



# How to Repair an AccuStream High-Cycle On/Off Valve Using Kit #13683

These instructions will demonstrate how to replace components of an AccuStream High-Cycle On/Off Valve with kit #13683

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 **TOOLS:**

- [13/16" wrench](#) (1)
- [7/8" wrench](#) (1)
- [1" wrench](#) (1)

 **PARTS:**

- [Repair Kit #13683](#) (1)
- [Needle Bearing #12178 \(included in kit\)](#) (1)
- [High-Pressure Valve Seal #11043 \(included in kit\)](#) (1)
- [Accu Seat #11010 \(included in kit\)](#) (1)
- [Actuator #12828](#) (1)
- [Adapter #13841](#) (1)
- [Valve Body #11033](#) (1)
- [Blue Goop #11111](#) (1)
- [Isopropyl Alcohol](#) (1)

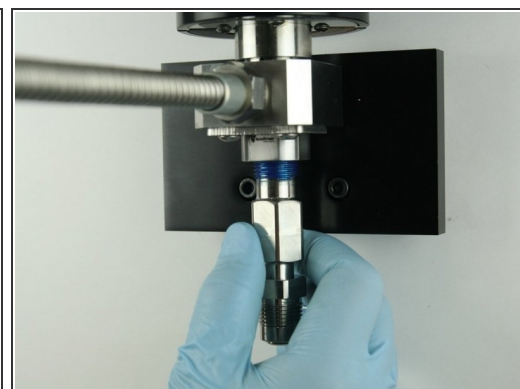
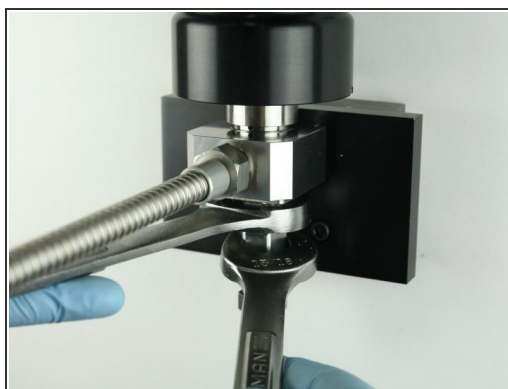
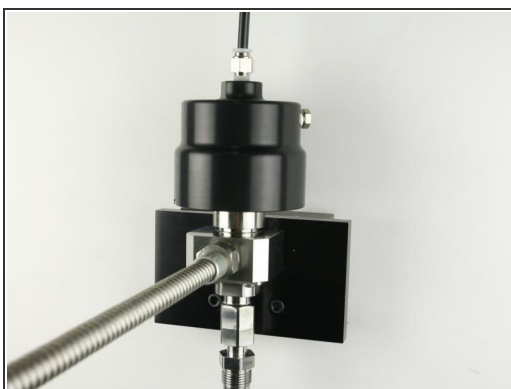
## Step 1 — How to Repair an AccuStream High-Cycle On/Off Valve Using Kit #13683



**⚠ Always make sure all high-pressure water has been removed from valve by following machine manufacturers' safety instructions. Failure to do so can cause severe injury or death.**

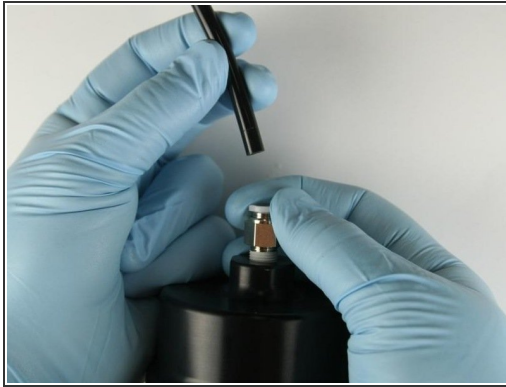
- Turn OFF all water pressure to the on/off valve.
- Turn the on/off valve ON to raise the needle from the [accu seat](#).

