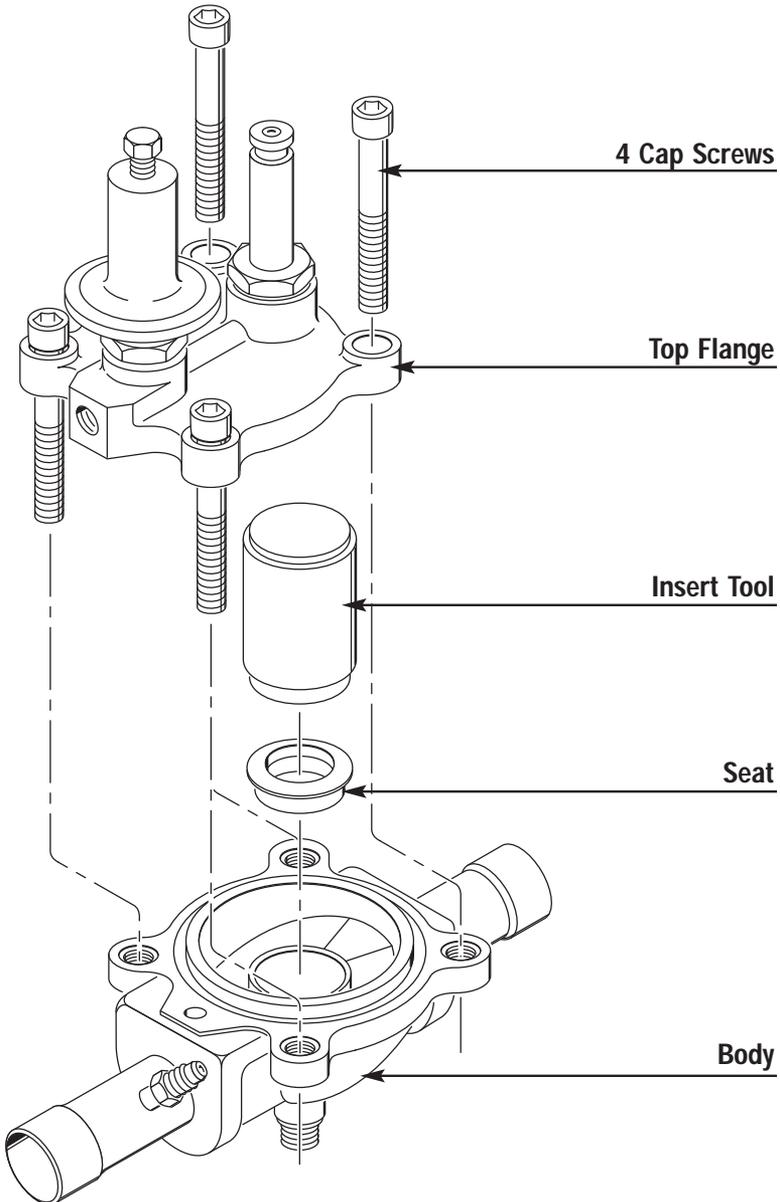


SPORLAN

Capacity Conversion Kit for SORIT-PI BODY

(Manufactured prior to 3204 date code.)



Capacity Conversion Kit Installation Instructions

1. Isolate and disassemble valve according to installation and service instructions. Discard existing piston, sleeve and o-rings.
 2. Place new seat in existing port. The new seat should fit snugly and stay in place. Be sure manual lift stem is fully retracted.
 3. The top of the insert tool is designed to fit the top flange machining. The bottom of the tool is designed to match the form of the new seat. Using the correct tool provided, hold the insert tool in well of the top flange.
- WARNING – ONLY use the tool which label matches the original valve size for converting process. For example: If converting a PI-5 size valve to a PI-4 or PI-3, use the tool labeled PI-5.**
4. Hold the top flange and insert tool against the new seat, sitting in the existing body.
 5. Begin threading bolts through the top flange and into the valve body.
 6. Snug the bolts by hand holding the assembly together. Visually make sure that all parts are in place, square and even.
 7. Tighten bolts in criss-cross pattern to evenly drive in the seat, using 5/16" T-handle allen wrench.
 8. It is extremely important that the seat is driven in even and square. Visually inspect the drive process to monitor the insertion. There is a visibly distinct stop designed in the new seat to ensure a complete and square assembly. The outermost diameter of the seat should come in complete contact with the existing seat in the valve body.
 9. The torque required to drive the seat in place is minimal, less than 5 ft-lb. Do not over torque the bolts in this process; the top flange can be permanently distorted.
 10. Visually inspect the new seat for complete contact to the existing body 360° around. If the seat is not completely driven in place, use the corresponding bolt or bolts to complete the drive, of the new seat.
 11. Once the new seat is in place remove the top flange and insert tool. Rebuild the valve with the new rebuild kit provided, according to the installation and service instructions.
 12. Replace the label on the adjustable element with the new one provided. This is necessary to signify the change in capacity of the valve. If the valve has the solenoid stop feature, a new nameplate is also provided and should be replaced.

