

# Service Letter

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**Bulletin:** 40001  
**Date:** 12 February 2009 Revised (10-12)  
**Product:** Compressors  
**Subject:** 7/20 Separator Install flange

## MODELS AFFECTED BY THIS FIELD MODIFICATION CAMPAIGN:

MODELS	SERIAL NUMBER
7/20	122604 - W/field kit
P65	122596 - New design

## LIMITATIONS:

This improvement can be installed on any 7/20 – P65 which uses the below separator vessel cpn's.

ASME - 22331227

EC - 22277347

## DESIGN CHANGE:

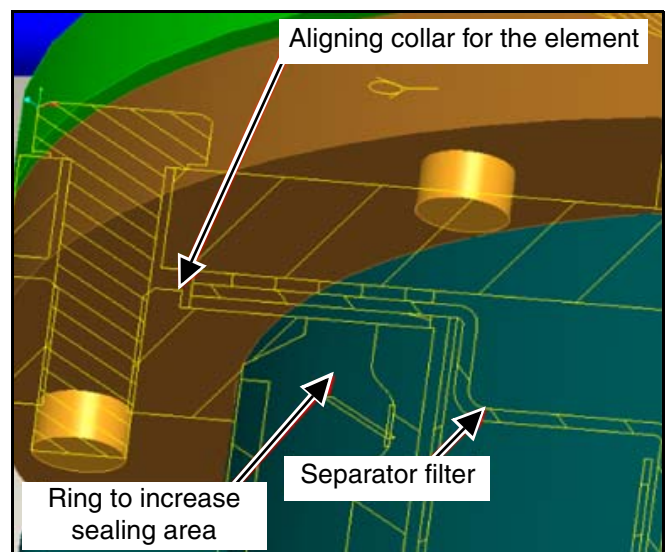
Improvements have been made to increase the sealing area between the lower separator vessel seal and the vessel flange. **[Figure 1]**

On P65 compressors the ASME vessel (22331227) has been upgraded to the new design from SN 122596 onwards.

This redesigned vessel features an internal ring which will increase the gasket sealing area and a collar which will force alignment of the separator filter.

The 7/20 compressor with CE vessel (22277347) meanwhile will have field kits fitted from factory until stock of this vessel is depleted. From that moment on we will also have design equal to P65.

**Figure 1**



## RETROFIT KIT COMPONENTS:

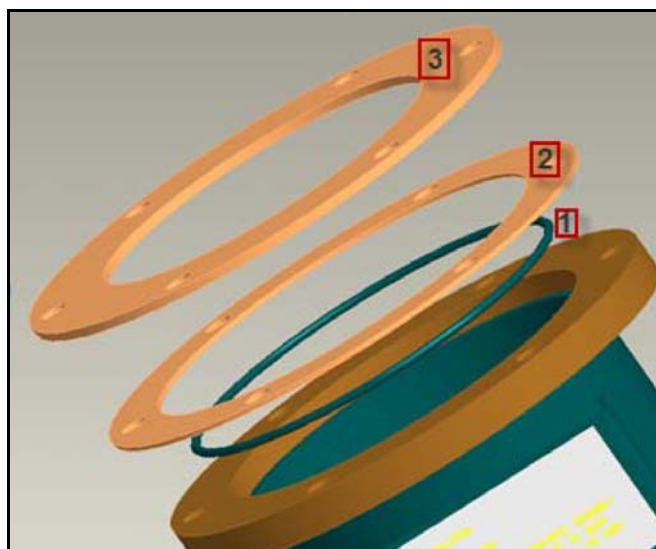
This field kit can be installed whenever separator filter alignment problems and /or oil carryover have been detected.

Complete kit as well as separate parts can be ordered if needed. **[Figure 2]**

## **Parts**

QTY.	P/N	DESCRIPTION
1	23378482	Complete Kit
1 #1	23378268	O-ring ( in kit )
1 #2	23378276	Center ring ( in kit )
1 #3	23378284	Sealing ring ( in kit )

