

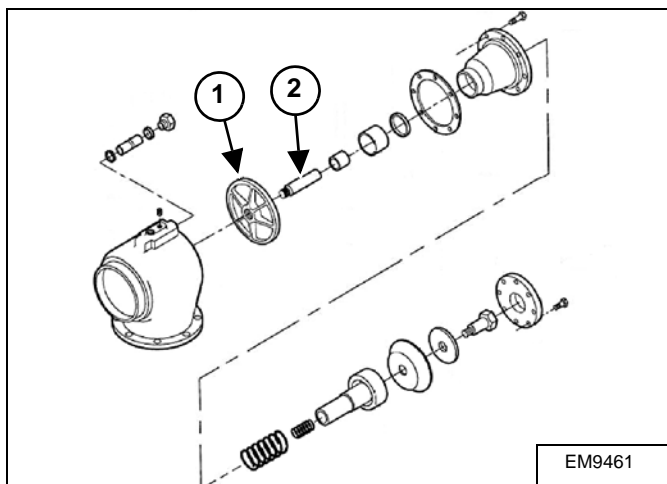
Service Letter

SL: 40024
Date: 23 November 2011
Product: Compressors
Subject: Unloader Assembly - Valve Plate Detaching From Valve Stem

MODEL	SERIAL CODE
HP750WCU-T3	B76
XP825WCU-T3	B77
HP750WCU-T2	C09
XP825WCU-T2	C10
HP915WCU-T3	C60
HP915WCU-FX-T3	E16
HP935WCU-T1	708
HP1600WCU-FX-T3	E09
HP1600WCU-T3	B83
HP1600FCU-EX-T3	E49
HP1600WCU-T3	E10
HP1600WCU-T1	692

NOTE: For the affected machine serial numbers, see the table on page 2.

Figure 1



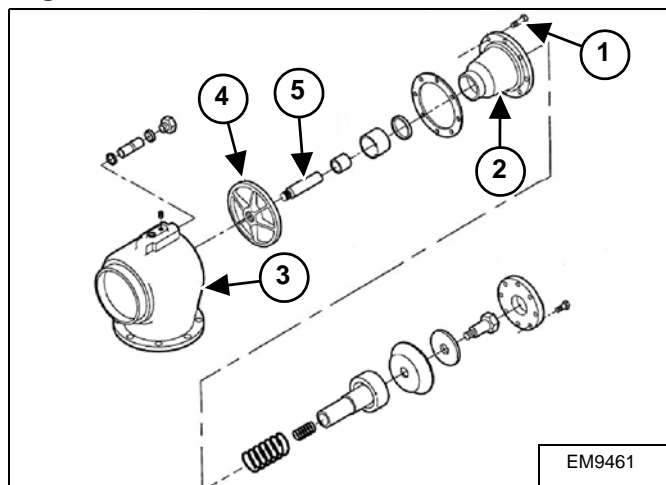
[Figure 1] Doosan Infracore has determined that the valve plate (Item 1) may come loose from the valve stem (Item 2) in the unloader valve assembly of the compressors listed in this letter.

This can cause the safety valve to open when full pressure is reached at start-up and may result in the release of compressed air/oil mix through the unloader and into the air end air cleaner during shutdown.

Therefore the unloader valve assembly must be inspected and repaired (if necessary) to make sure the valve plate and valve stem connection is tight.

Procedure

Figure 2



Disconnect the hoses and tubes from the rear of the unloader assembly. Remove the screws (Item 1) to remove the housing piston (Item 2) from the body (Item 3) **[Figure 2]**.

Remove the valve plate (Item 4) and valve stem (Item 5) from the housing piston (Item 1) **[Figure 2]**.

Protect the valve stem (Item 5) with cardboard and secure in a vise with the valve plate up. Try to remove (unscrew) the valve plate (Item 4) **[Figure 2]** from the valve stem by hand.

NOTE: If unable to remove the valve plate by hand, no further action is required. The valve plate and valve stem can be reinstalled and the machine can be put back into service.

If the valve plate (Item 4) can be removed from the valve stem (Item 5) **[Figure 2]** by hand, clean the threads of each part with cleaning solvent and allow the solvent to dry.

Apply Loctite® 271 on the threads of the valve plate (Item 4) and valve stem (Item 5) **[Figure 2]** and install the valve plate on the valve stem.

When the valve plate (Item 4) is approximately 3 - 4 mm (1/8 in) from the shoulder of the valve stem (Item 5) **[Figure 2]**, give it a quick spin. This will assure the valve plate locks to the valve stem shoulder and threads.

Reinstall the valve plate (Item 4) and valve stem (Item 5) assembly into the housing piston (Item 2) **[Figure 2]**.

Reinstall the housing piston (Item 2) into the body (Item 3), using the screws (Item 1) **[Figure 2]**. Reinstall the hoses and tubes to the rear of the unloader assembly.

Doosan Infracore Portable Power will allow warranty claims to be submitted for 2 hours labor, travel time and mileage. Warranty claims should refer to campaign 06-11. Warranty claims must be submitted by March 30, 2012.

AFFECTED MACHINE SERIAL NUMBERS	
429060UHVC09	432332UJVC09
429061UHVC09	432333UJVC09
429063UHVC09	432334UJVC09
429724UHVC09	432335UJVC09
429725UHVC09	429729UHVC10
429727UHVC09	429730UHVC10
429728UHVC09	430187UHVC10
430190UHVC09	430189UHVC10
430191UHVC09	431385UIVC60
430195UHV76	431386UIVC60
430373UIVC09	431387UIVC60
430374UIVC09	431388UIVC60
430701UIVC09	431390UIVC60
430702UIVC09	31391UIVC60
431840UIVC09	430194UHV708
431841UIVC09	431572UIV708