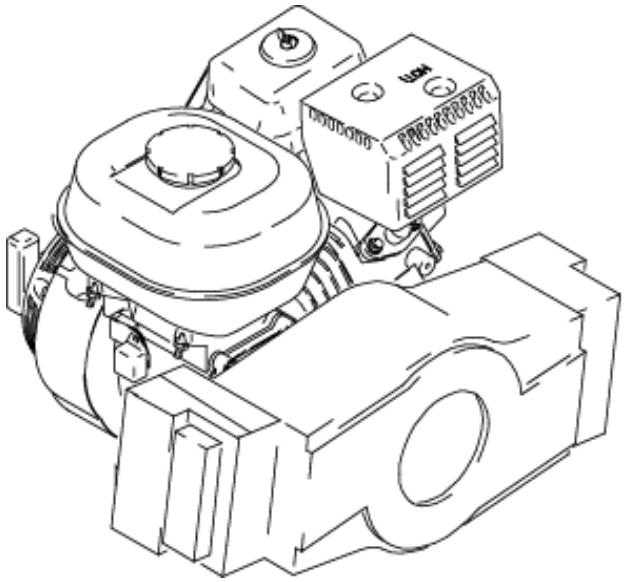
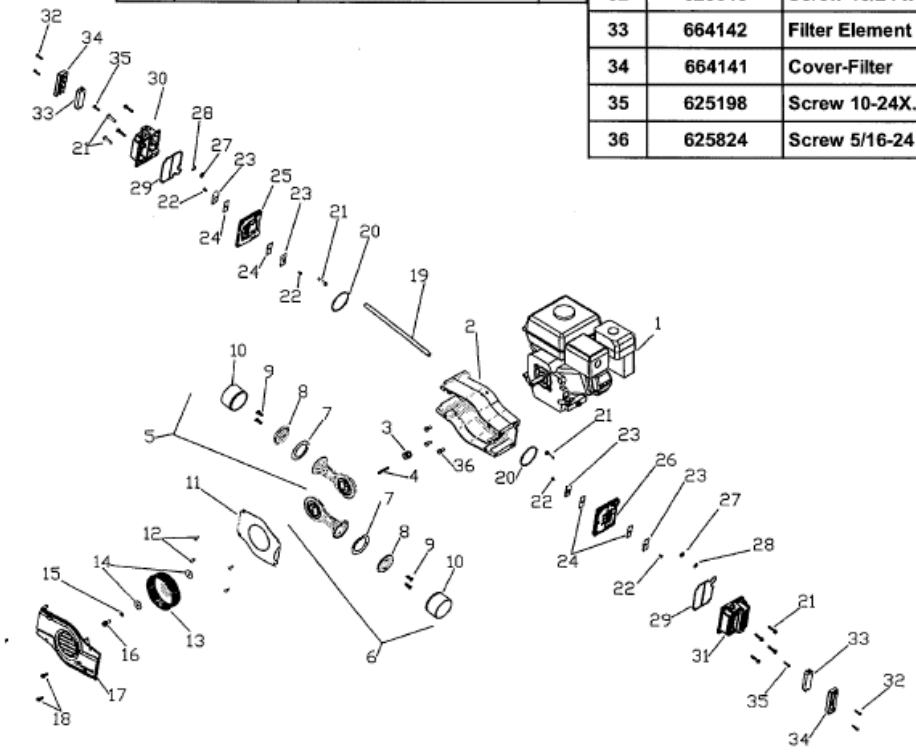
RTX 2000 Thomas Compressor TG-550
Graco PN 246888



Key	Part No.	Description	Qty.
1	643317	Engine-Honda 5.5HP	1
2	669115-540	Housing-Black	1
3	627247	Spring .75 ID X 1.0 L	1
4	626866	Key, Square - 3/16 x 1.8	1
5	666761	ConnRod, Ecc, Sleeve & Brg. Assy. (Inner)	1
6	666762	ConnRod, Ecc, Sleeve & Brg. Assy. (Outer)	1
7	626183	Piston Cup	2
8	626190	Retainer	2
9	625170	Screw 1/4-20 x .88	4
10	618193	Cylinder Sleeve	2
11	662805	Deflector Cover	1
12	625192	Screw 10-24 x .5 Pan Hd.	4
13	638891	Fan - Blower Wheel 5"	1
14	626274	Washer	2
15	626035	Lockwasher	1
16	625275	Screw 5/16-24 x .88	1

