

**A125-12-SRK
SEAL REPAIR KIT
FOR: A125-12 1 1/2" INTERNAL VALVE**

!!!WARNING!!!

READ AND UNDERSTAND ALL INSTRUCTIONS INCLUDED WITH THIS REPAIR KIT
RELIEVE ALL PRESSURE FROM SYSTEM BEFORE REMOVING VALVE FOR SERVICE

NOTE: Numbers in brackets [] refer to the number in the valve component list. Numbers in parenthesis () refer to quantities of the valve component.

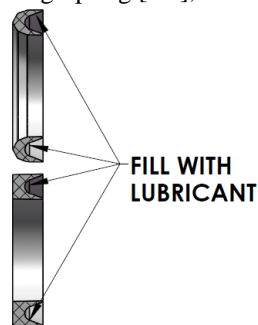
A. Disassembly

1. **EVACUATE ALL PRESSURE FROM SYSTEM BEFORE ANY DISASSEMBLY OR REPAIR.**
2. Remove (2) Mounting Screws [3], Cover Plate [4] and (2) Cover Washers [5] from Body [1] and retain.
3. Remove Packing Gland Assembly [2] and retain.
4. Remove Gland [2A] from Bonnet Stem [2B] and retain.
5. Remove Packing Spacer [2C], Female V-Packing [2D], (3) V-Packs [2E], and Male V-Packing [2F] from Gland [2A] and discard. Retain Packing Washer [2G] and Packing Spring [2H].
6. Remove O-Ring [2I] from Gland [2A] and discard.
7. Remove Cam Screw [2M], Cam Washer [2L], and Cam Assembly [2K] from Bonnet Stem [2B] and retain.
8. Remove Stem Bushing [2J] from Bonnet Stem [2B] and discard.
9. If installed in the bottom port, remove Flush NPT Plug [9] and retain.
10. Remove Nut [7] from Stem [8] and retain.
11. Remove Valve Holder Assembly [6] from Stem [7] and retain.
12. Remove Seal Retainer [6B] from Valve Holder [6A] and retain.
13. Remove Valve Seal [6C] and Excess Flow Seal [6D] from Valve Holder [6a] and discard.
14. Inspect Valve Body [1] and clean if necessary, be sure interior is free of dirt, residue and foreign particles.

B. Reassembly

1. Install Excess Flow Seal [6D] and Valve Seal [6C] in Valve Holder [6A].
2. Apply Loctite #271 to Seal Retainer [6B] and install into Valve Holder [6A].
3. Install Valve Holder Assembly [6] on Stem [8].
4. Apply Loctite #271 to threads of Nut [7] and install on Stem [8] and tighten.
5. Install Stem Bushing [2J] on Bonnet Stem [2B].

6. Apply Loctite #271 to threads of bonnet Stem [2B] and install Cam Assembly [2K], Cam Washer [2L], and Cam Screw [2M] on Bonnet Stem [2B] and tighten. Ensure that the Cam Assembly [2K] is installed as shown in Figure 1.
7. Install O-Ring [2I] on Gland [2A].
8. Fill Female V-packing [2D] and (3) V-Packs [2E] with Lubriplate or equivalent grease as shown.
9. Install Packing Spring [2H], Packing Washer [2G],



Male V-Packing [2F], (3) V-Packs [2E], Female V-Packing [2D], and Packing Spacer [2C] in gland [2A].

10. Install Gland [2A] on Bonnet Stem [2B].
11. Install Gland Assembly [2] into Body [1].
12. Apply Loctite #271 to threaded holes in Body [1]. Install (2) Mounting Screws [3] through Cover Plate [4] and (2) Cover Washers [5] into Body [1].
13. Install Flush NPT Plug [9] into Body [1] with thread sealant approved for use with Anhydrous Ammonia.
14. Connect the valve assembly outlet to a pressure source of at least 150 PSI. Check for leaks at all joints and stem seals using a suitable leak detector solution.



WARNING: These products contain a chemical known to the state of California to cause cancer and birth defects or reproductive harm

CAUTION: DO NOT USE THE VALVE IF ANY JOINT CONTINUES TO LEAK UNDER PRESSURE.