## Step 2



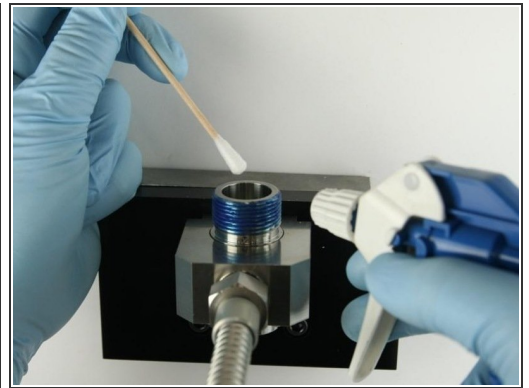
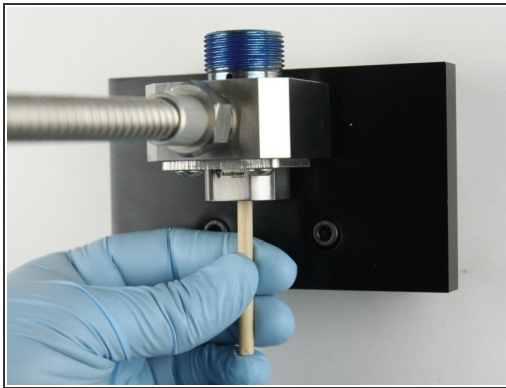
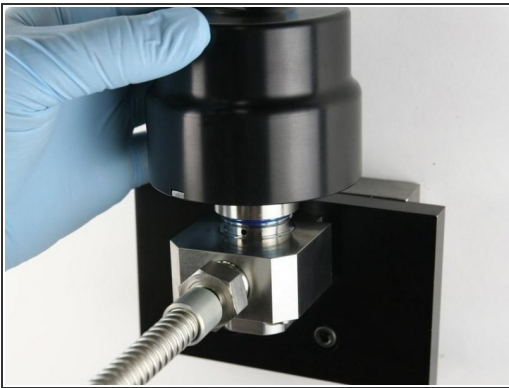
- Components can be replaced with the [valve body](#) in the mounting collar.
- Loosen the [adapter](#) from the valve body using 1" and 13/16" wrench.
- Unthread the adapter from the valve body.

### Step 3



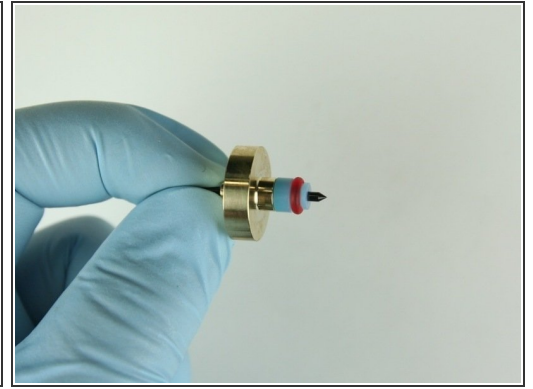
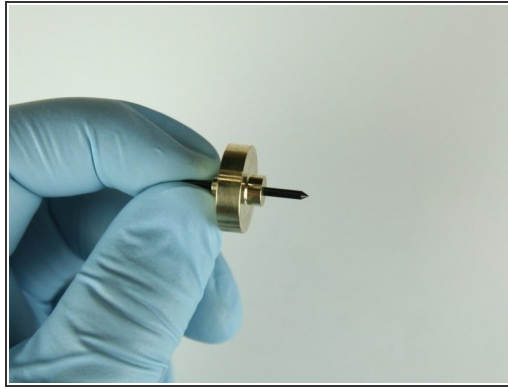
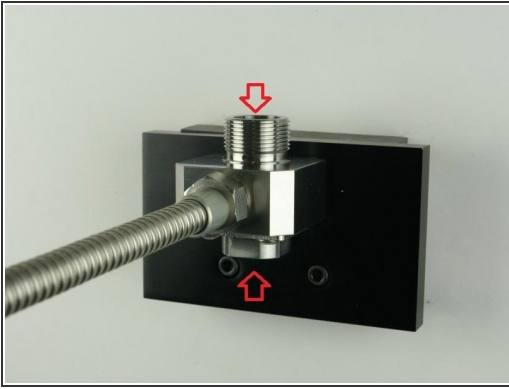
- Turn the air to the actuator OFF.
- Disconnect the air line from the [actuator](#).
- Loosen the actuator from the valve body using a 7/8" wrench.

### Step 4



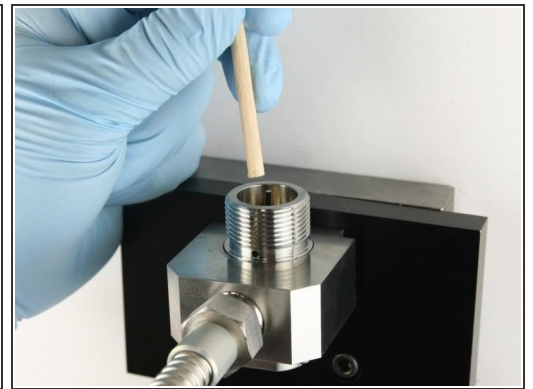
- Unthread the actuator from the valve body.
- Remove all the valve components from the valve body using the included dowel.
- Thoroughly clean the interior/exterior of the valve body with isopropyl alcohol before replacing the components.