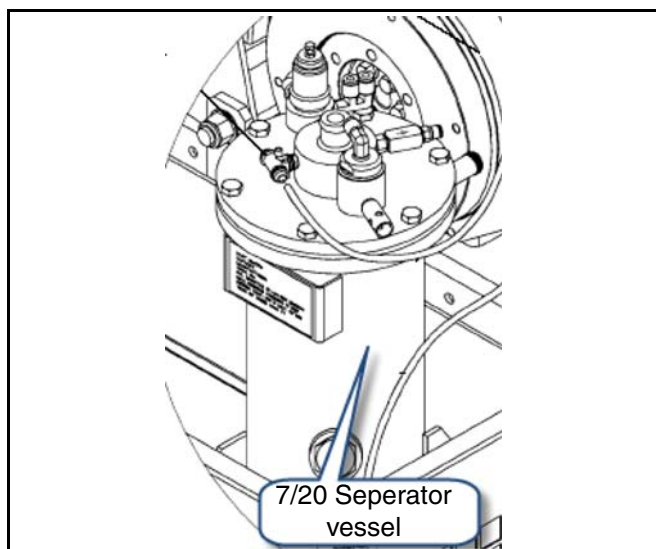
**Figure 2**



**INSTALLATION INSTRUCTIONS:**

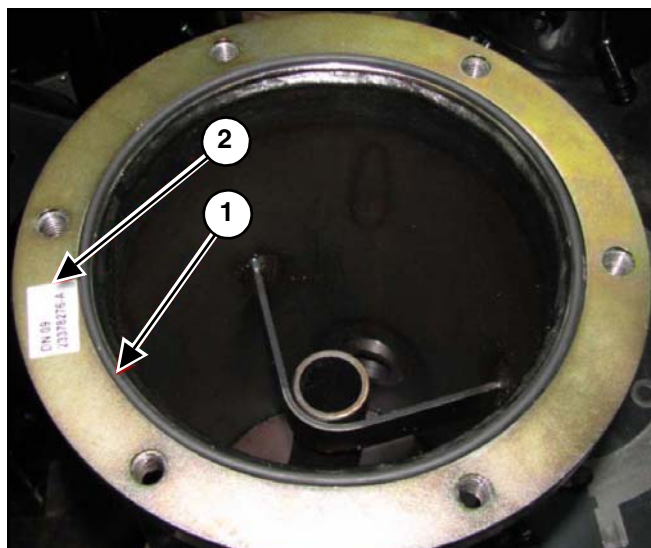
**! WARNING**

High pressure air can cause severe injury or death from hot oil and flying parts. Always relieve pressure before removing caps, plugs, covers and other parts from pressurized air system.



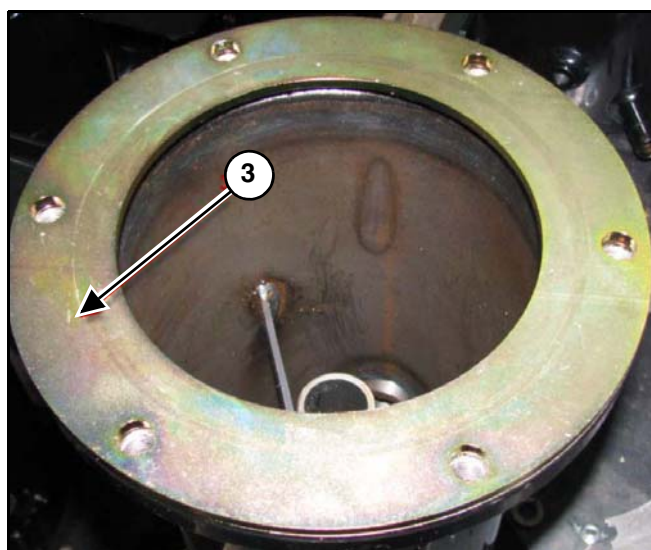
1. Remove hoses and other components to gain access to vessel lid.
2. Remove vessel lid mounting bolts.
3. Remove and discard separator filter and gaskets.
4. Install center ring (Item 2) and o-ring (Item 1) on the vessel flange. **[Figure 3]**

**Figure 3**



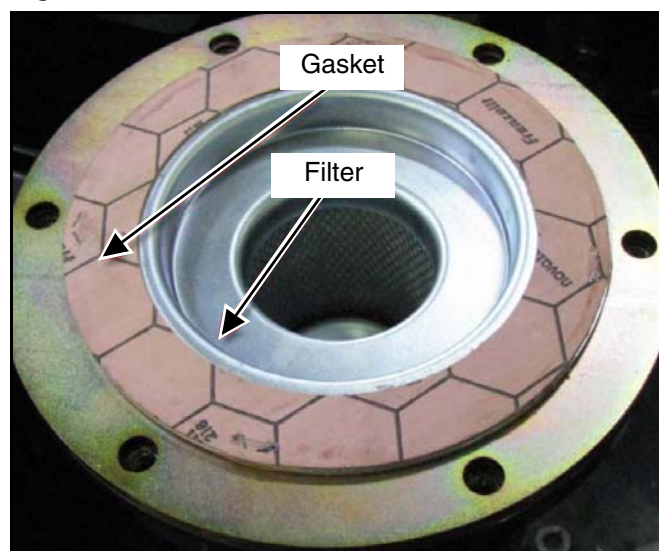
5. Install sealing ring (Item 3). **[Figure 4]**

**Figure 4**



6. Install separator filter with upper and lower gasket. **[Figure 5]**

**Figure 5**



7. Final installation. [Figure 6]

**Figure 6**



**IMPORTANT INFORMATION:**

**Note:**

Excessive oil carry-over may be caused by an oil-logged separator element. Do not replace element without first performing the following maintenance procedure:

1. Check compressor oil level
2. Thoroughly clean scavenge line, orifice and check valve.
3. Assure minimum pressure valve/orifice is operational.
4. After correction of the fault, run unit for 30 to 40 minutes to permit the filter element to clean itself.