

M & M Services, LLC

Welding & Gas Cutting Equipment Repair

11803 Carmenita Rd.

Whittier, CA 90605

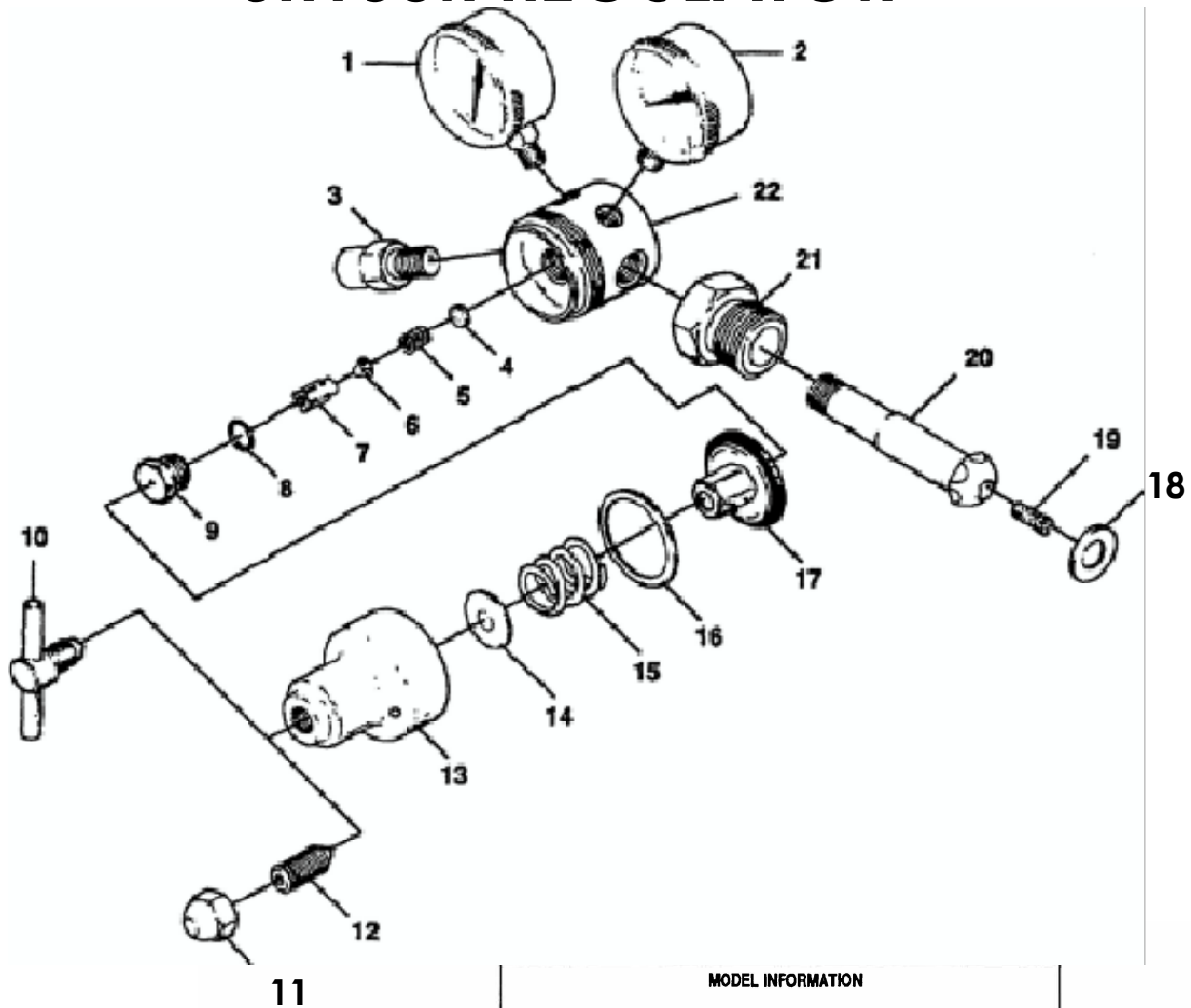
(562) 944-7440

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**FOR MORE BREAKDOWNS OR ASSISTANCE
FINDING PARTS YOU NEED, PLEASE EMAIL:**

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VICTOR AF150/CF153 FLOW REGULATORS & SR150R REGULATOR



MODEL INFORMATION

GAS	CGA Inlet No.	Model No.	Delivery Range
Argon & Argon/CO Mix	580	AF 150	8-25 SCFH
Argon & Argon/CO Mix	580	AFP 150	Preset @ 11 SCFH
CO ₂	320	CF 153	8-20 SCFH
CO ₂	320	CFP 153	Preset @ 10 SCFH
Oxygen	540	SR 150CR	4-60 PSIG
Acetylene	200	SR 160AR	2-15 PSIG

PARTS LIST

Ref. No.	Description	SR 150R	SR 160R	AF 150 CF 153	AFP 150 CFP 153	Ref. No.	Description	SR 150R	SR 160R	AF 150 CF 153	AFP 150 CFP 153
1	L.P./Flow Gauge	See Chart 1	See Chart 1	See Chart 1	See Chart 1	13	Housing Cap	0720-0206	0720-0206	0720-0206	0720-0206
2	H.P. Gauge	See Chart 1	See Chart 1	See Chart 1	See Chart 1	14	Spring Button	0706-0015	0706-0015	0706-0015	0706-0015
3	Outlet Connection	See Chart 2	See Chart 2	See Chart 2	See Chart 2	15	Adjusting Spring	See Chart 1	See Chart 1	See Chart 1	See Chart 1
4	Filter	0717-0038	0717-0038	0717-0038	0717-0038	16	Slip Ring	0705-0016	0705-0016	0705-0016	0705-0016
5	Valve Spring	0762-0060	0762-0060	0762-0060	0762-0060	17	Diaphragm Assembly	See Chart 1	See Chart 1	See Chart 1	See Chart 1
6	Friction Damper	0738-0015	0738-0015	0738-0015	0738-0015	18	Washer (CGA 320 Only)			1408-0065	1408-0065
7	Poppet Assembly	See Chart 1	See Chart 1	See Chart 1	See Chart 1	19	Filter	0717-0003	0717-0003	0717-0003	0717-0003
8	Nozzle Gasket	1408-0107	1408-0107	1408-0107	1408-0107	20	Inlet Swivel	See Chart 2	See Chart 2	See Chart 2	See Chart 2
9	Nozzle	See Chart 1	See Chart 1	See Chart 1	See Chart 1	21	Inlet Nut	See Chart 2	See Chart 2	See Chart 2	See Chart 2
10	Adjusting Screw	0750-0016	0750-0016	0750-0016	0750-0016	22	Body	See Chart 1	See Chart 1	See Chart 1	See Chart 1
11	Cap Nut	1403-0011	1403-0011	1403-0011	1403-0011						
12	Adjusting Screw	0750-0026	0750-0026	0750-0026	0750-0026						