Key	Part No.	Description	Qty.
17	662412-540	Front Cover - Black	1
18	625172	Screw 1/4-20 x .75	4
19	615671	Tube	1
20	623075	O-Ring	2
21	625171	Screw 1/4-20 x 1.25	10
22	625278	Screw 10-32 x .38	4
23	617497	Restraint	4
24	662563	Valve	4
25	662822	Valve Plate-Acrylic Coat	1
26	662823	Valve Plate-Acrylic Coat	1
27	623096	O-Ring	2
28	623155	Retaining Ring	2
29	623082	O-Ring - Head Gasket	2
30	662501	Head - Burgandy	1
31	662619	Head - Burgandy	1
32	625646	Screw 10/24 x .88	4
33	664142	Filter Element	2
34	664141	Cover-Filter	2
35	625198	Screw 10-24X.88	2
36	625824	Screw 5/16-24 x .75	3



HOT LINE

RETAIN FOR FUTURE REFERENCE

Graco Inc.
P.O. Box 1441
Minneapolis, MN 55440-1441

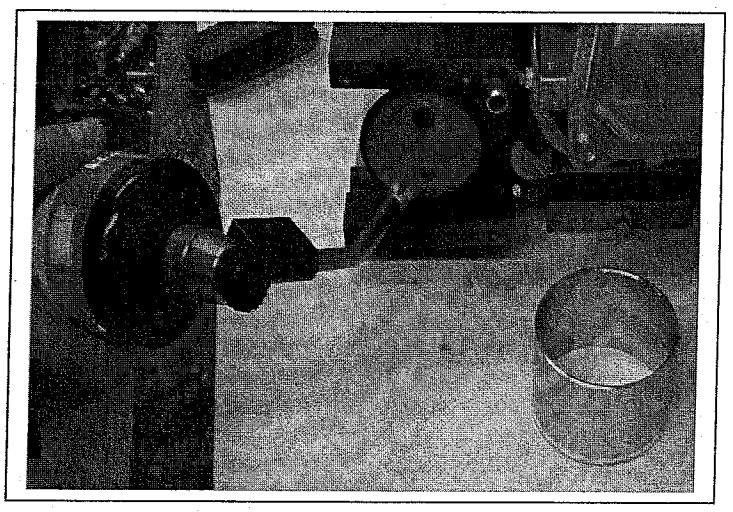
GRACO PRODUCT SERVICE **NUMBER**

July 15, 2005 **804**

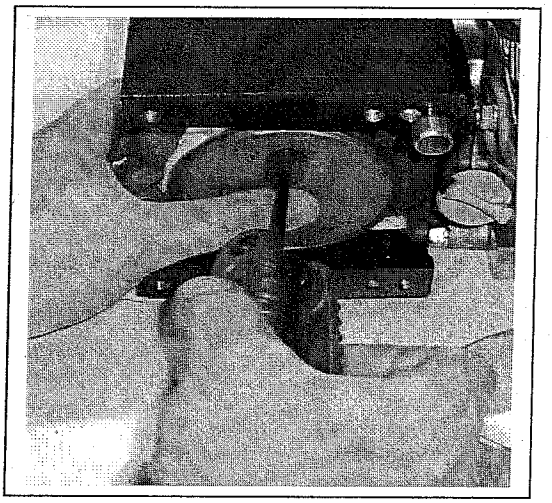
To: CED Service Centers

Sub: 246905, GTX 2000 Compressor Service Tip

The two screws in the piston must be removed in order to replace the piston seals used in the 118628 rebuild kit for the 240605 compressor used on the GTX 2000. These screws are retained with a thread locking material that makes removal extremely difficult unless the screws are heated with a propane torch prior to removal.



