Gast Oilless Rocking 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.

Used On Model (s)	Filter / Muffler	No. Required
8R series	N/A	N/A
55R series	N/A	N/A
LOA series	AH190	1
LAA series	AH190	2
SOA series	AH190	1
SAA series	AH190	2
ROA series	AH190	1
RAA series	AH190	2
71R142 series	B300F	1
71R645-vacuum series	B300F	2
71R545 high pressure series	B300F	1ea.
72R142 series	B300F	1
72R547 vacuum series	B300F	1ea.
72R645 vacuum series	B300F	2
74R130 series	B300A	1
75R135 series	B300A	1
75R635 series	B300A	2
81R640 series	B300A	2
82R637 series	B300A	2
85R632 series	B300A	2
86R1XX series	B300A	1
87R1XXX series	B300A	1

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Cup Wear

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

Used On Model (s)	Part No.	No. Required	Minimum Diameter (inches)
8R series	CUP1001	1	0.87
55R series	AL121	2	1.16
LOA series	AJ826	1	1.636
LAA series	AJ826	2	1.636
SOA series	AH175	1	1.636
SAA series	AH175	2	2.447
ROA series	AH175	1	2.447
RAA series	AH175	2	2.447
71R142 series	AT329	1	2.447
71R645-vacuum series	AT329	2	2.447
71R545 high pressure series	AT329 AT299A	1 1	2.447 1.635
72R142 series	AT280	1	2.697
72R547 vacuum series	AT329 AT280	1 1	2.697 2.703
72R645 vacuum series	AT280	2	2.697
74R130 series	AT329	1	2.447
75R135 series	AT280	1	2.697
75R635 series	AT280	2	2.697
81R640 series	AT329	2	2.447
82R637 series	AT280	2	2.697
85R632 series	AT280	2	2.697
86R1XX series	AT329	1	2.447
87R1XXX series	AT280	1	2.697

Check the thickness of the cup as shown below. If the cup(s) measure less than the minimum diameter in the last column, the cups(s) should be replaced.

How to measure the cup diameter:

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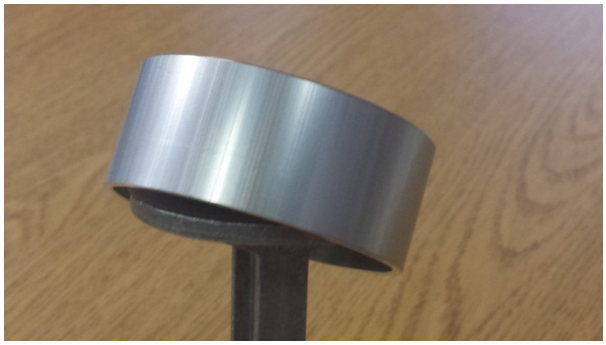
Oil-Less Rocking Piston Recommended Service Interval Instructions

Disassembly

1. Make sure unit is unplugged or is disconnected from electrical power.
2. Drain all air out of the tank if the unit is on 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 three or four cylinder head bolts depending on the model.
7. Remove the cylinder head and valve plate.
8. Remove the cylinder.
9. Measure the overall diameter of the cup using calipers as shown above. If the cup(s) measure less than the minimum diameter in the chart above, the cups(s) should be replaced.
10. For multi-head units, repeat steps 6-9.

Reassembly

1. To reinstall the cylinder over the piston, the cylinder must be put on at an angle as shown below to prevent damaging the cup.



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2. Once the cylinder is started on the piston cup, move it in a figure eight motion, gently pushing down at the same time.
3. Install the valve plate and cylinder head assembly and tighten head bolts according to the torque specifications below.

Model	Torque Specification (in-lbs)
8R series	6
55R series	30
LOA series	80
LAA series	80
SOA series	80
SAA series	80
ROA series	80
RAA series	80
71R142 series	50
71R645-vacuum series	50
71R545 high pressure series	100
72R142 series	50
72R547 vacuum series	50
72R645 vacuum series	50
74R130 series	50
75R135 series	50
75R635 series	50
81R640 series	50
82R637 series	50
85R632 series	50
86R1XX series	50
87R1XXX series	50

4. For multi-head units, repeat steps 1-3.
5. If the unit is a multi-head unit, reinstall the elbows and manifolds.
6. Replace the old filters and mufflers with new filters and mufflers.
7. Check that all external accessories such as relief valves and gauges are properly attached and in good working condition before operating product.
8. Reconnect power and test unit performance.