

# Part No. P69201

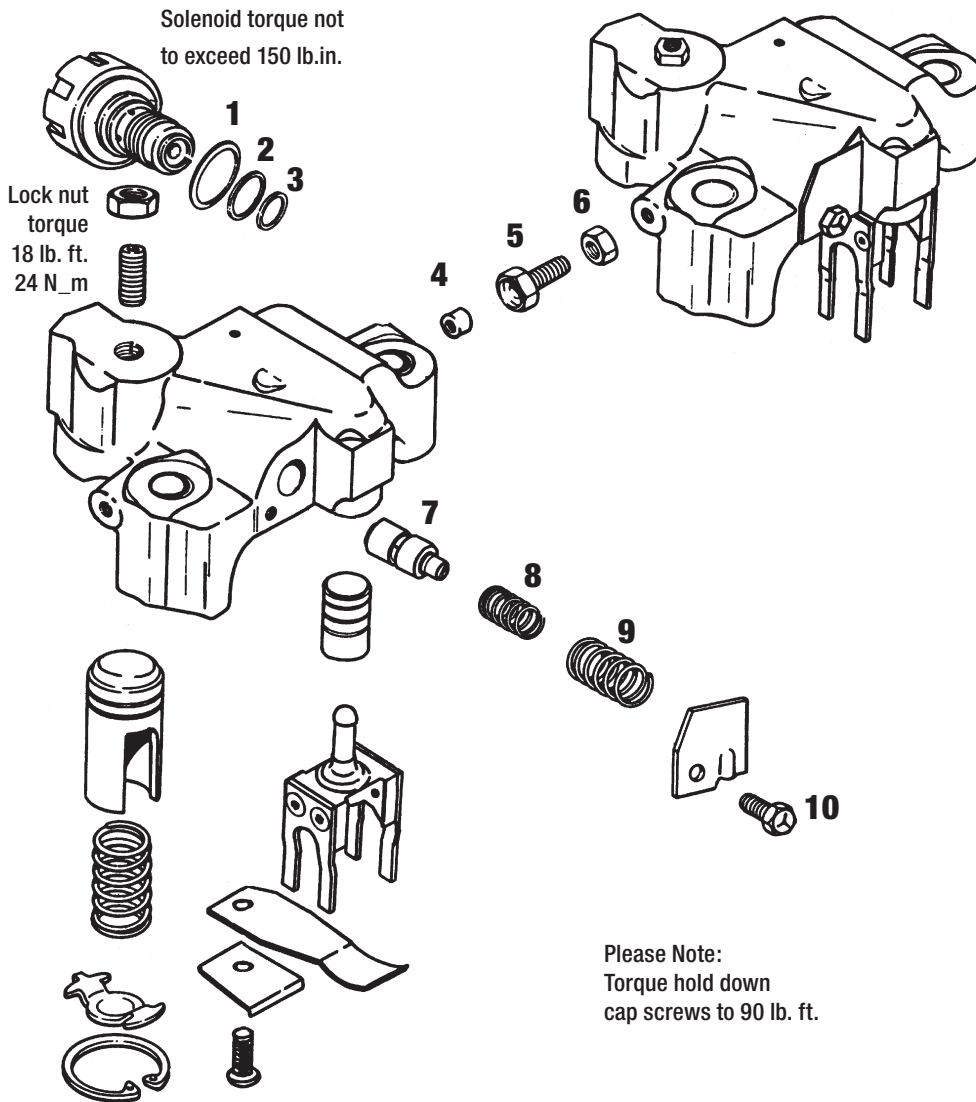
# TUNE UP KIT

Engine Application:

**Detroit**  
**71/92 Series**

Fits Models:

**6V-71, 6V-92**



ILLUS.#	PART #	DESCRIPTION	QTY.
1	P01081	O-Ring	2
2	P01082	O-Ring	2
3	P01083	O-Ring	2
4	P01332	Seal Ring	4
5	P01287	Oil Connector	4
6	P01340	Nut Hex Jam	4
7	P11930	Spool Valve	6
8	P07500	Inner Spring	6
9	P11434	Outer Spring	6
10	P01492	Cap Screw	6
Ni	P05383	Harness	2
Ni	P04653	Bushing Seal	2

NOTE: Valve cover gasket is not supplied

**Pacbrake**

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**PACBRAKE®**  
ENGINE & EXHAUST BRAKES

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## Installation Instructions

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### Removal Of The Housings From The Engine

- A) Clean the engine around the valve covers, remove covers and check the gaskets as a new one is not supplied.
- B) Loosen the slave piston adjusting screw lock-nuts.
- C) Remove wires to the solenoids and through-head bushings and discard.
- D) Loosen the oil supply connectors.
- E) Remove the housing hold down bolts.
- F) Remove all housings from the engine.

### Disassembly And Assembly Of The Brake Housings

- A) Place the housings on a clean work bench.  
**Note:** When removing all parts keep them in order of their original location for assembly later.
- B) Remove the slave piston adjusting screws.
- C) Using the proper tool, remove the solenoids. Adjustable pliers can damage the coil. Remove and discard seals.
- D) Remove the control valve covers. **Use caution** and wear eye protection, as the washers are under spring pressure! Remove the springs and control valves. The control valves should slide out easily using needle nose pliers or a magnet. If not, inspect the bore and control valve for damage. Discard control valves, springs, and cap screws.
- E) Turn the housings over and remove the capscrew, retainer, springs and master pistons. The piston should slide out easily. If not, inspect the bore and piston for damage. Removal of the piston and spring is for inspection and cleaning purposes only.
- F) **Slave piston removal.**  
**Use caution** and wear eye protection, as the slave piston return spring is under extreme pressure! Use a "C" clamp and a socket slightly smaller than I.D. of the slave fork. Using the "C" clamp, position the socket inside the fork. Compress the retainer just enough to remove the spring pressure, then remove retaining ring. Slowly back off the "C" clamp. Remove the retainer, spring, and slave piston. The slave pistons should slide out easily. If not, inspect the bore and piston carefully for damage. Removal of the slave piston assemblies is for cleaning and inspection only.
- G) Wash all the housings and parts in clean OSHA approved solvent, keeping the parts in relation to their original position. Wash the parts individually to avoid damage by contact with hardened surfaces.
- H) Assemble all parts into the housing using clean engine oil in the reverse procedure. Make sure all retaining rings are seated in their groove. During solenoid installation, it is important not to twist or cut the seals. Lubricate the seals with clean engine oil and torque to 150 lb in.
- I) Clean all gasket surfaces.
- J) Install on engine as per manufactures specifications.

For additional information visit our website @ [www.pacbrake.com](http://www.pacbrake.com) or call 1-800-663-0096

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