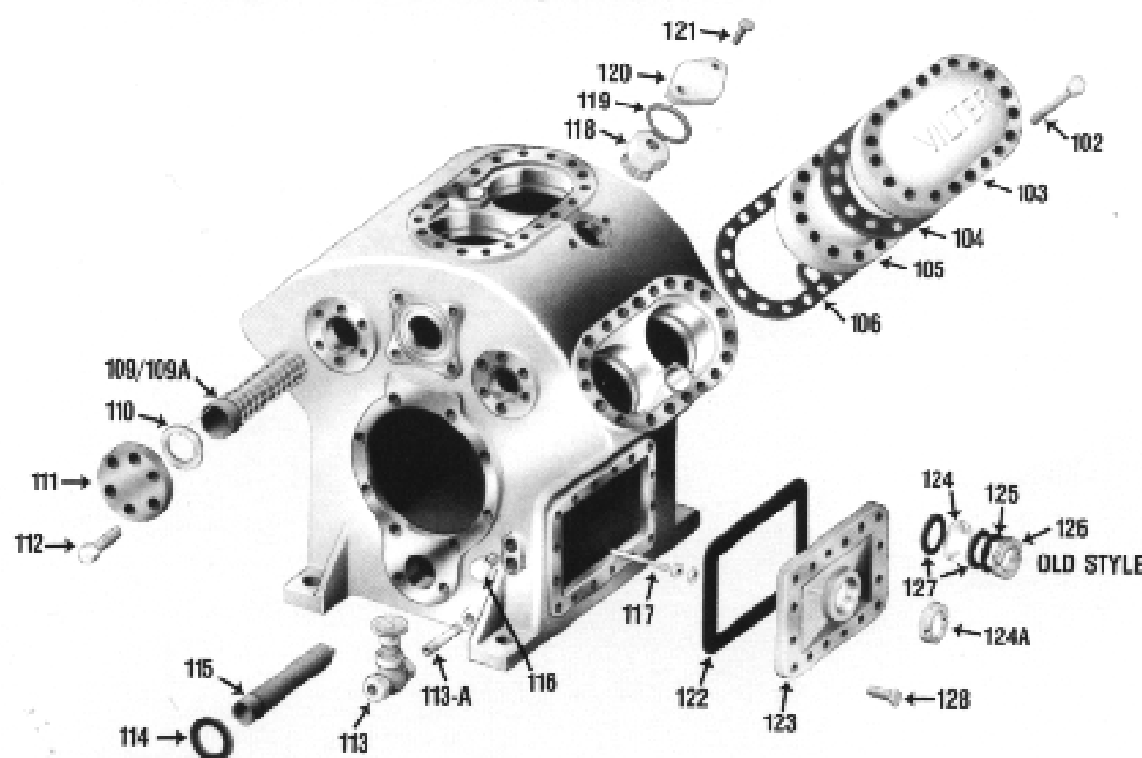


THE VILTER 400 SERIES COMPRESSOR PARTS CHART

BASIC FRAME & COVERS

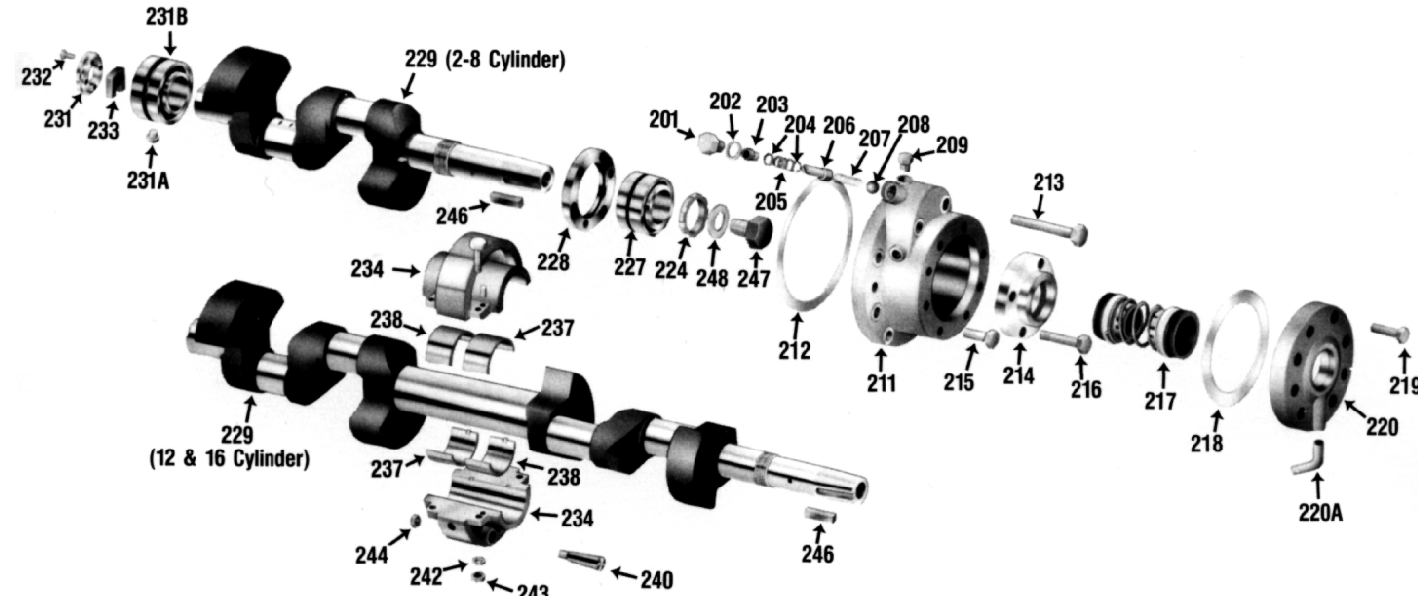


Reference Number	Vilter Part Number 450	Vilter Part Number 450XL	Description
102	13152G	13152G	Screw, 5/8" X 2-1/2" Hex. Head Cap (Used w/o Water Jacket)
102	13152L	13152L	Screw, 5/8" X 3-1/2" Hex. Head Cap (Used with Water Jacket)
103	30299A	30299A	Cover, Water Jacket
104	33329A	33329A	Gasket, Water Jacket
105	33330A	33330A	Cover Cylinder
106	33330A	33330A	Gasket, Cylinder Cover
109	-	-	Screen, Suction
109A	-	-	Bag, Suction Screen (Not Shown)
110	-	-	Gasket, Suction Screen/ Suction Tee Cover
111	-	-	Suction Tee Cover, Suction Screen; Cover, Suction Tee
112	-	-	Screw, Hex. Head Cap
113	1956H	1956H	Valve, 1/2" Oil Charge and Drain (Ammonia)
113	1956A	1956A	Valve, 1/2" Oil Charge and Drain (Halocarbon)
113A	13189G	13189G	Nipple, 1/2" X 4" Sch. 80 Pipe

Reference Number	Vilter Part Number 450	Vilter Part Number 450XL	Description
114	31889A	31889A	Gasket, Crankcase Oil Screen
115	A31886A	A31886A	Screen, Crankcase Oil
116	13264D	13264D	Plug, 1/2" Hex. Head Pipe
116	13264E	13264E	Plug, 3/4" Hex. Head Pipe
117	A31936A	A31936A	Pin Retaining Assembly For Crankcase Oil Screen
118	1271B	1271C	Safety Valve, Internal Relief
119	11323G	11323G	Gasket, 2" Flange
120	31954A	31954A	Cover, Safety Valve
121	13152E	13152E	Screw, 5/8" X 2" Hex. Head Cap
122	31894A	31894A	Gasket, Handhole Cover
123	124A	124A	Cover, Handhole
124A	1484A	1484A	Glass, Oil Sight- 2"
124-127	-	-	Glass, Oil Sight- 3" (Old Style)
128	13153E	13153E	Screw, 1/2" X 1-1/2" Hex. Head Cap

* Check your Operator's Manual for correct Part Number for your specific compressor model.