CHART 1

Description	SR 150R	SR 160R	AF 150 CF 153	AFP 150 CFP 153
Adjusting Spring	0761-0001	0761-0000	0761-0125	0761-0125
Diaphragm Assembly	0730-0081	0730-0082	0730-0067	0730-0067
Nozzle	0702-0073	0702-0073	0702-0072	0702-0072
Poppet Assembly	0739-0025	0739-0026	0739-0028	0739-0028
Body	0701-0267	0701-0267	0701-0261	0701-0262
H.P. Gauge	1424-0150	1424-0322	1424-0150	1424-0150
L.P. Gauge	1424-0321	1424-0320	1424-0254	N/A

CHART 2

Gas	CGA No.	Inlet Swivel	Inlet Nut	Outlet Connection
Oxygen	540	0967-0119	0967-0044	0950-0027
Acetylene	200	0964-0020	0964-0004	0960-0018
Argon & Argon/CO Mix	580	0970-0005	0973-0003	0950-0137
CO ₂ *	320	0985-0004	0985-0030	0950-0137

*Inlet washer 1408-0065 is required for CGA 320 inlet connections.

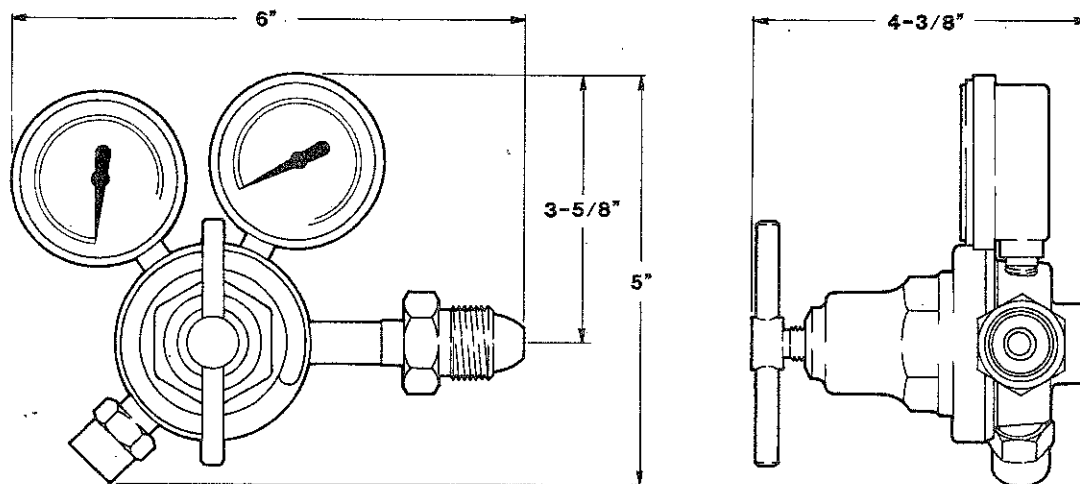
VICTOR®

AF 250 AND CF 253 FLOWGAUGE REGULATORS

PARTS AND SERVICE BULLETIN

FORM NO. 56-656

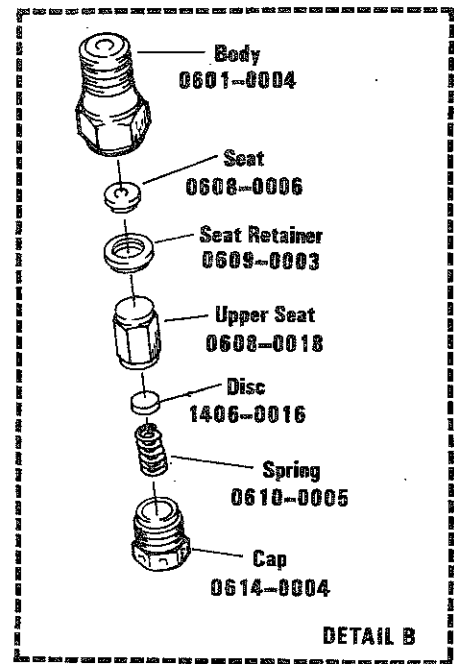
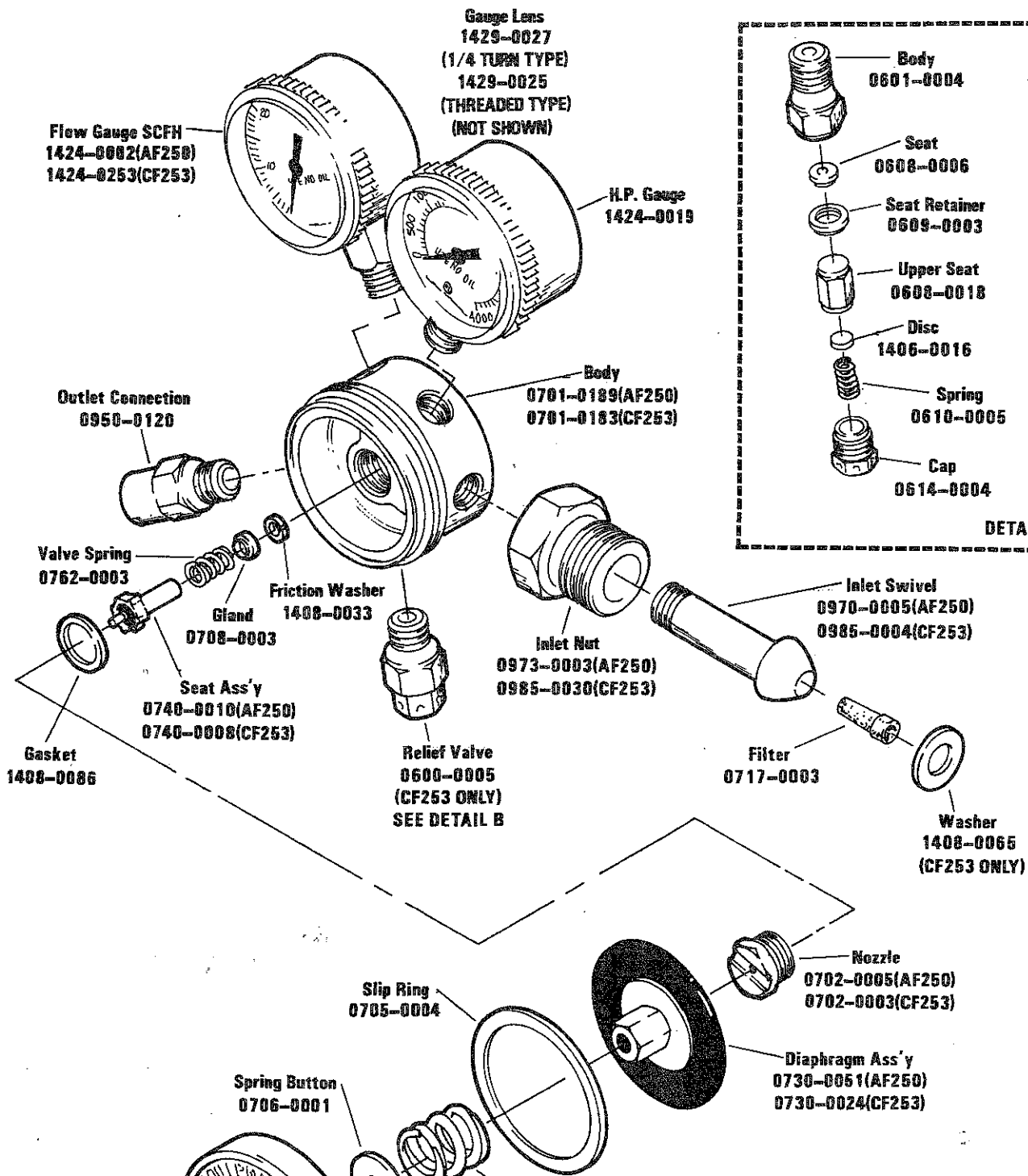
EFFECTIVE 9-86



