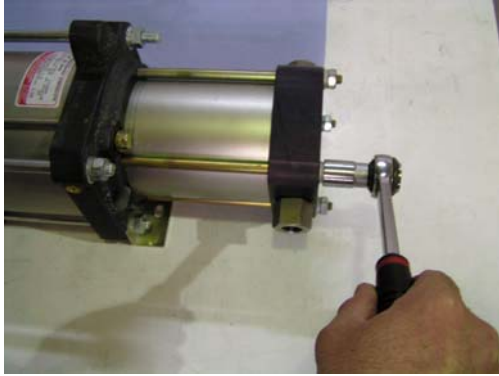


## 1.1 High-pressure sealing repair

### 1.1.1 Dismantling



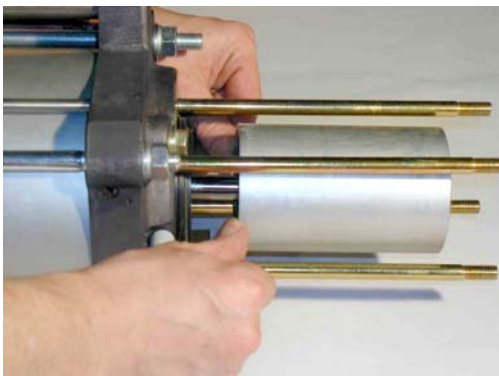
Loosen the four hexagon nuts from the stud bolts.



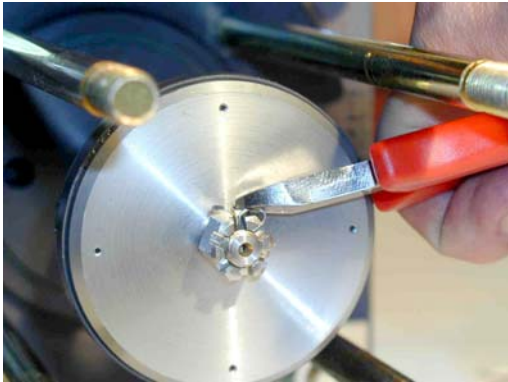
Carefully separate the compressor head by means of light taps with a plastic hammer from the HP cylinder.



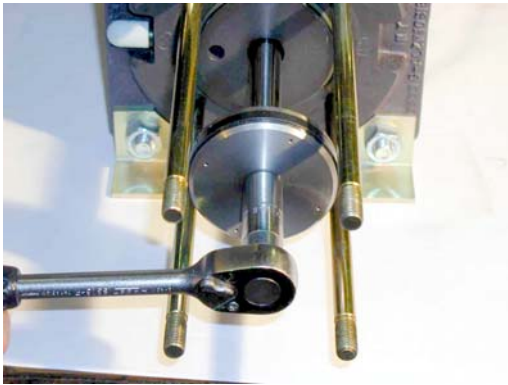
Loosen the HP cylinder by means of light taps with a plastic hammer from the top cover.



Draw the HP cylinder from the HP piston.



Remove the retaining pin of the castle nut.

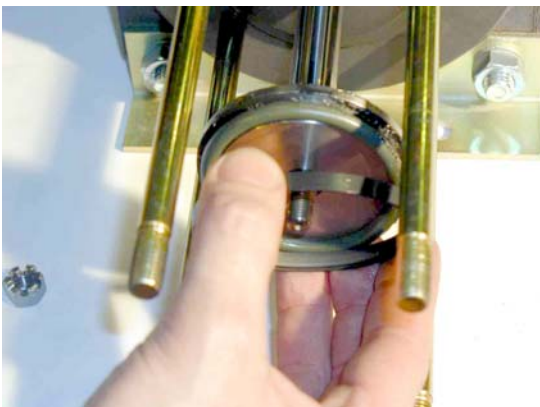


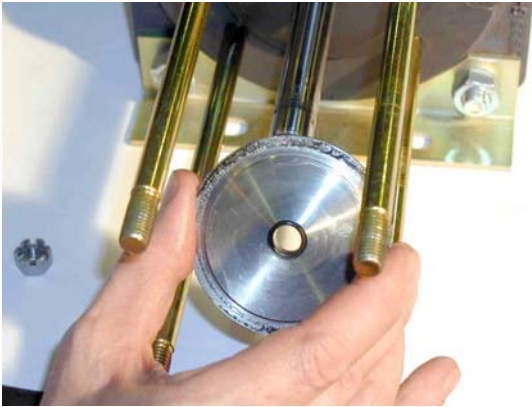
Loosen the castle nut. If the HP piston follows to turn, it is recommended to use an impact screwdriver to loosen the castle nut.