## Step 5



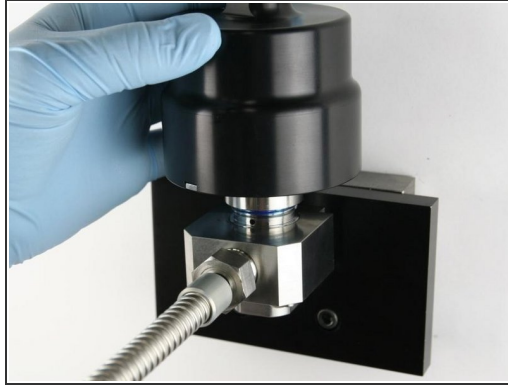
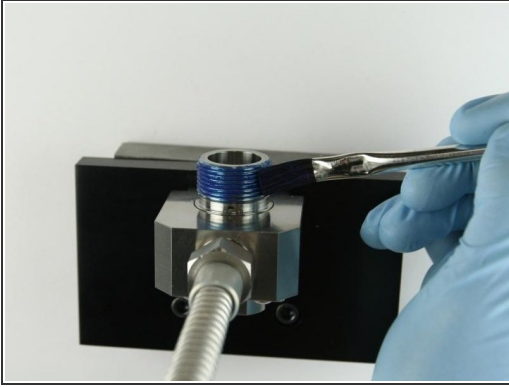
- Check the top and bottom of the bore for cracks/blemishes. If excessive wear or cracks are visible, replace the [valve body](#).
- Slide the [needle bearing](#) onto the needle point with the smaller step away from the needle point.
- Slide the [high-pressure valve seal](#) onto the needle point with the O-ring away from the needle bearing.

## Step 6



- Apply a high-pressure lubricant to the outside diameter of the high-pressure valve seal.
- Put the needle point at the top of the valve body.
- Use the dowel to push the needle in the valve body until the needle bearing bottoms out.

## Step 7



- Apply [Blue Goop](#) to the top threads of the valve body.
- Thread the actuator onto the valve body.
- Tighten the actuator to the valve body using a 7/8" wrench.

## Step 8



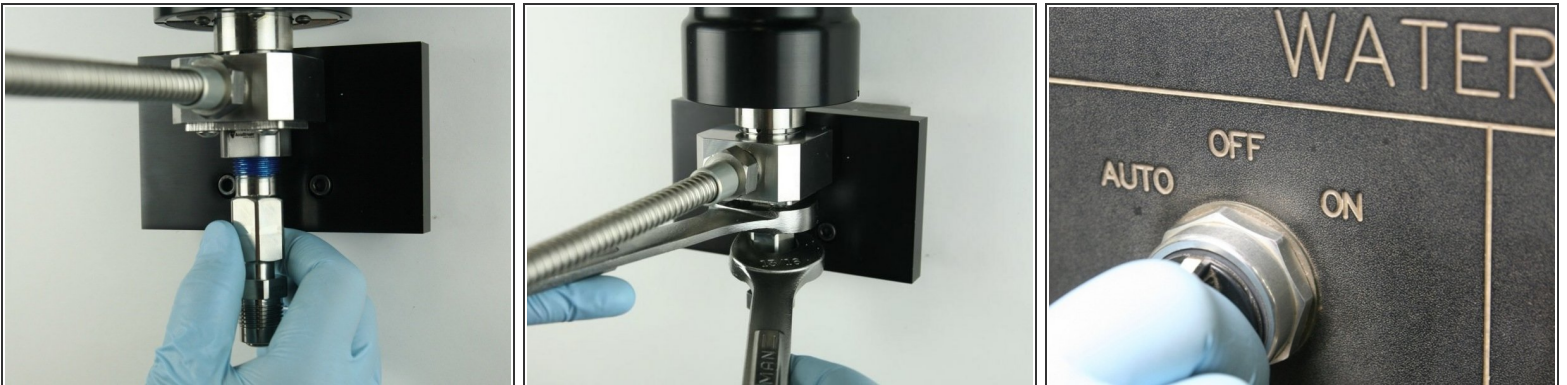
- Reconnect the air line to the top of the actuator.
- Clean the adapter of all blue goop with isopropyl alcohol or similar cleaning agent.
- Reapply Blue Goop to the top threads and to the top of the adapter.

## Step 9



- Put the accu seat at the top of the adapter with the flat side towards the adapter.
- Apply Blue Goop to the top of the accu seat.
- Turn the air to the actuator On.

## Step 10



- Thread the adapter into the valve body.
- Tighten the adapter into the valve body using a 1" and 13/16" wrench.
- Turn the air to the actuator OFF.

## Step 11



- Apply water pressure to the valve assembly to verify there are no leaks
- Quickly cycle the valve on and off a few times to purge the system of all contaminants before installing cutting head
- Reinstall cutting head and continue the cutting process.