



Instructions for replacing internal parts on the (S)ORIT-PI Valve

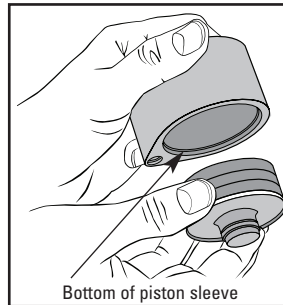
Once the system (or circuit) has been properly pumped down, and refrigerant has been removed:

1. On SORIT-PI models, switch off power to solenoid coil, and remove coil from solenoid enclosing tube.
2. On valves dated 3204 or later, loosen external pilot bleed flare nut and separate pilot line from pilot valve assembly.
3. Loosen the cap screws evenly and remove the pilot valve assembly, piston sleeve, and piston assembly.

NOTE: For proper valve operation, DO NOT REUSE old piston or pilot assembly. New piston and pilot assembly MUST be used together.

4. For (S)ORIT-PI products dated earlier than 3204, drill a 1/4" hole into the copper outlet fitting of the valve for external bleed pilot line. Refer to Table 1 for hole location. Take precautions to minimize copper chips from falling into valve outlet fitting. Insert end of external bleed line into newly drilled hole. Loosely connect external bleed line flare nut to male flare connection on pilot assembly. Wrap the valve body at the outlet fitting with a wet rag, or heat absorbing paste. Braze the 1/4" line into the outlet fitting of the valve.

5. When rebuilding a PI-5 that utilizes the brass cast body the A4 element needs to be removed on the new pilot assembly. Remove the A4 element and place 2 washers under each of the two cap screws. The length of the two cap screws needs to be reduced slightly because the brass cast body in these two locations is not threaded all the way through.



6. Place the new guide pin and O-Ring in the valve body. Place the new body O-Ring into the valve body. Note: Slightly oiling the O-Rings will help keep them in place

during assembly. Insert the new strainer into the piston sleeve with the new O-Ring. Install the new sleeve and piston assembly on the valve body. **Be sure to insert the piston into the piston sleeve from the bottom only, to avoid damaging the cup seal.**

7. Place the new body O-Ring in the pilot assembly. Insert the piston spring between the pilot assembly and the top of the piston. Place the pilot valve assembly on top of the piston sleeve. Tighten all four cap screws evenly in a criss-cross pattern to a torque of 25 ft. lbs.
8. Tighten the pilot bleed flare nut connection on the pilot assembly.
9. On SORIT-PI models, reinstall solenoid coil. Switch on power to the solenoid coil.
10. Check the valve for leaks, evacuate, and restart system (circuit).
11. Adjust pilot assembly for desired evaporator setting.

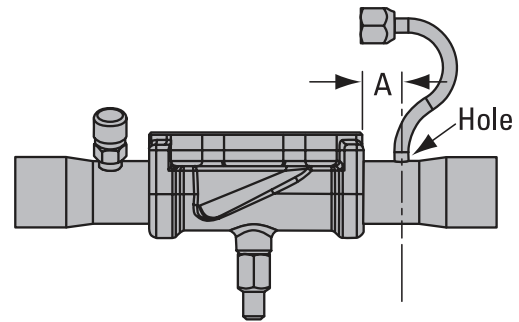


Table 1

Fitting Size	Dimension A Length from Body
5/8", 7/8", 1-1/8"	Approximately 1.3"
1-3/8", 1-5/8", 2-1/8"	Approximately 1.6"
PI-5 Cast Body Only	Approximately 2.1"

Valve Description	Rebuild Kits	Included in Kits					
		ORIT-PI pilot	SORIT-PI pilot	Piston and sleeve assembly			
		ORIT-PI pilot, adjustable element, (2) cap screws	SORIT-PI pilot, adjustable element, (2) cap screws	Piston sleeve, PI-2 piston assembly	Piston sleeve, PI-3 piston assembly	Piston sleeve, PI-4 piston assembly	Piston sleeve, PI-5 piston assembly, 4 washers
ORIT-PI-2	RK-ORIT-PI-2	1	–	1	–	–	–
ORIT-PI-3	RK-ORIT-PI-3	1	–	–	1	–	–
ORIT-PI-4	RK-ORIT-PI-4	1	–	–	–	1	–
ORIT-PI-5	RK-ORIT-PI-5	1	–	–	–	–	1
SORIT-PI-2	RK-SORIT-PI-2	–	1	1	–	–	–
SORIT-PI-3	RK-SORIT-PI-3	–	1	–	1	–	–
SORIT-PI-4	RK-SORIT-PI-4	–	1	–	–	1	–
SORIT-PI-5	RK-SORIT-PI-5	–	1	–	–	–	1