Remove the piston disk.

Remove the piston sealing ring and O ring from the HP piston.





Draw the HP piston from the piston rod.



Remove the O ring from the HP piston.



Remove the O rings of the HP head.



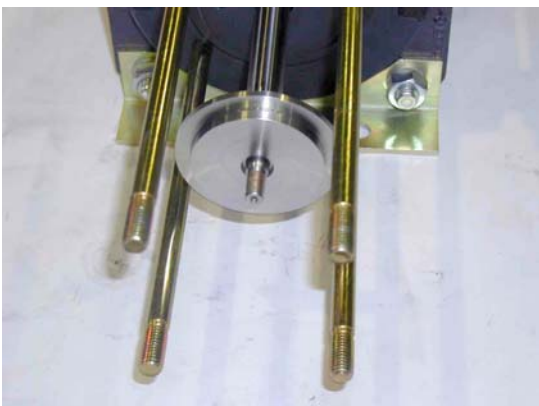
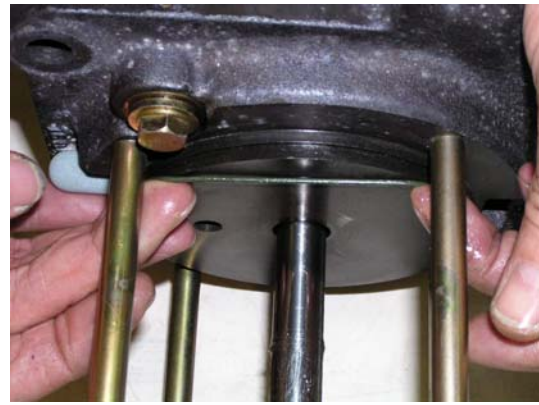
Dismantle the O ring that seals the HP cylinder.

## 1.1.2 HP piston assembly

Clean all re-used components and inspect them for any damage.

Slightly grease all sealing and guide elements.  
Use preferably MAXIMATOR grease Works No. 3610.1456.

Grease the top and bottom cover the O rings that seal the HP part and assemble the rings (first and second stage).



Attach the HP piston to the piston rod.

Grease the O ring and insert it into the groove between HP piston and piston rod.



Grease the O ring and mount it into the HP piston.



Grease the HP cylinder.



Insert the piston sealing ring into the HP cylinder and align the ring parallel ca. 13 mm below the cylinder edge.



Push the HP cylinder over the HP piston until the piston sealing ring fits close to the O ring.



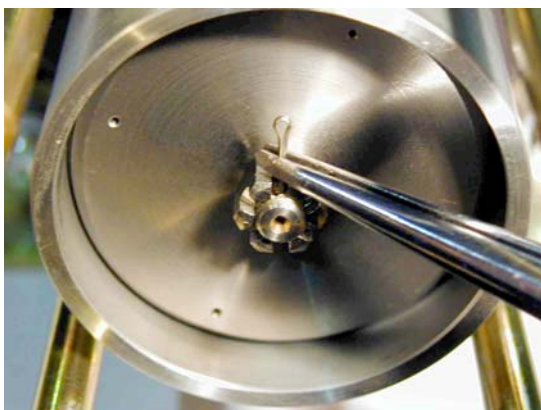
Attach the piston disk.



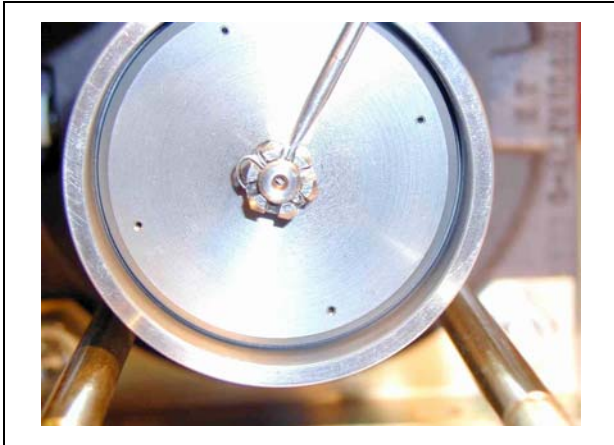
Attach the spring lock washer and the castle groove.