MODEL INFORMATION

Model No.	Gas	CGA Inlet No.	Flow Range
AF 250	Argon	580	10-40 SCFH
CF 253	Carbon Dioxide	320	7-35 SCFH 4-16 LPM

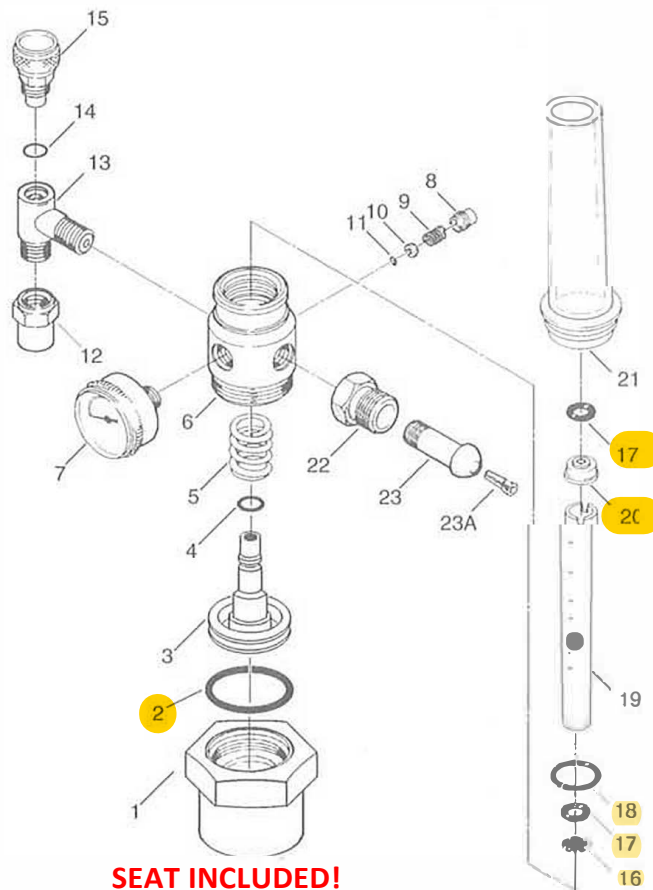
WARNING



VICTOR HRF1425 & HRF1480

PARTS LIST

Ref. No.	Description	HRF1425	HRF1480
1	Cap	0720-0209	0720-0209
* 2	O-Ring	1407-0226	1407-0226
3	Piston Ass'y w/Seat	0738-0025	0738-0025
* 4	O-Ring	1407-0225	1407-0225
5	Adjusting Spring	0761-0126	0761-0127
6	Body	0701-0332	0701-0332
7	Gauge	1424-0001	1424-0001
8	Retainer	0608-0065	0608-0065
9	Spring	0610-0010	0610-0010
10	Seat Retainer	0609-0001	0609-0001
*11	O-Ring	1407-0032	1407-0032
12	Adaptor	0911-0050	0911-0050
13	Outlet Block	0661-0116	0661-0116
*14	O-Ring	1407-0007	1407-0007
*15	Valve Assembly	0662-0067	0662-0067
*16	Screen	0717-0033	0717-0033
*17	O-Ring (2 Req'd)	1407-0015	1407-0015
*18	O-Ring	1407-0194	1407-0194
19	Flow Tube & Float	1015-0057	1015-0058
*20	Burst Capsule	1014-0002	1014-0002
21	Flowmeter Cover	1002-0001	1002-0001
22	Inlet Nut	0973-0003	CHART 1
23	Inlet Swivel w/Filter	0970-0015	CHART 1
23A	Filter	0717-0003	0717-0003
24	Inlet Washer	N/A	CHART 1



SEAT INCLUDED!
(Not pictured)

The replaceable seat for the piston assembly (#3) p/n 0741-0127

REPAIR KIT: 0790-0067

* Items most commonly required for repair and recommended for stock. (These items are included in Repair Kits).

CHART 1

Model No.	Gas	CGA Inlet No.	Swivel	Nut	Inlet Washer
HRF1480-320	Carbon Dioxide	320	0985-0004	0985-0030	1408-0065
HRF1480-580	Argon Argon/CO ₂ Mix	580	0970-0015	0973-0003	N/A

VICTOR®

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Victor Equipment Company

Customer Service
P.O. Box 1007
Denton, TX 76202-1007
800-426-1888
FAX 800-535-0557

Executive Offices
101 S. Hanley Road
St. Louis, MO 63105
314-721-5573
FAX 314-721-4822

