

Appendix A—Repair Kits and Gasket Sets

Compressor Repair Kits

Part Number	3549-X1	3550-X1	3551-X1	3552-X1	3552-X2	5578-X2A
Model Number	90J3, 91J3	290K3, 291M3	490K3, 491M3	690K3, 690P3	690M3, 691M3	891M3
Suction valve assembly	3483-1X	3483-1X (2) ²	2532-1X	3948-X (2) ²	3948-X (2) ²	3732-X
Discharge valve assembly	3485-X	3485-X (2) ²	2439-X (2) ²	3857-X (2) ²	3857-X (2) ²	3733-X
Valve cage	—	—	2448 (4) ²	2797 (4) ²	2797 (4) ²	—
Connecting rod bearing (pair)	1367	1367 (2) ²	1491 (2) ²	1719 (2) ²	3542 (2) ²	3542 (2) ²
Packing set	1452-1X1	1452-1X1 (2) ²	1452-1X1 (2) ²	1725-2X (2) ²	1725-2X (2) ²	1725-2X, 3810-X1
Piston rings	1772 (3) ²	1772 (6) ²	1773 (6) ²	1739 (6) ²	1739 (6) ²	1739 (8) ²
Ring expanders	1775 (3) ²	1775 (6) ²	1776 (6) ²	1740 (6) ²	1740 (6) ²	1740 (8) ²
Gasket set ¹	2526-XA ¹	1281-XA ¹	1481-X6A ¹	1744-X1A ¹	1744-X1A ¹	3970-X1A
O-ring ¹	—	—	—	—	2-261A (2) ^{1, 2}	—
O-ring ¹	—	—	2-242A (2) ^{1, 2}	—	—	—
O-ring ¹	—	—	2-253A (2) ^{1, 2}	—	—	—
Oil seal	3259	1278	1507 (490 only)	—	3526	3526
Oil seal	—	—	4438 (491 only)	—	—	—
Adapter plate gasket	—	—	1486	—	—	—

¹ All repair kits are furnished with Buna-N O-rings which are suitable for LPG and NH₃ applications

² Quantities larger than 1 are shown in parenthesis

Four-Way Valve Repair Kits

Description	Trim	Part Number	Connection Sizes
Four-Way Valve Repair Kits	PTFE and Buna-N trim	3122-X	1"
		3123-X	1¼"
		3130-X	2"

Gasket Sets

Model 91 Gasket Set (2526-XA)

Part Number	Description	Quantity
2-235A	O-ring, Buna-N	2
2526	Crankcase gasket	1
2717	Valve gasket, aluminum	2
2729	Crankcase inspection plate gas	1
2-031A	O-ring, Buna-N	2
2244	Inspection plate gasket	1
2716	Valve cap gasket, aluminum	2
2725	Bearing carrier gasket	1

Model 291 Gasket Set (1281-XA)

Part Number	Description	Quantity
1281	Filter screen screw gasket	1
1651	Inspection plate gasket	1
2-113A	O-ring, Buna-N	2
2-228A	O-ring, Buna-N	1
2702	Crankcase gasket	1
2716	Valve cap gasket, aluminum	4
2732	Center headbolt gasket - steel	2
1190	Adapter plate gasket	2
1285	Bearing carrier gasket	1
2-031A	O-ring, Buna-N	4
2-135A	O-ring, Buna-N	2
2-235A	O-ring, Buna-N	4
2713	Crankcase inspection plate gas	1
2717	Valve gasket, aluminum	4

Appendix A—Repair Kits and Gasket Sets (continued)

Model 491 Gasket Set (1481-X6A)

Part Number	Description	Quantity
1418	Valve gasket, aluminum	4
1480	Center headbolt gasket - steel	2
1488	Inspection plate gasket	1
1511	Crankcase inspection plate gas	1
2-139A	O-ring, Buna-N	2
2-228A	O-ring, Buna-N	1
1281	Filter screen screw gasket	1
1478	Valve cap gasket, steel	4
1481	Head gasket	1
1489	Crankcase gasket	1
1513	Bearing carrier gasket	1
2-143A	O-ring, Buna-N	4
2-243A	O-ring, Buna-N	2

Model 891 Gasket Set (3970-X1A)

Part Number	Description	Quantity
1281	Filter screen screw gasket	1
1761	Crankcase gasket	1
2-036A	O-ring, Buna-N	8
2-231A	O-ring, Buna-N	4
2-238A	O-ring, Buna-N	2
2114	Valve gasket, aluminum	8
2131	Bearing carrier gasket	1
4127	Lubricator gasket	1
1760	Inspection plate gasket	1
2-031A	O-ring, Buna-N	8
2-228A	O-ring, Buna-N	1
2-235A	O-ring, Buna-N	8
2-246A	O-ring, Buna-N	4
2123	Crankcase inspection plate gas	1
3874	Access cover gasket	2
3906	Gasket spiral wound	2

Model 691 Gasket Set (1744-X3A)

Part Number	Description	Quantity
1760	Inspection plate gasket	1
2-031A	O-ring, Buna-N	4
2-231A	O-ring, Buna-N	2
2-235A	O-ring, Buna-N	4
2-261A	O-ring, Buna-N	2
2123	Crankcase inspection plate gas	2
2131	Bearing carrier gasket	1
2716	Valve cap gasket, aluminum	4
4127	Lubricator gasket	1
1281	Filter screen screw gasket	1
1761	Crankcase gasket	1
2-228A	O-ring, Buna-N	1
2-233A	O-ring, Buna-N	2
2-247A	O-ring, Buna-N	2
2114	Valve gasket, aluminum	4
2129	Oil inlet gasket	1
2177	Flange gasket	2
3874	Access cover gasket	2