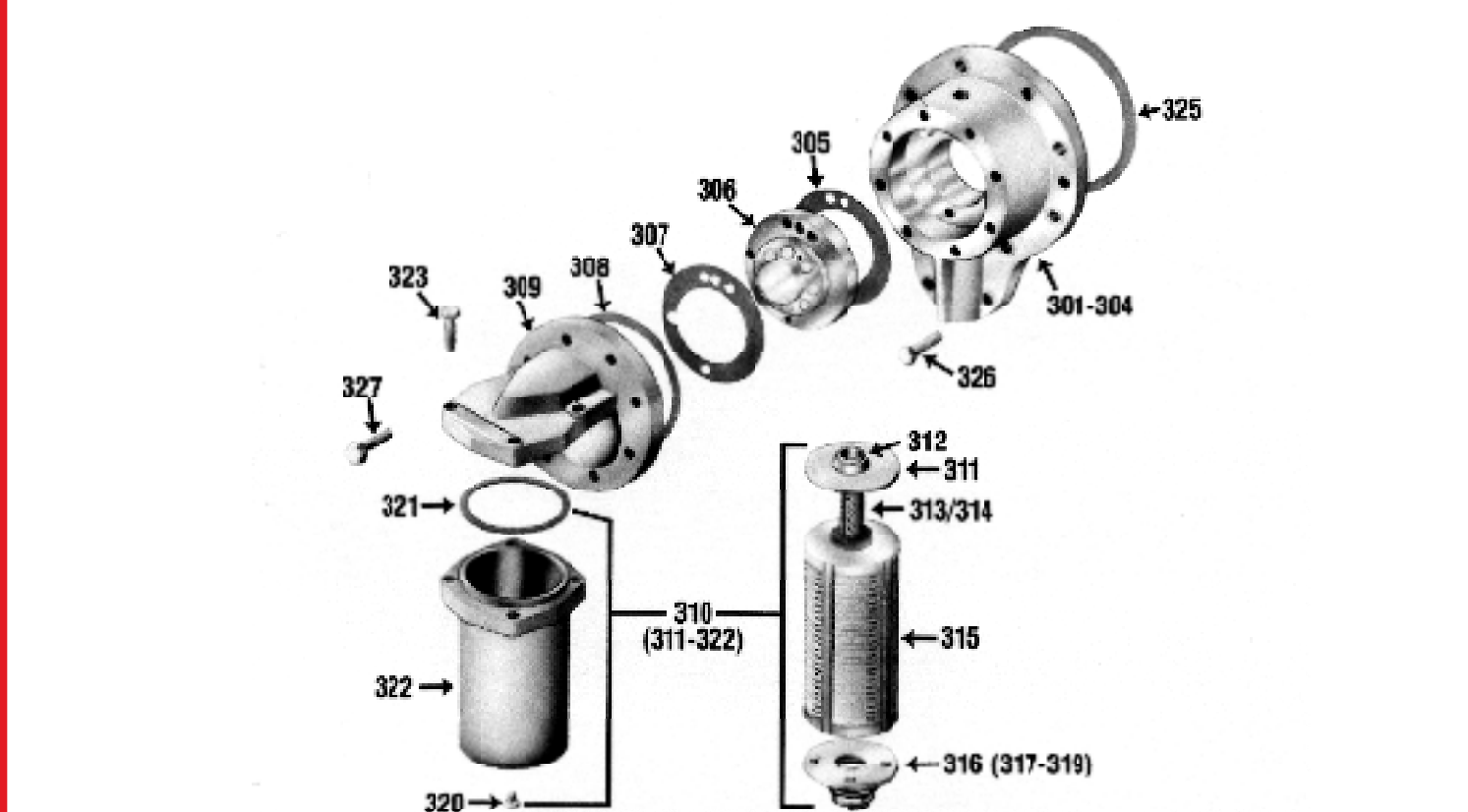
CRANKSHAFT & FRONT BEARING COVER



Reference Number	Vilter Part Number 450	Vilter Part Number 450XL	Description
202	30651C	30651C	Cap, Valve Gasket
201-208	KT486	KT486	Oil Relief Valve Kit
209	13264B	13264B	Plug, 1/2" Pipe
209-211	A36240A	A36240A	Cover, Front Bearing Assy. For 2-1/2" Shaft (Requires Oil Orifice in Item #214)
209-211	A36241A	A36241A	Cover, Front Bearing Assy. For 3" Shaft (Requires Oil Orifice in Item #214)
212	31890A	31890A	Gasket, Bearing Cover
213	13159E	13159E	Screw, 5/8" X 4" Socket Hd.
214	31885A	31885A	Retainer, Front Bearing (w/ oil hole) for 2-1/2" Shaft
214	33500A	33500A	Retainer, Front Bearing (w/ oil hole) for 3" Shaft
215	13152E	13152E	Screw, 5/8" X 2" Hex. Head
216	13153Q	13153Q	Screw, 1/2" X 4" Hex. Head
217	A33483A	A33483A	Seal, 2-1/2" Shaft Assembly
217	A33483A	A33483A	Seal, 3" Shaft Assembly
218	-	-	Check Model # (in Parentheses) KT509: Shaft Seal & Gasket (All 440, 2-4 Cyl. 450)
218	-	-	Check Model # (in Parentheses) KT509: Shaft Seal & Gasket (12-16 Cyl. 440, 6-16 Cyl. 450, All 450XL)
