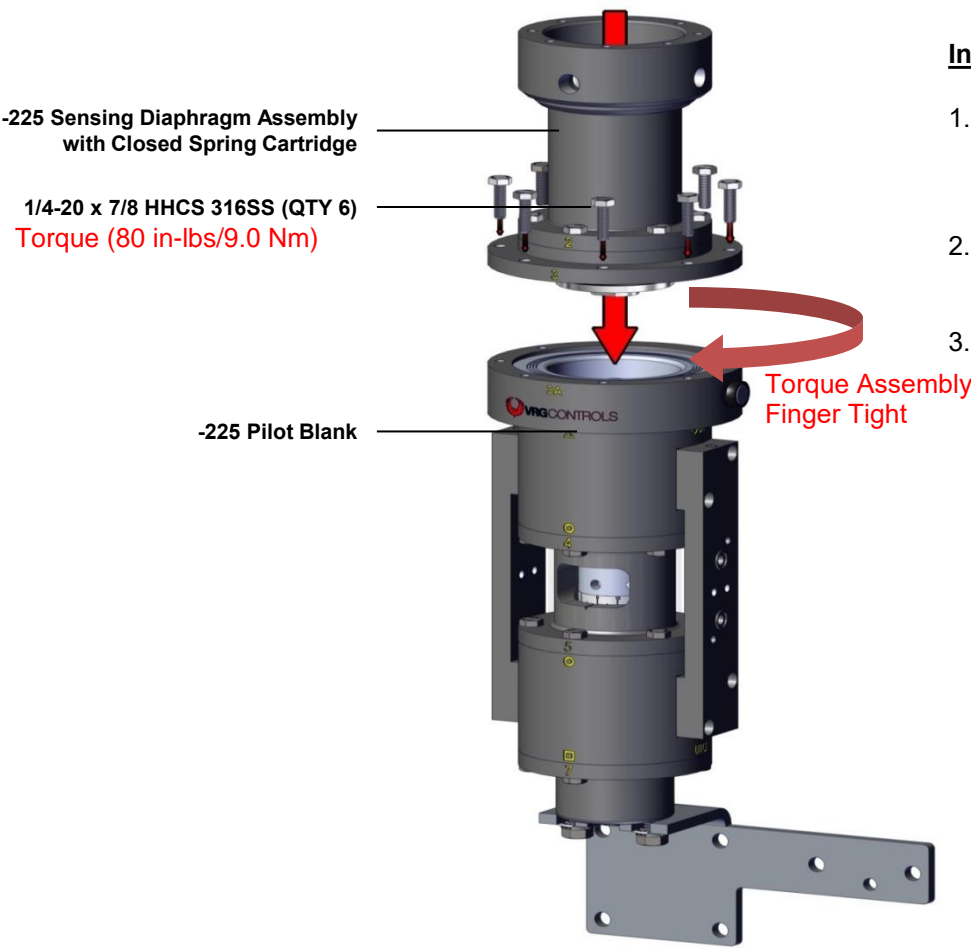
1. Lubricate -147 O-Ring and insert into -225 Sensing Flange
2. Bolt Closed Spring Cartridge to -225 Sensing Flange using 1/4 - 20 x 7/8 HHCS
3. Install -225 Sensing Diaphragm Assembly through -225 Sensing Flange and into Closed Spring Cartridge
4. Drop Reversing Tube through Closed Spring Cartridge and engage -225 Sensing Diaphragm Assembly
5. Thread 1/2 - 20 Machined Nut onto -225 Sensing Diaphragm Assembly and torque to 120 in-lbs. using 3/4 in Deep Well Socket wrench.



-225 Sensing Diaphragm Assembly
with Closed Spring Cartridge



Install -225 Sensing Diaphragm Assembly onto -225 Pilot Blank

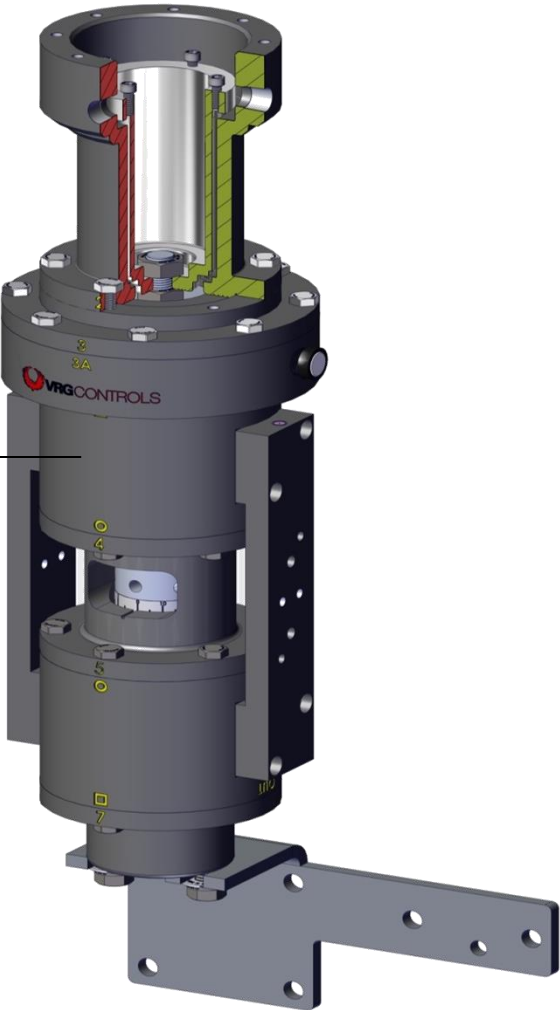


Instructions:

