



How to Repair A Flow Style Check Valve

#11282

These instructions will demonstrate how to replace components of a Flow Style Check Valve with kit #11282

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INTRODUCTION

Hypertherm is in no way affiliated with the above mentioned manufacturer

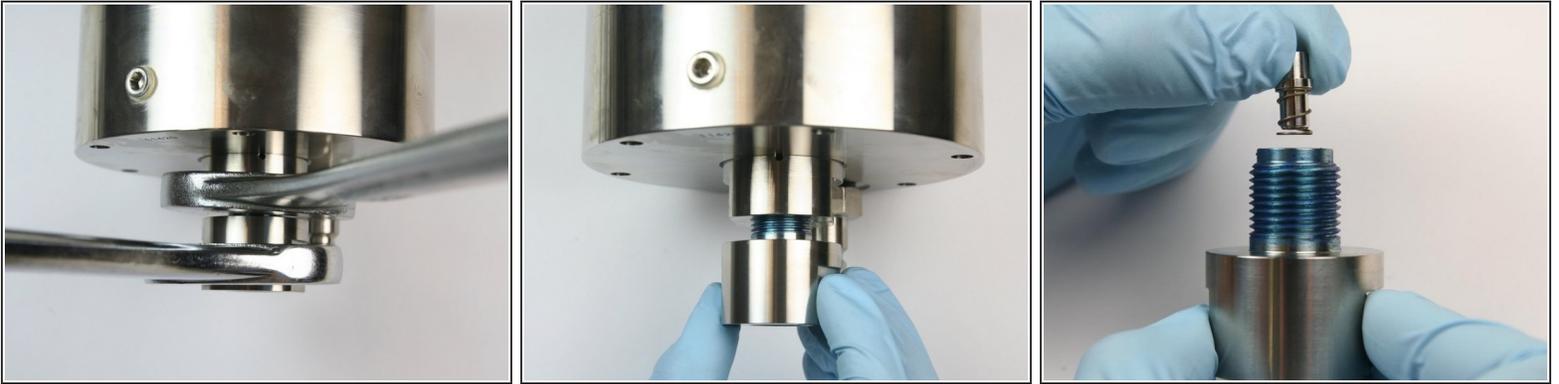
TOOLS:

- 1-1/4" wrench (1)
- 5/16" wrench (1)
- Spanner wrench (1)

PARTS:

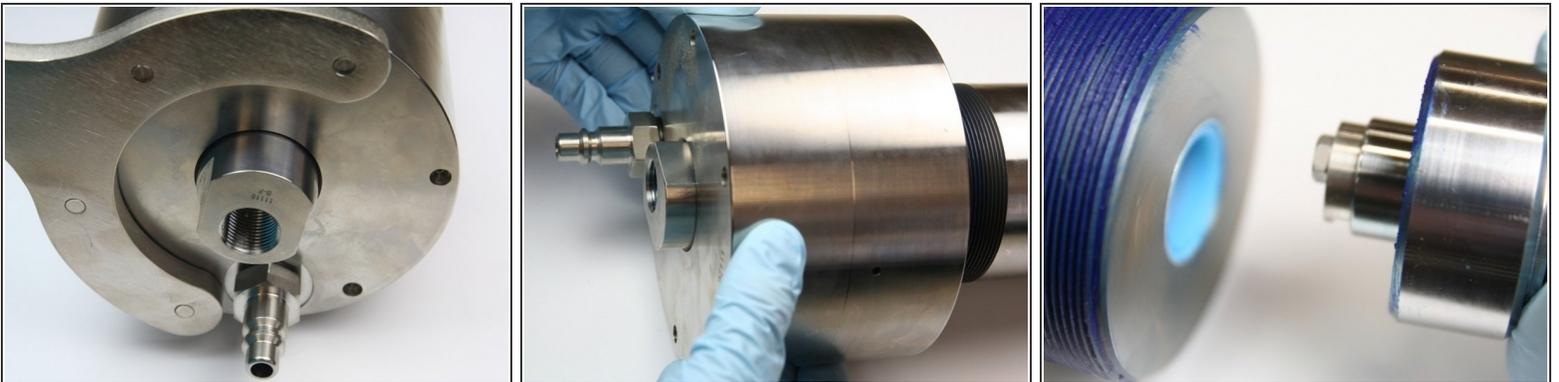
- Repair Kit #11282 (1)
- Outlet Poppet #11228 (Included in Kit) (1)
- Insert #11230 (Included in Kit) (1)
- Retaining Screw #11233 (Included in Kit) (1)
- Inlet Poppet #11229 (Included in Kit) (1)
- Inlet Poppet Housing #11232 (Included in Kit) (1)
- Poppet Spring #11234 (Included in Kit) (1)
- Outlet Body #11231 (1)
- Check Valve Body, 55K, Flow #11115 (1)
- High-pressure Cylinders, 60K #11117 (1)
- Blue Goop #11111 (1)
- Isopropyl Alcohol (1)
- Blue Loctite 242 (1)

Step 1 — How to Repair A Flow Style Check Valve #11282



- Loosen the [outlet body](#) from the [check valve body](#) using two 1-1/4" wrenches.
- Unthread the outlet body from the check valve body.
- Remove the [outlet poppet](#) and the [poppet spring](#) from the outlet body.

Step 2



- Loosen the [end cap](#) from the [high-pressure cylinder](#) with a spanner wrench.
- Unthread the end cap from the intensifier.
- Remove the check valve body from the high-pressure cylinder.

Step 3



- Remove the insert from the check valve body.
- Loosen the [retaining screw](#) from check valve body using 5/16" and 1-1/4" wrench.
- Unthread the retaining screw from the check valve body.