219	13153F	13153F	Screw, 1/2" X 1-3/4" Hex. Hd.
220	31044A	31044A	Cover, 3" Shaft Seal
220	32564A	32564A	Tube, Oil Drain
220A	35078A	35078A	Locknut, 2-1/2" Shaft
224	KT366	KT366	Locknut, 2-1/2" Shaft
224	KT367	KT367	Locknut, 3" Shaft

* Check your Operator's Manual for correct Part Number for your specific compressor model. Splash shield included in crankshaft with bearings.

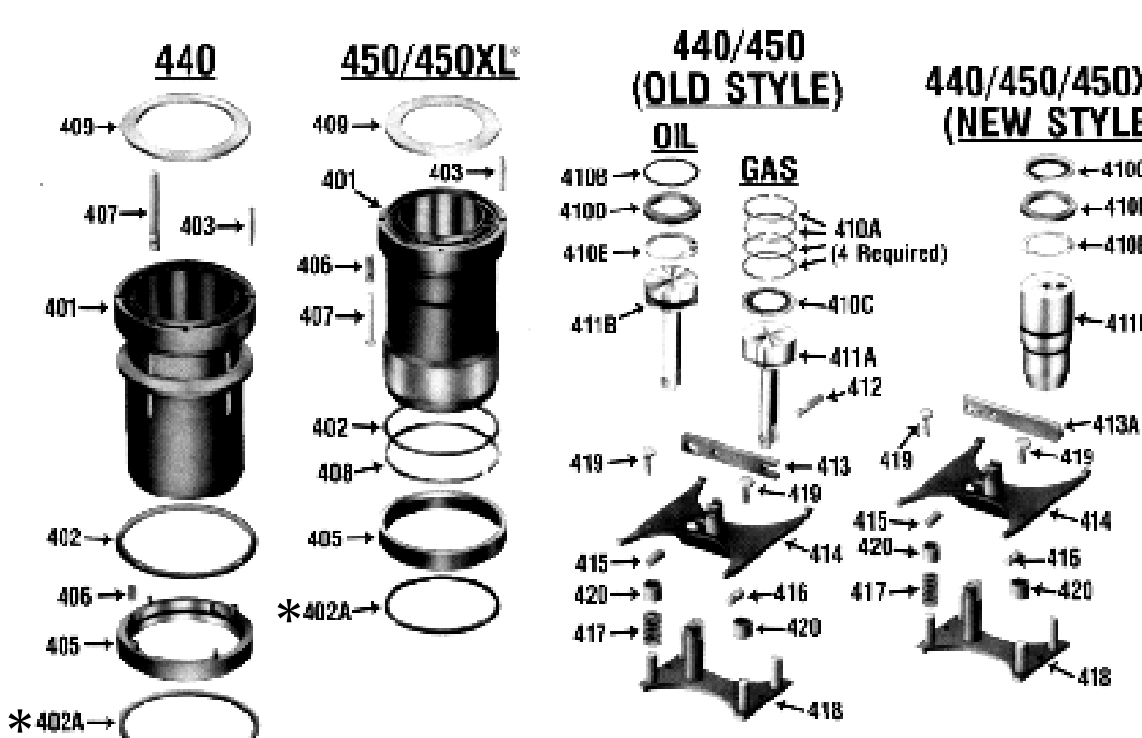
REAR BEARING COVER & FILTER ASSEMBLY



Reference Number	Vilter Part Number 450	Vilter Part Number 450XL	Description
301-304	KT092	KT092	Rear Bearing Cover Assembly
306	KT519A	KT519A	Oil Pump w/ Gaskets
307-323	KT256	-	Conversion Kit, Std. Tri-Micro Cover, Oil Pump and Filter Head
309	-	-	Tri-Micro Oil Filter Assembly with Bypass Relief
310	A35240A	A35240A	Tri-Micro Oil Filter Assembly w/o Bypass Relief
311	1448J	1448J	Spool, Internal with Bypass Relief
311	2046A	-	Spool, Internal w/o Bypass Relief
312	1448H	1448H	Seal, Spool End
313	1448K	1448K	Strainer Tube
314	1448L	1448L	Ring, Strainer Tube Retaining

* Check your Operator's Manual for correct Part Number for your specific compressor model.