Heat screw heads



Remove

Best Regards

Chuck Steiner
Product Service Manager
csteiner@graco.com

118628 Compressor Rebuild Kit

MODEL 1916
COMPRESSOR REBUILD KIT
TG-550 SERIES

CAUTION: Improper assembly or use of damaged parts may lead to premature failure. To avoid frequent repairs follow the recommended assembly procedures.

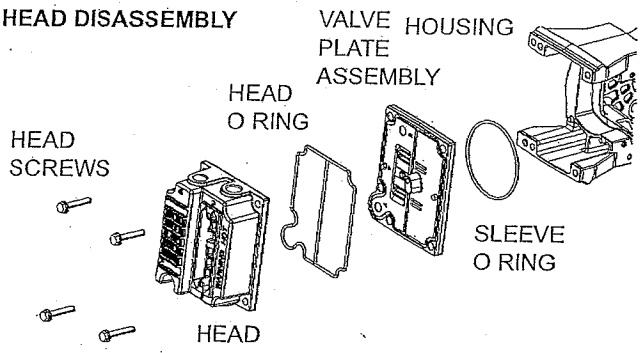
WARNING: Drain compressed air from the tanks before disassembly. Allow engine and compressor to cool before disassembly. PREVENT ACCIDENTAL STARTING by removing spark plug wire when servicing engine or compressor

NOTE: Before you begin, read these instructions thoroughly. Gather the necessary tools. This kit is for a unit with two heads and cylinders.

Tools Required: T-25 Torx screwdriver
Phillips head screwdriver
Adjustable Torque Driver

ATTENTION: To avoid confusion, only service one head/valve plate assembly at a time.

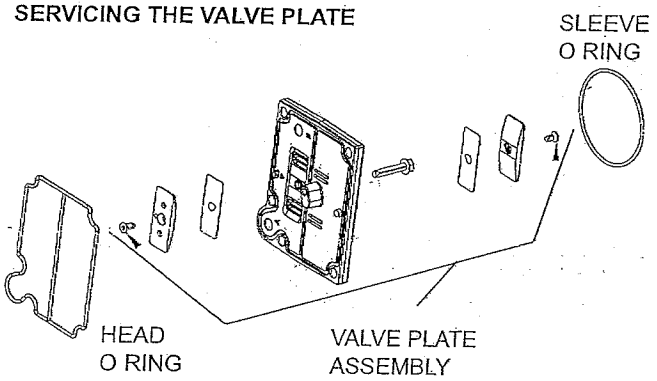
HEAD DISASSEMBLY



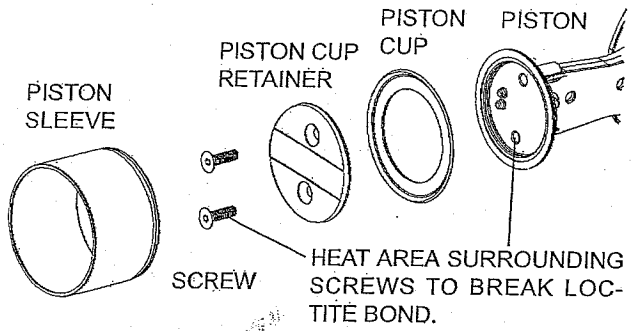
STEP 1. Loosen the four head screws and remove the head and valve plate from the compressor housing.

STEP 2. Loosen and remove the hex fitting of the hose assembly at the control valve (3/4" hex).

SERVICING THE VALVE PLATE



REPLACING PISTON CUP AND SLEEVE



STEP 3. Remove the cylinder sleeve by pulling it from the connecting rod.

STEP 4. Loosen and remove the 2 screws in the center of the piston cup retainer. NOTE: It may be necessary to heat the top of the piston to help break the old loctite bond. Remove piston cup retainer and old piston cup.

STEP 5. Assemble new piston cup with supplied screws 625170. Tighten both screws to 95 in-lbs.

