



How to Repair a Flow Style High-Cycle On/Off Valve (Insta 2) Using Kit #13687

These instructions will demonstrate how to replace components of a Flow Style High-Cycle On/Off Valve (Insta 2) with kit #13687.

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INTRODUCTION

Hypertherm is in no way affiliated with the above mentioned manufacturer.



TOOLS:

- [1" wrench](#) (1)
- [3/4" wrench](#) (1)
- [7/8" wrench](#) (1)



PARTS:

- [On/Off Valve Repair Kit #13687](#) (1)
- [O-ring #11145 \(included in kit\)](#) (1)
- [Poppet Seat #11141 \(included in kit\)](#) (1)
- [Bushing Stem #11273 \(included in kit\)](#) (1)
- [High-Pressure Valve Seal #11276 \(included in kit\)](#) (1)
- [Back-up Ring #11274 \(included in kit\)](#) (1)
- [Actuator #12129](#) (1)
- [Valve Body #11272](#) (1)
- [Nozzle Tube #11358-4](#) (1)
- [Blue Goop #11111](#) (1)
- [Isopropyl Alcohol](#) (1)


Step 1 — How to Repair a Flow Style High-Cycle On/Off Valve (Insta 2) Using Kit #13687

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

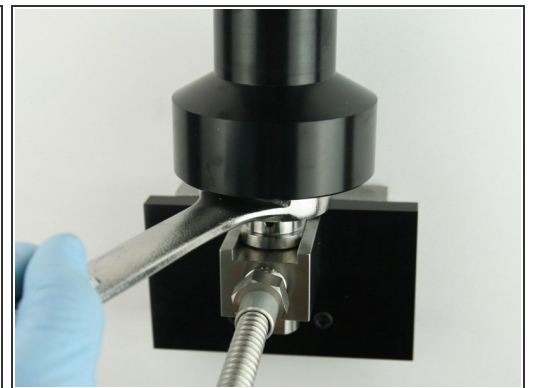
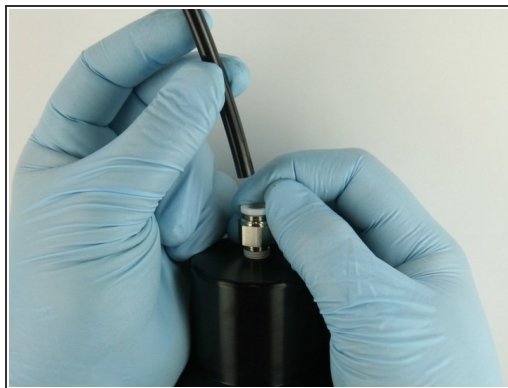
- Turn OFF all water pressure to the on/off valve
- Turn the on/off valve ON to raise the poppet stem from the [high-pressure seat](#).

Step 2



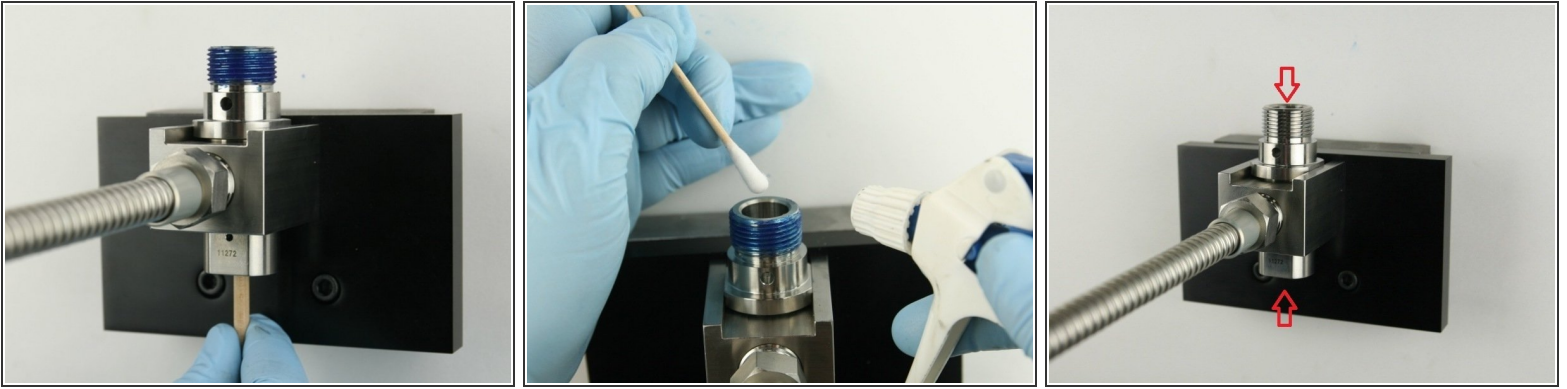
-  The [valve kit](#) components can be replaced with the [valve body](#) in the mounting collar
- Unthread the [nozzle tube](#) from the valve body using a 3/4" and 7/8" wrench.

