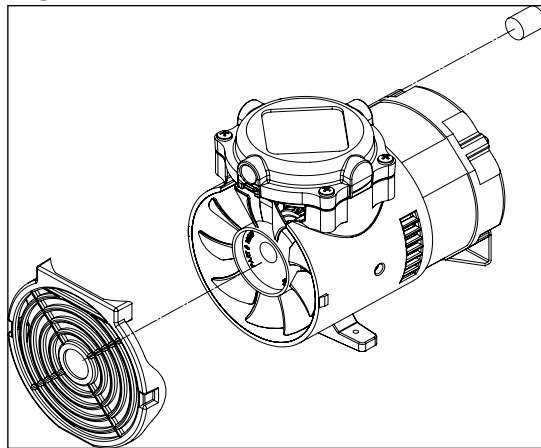


## REASSEMBLE FAN AND FRONT COVER

**STEP 18.** Assemble fan onto nib of the connecting rod assembly ensuring that the flat on the nib aligns with the flat of the fan hub.

**STEP 19.** Assemble front cover to housing by snapping slots on side of front cover onto tabs on side of the housing.

Figure 7



## COMPRESSOR SERVICE KIT

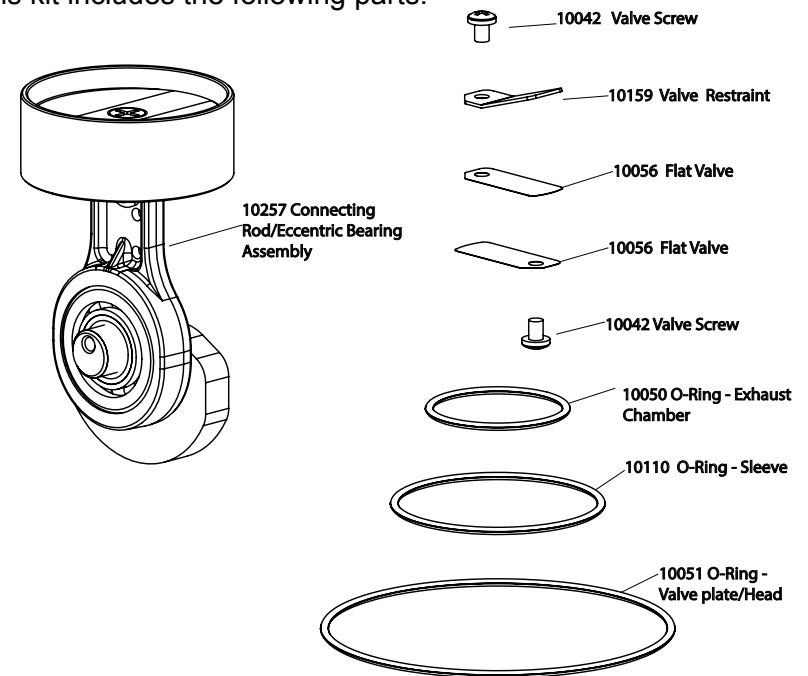
Part# 300618

EMS e-PRO HD

**WARNING:** Unplug the compressor before beginning disassembly.

**CAUTION:** Improper assembly or use of damaged parts may lead to premature failure. To avoid frequent repairs follow the recommended assembly procedures.

This kit includes the following parts:



**NOTE:** Before you begin, read these instructions thoroughly and assemble the necessary tools. You will need:

- #2 Phillips bit for torque wrench (head screws, valve screws)
- 1/8" allen wrench bit for torque wrench (eccentric screw)
- Torque wrench (18-55 inch pounds)
- Clean cloths

## DISASSEMBLY

**STEP 1.** Clean external surfaces of compressor.

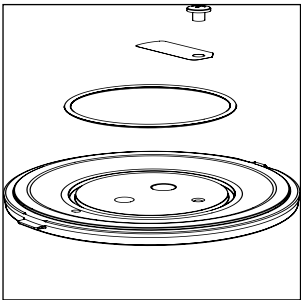
**STEP 2.** Loosen and remove the 4 head screws (1) and compressor head (2) (Figure 1).

**STEP 3.** Carefully separate valve plate (5) from head.

**STEP 4.** Remove head O-ring (4) and discard. Carefully remove and discard exhaust cavity (3) O-ring from topside of valve plate.