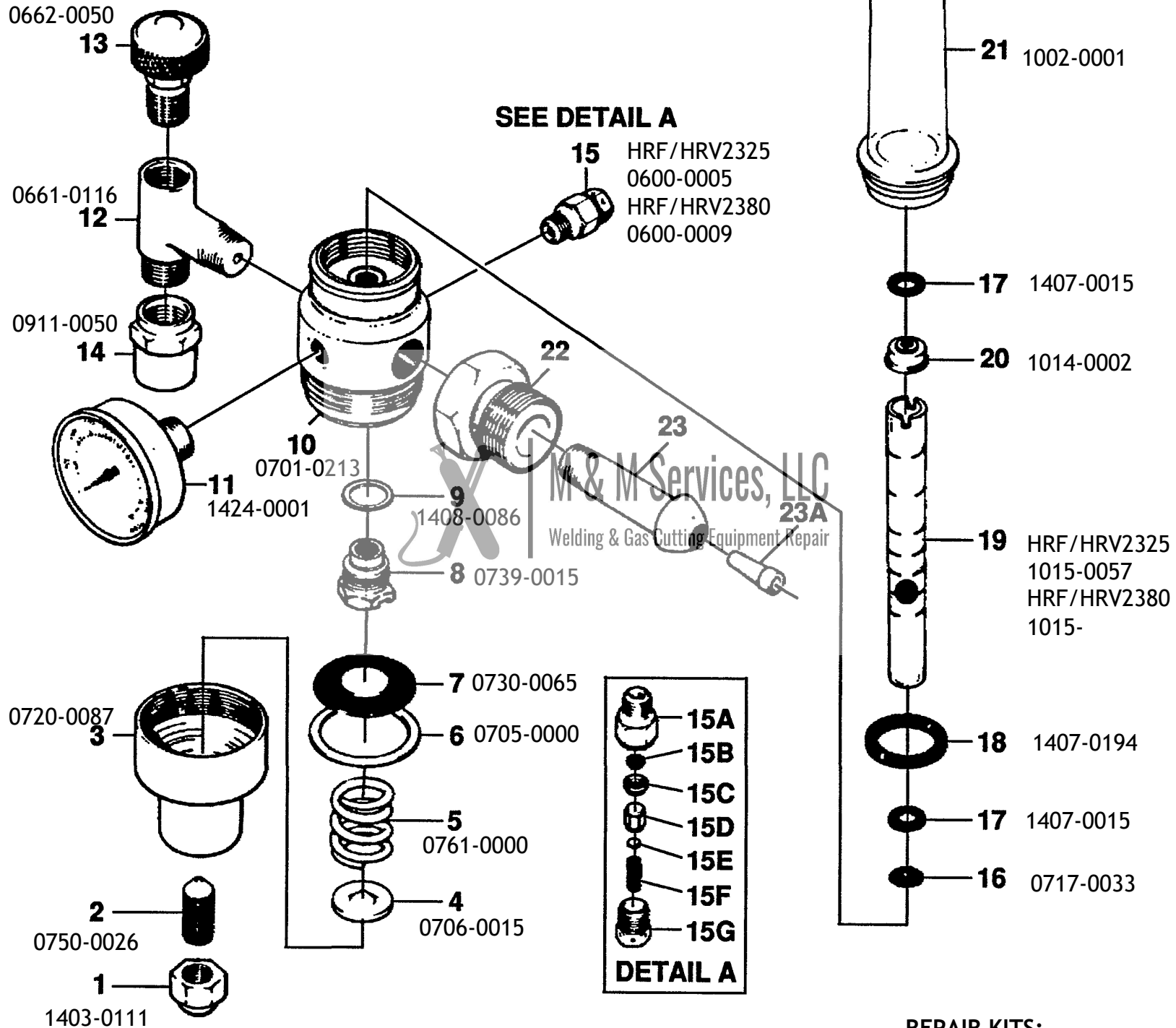
International
P.O. Box 12250
Wichita, KS 67277
316-942-6501
FAX 316-946-8130

Canada
2220 Wycroft Road
Oakville, Ontario, Canada L6L5V6
905-827-1111
FAX 905-827-3648

Europe
Europa Building
Chorley North Industrial Park
Chorley, Lancashire PR6 7BX, England
44-2572-61755
FAX 44-2572-61756

Victor HRF2325 / HRF2380 Victor HRV2325 / HRV2380

11803 Carmenita Rd.
Whittier, CA 90605
(562) 944-7440
www.mandmservicesllc.com



DETAIL A - SAFETY RELIEF VALVE

INLET NUT & NIPPLE

- 22 (HRF2325) 580NU
- 22 (HRF2380) 320NU
- 23 (HRF2325) 580NI
- 23 (HRF2380) 580NI
- #23 INCLUDES 23A (FILTER)

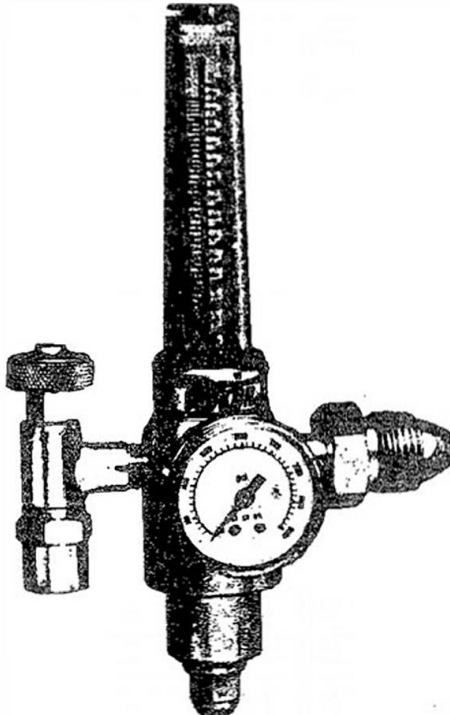
- 15A 0601-0004
- 15B 0608-0006
- 15C 0609-0003
- 15D 0608-0018
- 15E 1406-0016
- 15F 0610-0005(2325) 0610-0007(2380)
- 15G 0614-0004

REPAIR KITS:

- HRF2325/HRV2325
0790-0120
- HRF2380/HRV2380
0790-0119
- HRF2325 CGA580
- HRF2380 CGA320

VICTORWELDING & CUTTING
APPARATUS

56-0660

**MODEL HRF2380 / HRF2325
REGULATOR-FLOWMETER
COMBINATION
Parts Bulletin****MODEL INFORMATION**

Model No.	Gas	Inlet Connection CGA	Flow Range SCFH
HRF2380	Carbon Dioxide	320	8-28
HRF2325	Argon and Helium	580	20-150 (HELIUM) 10-50 (ARGON)

SERVICE NOTES

- (1) Use Loctite Number 222 on all pipe threads.
- (2) Use Lubricant (0034-0021) on adjusting screw, O-rings, and needle valve.
- (3) Use 15 foot lbs. torque to tighten cap.
- (4) Clean all metal parts with trichlorethylene before assembly. **DO NOT** allow O-rings, seats, diaphragm or plastic parts to come into contact with trichlorethylene as damage will occur.
- (5) To clean inlet filter, blow-out filter in reverse direction to normal flow.
- (6) Preset to 80 psig. (HRF2380). Preset to 25 psig (HRF2325).

NOTE: FOR REPAIR TOOLS SEE REPAIR TOOLS MANUAL, FORM NO. 56-121.