Step 3



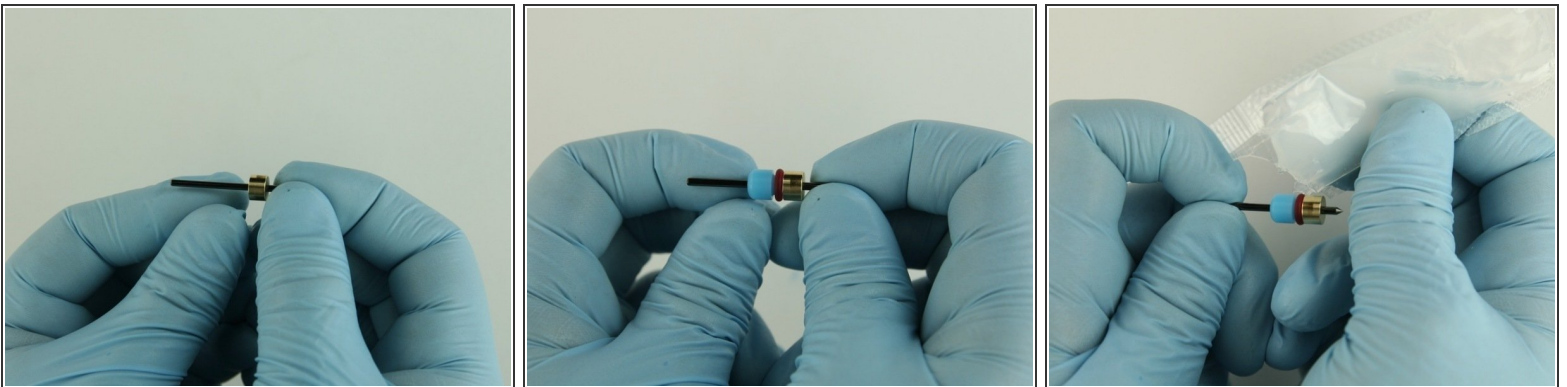
- Turn the air to the actuator OFF at the controls
- Disconnect the air tube from the actuator.
- Unthread the actuator from the valve body using 1-1/8" wrench.

Step 4



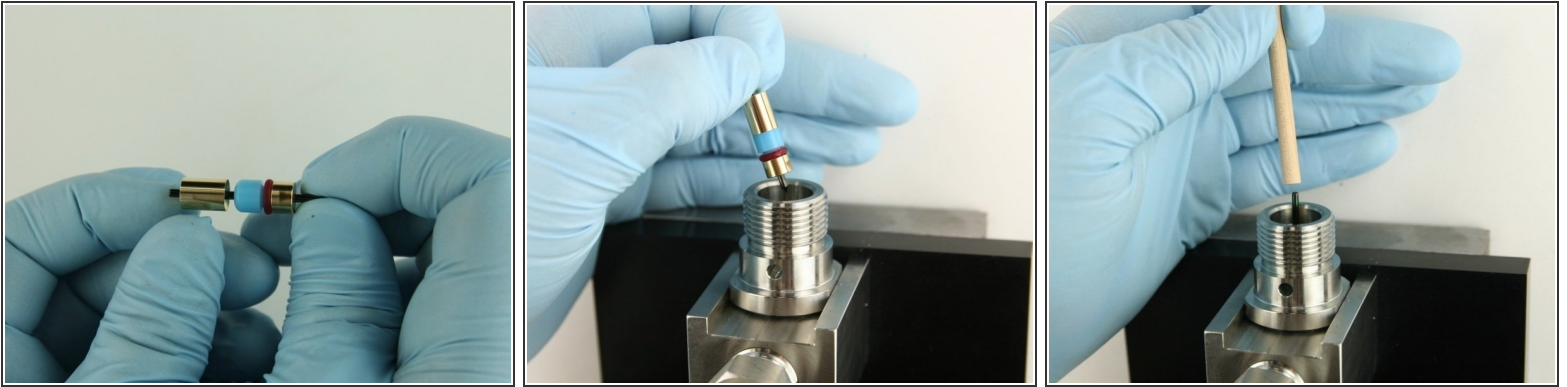
- Remove the old valve components from the valve body with the included dowel.
- Thoroughly clean the interior/exterior of the valve body with isopropyl alcohol or a similar cleaning agent before replacing the components.
- ❗ Visually inspect the top and bottom of the bore for cracks/blemishes. If excessive wear or cracks are visible, replace the [valve body](#).

