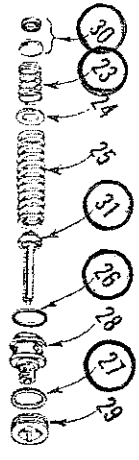
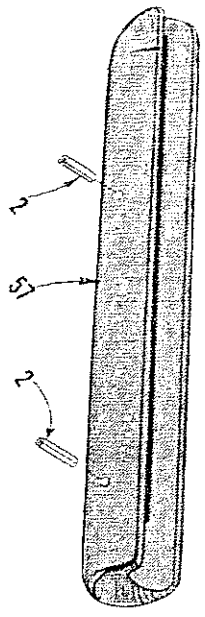
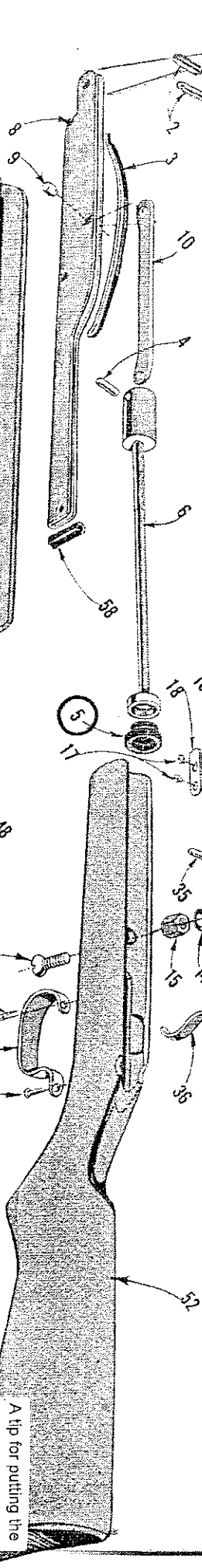


Part 19 is the bolt o-ring, not present on all guns. There will be a groove for this in the bolt if your gun's design had this. It is best replaced over the end of the bolt as removing the bolt is not easily done, even with the right tools.



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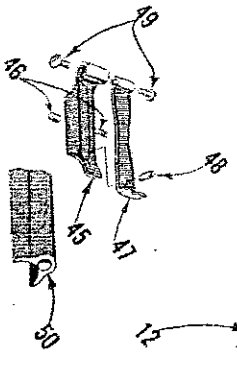


It is recommended to use a light application of Crosman Pellgunoil or quality air tool lubricant on rubber parts as you assemble the gun.

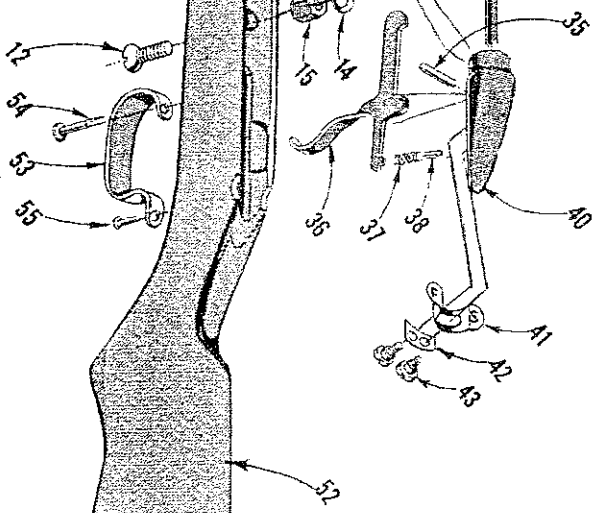
Part 5 is the piston head that can be difficult to remove, in which case it needs to be dug out of the cup. The new one should be easily pressed in by working a small screwdriver into the groove. Small batches of these models were made with a different machine head cup. Let us know if you have a different head from what was provided.

Part 30 is the check valve and is replaced by a teflon disc as the manufacturer has discontinued the original part.

Part 23 is the check valve spring, old ones are often fatigued or corroded allowing air to escape from the intake valve.



Part 31 is the exhaust valve and this design did change slightly on account of the old design was completely brass and had a reinforced steel tip. These newer improved ones have a solid steel shaft. On rare occasion, this needs to be polished down if tight fit in the valve guide.



Part 26 is a thin gasket that seals the valve guide (#28) to the compression tube. This can sometimes be reused as it is a non moving part. We have included a thin o-ring to replace this if it is damaged during disassembly.

Part 27 is a lead washer that is best reused, if it is damaged while servicing, the white PTFE split washer can be used to lock the retaining nut.

A tip for putting the retaining nut back in...  
Wrapping something like duct tape around the middle of the the tool to the thickness of the the inside diameter of the tube is a great help in avoiding cross threading and will allow you to get added force on the assembly which is often needed.

**Benjamin Sheridan  
Soldered Valve  
Repair Instructions**

**1. Remove stock assembly from action/barrel assembly by removing the receiver stock screw #12.**

**2. In order to replace the rubber piston head #5 you must first remove the piston rod assembly #6. To do this, the roll pins #2 must be tapped out and the muzzle cap #1 removed. Now, you can line up the pin holding the pump handle in with the roll pin hole and punch that out too #4. Now remove the piston rod and pull the old rubber piston head off and replace with new rubber piston head. Do not reassemble until you have completed step 3.**

**Next step is to remove the valve assembly.**

**3. Remove the retaining cap assembly #40. It is located at the back of the action behind breech. Once you have removed this cap you will be able to remove the spring, guide and hammer (#32,#33 and #34) to access the tube and remove your valve assembly. There were several designs as far as safety and trigger configurations. Special care is needed to be sure that this is disassembled in a way that nothing is lost i.e. springs and small parts. The rocker safety design on these directions requires a pin to be removed to get the trigger out of the way, 37 + 38 will fall out when doing this. For getting the parts out of the Soldered Valve body you need to insert the square end of the metal valve tool (supplied with the kit) into the tube. It will fit into the valve guide retaining nut #29.**

**Unscrew this nut using punch or tool as as a t-handle. Once unscrewed and removed, flip tool over and thread the end over the valve guide #28 and use wrench to pull guide and assembly out of tube. You can now replace old parts with new. The parts in your kit have been circled on the drawing. They are #30,#23,#31,#27\*,#5 #19.**

**#30 is now made of teflon as the part has been discontinued by the manufacturer.**

**5. After all parts have been replaced you can reassemble your rifle.**