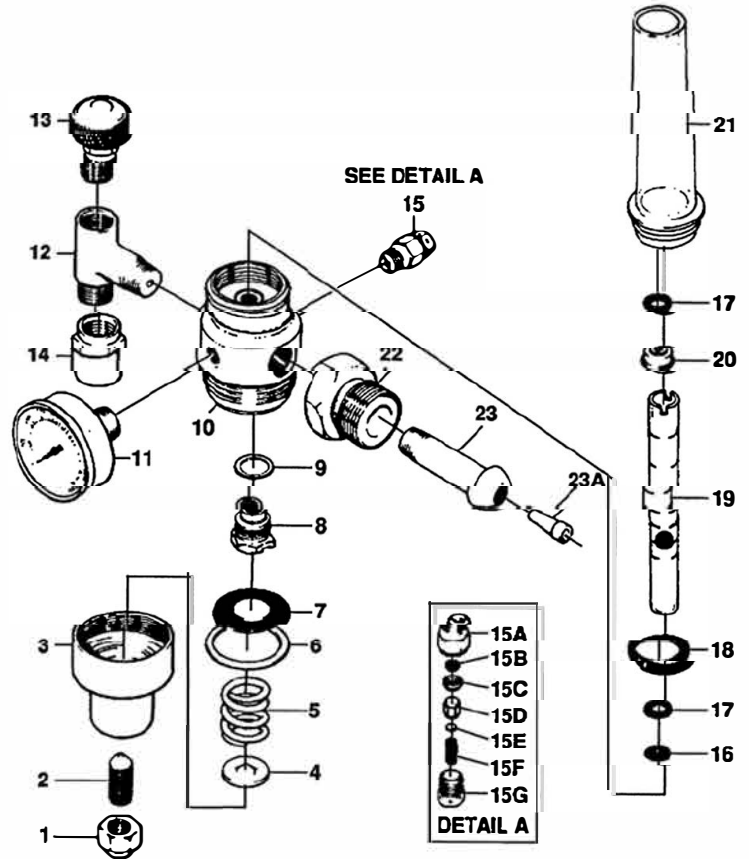
CAUTION

Welding apparatus improperly maintained or repaired can be dangerous. Some parts and accessories manufactured by others may fit VICTOR apparatus but not conform to VICTOR's exacting standards. For your own protection, specify and use only VICTOR-made parts and accessories with your VICTOR apparatus.

Service or repair of VICTOR apparatus should be performed only by an authorized VICTOR repair technician. Improper service or repair, or modification of the product could result in damage to the product or injury to the operator.

PARTS LIST

Ref. No.	Description	HRF2325	HRF 2380
1	Cap Nut	1403-0011	1403-0011
2	Adjusting Screw	0750-0026	0750-0026
3	Cap	0720-0087	0720-0087
4	Spring Button	0706-0015	0706-0015
5	Adjusting Spring	0761-0000	0761-0000
6	Sip Ring	0705-0000	0705-0000
7	Diaphragm Ass'y.	0730-0065	0730-0065
8	Cartridge	0739-0015	0739-0015
9	Gasket	1408-0086	1408-0086
10	Body	0701-0213	0701-0213
11	Gauge	1424-0001	1424-0001
12	Valve Body	0661-0116	0661-0116
13	Control Valve Ass'y	0662-0050	0662-0050
14	Adaptor	0911-0050	0911-0050
15	Safety Valve	0600-0005	0600-0009
15A	Body	0601-0004	0601-0004
15B	Seat	0608-0006	0608-0006
15C	Seat Retainer	0609-0003	0609-0003
150	Upper Seat	0608-0018	0608-0018
15E	Disc	1406-0016	1406-0016
15F	Spring	0610-0005	0610-0007
15G	Cap	0614-0004	0614-0004
16	Screen	0717-0033	0717-0033
17	O-Ring (2 Req'd)	1407-0015	1407-0015
18	O-Ring	1407-0194	1407-0194
19	Flow Tube & Float	1015-0057	1015-0060
20	Burst Capsule	1014-0002	1014-0002
21	Flowmeter Cover	1002-0001	1002-0001
22	Inlet Nut	0973-0003	0985-0030
23	Inlet Swivel W/Filter	0970-0015	0985-0004
23A	Filter	0717-0003	0717-0003
Not Shown	Inlet Washer	N/A	1408-0065



REPAIR KITS

HRF 2380	0790-0119
HRF 2325	0790-0120

*Items most commonly required for repair and recommended for stock



WORLD HEADQUARTERS: 101 S. Hanley Road • St. Louis, MO 63105 • 314-721-5573 • FAX 314-721-4822

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Victor Equipment Company

U.S.A.
Customer Service
P.O. Box 1007
Denton, TX 76202-1007
800-426-1888
FAX 800-535-0557

International Customer Service
2220 Wyecroft Road
Oakville, Ontario L6L5V6
Canada
905-827-9777
FAX 905-827-9797

Canada
2220 Wyecroft Road
Oakville, Ontario L6L5V6
Canada
905-827-1111
FAX 905-827-3648

Europe
Europa Building
Chorley North Industrial Park
Chorley, PR6 7BX, England
44-1257-261755
FAX 44-1257-261756

Asia/Pacific PTE, Ltd.
Hillview House Units 401-403
1 Jalan Remaja
Singapore 668662
65-763 4022
FAX 65-763-5812

Mexico
Calle de Zaragoza #25
Col. Santa Cruz Atoyac
C.P. 03910 Mexico, D.F.
52-5-605-8408
FAX 52-5-604-9671

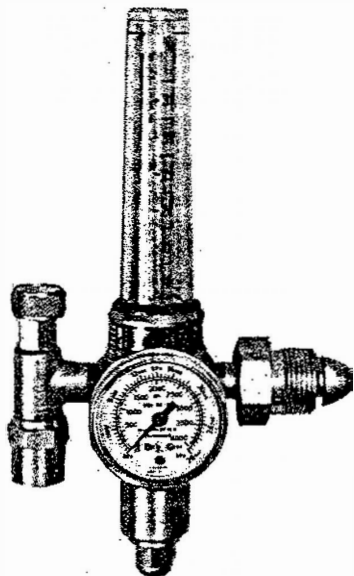
VICTOR®

PARTS & SERVICE BULLETIN

MODEL HRF2425 / HRF2480 REGULATOR-FLOWMETER COMBINATION

FORM NO. 0056-1294

EFFECTIVE: November 1990



MODEL INFORMATION

Model No.	Gas	Inlet Connection CGA	Delivery Range (SCFH)
HRF2425	Argon Argon/CO ₂ Mix Helium	580	5-50 5-40 20-150
HRF2480	Carbon Dioxide	320	8-28
HRF2480	Argon Argon/CO ₂ Mix	580	7.5-37.5 10-38

SERVICE NOTES

1. Before assembly, clean all metal parts with a cleaner that is safe for use with high pressure oxygen. Contact a chemical/cleaning supply distributor for recommended cleaners for use with high pressure oxygen. Always use cleaning solvents in accordance with the manufacturer's instructions. **WARNING: DO NOT** allow nonmetal parts to come in contact with any cleaning solvent! Cleaning solvents cause elastomeric and plastic parts to swell and stress crack. If these parts require cleaning, use a mild soap solution, followed by thorough rinsing in water. Dry these parts completely before installing in the Regulator. **REPLACE NONMETAL PARTS THAT HAVE COME IN CONTACT WITH OIL, GREASE OR ANY OTHER PETROLEUM BASED SUBSTANCE!**
2. Use LOCTITE® #79 Thread Sealant (0028-0056) on all pipe threads.
3. Use LIQUID O-RING® #151L (0034-0021) on Adjusting Screw, O-rings, and Needle Valve.
4. Tighten Cap to a torque of 15 foot-lbs.
5. Blow out Filter in reverse direction to normal flow to clean Inlet Filter.
6. Tighten Nozzle to a torque of 8-10 foot-lbs.
7. Preset to 25 PSIG (HRF2425). Preset to 80 PSIG (HRF2480).

