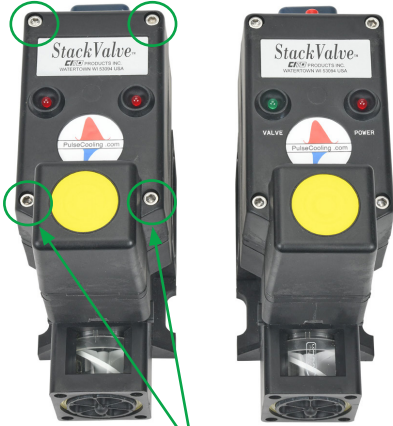




Assembly: Determine how many StackValves you want to assemble together. You only need to modify one of the valves for 2 or 3 together, two valves if you are assembling 4 or 5, etc..



1.



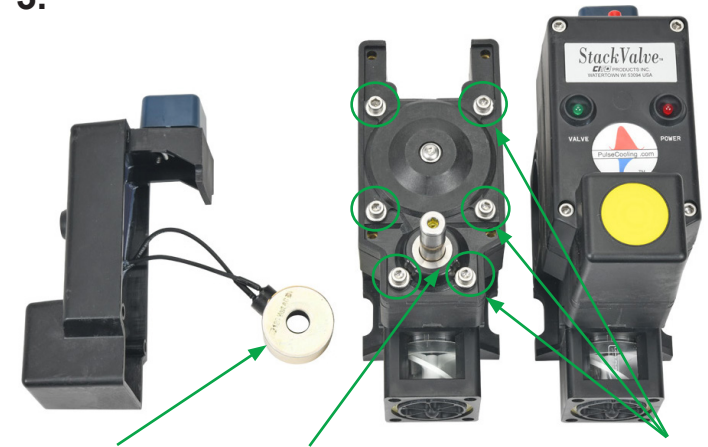
Using a 5/32" hex wrench, remove the (4) socket head cap screws holding the StackValve top on. Remove the top by pulling straight up.

2.



Remove the retaining clip holding the solenoid coil and remove the coil assembly. A large flathead screwdriver can assist in removing the clip.

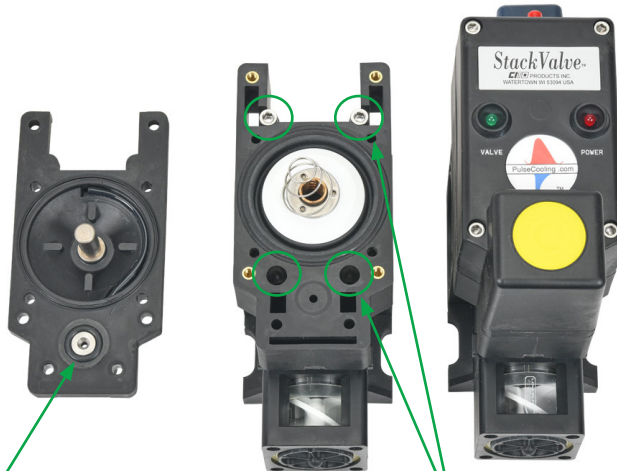
3.



Be sure to retain the retaining clip, the loose parts of the coil assembly and the wave spring washer that is underneath it.

Using a 5/32" hex wrench, remove the (6) socket head cap screws and washers holding the top plate assembly. Remove the top plate assembly.

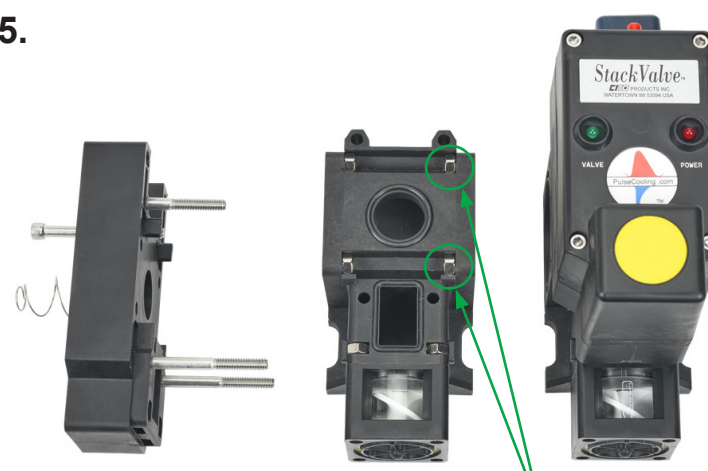
4.



There is an orifice that might fall loose. Be sure to retain this part for reassembly later.

Using a 3/16" hex wrench, remove the (4) socket head cap screws holding the seat body. Remove the seat body.

5.



For each side that will have an adjacent StackValve, replace the nuts in the body with socket head cap screws from bolt kit BK-9100. Place an o-ring (included in BK-9100) between the two valve bases. Tighten the screws to the adjacent valve body.

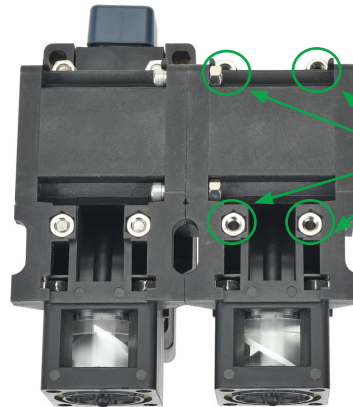
Before reassembly, ensure that all nuts are in place before bolting the seat body back onto the base.

6. These nuts must be slid tight to the outside of the groove



These nuts must be in place before assembling any further.

Note: Rear view



These (4) nuts must be in place on the back of the base. These are what the (4) socket head cap screws for the seat body will attach to.

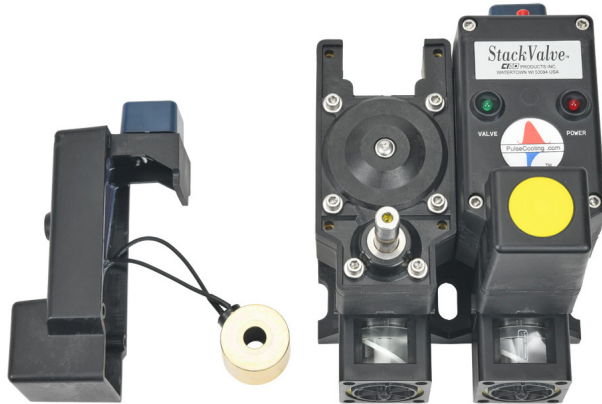
- 7.



Using the (4) socket head cap screws removed earlier in step #4, bolt the seat body back onto the base.

If the orifice was loose from earlier, place it on the seat body over the small hole in the center of the seat body with the flat side on the base and the cone pointing up.

- 8.



Guide the metal post into the spring and ensure the orifice is located properly. Then attach the top plate to the seat body using (6) screws and washers from step #3. Torque (6) screws to 60 in-lbs

- 9.



Place the wave washer on the solenoid stem, then assemble the solenoid coil onto the stem. Secure in place using the retainer clip removed earlier. Press down on the coil assembly and use pliers to assist securing the clip in place.

- 10.



Bolt the StackValve top back onto the assembly using the 4 bolts removed earlier in step #1. The coil might need to be rotated to allow for the top to fit properly. Remember to use the bolts and nuts from BK-9100 to bolt the rear of each module together.