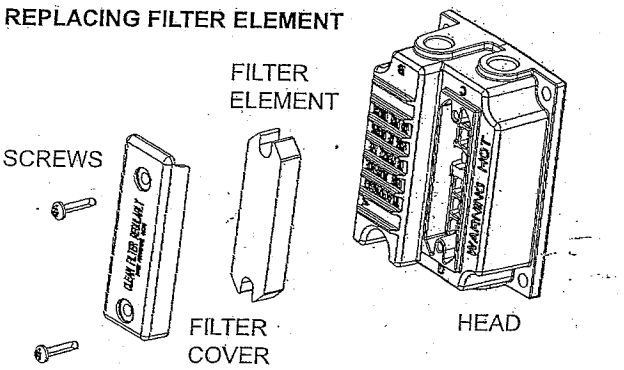
STEP 6. Carefully slip the new sleeve over the piston cup and into the groove in the housing. You may have to squeeze the cup to get it on. Take care not to fold over, cut or damage the cup while assembling the cylinder sleeve.

STEP 7. Replace the old valve plate assembly with the new one from this kit.

STEP 8. Remove the old O-rings from the valve plate. Replace with new O-rings in the grooves on the valve plate.

STEP 9. Assemble valve plate and head. Install the four head screws (port "E" on head should be nearest the engine). Reconnect the hose.

REPLACING FILTER ELEMENT



STEP 10. Remove filter cover by removing the 2 screws. Replace the foam filter. Replace cover and tighted both screws to 45" pounds.

PARTS LIST for 1916 REBUILD KIT

Part No.	Description	Qty.
618193	Cylinder Sleeve	2
623075	O-Ring - Cylinder Sleeve	2
623082	O-Ring Gasket - Head	2
662825	Valve Plate Assembly	1
662824	Valve Plate Assembly	1
625170	Screw - Piston Cup	4
626183	Piston Cup	1
664142	Filter	1

SERVICE KIT 287845

1918 COMPRESSOR SERVICE KIT
TG-550 SERIES

CAUTION: Improper assembly or use of damaged parts may lead to premature failure. To avoid frequent repairs follow the recommended assembly procedures.

WARNING: Drain compressed air from the tanks before disassembly. Allow engine and compressor to cool before disassembly. PREVENT ACCIDENTAL STARTING by removing spark plug wire when servicing engine or compressor. Also remove the spark plug for ease of rotating motor shaft.

NOTE: Before you begin, read these instructions thoroughly. Gather the necessary tools. This kit is for a unit with two heads and cylinders. Familiarize yourself with the parts in the kit.

Tools Required: T-25 Torx® screwdriver
Phillips head screwdriver
Adjustable torque driver
5/16" Socket for torque driver
3/4" Wrench
1/4" Allen® hex bit for torque driver

Parts List for 1918 Service Kit

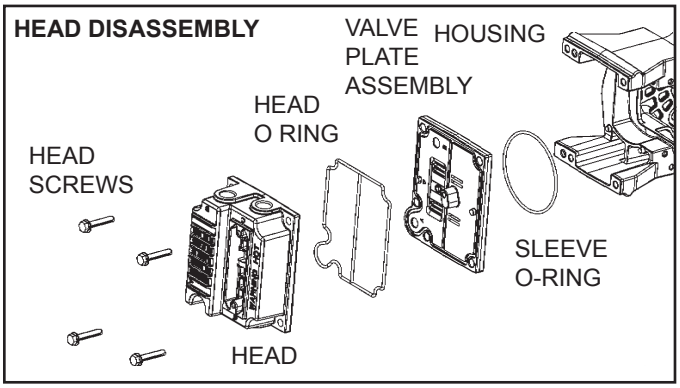
Part No.	Description	Qty.
623075	O-Ring - Cylinder Sleeve	2
623082	O-Ring Gasket - Head	2
666931	Inboard Connecting Rod Ass'y (stamped "580" on the eccentric)	1
666932	Outboard Connecting Rod Ass'y (stamped "582" on the eccentric)	1

Rietschle Thomas
A Thomas Industries Company

For service, contact the dealer from whom you purchased the compressor. To order parts, visit our website www.thomasairpac.com or phone our customer service center at: 1-800-558-7721

STEP 1. Loosen and remove the hex fitting of the hose assembly at the control valve (3/4" hex).

