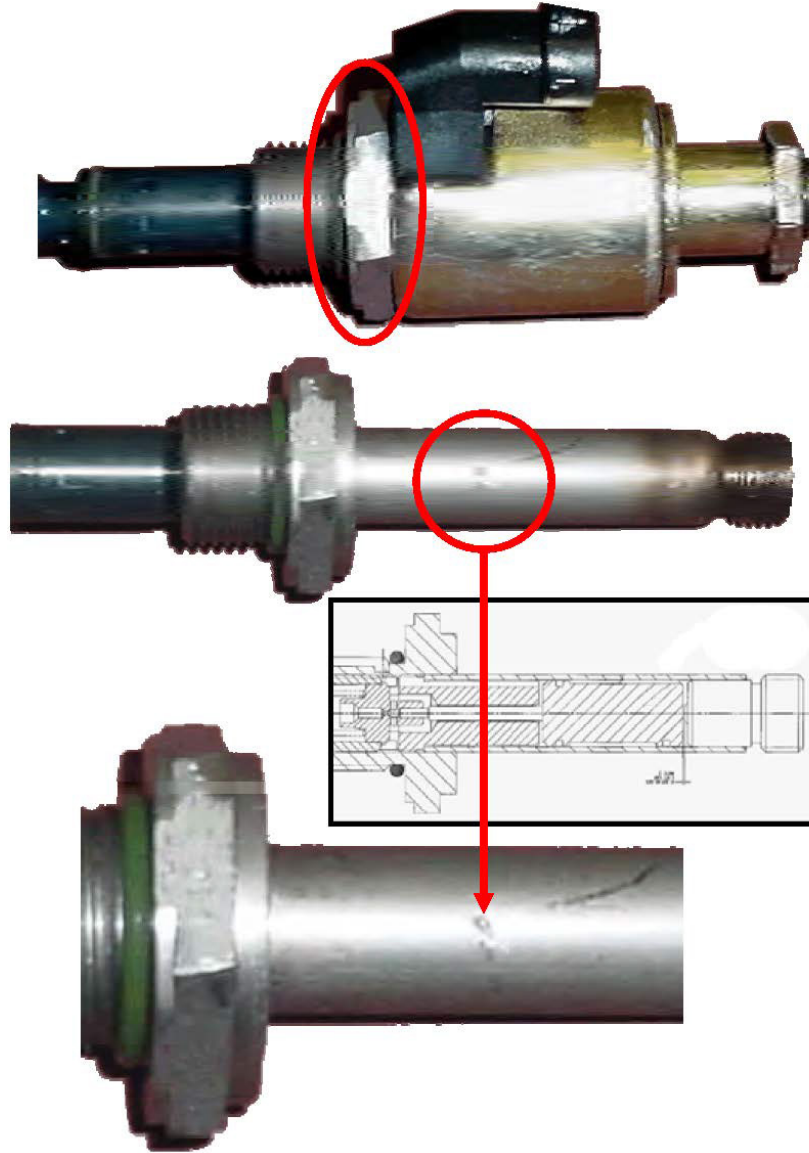


SUBJECT: IPR Valve External Damage During Installation

External damage to an IPR valve tube during installation can create enough internal distortion to prevent the armature from moving freely. In the photos above, note the damaged valve hex flats, which offer evidence the socket slipped and damaged the tube during installation. To avoid similar damage, we recommend using a six point deep well socket.

Valves determined to have this type of damage will not be considered for warranty:

- Armature tube assembly torque: 35 lb-ft
- Coil assembly torque: 53 lb-in

For more information visit

AlliantPower.com

Alliant Power Technical Support: 800.735.9775 | techsupport@AlliantPower.com