NOTE: For additional information, refer to Apparatus Service and Testing Procedures (Form No. 56-0886) and Repair Tools Manual (Form No. 56-0121).

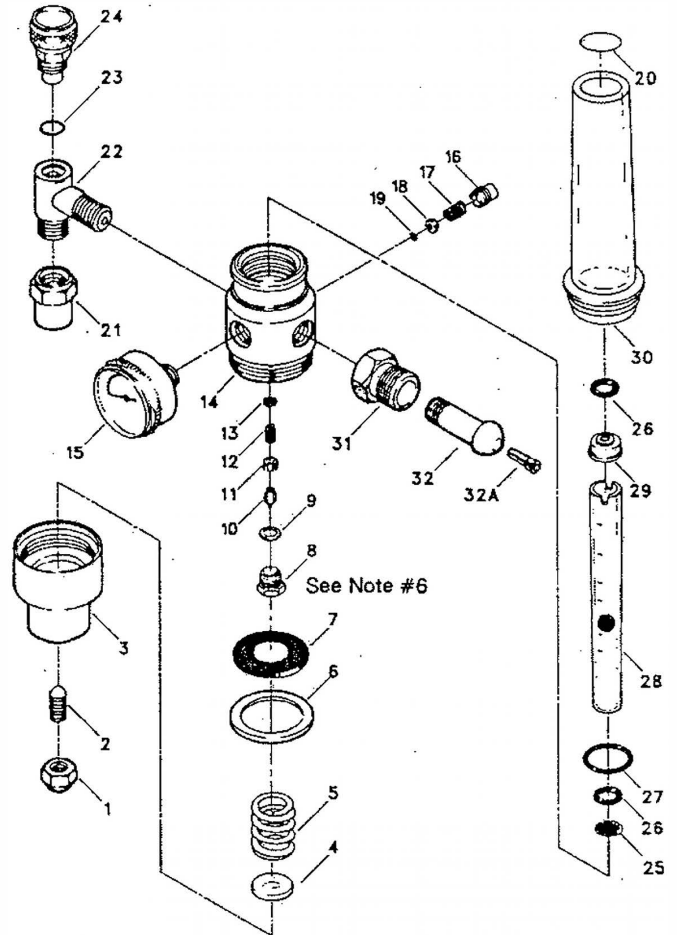
⚠ WARNING

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PARTS LIST

NO.	Description	HRF2425	HRF2480
1	Cap Nut	1403-0011	1403-0011
2	Adjusting Screw	0750-0026	0750-0026
3	Cap	0720-0205	0720-0205
4	Spring Button	0706-0015	0706-0015
5	Adjusting Spring	0761-0000	0761-0000
*6	Slip Ring	0705-0016	0705-0016
*7	Diaphragm Assembly	0730-0065	0730-0065
8	Nozzle	0702-0073	0702-0073
*9	Gasket	1408-0107	1408-0107
*10	Poppet Assembly	0739-0025	0739-0025
*11	Friction Damper	0738-0005	0738-0005
12	Spring	0762-0060	0762-0060
13	Filter	0717-0038	0717-0038
14	Body	0701-0314	0701-0314
15	Gauge	1424-0001	1424-0001
16	Retainer	0608-0065	0608-0065
17	Spring	0610-0012	0610-0043
18	Seat	0609-0002	0609-0002
*19	O-Ring	1407-0255	1407-0032
20	Decal	1415-0088	1415-0088
21	Adaptor	0911-0050	0911-0050
22	Outlet Block	0661-0116	0661-0116
23	O-Ring	1407-0007	1407-0007
*24	Valve Assembly	0662-0067	0662-0067
*25	Screen	0717-0033	0717-0033
*26	O-Ring (2 Req'd)	1407-0015	1407-0015
*27	O-Ring	1407-0194	1407-0194
28	Flow Tube & Float	1015-0057	1015-0058
*29	Burst Capsule	1014-0002	1014-0002
30	Flowmeter Cover	1002-0001	1002-0001
31	Inlet Nut	0973-0003	CHART 1
32	Inlet Swivel w/Filter	0970-0015	CHART 1
32A	Filter	0717-0003	0717-0003
33	Inlet Washer	N/A	CHART 1



28A red ball/float 1405-0023

REPAIR KITS

HRF2480	0790-0131
HRF2425	0790-0132

* Items most commonly required for repair and recommended for stock. (These items are included in Repair Kits).

CHART 1

Model No.	Gas	CGA Inlet No.	Swivel	Nut	Inlet Washer
HRF2480-320	Carbon Dioxide	320	0985-0004	0985-0030	1408-0065
HRF2480-580	Argon Argon/CO ₂ Mix	580	0970-0015	0973-0003	N/A

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Victor Equipment Company

VICTOR®

U.S.A.
Customer Service
P.O. Box 1007
Denton, TX 76202-1007
800-426-1888
FAX 800-535-0557

International Customer Service
2220 Wycroft Road
Oakville, Ontario L6L5V6
Canada
905-827-9777
FAX 905-827-9797

Canada
2220 Wycroft Road
Oakville, Ontario L6L5V6
Canada
905-827-1111
FAX 905-827-3648

Europe
Europa Building
Chorley North Industrial Park
Chorley, PR6 7BX, England
44-1257-261755
FAX 44-1257-261756

Asia/Pacific PTE, Ltd.
Hilview House Units 401-403
1 Jalan Remaja
Singapore 2366
65-763-4022
FAX 65-763-5812

Mexico
Calle de Zaragoza #25
Col. Santa Cruz Atoyac
C.P. 03910 Mexico, D.F.
52-5-605-8408
FAX 52-5-604-9671