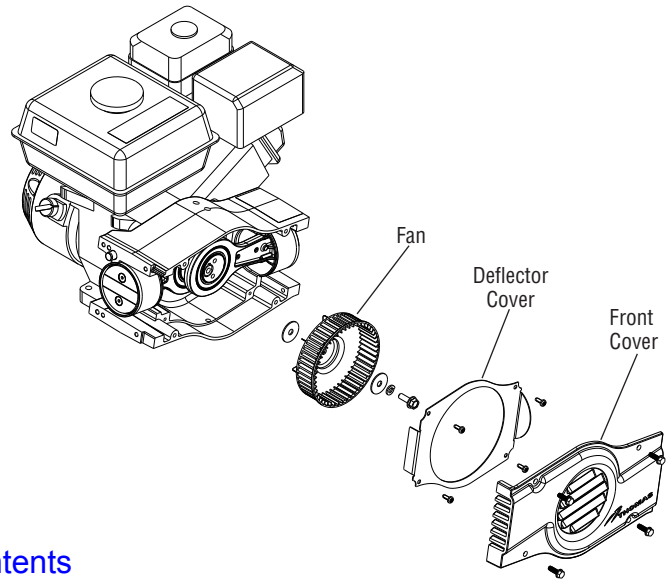
STEP 2. Loosen the four head screws from each head and remove the head and valve plate assembly from the compressor housing. Discard the o-rings. Lay the heads on the same side they came off. They are to be replaced on the same side they were removed.



STEP 3. Remove the 4 front cover screws and remove the front cover. Remove 4 deflector cover screws and remove the deflector cover. Set both covers aside.

STEP 4. Remove the 5/16" screw holding fan, and set aside parts for assembly later.

Note: It may be necessary to secure motor shaft by inserting 1/4" Allen® wrench through housing access holes into eccentric set screw.



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Part No. 642704 06/05

STEP 5. Rotate shaft so the key way is in the 3:00 position, and using access holes on the top of the housing, insert 1/4" Allen® hex, and loosen the eccentric set screw. Rotate shaft so that the key way is now in the 12:00 position, and remove the next set screw from the eccentric. Slide connecting rod assembly off and discard.

⚠ **CAUTION:**With a pencil, mark the shaft where the inboard connecting rod is located. **This is only for reference, and not to be used for exact measurement, or damage will occur.**

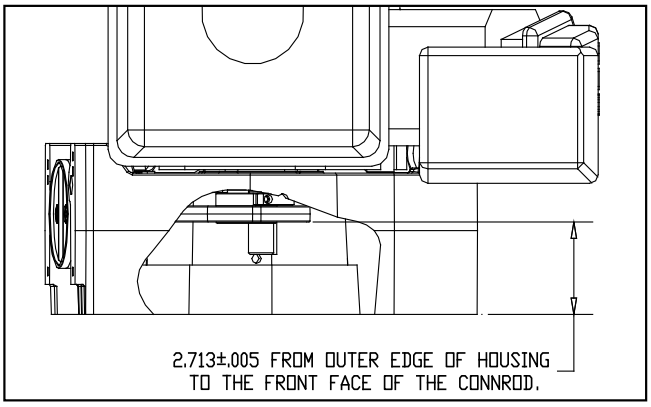
STEP 6. Rotate shaft so the key way is in the 9:00 position, and using access holes on the top of the housing, insert 1/4" Allen® hex, and loosen the eccentric set screw. Rotate shaft so that the key way is now in the 12:00 position, and remove the next set screw from the eccentric. Slide connecting rod assembly off and discard.

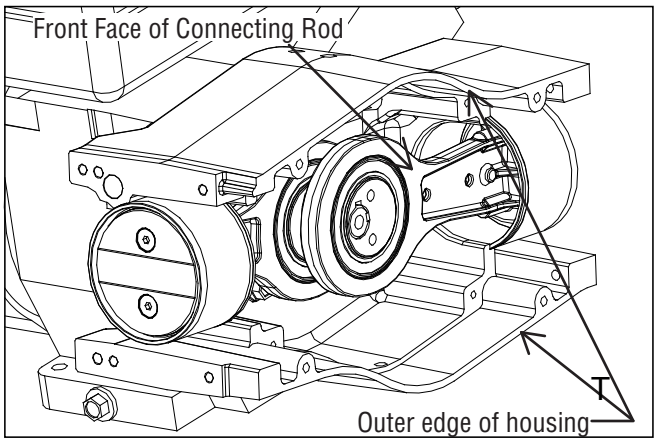
Note: Remove the key and discard spring. Replace the key for assembly.

