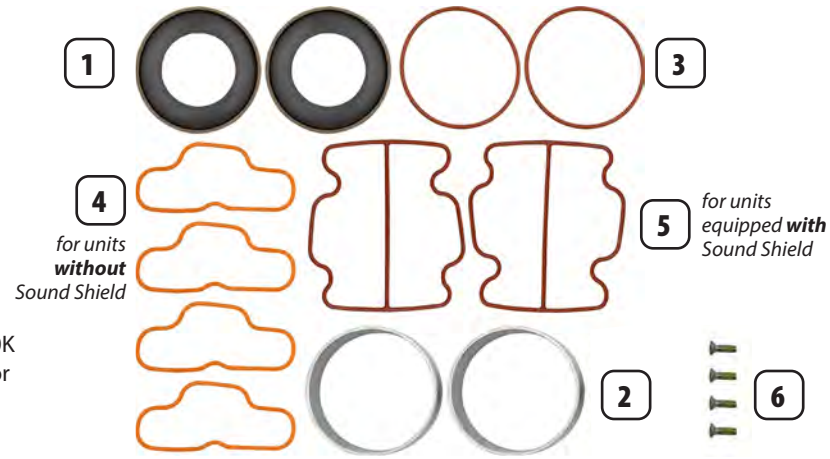
# Stratus Series Repair Kit Instructions

## for Stratus SRC25, SRC25SS, SRC252, SRC252SS, SRC50, SRC50SS, SRC502 and SRC502SS Compressors

**Repair Kit***

1. Piston Cups
2. Cylinders
3. Cylinder O-Rings
4. Head O-Rings *use for units* ***without*** *Sound Shield*
5. Head O-Rings *use for units* ***with*** *Sound Shield*
6. Cup Retainer Screws

*Repair kit contents may vary depending on your compressor. SRC50K contents are shown, SRC25K will have half the components shown for single cylinder repair.



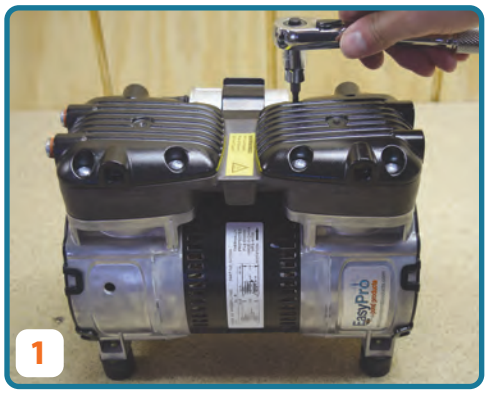

WARNING: Electrical shock hazard. Disconnect electrical supply before performing maintenance. Vent all air lines to release vacuum or pressure. Failure to follow these instructions may result in death, fire or electrical shock.

WARNING: Injury hazard. Product surfaces become very hot during operation, allow surfaces to cool before handling.

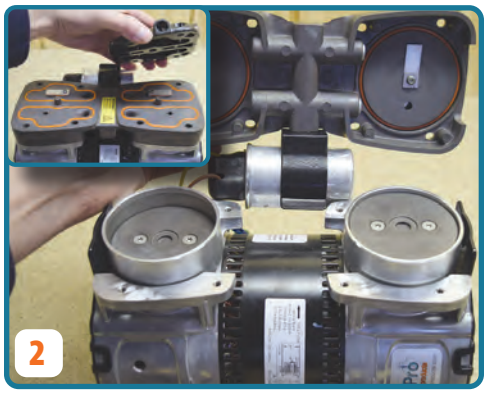
WARNING: Do not use oil to lubricate parts. SRC compressors use an oil-less design. Using oil may result in failure of the unit.

**Before beginning, you will need:**

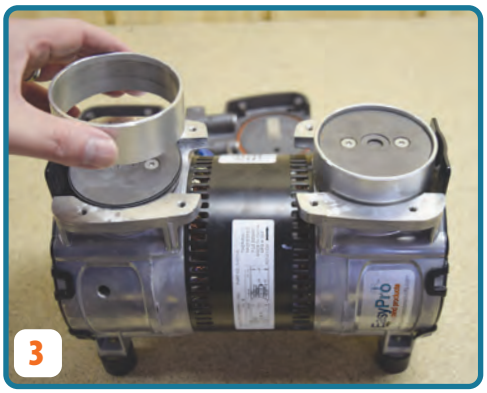
1. Clean work space
2. T20 and T25 Torx driver
3. Torque driver
4. Water based solvent
5. Thread locking compound (Loctite® 222)



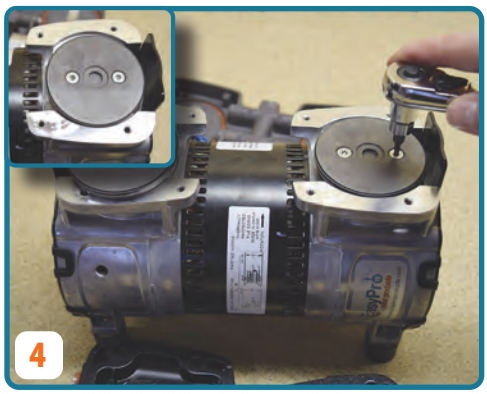

Remove screws from the head of compressor using T25 Torx driver. Remove the head.