Step 4



- Remove the [inlet poppet housing](#) from the top of the check valve body.
- Remove the [inlet poppet](#) from the check valve body.
- Remove the outer O-ring from the check valve body.

Step 5



- Remove the inner O-ring from the check valve body.
- Thoroughly clean the interior/exterior of the check valve body.
- Make sure there are no scratches/galling and replace if necessary.

Step 6



- Clean the outlet body threads of all [Blue Goop](#).
- Put the inlet poppet from the kit with the larger surface down on top of the check valve body over the non-threaded hole.
- Put the inlet poppet housing over the inlet poppet on top of the check valve body.

Step 7



- Apply blue loctite 242 to the first two threads of the retaining screw.
- Put the retaining screw through the inlet poppet housing into the top of the check valve body.
- Thread in the retaining screw to the check valve body.

Step 8



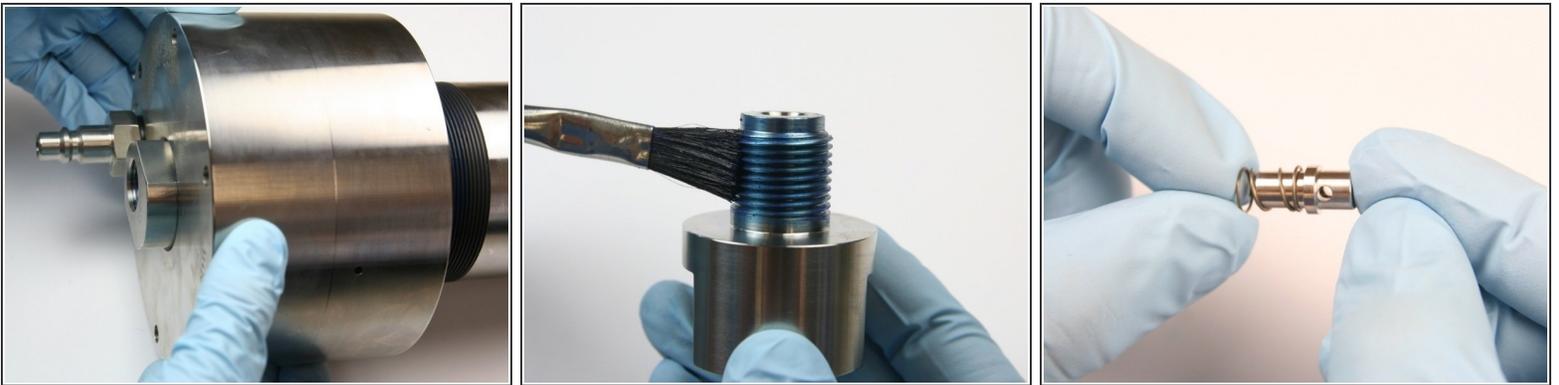
- Tighten the retaining screw into the check valve body using a 5/16" and 1-1/4" wrench.
- Lubricate both the O-rings from the kit with an O-ring lube.
- Slide on the first O-ring to the inner groove of the check valve body.

Step 9



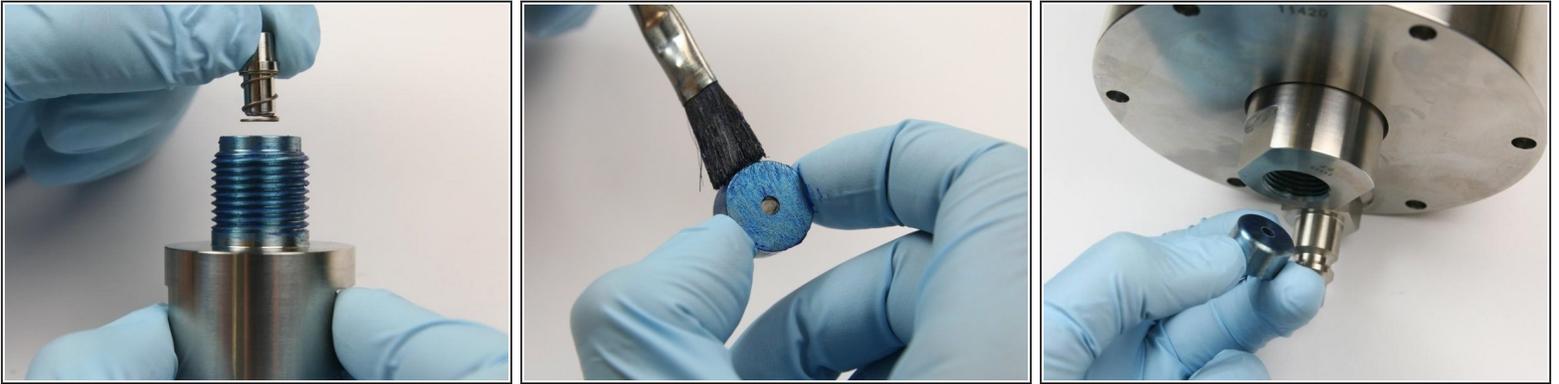
- Slide the second O-ring to the outer groove of the check valve body.
- Apply a light coat of Blue Goop around the outer face of the check valve body.
- Proceed with the installation of the check valve body into the intensifier.

Step 10



- Thread the end cap onto the high-pressure cylinder.
 - Hand tighten the end cap on to the high-pressure cylinder.
- Apply Blue Goop to the outlet body threads.
- Put the poppet spring onto the larger end of the outlet poppet.

Step 11



- Put the outlet poppet and the poppet spring with the spring first into the outlet body.
- Apply Blue Goop to all surfaces of the insert.
- Put the insert, with the rounded side first, into the bottom of the check valve body.

Step 12



- Thread the outlet body into the bottom of the check valve body.
- Tighten the outlet body into the check valve body using two 1-1/4" wrenches.
- Connect the high and low-pressure water connections and continue the cutting process.