⚠ **WARNING:** New connecting rod assemblies must hand slide on shaft without using force.

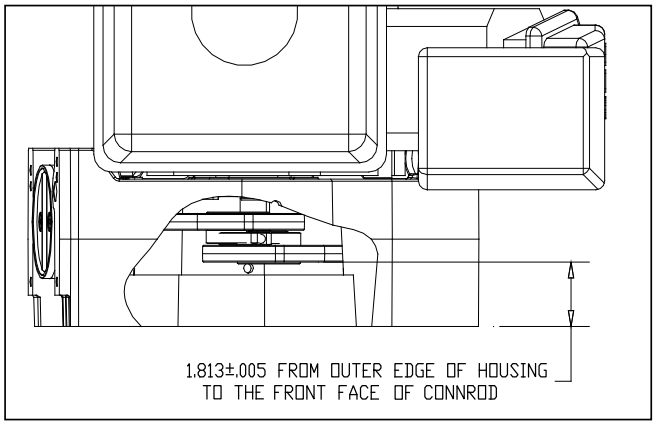
STEP 7. Rotate shaft so the key way is in the 9:00 position. Slide inboard connecting rod assembly (stamped "580") onto shaft with eccentric in, and the sleeve in the 9:00 position. Do not remove the sleeve. The distance from the face of the connecting rod to the edge of the housing must be 2.713 ±.005. Torque the eccentric screw to 100 in-lbs.

⚠ **CAUTION:** Use the pencil mark only as reference. Using the mark for the only means of measurement will result in damage.





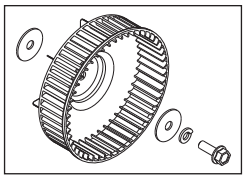
STEP 8. Rotate shaft so the key way is in the 3:00 position. Slide outboard connecting rod assembly (stamped "572") onto shaft with eccentric in, and the sleeve in the 3:00 position. Do not remove the sleeve. The distance from the face of the connecting rod to the edge of the housing must be 1.813" ±.005. Torque the eccentric screw to 100 in-lbs.



STEP 9. Rotate shaft so the key way is in the 12:00 position. Using a punch, tap in the key until it's flush to outboard rod assembly. Using the two access holes in the top of the housing, torque the two key way set screws to 100 in-lbs.

STEP 10. Replace deflector cover. Secure to housing with 4 - Torx® T-25 screws, and torque to 45 in-lbs.

STEP 11. Apply 242 Loctite® to threaded hole of the engine shaft. Assemble fan, pictured below, and torque screw to 120 - 130 in-lbs.



STEP 12. Obtain one of the heads, and remove the two filter cover screws using T-25 Torx® screwdriver. Under the filter, locate the retaining screw, and remove with T-25 Torx® screwdriver. Flip over to valve plate side, and remove the screw securing the head. Seperate valve plate from head, remove o-ring, discard, and replace with new o-ring from kit. Reassemble head and valve plate. Torque the retaining screw on the head side to 45 in-lbs. Turn over, torque the screw on the valve plate side to 110 in-lbs. Reinstall filter. Orient filter cover to head with opening (intake port) pointing down and torque two screws to 40 - 50 in-lbs. Repeat this step for other head.

STEP 13. Assemble cylinder sleeve o-ring into groove of valve plate, and secure to housing using 4 screws, and torque to 110 in-lbs. Check that cross through tube is seated in head. Repeat this step on other side.

STEP 14. Assemble front cover to housing and torque 4 screws to 110 in-lbs.

STEP 15. Apply sealant to 2nd - 3rd thread of pipe thread, and fasten hose to head using 11/16" wrench.