CYLINDER LINER & CAPACITY CONTROL



Reference Number	Vilter Part Number 450	Vilter Part Number 450XL	Description
401	32687A	34510A	Liner, Cylinder (Single-Stage)
401	33179A	34710A	Liner, Cylinder (Integral Two-Stage)
402	2176BH	2176BH	Seal, "O" Ring, Upper
402A	2176BL	2176BL	Seal, "O" Ring, Lower (Integral Two-Stage)
403	1193Q	1193Q	Pin, 1/8" X 1-1/2" Roll
405	A33351A	35071A	Spring, Lift
406	33352A	35068A	Spring, Lift
407	33350A	35070A	Pin, Lift
408	1971A	1971A	Retainer, Lift Ring
409	31909A	31909A	Plate, Suction Valve
410A(a)	31989L	31989L	Ring, Piston, Gas (Old Style)
410B(a)	2045A	2045A	O-Ring, Oil (Old Style)
410C(b)	2557A	2557A	Ring, Gas
410D(b)	2639A	2639A	Ring, Oil
410E	2638A	2638A	Retainer, Snap Ring, Oil
411A	410C/KT034	KT034	Piston, Gas (Old Style)
411B	KT364	KT364	Piston, Oil (Old Style)
411C(d)	35315A	35315A	Piston, Gas or Oil
412	33250C	33250C	Pin, Long Pivot
413(e)	33338A	33338A	Arm, Yoke Lifting (Old Style)
413A(e)	41725A	41725A	Arm, Yoke Lifting (New Style)

Reference Number	Vilter Part Number 450	Vilter Part Number 450XL	Description
414	A33335A	A33335A	Yoke Assembly, Std. Unloading
414	A33575A	A33575A	Yoke Assembly, Single Cyl. Unloading
415	1193X	1193X	Pin, 3/8" X 1 1/16" Roll
416	33250B	33250B	Spring, Short Pivot
417	33686A	33686A	Spring, Unloader Yoke
418	A33347A	A33347A	Yoke Guide, Std. Unloading
418	A33576A	A33576A	Yoke Guide, Single Cyl. Unloading
419	1352D	1352D	Screw, 3/8" X 1" Hex Head Lock, Single Cyl. Unloading
420	33618A	33618A	Spacer, Sleeve, Single Cyl. Unloading