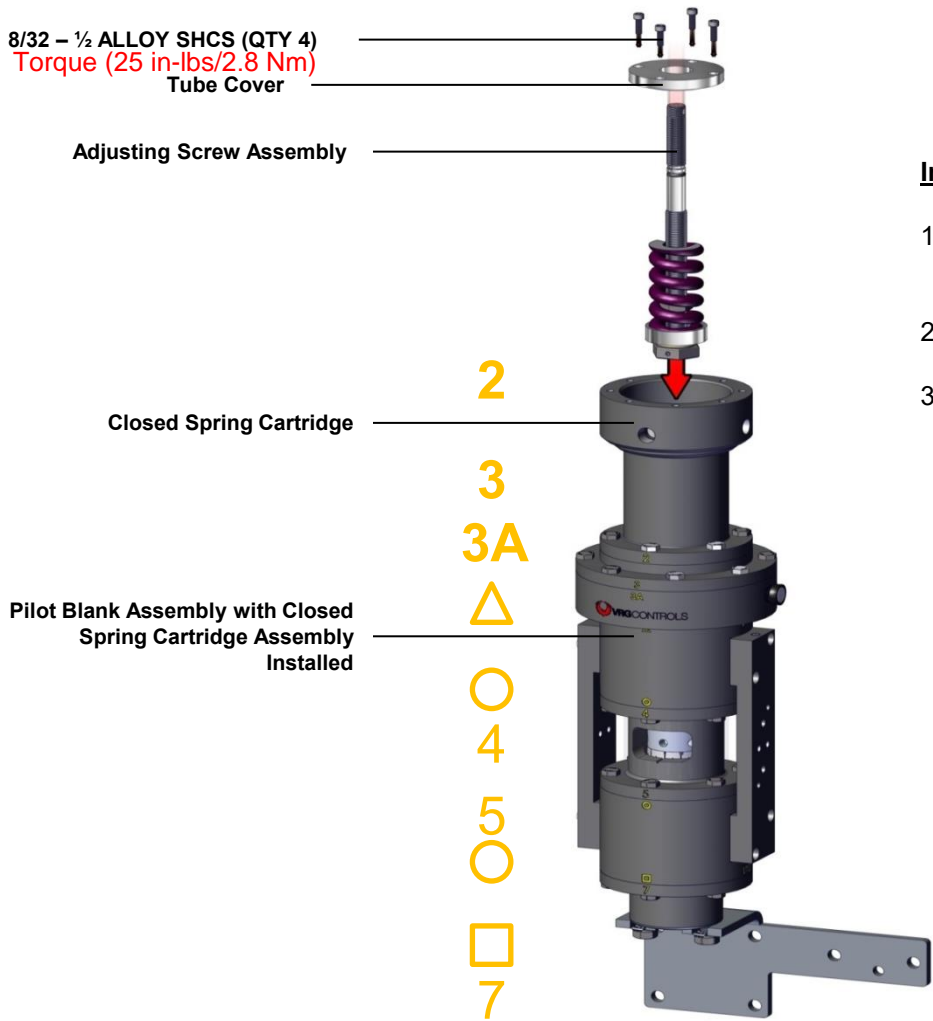
1. Spin -225 Sensing Diaphragm Assembly with Closed Spring Cartridge onto -225 Pilot Blank until it bottoms out
2. Adjust assembly so that “3A” and “3” align on front of -225 Pilot Blank Assembly
3. Bolt assembly together using 1/4 - 20 x 7/8 HHCS



-225 Pilot Blank & -225 Sensing
Diaphragm Assembly



Install Setpoint Adjusting Screw Assembly

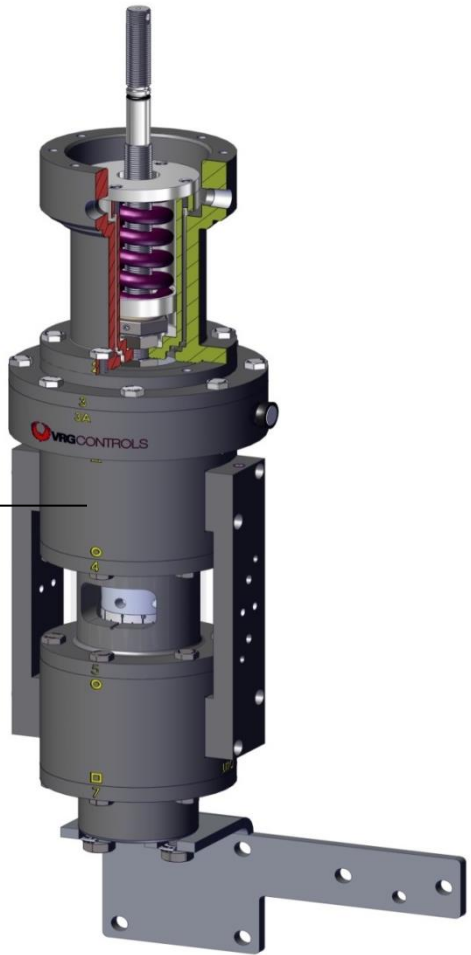


Instructions:

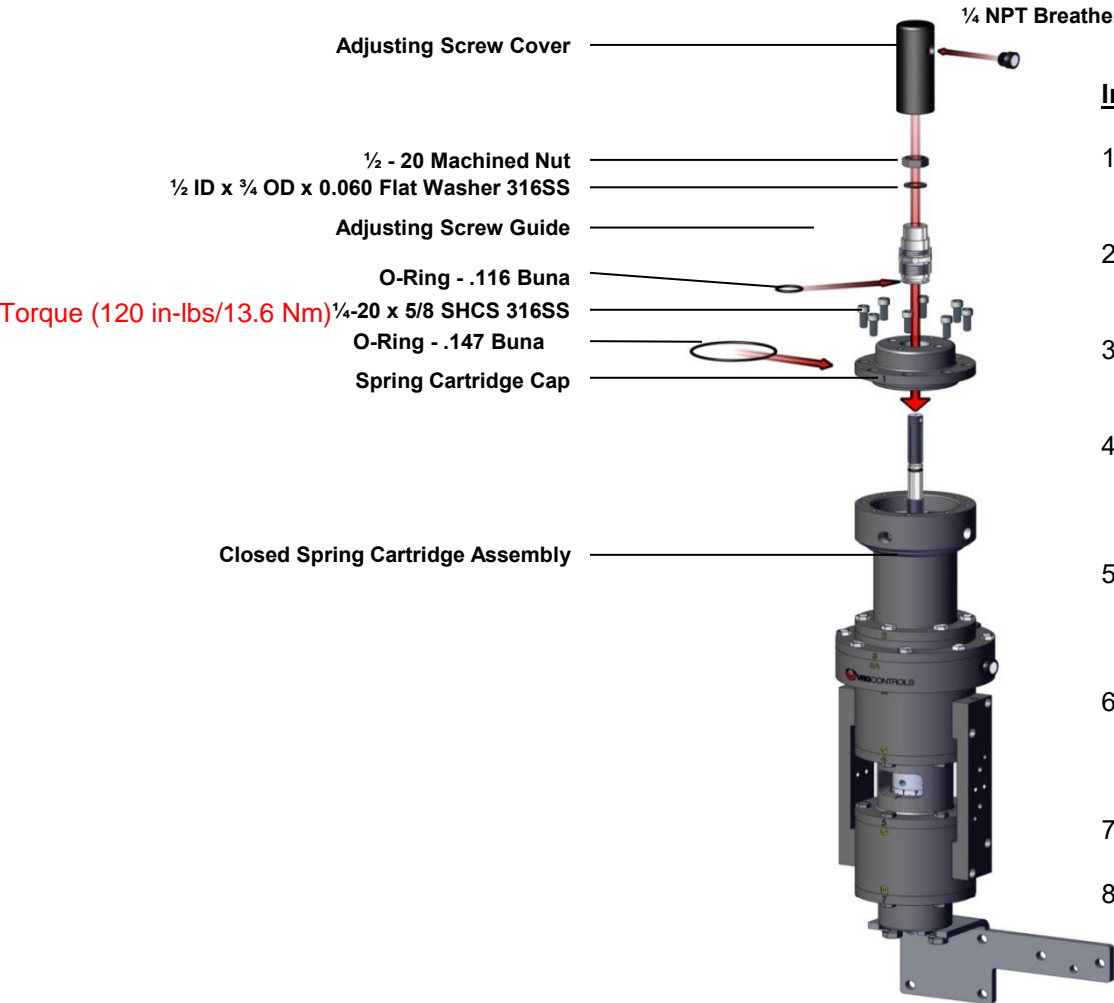
1. Slip entire Setpoint Adjusting Screw Assembly into Reversing Tube (inside Closed Spring Cartridge)
2. Insert 8/32 – 1/2 ALLOY SHCS into Tube Cover
3. Tighten 8/32 – 1/2 ALLOY SHCS in star pattern. Hold opposing side of Tube Cover down when tightening first screw to ensure proper alignment when tightening



Pilot Blank Assembly with
Setpoint Adjusting Screw
Assembly Installed



Install Spring Cartridge Cap Assembly



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
- 3
- 3A
- △
-
- 4
- 5
-
-
- 7





VPC-225-DA-SN Completed
Assembly with Fittings & Gages
Installed





VPC-225-DA-SN Completed
Assembly with Fittings & Gages
Installed

