

# Step by Step Assembly Instruction

## BPR15000A



Step 1

Apply RED LokTite to Brass Bushing, P/N 20096



Step 2

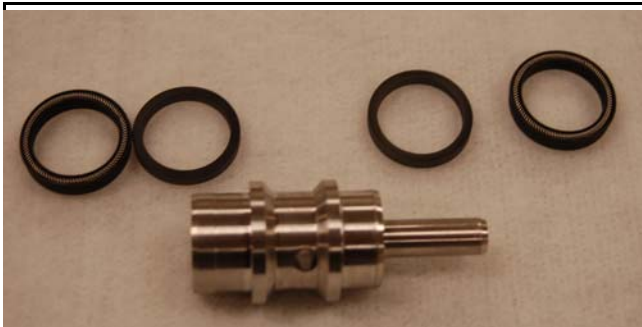
Install Brass Bushing 20096 in Body 20203



Bushing Properly Installed

# Step by Step Assembly Instruction

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Seat Holder, P/N 20208  
Cup Seals (2 ea.), P/N 71001864  
BU Rings (2 ea.), P/N 71001883



### Step 3

Install BU Rings, P/N 71001883 (2 ea.) on  
Seat Holder, P/N 20208

**CAUTION : ORIENTATION**  
BU Rings go on first in both locations.



### Step 4

Install Cup Seals, P/N 71001864 (2 ea.) on  
Seat Holder, P/N 20208

**CAUTION : ORIENTATION**  
SS spring is visible in both locations.

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	<p>Step 5</p> <p>Install Seat, P/N 20121 in Seat Holder</p>
	<p>Step 6</p> <p>Install Seat Cup Seal, P/N 71001862 around Seat.</p>
	<p>Step 7</p> <p>Install ATM Cup Seal, P/N 71001858 on Seat Holder Stem</p> <p><b>CAUTION : ORIENTATION</b> SS spring goes on stem first.</p>

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### Step 8

Install ATM BU Ring, P/N 71001883 on Seat Holder Stem.



### Step 9

Install Seat Holder Assy in Body, P/N 20203

**CAUTION :** Care must be taken to compress Cup Seal edges into the Body bore.

Gently rock the Seat Holder around the Bore opening while pushing the Seat Holder down to get the Cup Seal started.



**Seat Holder Properly Installed**

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	<p>Step 10</p> <p>Install Pin Spring, P/N 71002603 in Piston, P/N 20205</p>
	<p>Step 11</p> <p>Install BU Ring, P/N 71001881 on Piston, P/N 20205</p>
	<p>Step 12</p> <p>Install Cup Seal, P/N 71001864 on Piston, P/N 20205</p>

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Step 13

Install Pin, P/N 20007 in Pin Stop, P/N 20206.



Use the Square Base to hold the Pin Stop in preparation for pressing the Pin into the Pin Stop



Step 14

Press The Pin into the Pin Stop

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Pin properly installed in Pin Stop.



Step 15  
Install Pin & Pin Stop in  
Pin Holder, P/N 20207.



Step 16  
Apply Blue LokTite to  
Pin Holder, P/N 20207.



Step 17  
Install Pin Holder Assy in  
Piston. P/N 20205

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Step 18

Securely tighten Pin Holder Assy to  
Piston. P/N 20205



Step 19

Install Piston. P/N 20205 in  
Body, P/N20203

CAUTION : Care must be taken to compress Cup Seal  
edges into the Body bore.

Gently rock the Piston around the Bore opening while  
pushing the Piston down to get the Cup Seal started.



Piston properly in place.



# Step by Step Assembly Instruction

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Step 20

Install Piston Washer, P/N 20211 on Piston.



Step 21

Install "O" Ring on Body

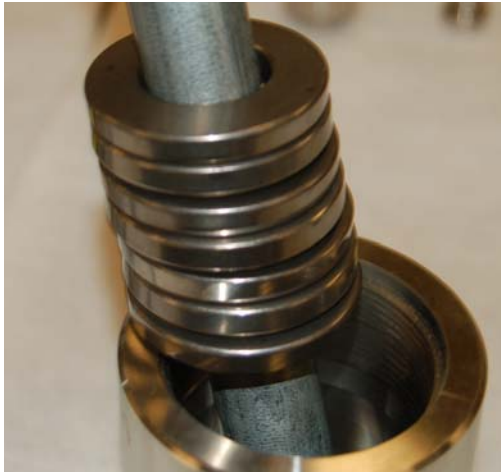


Step 22

Apply SynLube to Body threads

# Step by Step Assembly Instruction

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### Step 23

Install Spring Stack (7 Springs P/N 71001965) in Spring Cap, P/N 20204

CAUTION : ORIENTATION - Springs are not "Nested" but opposed.



### Step 24

Install Spring Cap onto Body Assembly.



### Step 25

Tighten Spring Cap until contact with Body is achieved.

# Step by Step Assembly Instruction

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Step 26

Apply anti-sieze to threads on Handle Assembly

Step 27

Install Handle Assembly in Body.

**COMPLETED UNIT READY FOR TESTING**