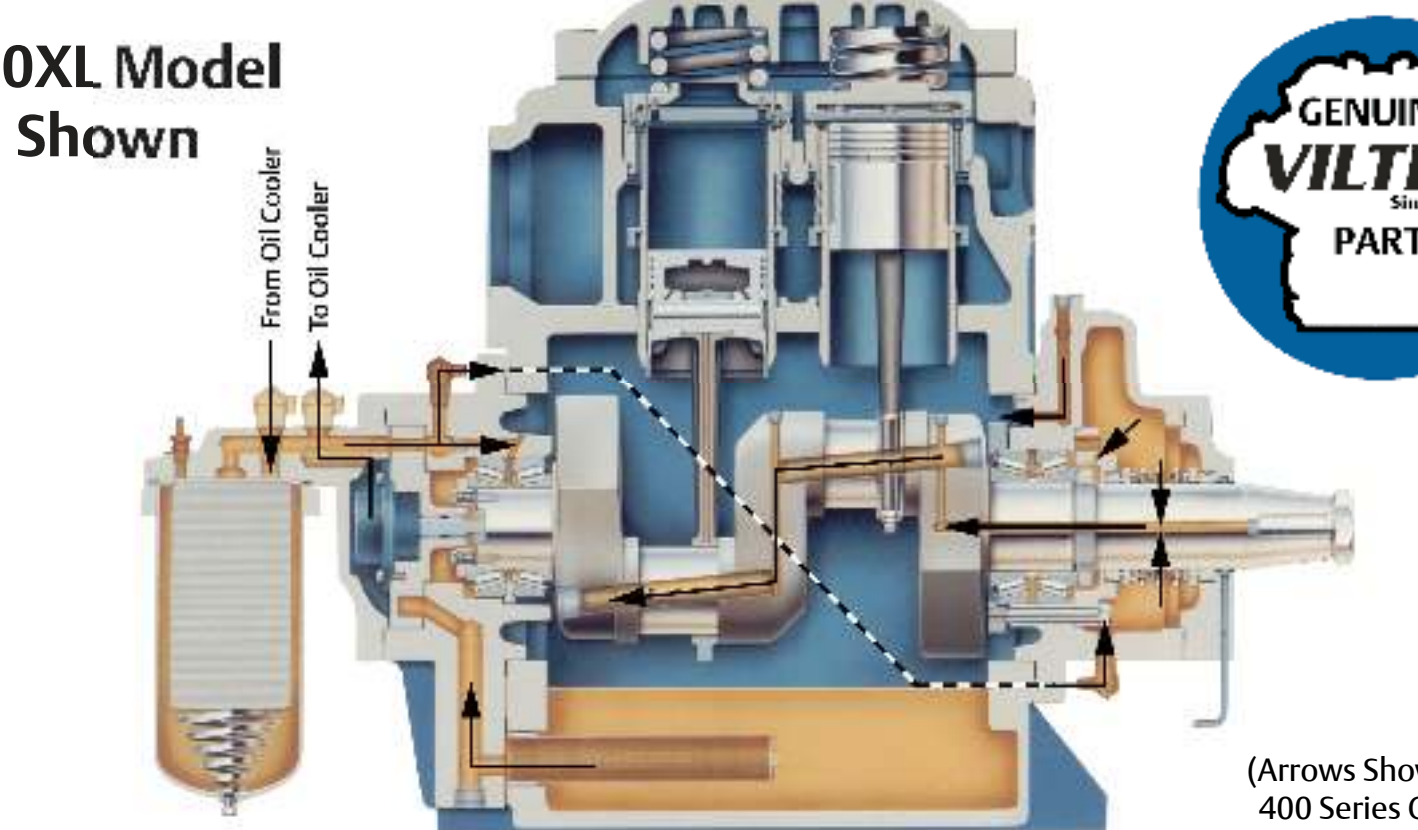
(a) 410A and 410B- Sold for replacement use only; will not fit present pistons.
 (b) 410C and 410D- Not interchangeable with old (410A and 410B).
 (c) 411A and 411B- Present pistons cannot be used with old rings kit. KT034 contains 410C; KT364 contains 410D/E.
 (d) 411C- New piston not interchangeable with old (requires different frame). New piston has two grooves- top for gas and bottom for oil.
 (e) 413 and 413A- Yoke lifting arms not interchangeable.