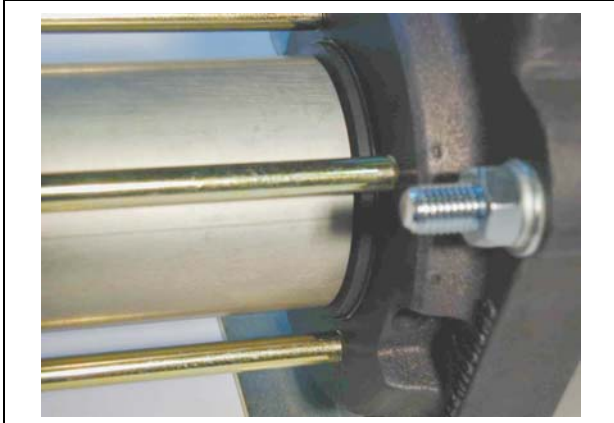
Tighten the castle groove with 25 Nm. The piston sealing ring is pushed onto the O ring during tightening.



Use the retaining pin to secure the castle nut (appropriately bend the retaining pin with a screwdriver).

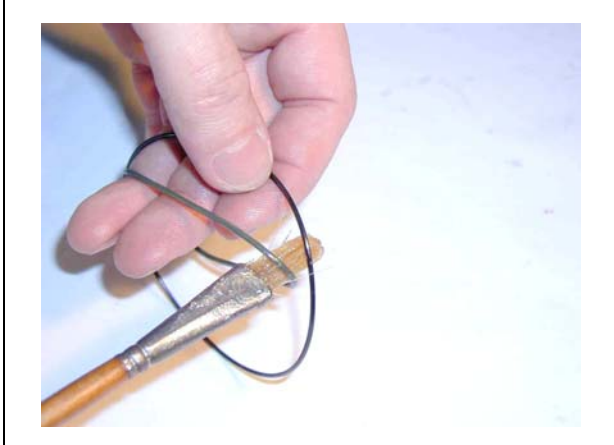


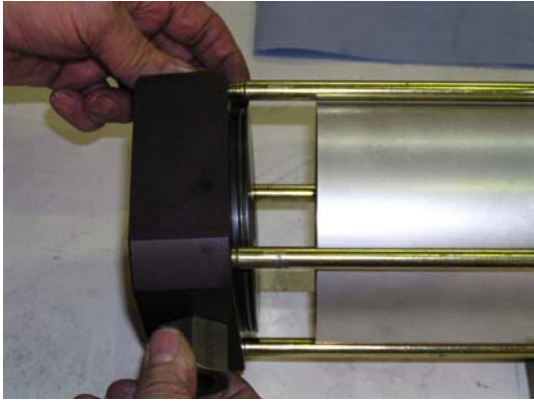
**1.1.3 HP cylinder assembly**



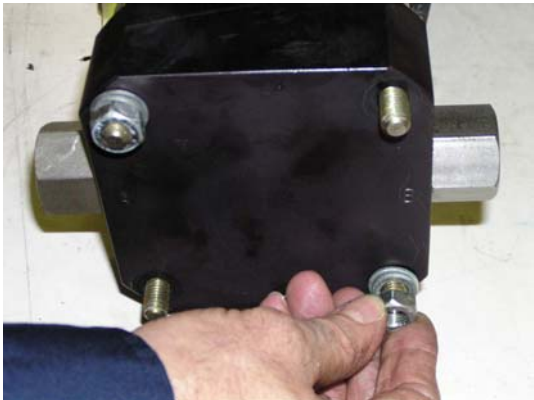
Push the HP cylinder over the O ring of the top cover till to the stopper.  
Caution: Make sure not to damage the O ring.

Grease and mount the O rings that seal the HP head.





Push the compressor head over the stud bolts. Make sure that the suction and pressure lines can be mounted without any warping.



Attach the hexagon nuts and screw retainers to the stud bolts. (Do not tighten!)