

## HD612B PARTS LIST

**Discontinued Model – parts availability may be limited.**

Serial # \_\_\_\_\_

ID# \_\_\_\_\_

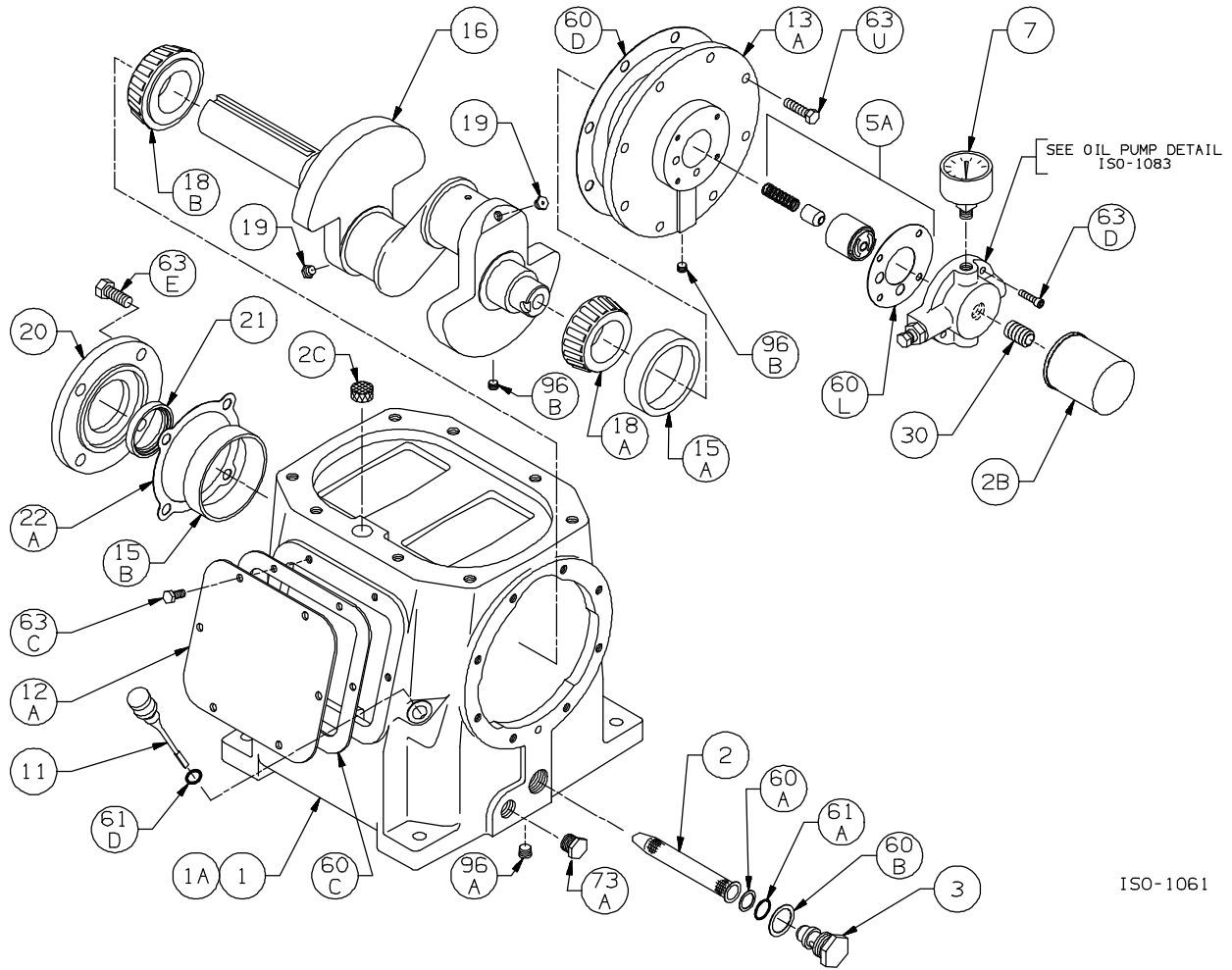
### Gasket Sets and Special Tools

Gasket Set	Buna-N & Iron	794699
	FKM & Iron	794697
	PTFE & Iron	794698
	Neoprene & Iron	794696
	Ethylene Propylene & Iron	794695
Packing Installation Tool		790538
Spanner Wrench, 1/4" Adjustable		790316
Wrench for Valve Holdown Screw		790535
Tool Kit		790199