**STEP 5.** Remove and discard screw, valve flapper and valve restraint from top of valve plate

Figure 2



**STEP 6.** Remove and discard cylinder O-ring, screw and intake valve flapper from underside of valve plate (Figure 2)

**STEP 7.** Remove front cover(A) (Figure 3). Remove fan (B) from eccentric bearing assembly (C).

**STEP 8.** Rotate eccentric bearing assembly to align set screw with eccentric set screw access hole. Loosen set screw with 1/8 allen wrench. Slide connecting rod assembly off shaft. Remove from housing and discard.

Figure 1

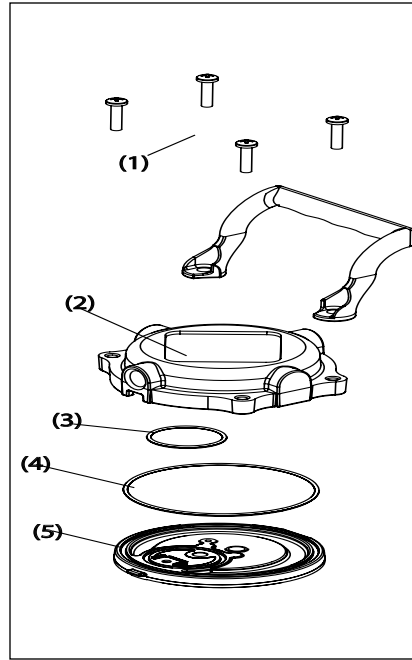
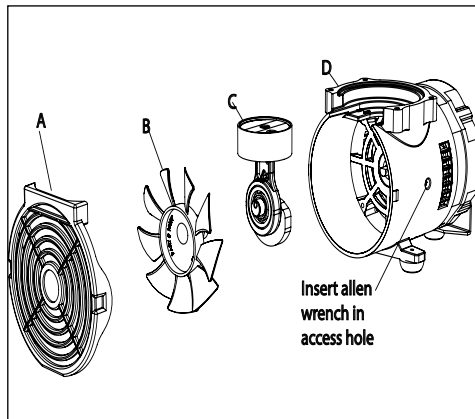


Figure 3



## REASSEMBLE VALVE PLATE

**STEP 9.** Clean bottom of valve plate with a clean, soft cloth (Figure 4). Install intake valve flapper covering intake port. Install valve flapper screw and torque to 18 inch pounds keeping flapper secure and properly aligned over intake port.

**STEP 10.** Carefully install cylinder O-ring into O-ring groove.

**STEP 11.** Clean top of valve plate with a clean, soft cloth (Figure 5). Install exhaust valve flapper with notch to the right. Place restraint on top of flapper with the notch to the right. Install valve flapper screw and torque to 18 inch pounds keeping flapper and restraint properly aligned over exhaust port.

Figure 4

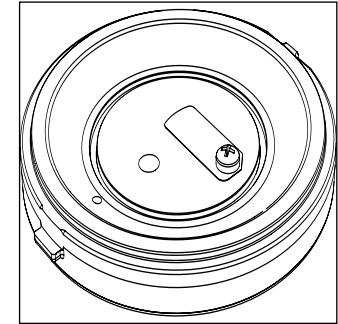
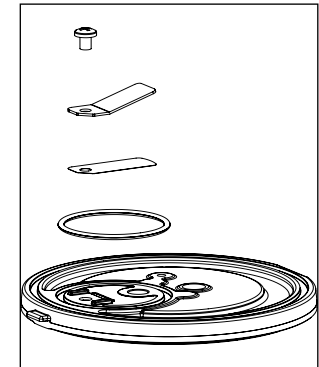


Figure 5



## REASSEMBLE ROD, VALVE PLATE ASSEMBLY AND HEAD

**STEP 12.** Insert new rod assembly through opening in the housing. **Align eccentric set screw with the flat of the shaft.** Push assembly onto shaft until eccentric contacts housing bearing.

**STEP 13.** Torque eccentric set screw to 55 inch pounds.

**STEP 14.** With exhaust valve facing the front, place the valve plate assembly on the compressor housing so the lip of the cylinder housing fits into O-ring groove on valve plate assembly, ensure cylinder O-ring remains properly seated. (Figure 6)

**STEP 15.** Carefully install head O-ring and exhaust cavity O-ring, seated firmly into grooves.

**STEP 16.** Place head on top of valve plate aligning the tabs on the valve plate with the slots on the head and exhaust cavity towards the front.

**STEP 17.** Insert and tighten 4 head screws to 40 inch pounds in a criss crossed pattern.

Figure 6