For Single Cyl. Parts, Contact Vilter Customer Service

VILTER Since 1867

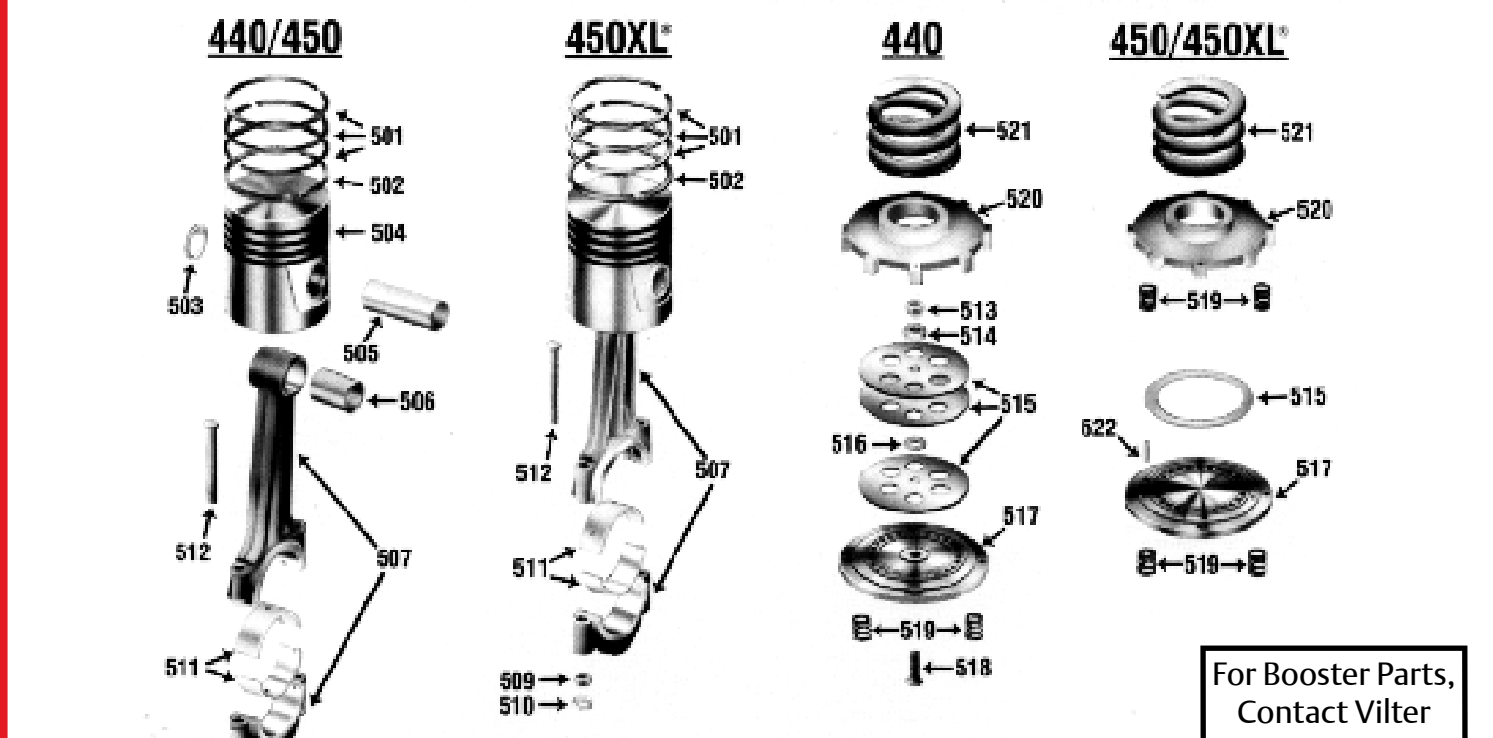
EMERSON Climate Technologies

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 Telephone: 414-744-0111 Fax: 414-744-3483
 e-mail: parts.vilter@emerson.com



Replacement Parts List 440, 450 & 450XL Series Compressors

PISTON, CONNECTING ROD & SAFETY HEAD



Reference Number	Vilter Part Number 450	Vilter Part Number 450XL	Description
501	31989M	31989M	Piston Ring, Compression
502	31989N	31989N	Piston Ring, Oil
503	33244A	33244A	Snap Ring, Piston Oil
501-505	KT213	KT213	Piston, Rings, and Pin Kit
501-512	KT478	KT478	Piston, Rings, and Connecting Rod Assembly
506-512	KT463	KT463	Connecting Rod with Bearings
506	31989B	31989B	Bushing, Piston Pin
507	See Kits Above	-	Connecting Rod
509	2027A	2027A	Nut, 3/8" UNF, Hex.
510	2028A	2028A	Nut, 3/8" Lock
511	KT512	KT512	Bearing Set, Connecting Rod - Standard
511	KT513A	KT513A	Bearing Set, Connecting Rod - 0.015" Undersize
511	KT513	KT513	Bearing Set, Connecting Rod - 0.030" Undersize
512	31955A	31955A	Bolt, Connecting Rod
513-518	A32695C	-	Safety Head Assembly - Ammonia

Reference Number	Vilter Part Number 450	Vilter Part Number 450XL	Description
513-518	A32695D	-	Safety Head Assembly - Halocarbon
513	1776B	-	Nut 3/8" Lock Valve Retaining
514	31990B	-	Washer, Diaphragm Valve
515	31939B	-	Valve, Diaphragm Discharge
515	-	35080SS	Plate, Discharge Valve
516	31990A	-	Spacer, Diaphragm Valve
517	33531B	-	Safety Head, Ammonia
517	33532B	-	Safety Head, Halocarbon
517/522	-	A35082A	Safety Head & Pins Assembly - Ammonia
517/522	-	A35272A	Safety Head & Pins Assembly - Halocarbon
518	31964A	-	Screw, Valve Retaining - 60° (Old Style)
518	1527B	-	Screw, Valve Retaining - 82°
519	33803A	33803A	Spring, Valve
520	31941B	-	Yoke, Safety Head
520/522	-	KT543	Safety Head Yoke and Pin Kit
521	31882A	35252A	Spring, Safety Head
522	-	1712F	Pin, 3/16" X 1 1/16" Roll

