

Gast Oilless Piston Recommended Service Intervals

Intake Air Filter and Muffler Assembly

Intake air filters should be replaced annually for maximum performance and protection of the compressor. The intake filter should be changed more often when the compressor is operating in extreme conditions with high levels of contaminants in the air. Muffler assemblies should be replaced every 6 months under normal operating conditions and more often when operating under extreme conditions.

Model	Filter / Muffler	Model	Filter / Muffler
1HAA	B300A	3HEB	B300F
1HAB	B300A	3HEE	B300F
1HAE	B300A	3LEM	B300F
1LAA	B300A	4VCF	B300F
1VAF	B300A	4VSF	B300F
2HAH	B300A	4HCJ	B300A
2LAF	B300F	4LCB	B300A
1VBF	B300A	4HCC	B300A
2LBB	B300A	5LCA	B300A
2HBB	B300A	5HCD	B300A
2HBC	B300A	5HCA	B300A
3HBB	B300A	6HCN	B300F
3LBA	B300A	6HCA	B300F
3LBD	B300A	7LDE	B300F
PAB	B300A	7HDD	B300A
VAB	B300A	8LDF	B300F
VBB	B300A	8HDM	B300F
PBB	B300A		

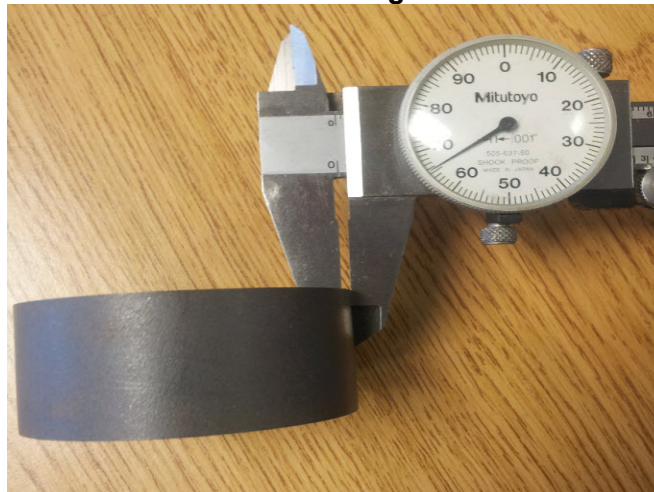
Rings & Rider Ring

Gast piston compressors are engineered to have low wear rate, but like all piston compressors, the piston ring and rider ring will eventually require replacement. The rings should be replaced when any one ring in the compressor wears to the point that it measures less than the minimum thickness dimension illustrated in the chart below. Rings should always be replaced as a complete set.

	Minimum Thickness (inches)	Minimum Thickness (inches)		Minimum Thickness (inches)	Minimum Thickness (inches)
Model	Piston Ring AF527	Rider Ring AF594	Model	Piston Ring AF541	Rider Ring AF595
1HAA	0.100	0.055	3HEB	0.100	0.055
1HAB	0.100	0.055	3HEE	0.100	0.055
1HAE	0.100	0.055	3LEM	0.100	0.055
1LAA	0.100	0.055	4VCF	0.100	0.055
1VAF	0.100	0.055	4VSF	0.100	0.055
2HAH	0.100	0.055	4HCJ	0.100	0.055
2LAF	0.100	0.055	4LCB	0.100	0.055
1VBF	0.100	0.055	4HCC	0.100	0.055
2LBB	0.100	0.055	5LCA	0.100	0.055
2HBB	0.100	0.055	5HCD	0.100	0.055
2HBC	0.100	0.055	5HCA	0.100	0.055
3HBB	0.100	0.055	6HCN	0.100	0.055
3LBA	0.100	0.055	6HCA	0.100	0.055
3LBD	0.100	0.055	7LDE	0.100	0.055
PAB	0.100	0.055	7HDD	0.100	0.055
VAB	0.100	0.055	8LDF	0.100	0.055
VBB	0.100	0.055	8HDM	0.100	0.055
PBB	0.100	0.055			

Check the thickness of the rider ring. It should measure greater than .055". Change all rings if thickness measures .055" or less.

How to measure ring thickness:



Oil-Less Piston Service Kit Installation Instructions

Disassembly

1. Make sure unit is unplugged or is disconnected from electrical power and that the air pressure in the system has been relieved.
2. Drain all air out of the receiver tank if the unit is installed with a tank assembly.
3. Remove the external filters (mufflers on vacuum units) and discard.
4. Remove the shroud (shrouds on multi-head units) and set aside.
5. For multi-head units disconnect the manifold to the first head being serviced.
6. Remove the four cylinder head bolts.
7. Remove the cylinder head valves and valve plate.
8. Remove the two cylinder bolts and then remove the cylinder.
9. Remove the rider ring and measure its thickness. If the thickness is less than .055 inches a new rider ring should be installed.
10. For multi-head units, repeat steps 6-9.

Reassembly

1. Install cylinder over the piston and install the cylinder bolts finger tight.
2. Turn the cooling fan by hand to bring the piston up to top dead center.
3. Place a straight edge on the face of the cylinder and move the cylinder down until the straight edge just touches the piston face.
4. Tighten the cylinder bolts to 155 in-lbs.
5. Install the head assembly and tighten the head bolts to 155 in-lbs.
6. For multi-head units, repeat steps 1-5.
7. If the unit is a multi-head unit, reinstall the elbows and manifolds.
8. Replace the old filters and mufflers with new filters and mufflers.
9. Check that all external accessories such as relief valves and gauges are properly attached and in good working condition before operating product.
10. Reconnect power and test unit performance.