(314) 832-4500
Telex 44-2310

Essex Precision Controls, Inc.
8213 GRAVOIS AVENUE ● ST. LOUIS, MO. 63123

ESSEX PRECISION CONTROLS, INC.
K-1248-8-4
BOEING P/N 60B00232-6
OVERHAUL AND PARTS LIST

IN-LINE CHECK VALVE

NOTE: This manual supercedes the Kohler manual dated October 14, 1968

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TABLE OF CONTENTS

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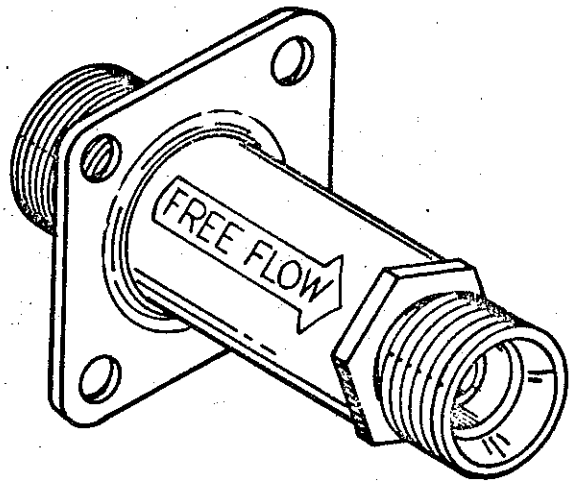
Model No. K1248-8-4



In-Line Check Valve

Figure 1

1. Description and Operation. (See Figure 1.)

   A. The in-line check valve a spring loaded poppet type. This valve is used in the Hydraulic Plumbing System.

2. Disassembly. (See Figure 2.)

   A. Remove cap (5) from sub-assembly (1).

   B. Remove and discard O'ring seal (4).

   C. Remove spring (3).

   D. Carefully remove disk (2) to avoid scoring or scratching body (1).

3. Cleaning.

   A. Wash all parts in Stoddard Solvent (P-S-661), or equivalent. Drain or blow off cleaning solvent with dry, filtered, compressed air.

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4. Inspection. (See Figure 2.)

   A. Inspect all threads for stripping or other damage.

   B. Inspect spring (3) for set condition. A force of 6.4 ounces ± .64 ounce shall compress the spring to a height of 0.428 inch.

   C. Inspect cap (5), disk (2) and body sub-assembly (1) for cracks, scores, nicks, abrasions or burrs.

   D. Inspect valve seat in body sub-assembly (1) to ensure presence of sharp seating edge.

   E. Inspect disk (2) for unusual wear patterns.

5. Repair. (See Figure 2.)

   A. Repair minor thread damage by chasing.

   B. Replace spring (3) if it does not meet inspection limits specified in Paragraph 4.B.

   C. Repair minor damage to cap, disk and body by removing high metal, blending and polishing. Disk must fit into body with a smooth movement. No binding is permitted. If parts bind after repair, replace disk.

   D. Worn valve seat in body sub-assembly may be machined to restore sharp-edged seat, free of nicks and burrs.

   E. Disk seating surface may be refinished to remove minor depressions.

   F. O'ring (4) must be replaced each time valve is repaired.

6. Assembly. (See Figure 2.)

   A. If seat in body sub-assembly (1) or seating surface on disk (2) were repaired. The mating seating surfaces should be lapped together, using Grade 38-1200 compound United States Products Co., Pittsburgh, PA. or equivalent for 45 seconds. Clean parts per Paragraph 3.A.

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B. Place body sub-assembly (1) in suitable holding fixture. Locate body so that flow arrow is pointing upward.

C. Place disk (2) in body sub-assembly (1).

D. Place spring (3) in body sub-assembly (1) on top of disk (2).

E. Place new O'ring (4) on cap (5).

F. Screw cap (5) onto body sub-assembly (1) torque to 25-30 lb-ft.

7. Fits and Clearances. Not applicable.

8. Testing.

A. Test Equipment Requirements.

(1) One 0-15 psig hydraulic gage, accurate to within ± 1 percent.

(2) One 0-5000 psig hydraulic pressure gage, accurate within ± 1 percent.

(3) Source of supply Skydrol 500 hydraulic fluid 0-4500 psig.

B. Cracking Pressure Test. Slowly apply pressure to the valve inlet. The valve shall open at pressure of 2-8 psig.

C. Leakage Test External. Apply pressure to 4500 psig to outlet of valve. No permissible external leakage allowed.

D. Leakage Test Internal. Apply pressure to 2000 psig to outlet of valve, hold for 3 minutes. No internal leakage allowed.

9. Trouble-Shooting.

A. No special trouble-shooting procedures are required. If valve does not pass test, it must be disassembled, re-inspected for faulty parts or assembly techniques, re-assembled and re-tested.

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IN-LINE CHECK VALVE

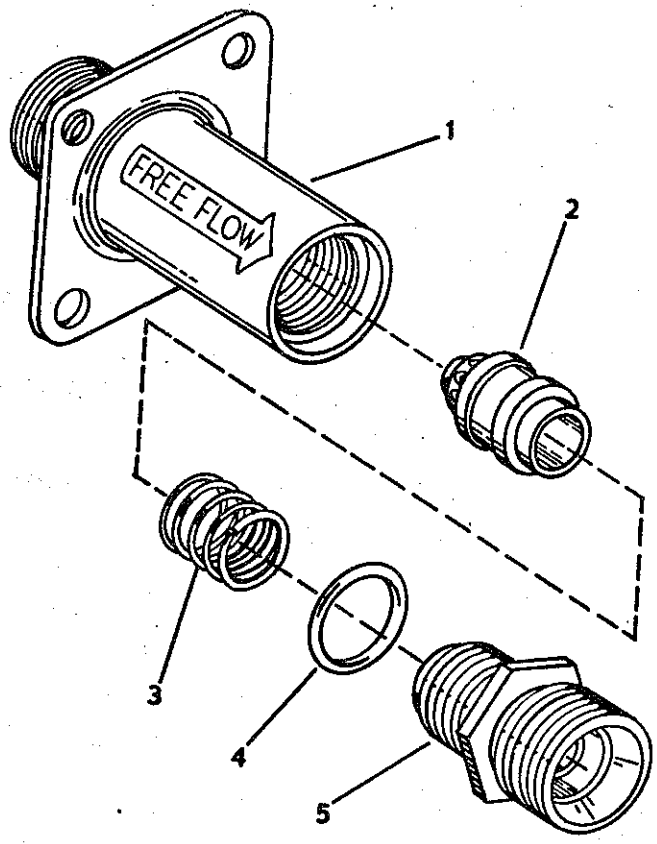
10. Storage Instructions.

A. Drain excess test fluid from the valve.

B. Cap ports with suitable caps, wrap in heavy packing paper and package in cardboard carton.

11. Special Tools, Fixtures and Equipment. None required.

12. Illustrated Parts List.



Exploded View - In-Line Check Valve

Figure 2

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FIG.	ITEM	PART NUMBER	NOMENCLATURE 1 2 3 4 5 6	EFFECT FROM TO	UNITS PER ASSY.
2		K1248-8-4	VALVE, In-Line, Check		RF
	1	A8790	Body Sub-Assy		1
	2	A2002	Disk		1
	3	A208	Spring		1
	4	NAS1611-112	O'Ring		1
	5	A8793	Cap		1