FLOWMETER REGULATOR

355

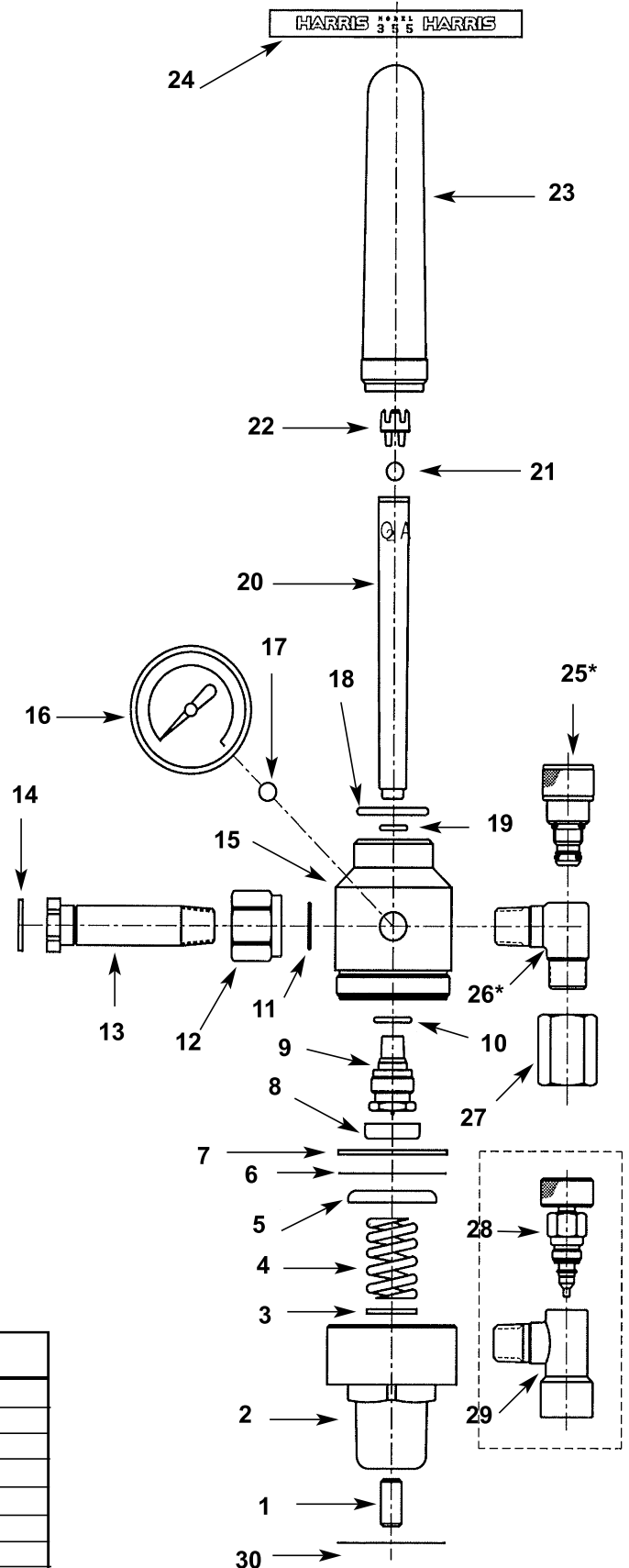


Product Key

PART NO.	MODEL NO.	DESCRIPTION	CODE
3100201	355-CD-320	Flowmeter Reg., Carbon Dioxide	A
3100200	355-Ar-580	Flowmeter Reg., Argon	B
3100204	355-Ar/He-580	Flowmeter Reg., Argon	C
3100205	355-He-580	Flowmeter Reg., Helium	D
3100207	355-N ₂ /AIR-580	Flowmeter Reg., Nitrogen	E
3100206	355-N ₂ /AIR-590	Flowmeter Reg., Ind. Air	F

Parts List

REF. NO.	PART NO.	MODEL NO.	DESCRIPTION	CODE
1	9000833		Screw, pressure adj.	A thru F
2	9000019	0110-B	Bonnet	A thru F
3	9003974	9264-3	Pivot	A thru F
4	9000084	0185-3	Spring	A thru F
5	9000028	0133	Disc, Diaphragm	A thru F
6	9000058	0171	Slip ring	A thru F
7	9005120	30132	Diaphragm, Neo/Poly	A thru F
8	9005122	30166	Plate, plunger	A thru F
9	9100601	A-301-0	Capsule	A thru F
10	9005112	30196	O-Ring, capsule	A thru F
11	9004030		Ring, retaining	A
12	9002986	6659-E	Nut, Carbon Dioxide CGA-320	A
	9003048	6659-T	Nut, Ar, N ₂ , He CGA-580	B thru E
	9003052	6659-U	Nut, Industrial air CGA-590	F
13	9005114		Inlet Stem, CGA-320 1/4NPT 2.5"	A
	9005109		Inlet stem, CGA-580,510,590 1/4 NPT 3.5"	B thru F
14	9002908	6639-G	Gasket	A
15	9001047	35510-2	Body	A thru F
16	9001036		Gauge, 11/2" 4000# back mount	A thru F
17	9008148		Filter	A thru F
18	9000811	2-118	O-Ring, 2-118	A thru F
19	9000812	5-052	O-Ring, 5-052	A thru F
20	9105500		Tube, 5592-AR/CD Flow	A, B
	9105504		Tube, 5592-AR/He Flow	C
	9105502		Tube, 5592-He/H ₂ Flow	D
	9105503		Tube, 5592-N/Air Flow	E, F
21	9002370		Ball, .250 S.S.	A, B
	9005403		Ball-Float-Black Glass	C
	8805404		Ball, Float for Hyd. FM RD	D
	8805400		Ball, 316 S.S.	E, F
22	9000806		Bumper	A thru F
23	9000809	86029	Tube cover	A thru F
24	9000810		Decal (not sold)	A thru F
25*	9105505	5595	Needle valve Assy. (Inc. o-ring)	A thru F
26*	8801060	35510-1	Outlet, Needle valve	A thru E
	8801059	35510-L	Outlet, Needle valve	F
27	9000002		Adaptor,	A thru E
28	9100929	86195	Needle valve Assy. (Inc. o-ring)	A thru E
29	8801061	35510-2	Body, RH N.V-Outlet	A thru F
30	-		Nameplate (not sold)	A thru F



*Note: To be obsolete. If not available replace with items 28 & 29

Service Notes

ITEM NO.	TORQUE	SERVICE TOOL OR NOTES
1		Use Permatex-Lock Nut, Set 21-23 PSI @ Flow
2	18-22 ft./lb.	1 3/16 Hex socket wrench
9	10-14 ft./lb.	5/8 Hex socket wrench
10 & 19		Water lube
13	18-26 ft./lb.	11/16 Hex socket wrench
16		7/16 Open end wrench. Use PTFE tape
18		Use Christo-Lube MCG 111 or 128 on 9000811
25 & 28	7-10 ft./lb.	9/16 Open end wrench
26 & 29	18-26 ft./lb.	5/8 Open end wrench. Loctite® 290

04/26/2013



FLOWMETER REGULATOR

355-2

Product Key

PART NO.	MODEL NO.	DESCRIPTION	CODE
3100201	355-2 CD/Ar-320	Flowmeter Reg., Carbon Dioxide	A
3100200	355-2 Ar-580	Flowmeter Reg., Argon	B
3100204	355-2 Ar/He-580	Flowmeter Reg., Argon	C
3100205	355-2 He-580	Flowmeter Reg., Helium	D
3100207	355-2 N ₂ /AIR-580	Flowmeter Reg., Nitrogen	E