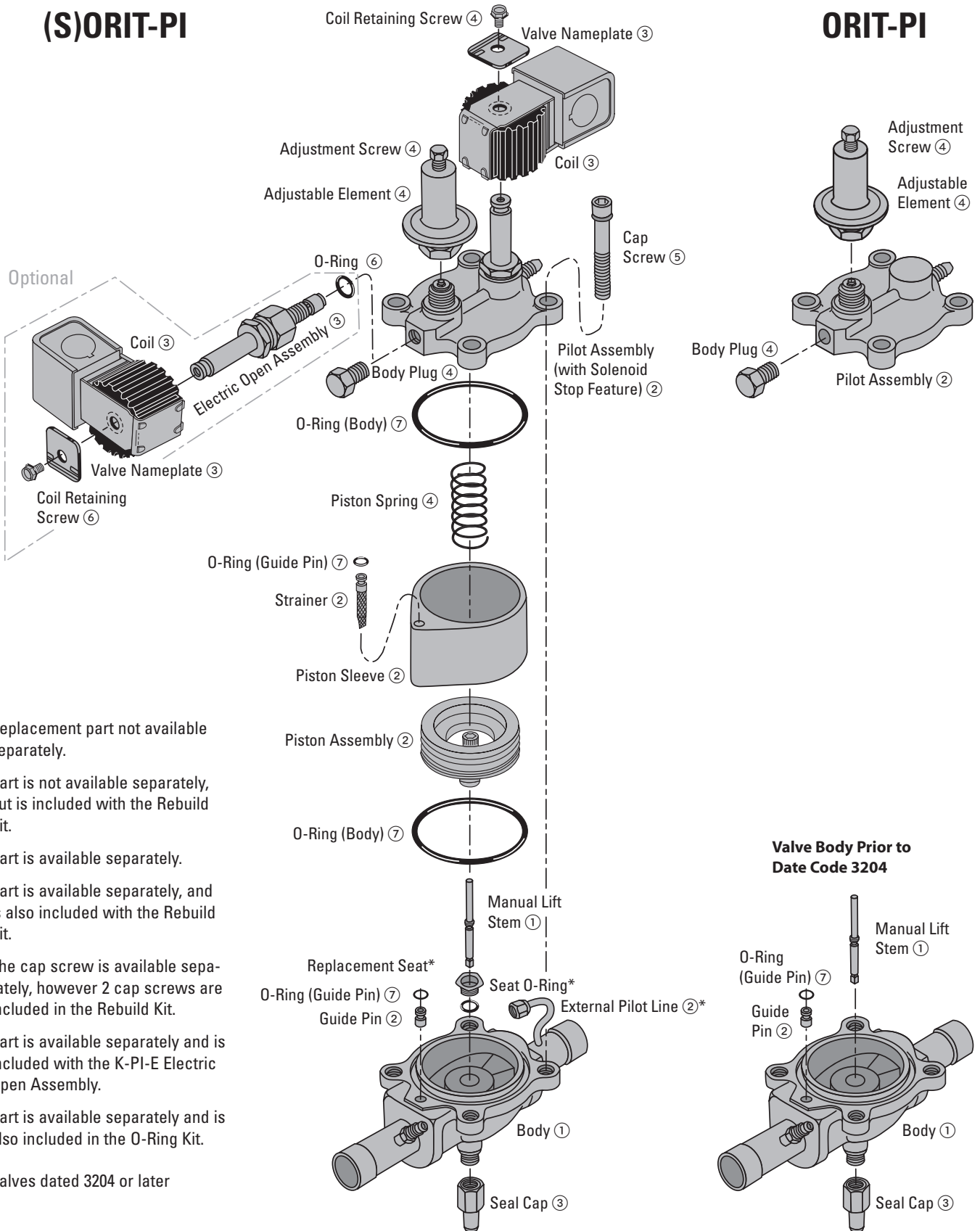
All RK kits contain the following: strainer with O-Ring, guide pin with O-Ring, external pilot line, piston spring and 2 cap screws. The SORIT kits also include a coil retaining screw and a replacement name tag with labels for proper identification.

NOTE: Valve piston is included with the Rebuild kit and must be replaced for proper valve operation.

Sizing kits available for resizing valves, see SD-277 for kit information.

(S)ORIT-PI

ORIT-PI



- ① Replacement part not available separately.
- ② Part is not available separately, but is included with the Rebuild Kit.
- ③ Part is available separately.
- ④ Part is available separately, and is also included with the Rebuild Kit.
- ⑤ The cap screw is available separately, however 2 cap screws are included in the Rebuild Kit.
- ⑥ Part is available separately and is included with the K-PI-E Electric Open Assembly.
- ⑦ Part is available separately and is also included in the O-Ring Kit.

*on valves dated 3204 or later



Sporlan Division
Parker Hannifin Corporation
206 Lange Drive
Washington, MD 63090
636-239-1111 • FAX 636-239-9130
www.sporlan.com