Step 5



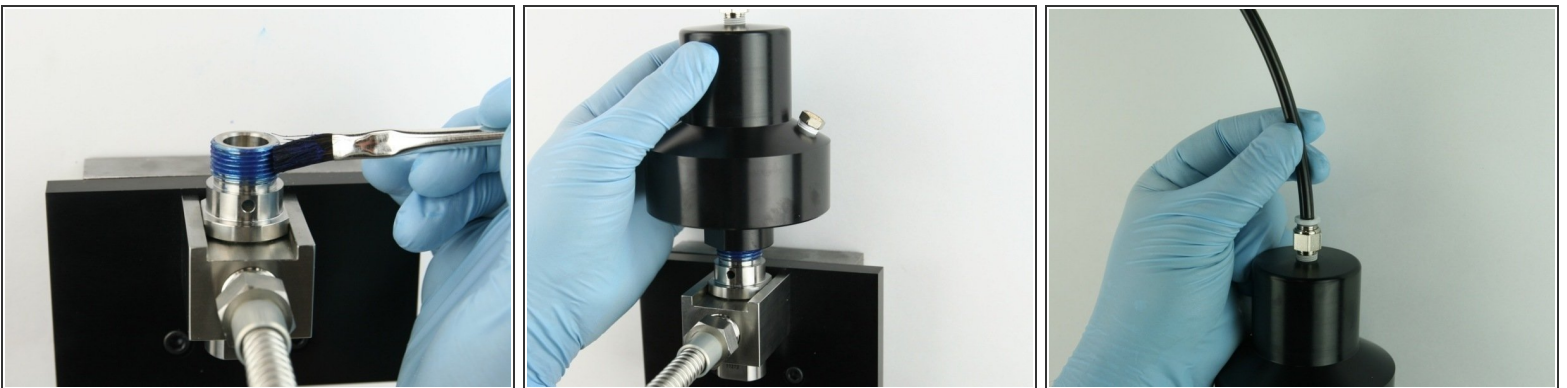
- Put the [bushing stem](#) onto the poppet stem.
- With the O-ring down, slide the [high-pressure valve seal](#) onto the poppet stem behind the bushing stem.
- Apply a high-pressure lubricant or similar ([11136](#)) to the outside diameter of the high-pressure valve seal.

Step 6



- Put the [back-up ring](#) with the concave side towards the high-pressure seal on the poppet stem behind the high-pressure seal.
- Put the poppet stem, with the point down, at the top of the valve body.
- Use the dowel to push the poppet stem down until the back-up ring is flush with the top of the bore.

Step 7



- Apply [Blue Goop](#) to the top of the valve body threads.
- Thread (hand tighten) the actuator to the top of the valve body.
- Reconnect the air line to the top of the actuator.

Step 8



- Apply Blue Goop to all surfaces of the high-pressure seat.
- Put the high-pressure seat at the bottom of the valve body.
- Put the [O-ring](#) behind the high-pressure seat so it is held in place.

Step 9



- Turn the air to the actuator ON to relieve the pressure from the poppet stem.
- Thoroughly clean the nozzle tube of all the Blue Goop.
- Reapply Blue Goop to the threads of the nozzle tube.

Step 10



- Thread the nozzle tube into the bottom of the valve body.
- Tighten the nozzle tube to the valve body using 3/4" and 7/8" wrench.
- Turn the air to the actuator OFF to set the poppet stem into the high-pressure seat.

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 the cutting head.
- Reinstall the cutting head and continue the cutting process.