Parts List

REF. NO.	PART NO.	MODEL NO.	DESCRIPTION	CODE
1	8802591		Screw, Pressure Adj.	A thru E
2	9000649	60111	Bonnet	A thru E
3	9003974	9264-3	Pivot	A thru E
4	9000669		Spring	A thru E
5	9000638	60133A	Plate, Backing	A thru E
6	9000635	60171	Slip ring	A thru E
7	9000639	30132	Diaphragm,	A thru E
8	9000641	60133	Cap	A thru E
9	9100601	A-301-0	Valve-Asy	A thru E
10	9005112	30196	Seal, Valve Asy.	A thru E
11	9004030		Ring-Retaining	A
12	9002986	6659-E	Nut, Carbon Dioxide CGA-320	A
	9003048	6659-T	Nut, Ar, N ₂ , He CGA-580	B thru E
13	9005114		Inlet Stem, CGA-320 1/4NPT 2.5"	A
	9005109		Inlet stem, CGA-580, 1/4 NPT 3.5"	B thru E
14	9002908	6639-G	Gasket	A
15	9001051	35510-4	Body,	A thru E
16	9001036		Gauge, 1-1/2" 4000# back mount	A thru E
17	9008148		Filter	A thru E
18	9000811	2-118	O-Ring, 2-118	A thru E
19	9105500		Tube, 5592-AR/CD Flow	A, B
	9105504		Tube, 5592-AR/He Flow	C
	9105502		Tube, 5592-He/H ₂ Flow	D
	9105503		Tube, 5592-N ₂ /Air Flow	E, F
20	9002370		Ball, 250 S.S.	A, B
	9005403		Ball-Float-Black Glass	C
	8805404		Ball, Float for Hyd. FM RD	D
	8805400		Ball, 316 S.S.	E
21	9000809	86029	Tube Cover	A thru E
22	9000810		Decal (not sold)	A thru E
23	9000806		Bumper	A thru E
24	9000812	5-052	O-Ring, 5-052	A thru E
25	9100929	86195	N.V-Asy,	A thru E
26	8801061	35510-2	Body, RH N.V-Outlet	A thru E
27*	9105505	5595	N.V-Asy W/ O-ring	A thru E
28*	8801060	35510-1	Body, RH NDV VLV Outlet	A thru E
29*	9000002		Adaptor, 9/16-18X5/8-18FF	A thru E
30	-		Nameplate (not sold)	A thru E

Note: Earlier models used items 27, 28 and 29. Items 27 and 28 to be obsoleted - if not available replace with items 25 and 26

Service Notes

Harris 355 repair kit p/n RK-355-2

Parts included:

(5) Plate, backing

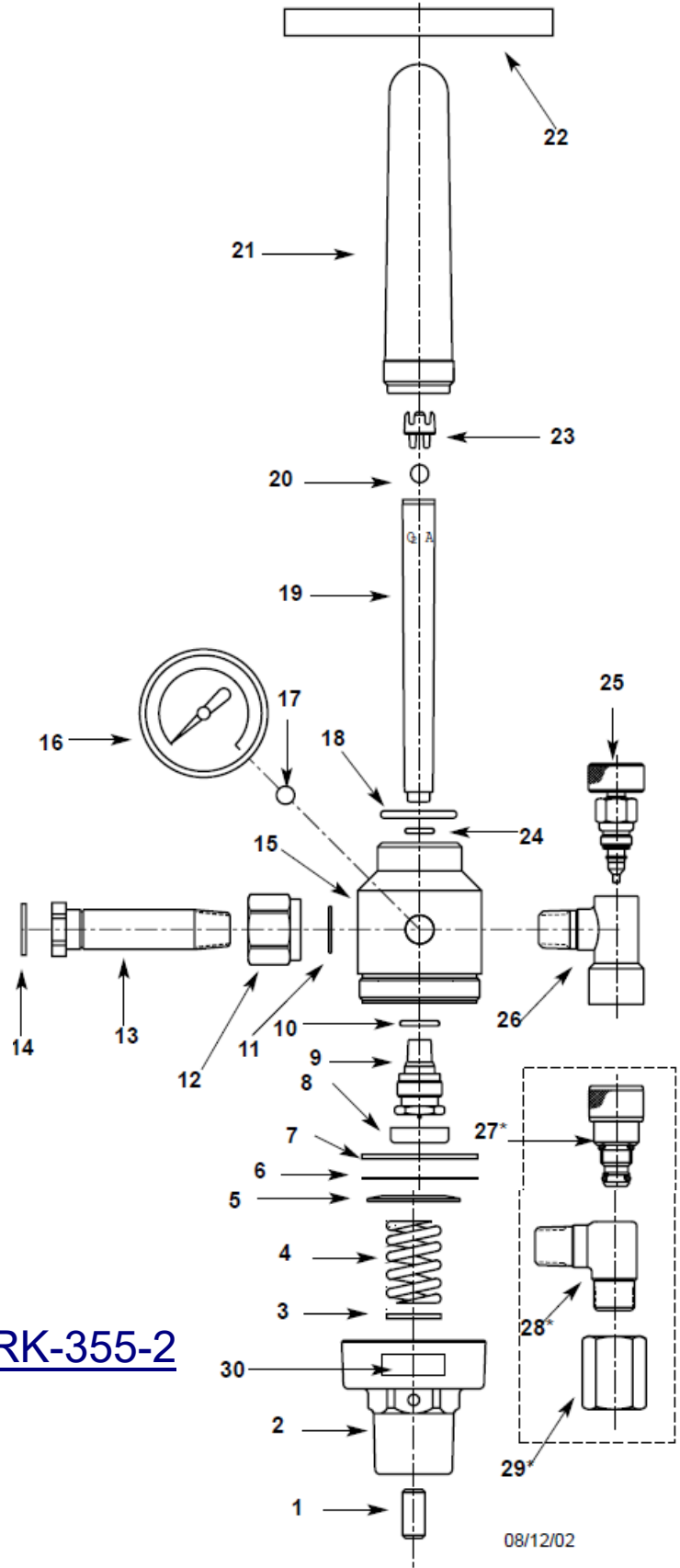
(6) Slip ring

(7) Diaphragm

(8) Cap

(9) Valve (Seat)

(10) O-ring (Seat)



FIND_NO	DESCRIPTION	H2051A-580
1	OUTER TUBE	15177
2	O-RING	15196
3	PIN	15237
4	SAFETY SPACER	15227
5	FLOAT	15178
6	FLOW TUBE	15172
7	O-RING	14613-35
8	SUPPORT	15190
9	LABEL	15807
11	PISTON	15761
13	NUT	CGA580-1
14	TAILPIECE	15778
15	BODY	15587
22	GAUGE	GA075-15
23	FILTER	H713-23
24	FILTER	8203
25	SPRING	15589
26	VALVE ASSEMBLY	15213-1