For Booster Parts, Contact Vilter Customer Service

VMC Compressor Bulk Pack Kits				440VMC Compressor Conversion Kits				450XL VMC Series Compressor Overhaul Kits				440 VMC Series Compressor Overhaul Kits				
Vilter Part Number	Description	Part Number in Kit	Qty Per Kit	Cast Iron Flat Top, Cast Iron Cup Type and Aluminum Cup Type to Aluminum Flat Top. (Parts Needed for One Cylinder)	Vilter Part Number	Items Included		Listed below are minor and major 450XL VMC compressor overhaul kits. The numbers in the parenthesis are the quantity of the items included with the kit, the item numbers correspond to item numbers in the above parts chart.	Vilter Part Number	Model	Items Included		Listed below are minor and major 440 VMC compressor overhaul kits. The numbers in the parenthesis are the quantity of the items included with the kit, the item numbers correspond to item numbers in the above parts chart.	Vilter Part Number	Model	Items Included
KT645	Tri-Micro Oil Filter Recharge Elements All VMC.	1448C	6		KT073A	401, 402, 407, 501 thru 505, 513 thru 520.		KT041MNX	452XL	Minor Overhaul Kit: (1104, (1106, (1122, (4)504, (2)507, (2)508, (16)511, (8)515.			KT041MN	442	Minor Overhaul Kit: (1104, (1106, (1122, (4)510, (2)511, (8)519.	
KT646	Suction Valve Plates 400 Series VMC.	31909A	12		KT074A	401, 402, 403, 405, 406, 407, 501 thru 505, 513 thru 520.		KT043MNX	454XL	Minor Overhaul Kit: (2104, (2106, (1122, (8)504, (4)507, (4)508, (32)511, (16)515.			KT043MN	444	Minor Overhaul Kit: (2104, (2106, (1122, (8)510, (4)511, (16)519.	
KT647	Diaphragm Discharge Valves 400 Series VMC.	31939B	12		KT119A	401, 402, 407, 501 thru 520.		KT045MNX	456XL	Minor Overhaul Kit: (3104, (3106, (1122, (12)504, (6)507, (6)508, (64)511, (24)515.			KT045MN	446	Minor Overhaul Kit: (3104, (3106, (1122, (12)510, (6)511, (24)519.	
KT647XL	Discharge Valve Plates 450 and 450XL VMC.	35080SS	12		KT123	401, 402, 403, 405, 406, 407, 501 thru 520.		KT049MNX	458XL	Minor Overhaul Kit: (4104, (4106, (1122, (16)504, (8)507, (8)508, (64)511, (24)515.			KT049MN	448	Minor Overhaul Kit: (4104, (4106, (1122, (16)510, (8)511, (24)519.	
KT648	Valve Spring Kit 400 Series VMC.	33803A	100					KT051MNX	4512XL	Minor Overhaul Kit: (6104, (6106, (1122, (24)504, (12)507, (12)508, (96)511, (48)515.			KT051MN	4412	Minor Overhaul Kit: (6104, (6106, (1122, (24)510, (12)511, (24)519.	
KT649	Compression Ring 400 Series VMC.	31989M	24					KT055MNX	4516XL	Minor Overhaul Kit: (8104, (8106, (1122, (32)504, (16)507, (16)508, (128)511, (64)515.			KT055MN	4416	Minor Overhaul Kit: (8104, (8106, (1122, (32)510, (16)511, (24)519.	
KT650	Oil Control Ring 400 Series VMC.	31989N	8					KT041MJX	452XL	Major Overhaul Kit: (1217, (1218, (1315A, (2)409, (6)501, (2)502, (2)512, (1)KT041MNX.			KT041MJ	442	Major Overhaul Kit: (1217, (1218, (1315A, (2)409, (6)501, (2)502, (2)512, (1)KT041MNX.	