



REPLACEMENT INSTRUCTIONS

CYLINDER HEAD KIT

MODELS VT2351 AND VT2529

Items which may be on the pump but are not a part of this kit include the inlet valve cover plate, rectangular top-plate gasket, filter retainer, felt filter, and filter screen. Also, this universal head has four tapped exhaust holes instead of two. Use up to three of the NPT plugs provided to plug the unused holes. Use pipe dope or Teflon® tape to seal the threads.

NOTE: The VT2529 kit does not have replacement valves. If re-using old valves, be very careful during removal. Note exactly which valve came from which location. The valves all look the same, but important differences exist between them. Correct placement of each valve is important to the operation of the compressor. In the illustration below, parts with an asterisk (*) are not included in the VT2529 kit.

Assemble the new head as follows:

1. Assemble the flapper valves and restrictors by placing them on the replacement head, see below.
2. Position the cylinder head gasket onto the top of the cylinder along with the new head. Be sure the two center holes in the cylinder, the gasket and the head are aligned. Insert the four 5½" head bolts into the corner holes, hand tighten only.

Assemble the top plate as follows:

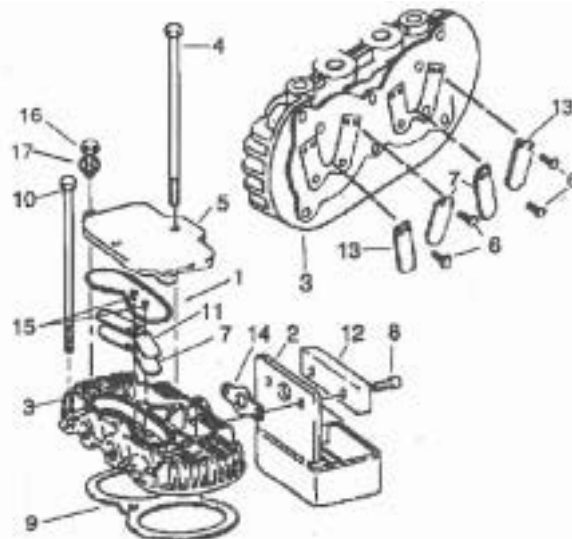
1. Place the O-ring in the groove surrounding the outlet valve chamber. Silicon grease may be used to hold the O-ring in the groove.
2. Position the top plate so the bolt holes on the plate and the head are aligned and put the two 6" bolts into the center of the head. Torque these bolts to 11 - 12 ft/lbs.
3. Put the two 1/4" screws in the holes at the edge of the top plate, through the plate, and into the head. Tighten to 9 - 10 ft/lbs.
4. Torque the hand tightened 5½" bolts to 11 - 12 ft/lbs. First, tighten two which are diagonally across from each other, on opposite corners of the head. Then, torque the remaining two bolts.

Assemble the air filter as follows:

1. Place the gasket on the head intake flange and hold in place as you put the filter housing on the gasket. Align the holes in the flange, the gasket, and the housing (at the top edge of the side of the housing).
2. Insert the two screws through the holes in the filter housing and the gasket, and into the flange. Tighten screws to snug, then one-quarter turn further.
3. Place the filter on the small shelf in the housing, being sure the large hole aligns with the air intake and the two small holes align with the two screws.
4. Close the filter housing, your air filter is ready for operation.

To clean or change a filter, open the filter housing by swinging it out and down. Remove and clean the filter in hot soapy water. Replace the filter if it won't clean up. Put the filter back in the housing and close it.

New head including top plate, valves, and air filter



Ref. No.	Description	Part Number	Qty.
1	O-ring	ST157900AV	1
2	Filter housing	VT035000AV	1
3	Cylinder head	VT015003AG	1
4	◆ Cap screw, 5/16" - 18 x 6"	ST074302AV	2
5	Head top plate	VT035100AV	1
6	* Screw, pan head, 1/4" long	ST073231AV	8
7	* Flapper valve, .015" thick	VS001801AV	4
8	Screw, 1/4" - 20 x 3/4"	ST074402AV	4
9	* Cylinder gasket (2¾" cylinders)	XA003300AV	1
	* Cylinder gasket (3" cylinders)	XA005700AV	1
10	Cap Screw, 5/16" - 18 x 5½"	ST021800AV	4
11	* Valve restrictor, .048" thick	VT021500AV	2
12	Foam Filter	ST128500AV	1
13	* Flapper valve, .008" thick	VS001800AV	2
14	Gasket	XA010600AV	1
15	* Screw, pan head, 5/16" long	ST073261AV	4
16	Cap screw, 1/4" - 20 x 3/4"	ST074313AV	2
17	Helical lockwasher 1/4" Plug, 1/8 - 27 Plug, 3/8 - 18	ST071023AV ST022400AV ST072910AV	2 1
◆ One screw is provided in kit. * Not in VT2529 kit. ● Not shown in illustration.			