Mark the orientation of head plate(s) and remove. Mark the orientation of valve plate(s), and remove valve plate(s). Clean valve plates with water based solvent. Take care not to scratch valve seats.




Remove old cylinders and discard.

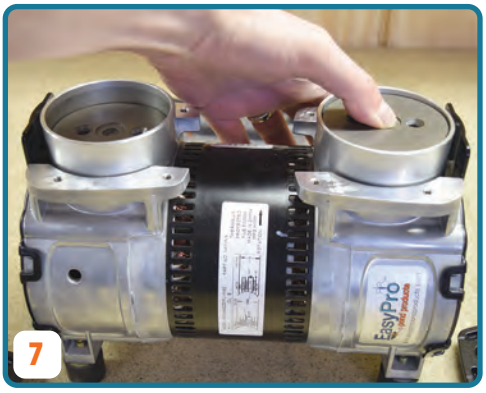



Remove screws from cup retainer plate with T20 Torx driver. Discard old cups and retainer screws.


Set new cylinder(s) on piston(s).


Remove new piston cup(s) from protective cardboard packaging. Set new piston cups onto retainer plate, these parts will sit flat against each other.

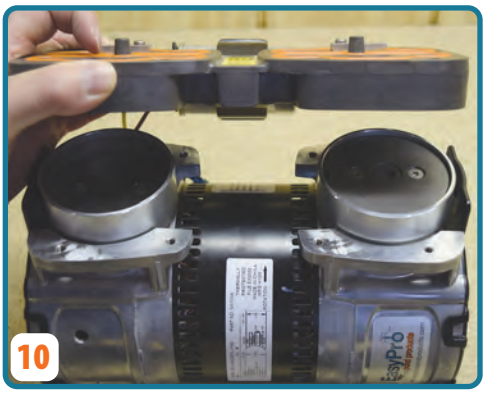
# Stratus SRC Series Repair Kit Instructions



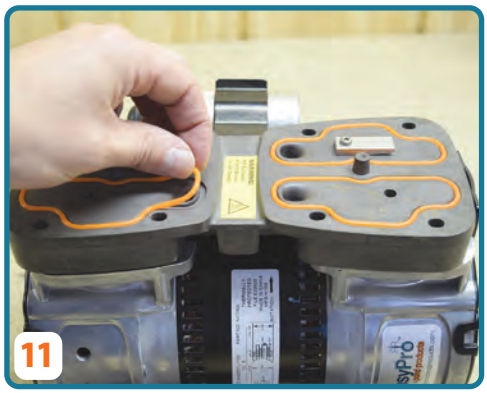

Press retainer plate with piston cup into cylinder all the way to the piston. The cylinder can be rotated to align the screw holes. Apply thread locking compound (Loctite® 222) to retainer screws, torque screws to 10-13 inch-pounds.


Remove the cylinder o-ring(s) from the bottom of valve plate(s) and install new o-rings.


Inspect the leaf valves for damage or wear. NOTE: There is one intentionally "bent" leaf valve per set. If leaf valves need to be replaced, a complete leaf valve plate can be ordered. The screws holding the leaf valves are susceptible to breaking which makes individual leaf valve replacement very difficult.




Check that orientation of the valve plate(s) with ports is correct and place over cylinders.




Remove old and install new head o-rings in the o-ring grooves on top of valve plate


Reinstall head over valve plate(s) checking that orientation with ports is correct. Torque screws to 50 inch-pounds

**13** Before putting the unit back into service it should be run for five minutes and the cylinder head screws should be checked for tightness. If these screws come loose during operation the unit will experience extensive damage and voids the warranty of the unit.

- Install the air intake filter into inlet port and leave outlet port open. It is not necessary to connect outlet plumbing connections at this point.
- Plug in unit and run for five minutes listening for any odd noises or clicking sounds. If any of these noises are heard, unplug unit immediately.
- After running for five minutes, remove head and valve plate and check the cylinder head screws. Tighten the screws to 10-13 inch-pounds and reassemble valve plate and head to put unit back into service.

***Check that all external accessories such as relief valves and gauges are not damaged before re-operating product.***

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Unit must be unplugged before servicing

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