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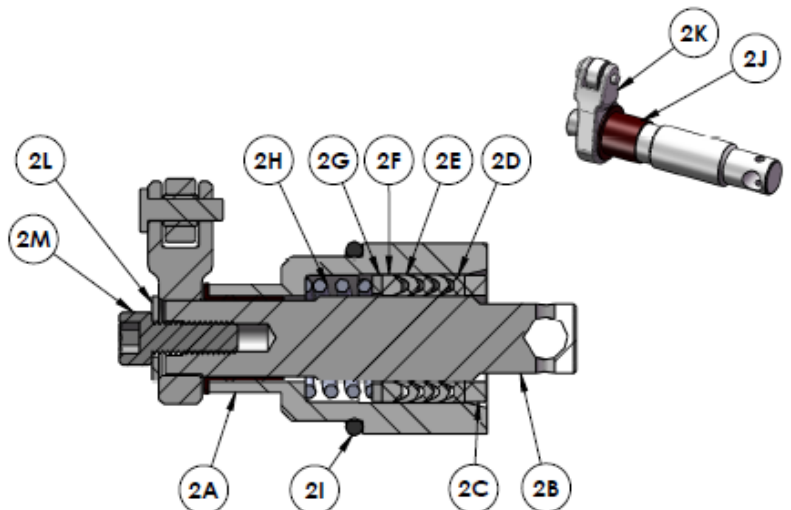
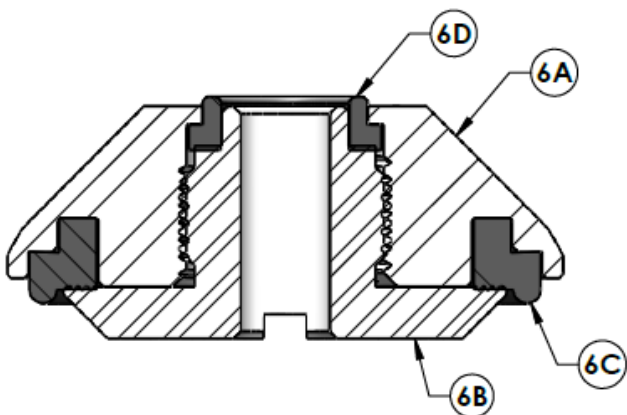
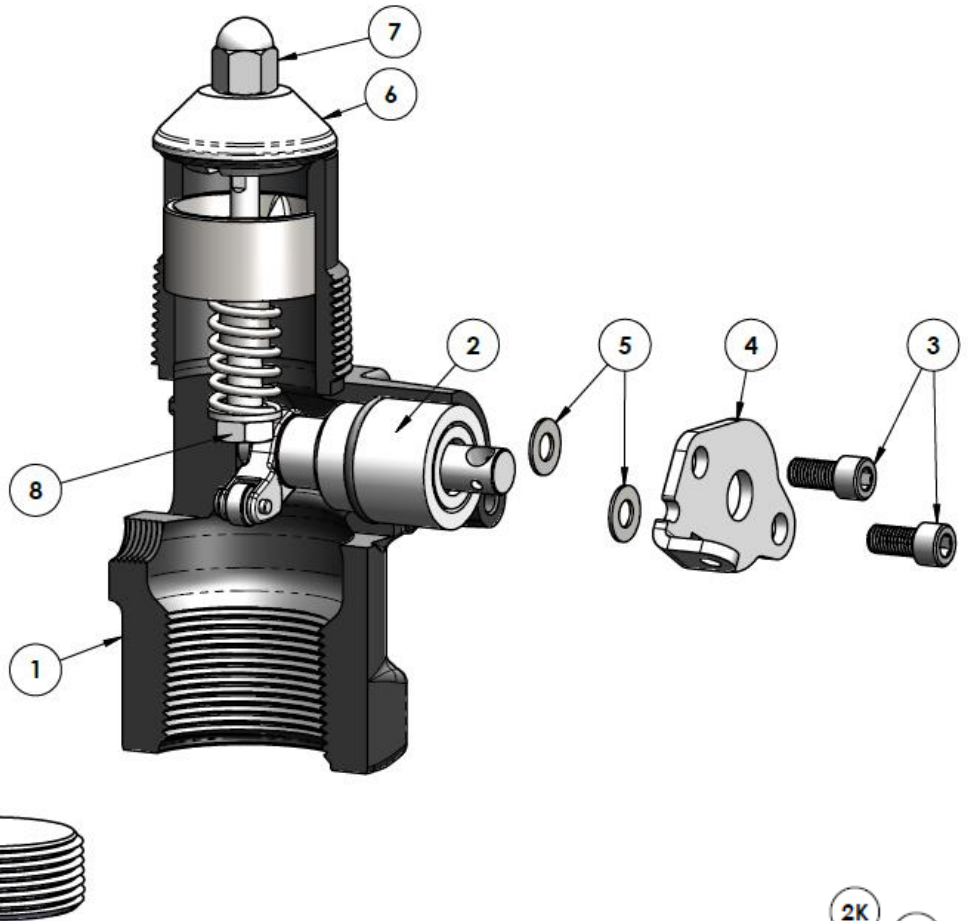
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Component List

1. Body
2. Gland Assembly
 - 2A. Gland
 - 2B. Bonnet Stem
 - 2C. Packing Spacer
 - 2D. Female V-Packing
 - 2E. V-Packs; Qty: 3
 - 2F. Male V-Packing
 - 2G. Packing Washer
 - 2H. Packing Spring
 - 2I. O-Ring
 - 2J. Stem Bushing
 - 2K. Cam Assembly
 - 2L. Cam Washer
 - 2M. Cam Screw
3. Mounting Screws; Qty: 2
4. Cover Plate
5. Cover Washers; Qty: 2
6. Valve Holder Assembly
 - 6A. Valve Holder
 - 6B. Seal Retainer
 - 6C. Valve Seal
 - 6D. Excess Flow Seal
7. Nut
8. Stem
9. Flush NPT Plug



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