

RED HEAD VALVES™

mfd by MTM Inc.
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RECEIVER REPAIR KIT For PP20FRM, PP20FTM and PP20FTM-AT

NOTICE: SERVICE PARTS FOR RECEIVER UNITS WITH REMOVABLE SNAP RINGS OR HEX HEAD POPPET SLIDE STUDS ARE NOT FURNISHED WITH THIS KIT. CONTACT RED HEAD VALVES™ FOR PROPER SERVICING OF UNITS WITH REMOVABLE SNAP RINGS OR HEX HEAD POPPET SLIDE STUDS. IF YOU ARE UNSURE WHICH TYPE OF UNIT YOU HAVE, CONTACT RED HEAD VALVES™ FOR IDENTIFICATION.

CONTENTS:

1 each #73-Q4330-U	Quad ring seal: – X-seal, large cross-section
1 each #71-041-N	O’ring nitril: Flange to black bulb seal with small cross-section
3 each #61-2019	Torsion spring
3 each #62-2020	Bush poppet slide
1 each #62-2027	Safety wire
3 each #61-2021	Snap ring, Permanent-type (not reusable after installation)
1 each #69-RRK	Receiver Repair Kit installation instructions, snap ring tool drawing and NOTICE

INSTALLATION:

1. Read attached Notice before proceeding.
2. If applicable, remove black bulb cover.
 - a. Remove hose clamp.
 - b. Heat valve in oven to 150 degrees F°.
 - c. Remove black bulb cover from valve.
3. Replacing three (3) each #61-2019 torsion springs and three (3) each #62-2020 bushing poppet slides:

NOTE: Permanent-type snap rings must be installed with special tool (drawing included). Removal of snap ring is not recommended or necessary for torsion spring replacement. **DO NOT RE-USE** any type of snap ring after installation has occurred. **DO NOT SUBSTITUTE;** snap rings are not interchangeable.

RECEIVER REPAIR KIT

- a. Remove X-seal. Depress poppet, roll X-seal out of groove or use a thin smooth blade (feeler gauge) between X-seal and groove sidewall and lift out. Machined surfaces are for sealing – “DO NOT DAMAGE”.
 - b. Heat valve flange to 200 F°. This will release red loctite applied to threads on poppet slide studs.
 - c. Remove safety wire. Carefully copy loop, tie and safety wire routing for later replacement.
 - d. Loosen three (3) each poppet slide studs, leaving several threads engaged. **When gripping, do not damage bushing sliding surface.**
 - e. Remove only one poppet slide stud at a time. Do not damage bushing sliding surface
 1. Remove torsion spring and poppet slide bushing.
 2. Thoroughly clean poppet slide stud threads and flange female threads.
 3. Install new torsion spring and poppet slide bushing from service kit.
 4. Apply a drop of red loctite to threaded hole and a drop to poppet slide stud threads.
 5. Replace poppet slide stud. Repeat steps 1 – 5 above for each slide stud.
4. Replacing one (1) each #73-Q4330-U X-seal – all units:
Find X-seal in service kit and note yellow identifying mark.
- a. Depress poppet, roll X-seal out of grooved or use a thin smooth blade (feeler gauge) between X-seal and groove sidewall and lift out. Machined surfaces are for sealing – “DO NOT DAMAGE”.
 - b. Install new X-seal. Stretch X-seal over poppet ensuring X-seal does not roll or twist during installation. X-seal must be properly seated in groove.
5. If applicable, replace black bulb cover :
- a. Heat black bulb cover in oven to 150 degrees F.
 - b. Replace flange o-ring (flange to bulb seal). Do not roll or twist during installation.
 - c. Press black bulb cover over flange being careful not to damage o’ring.
 - d. Install hose clamp.
6. Check valve for smooth operation and fluid seal.

You may contact Read Head Valves™ if you need technical assistance or wish factory installation of your service kit at (918) 824-3700.

SUMP RING TOOL

Tool Steel RC 60+

