



## Figure 1

## Spool Kits 217435-2 and 1583089-1 consist of a spool return spring, two seals, a spool cap, and a retaining screw. These components are used to replace the worn components on 626 Pneumatic Tooling Assembly 189721-[] (hand-actuated system without logic). See Figure 1 for the repair kit to spool value cross-reference. For detailed information concerning the pneumatic tooling assembly, refer to Customer Manual 409-5862.



1. INTRODUCTION

*Kit components are available separately. Figure 2 lists the individual part numbers.* 

## 2. ASSEMBLY PROCEDURE

1. DISCONNECT PNEUMATIC TOOL FROM MAIN AIR SUPPLY.

2. Remove the retaining screw on the end of the tool switch lever. Slide the pivot base until the end of the switch lever clears the hole in the top of the spool valve.

3. Push the spool assembly from the hole in the top of the spool valve until it falls out of the bottom.

4. Remove the spool return spring and seals from the spool assembly and discard; replace with the components from the spool kit. Remove the retaining ring and the spool cap from the hole in the top of the spool valve. Push the spool cap into the hole in the top of the spool valve, and secure with the retaining ring.

5. Apply a thin coat of Dow Corning 55 Lubricant<sup>†</sup> to the spool assembly.

6. Push the spool assembly (threaded end first) into the hole in the bottom of the spool valve until it butts against the spool cap. Be sure the spool return spring is in position as shown below.

7. Slide the pivot base until the hole in the end of the switch lever is over the spool cap. Replace the retaining screw.

8. Connect the pneumatic tool to the main air supply. Actuate the pneumatic tool to ensure proper operation.



When tool is connected to main air supply, the piston will retract; when tool is actuated, piston will extend. To avoid personal injury, keep hands and fingers away from the front of the tool.

## 3. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

• Updated document to corporate requirements.

<sup>†</sup> Product of Dow Corning Corporation, Midland, MI



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