### Bulletins Needed For Complete Parts List

This page	9E-191
Crankcase	9F-031
Oil Pump	9G-011
Flywheel	9H-040
Crosshead	9J-091
Cylinder	9L-090
Head	9M-150
Head with Unloaders	9M-160

Notes:



ISO-1061

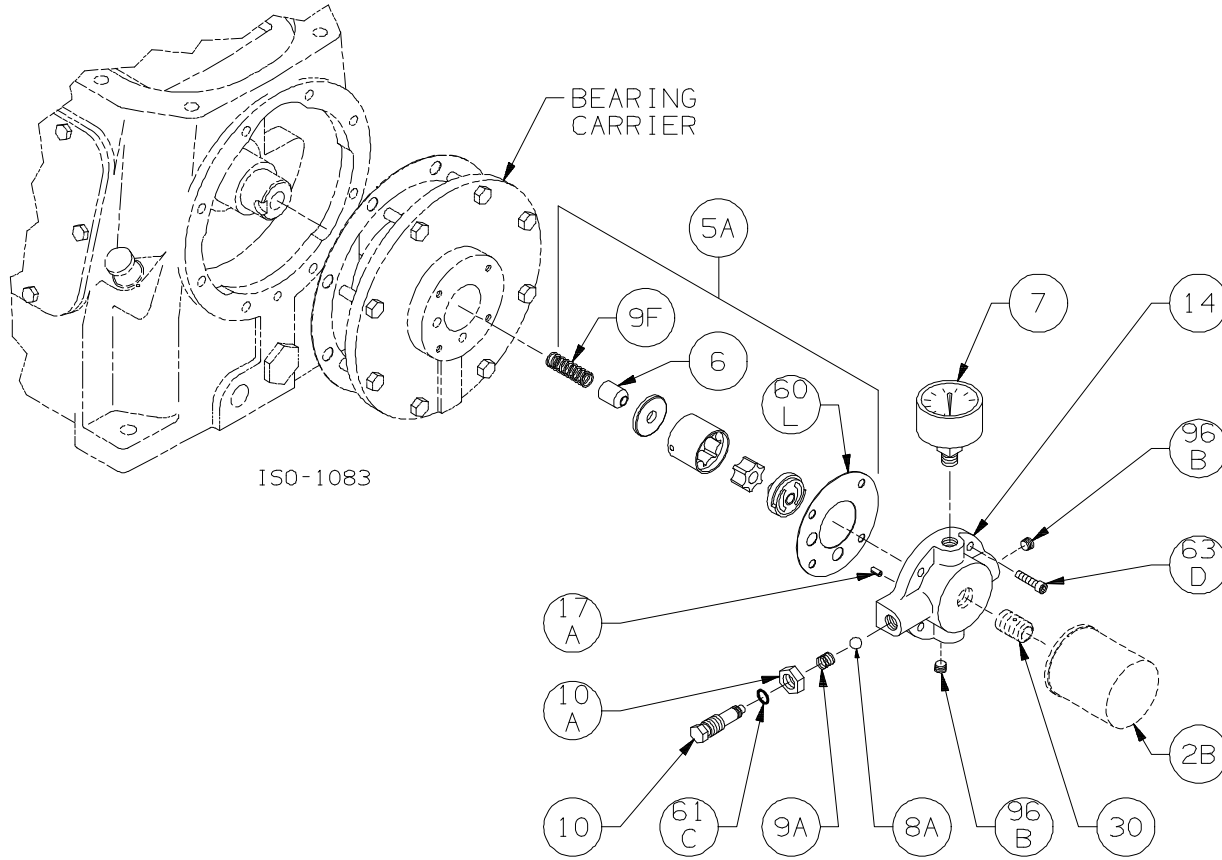
**Crankcase Assembly:**  
 Models HD601B, HD602B, HD603B, HDL601B, HDL602B, HDL603B,  
 HD612B, HD613B, HDL612B, HDL613B

ISO1061

Ref	Description	Qty	Part No
1	Crankcase Assembly	1	794759
	Crankcase Assembly - w\ Oil Filter		794758
1A	Crankcase	1	794709
2	Oil Intake Screen	1	792135
2B	Oil Filter	1	794726
2C	Breather Filter	1	794752
3	Oil Screen Plug	1	792145
5A	Oil Pump Kit	1	794760
7	Oil Pressure Gauge	1	790012
11	Oil Bayonet Assembly	1	792162
12A	Inspection Plate	1	794140
13A	Bearing Carrier	1	794714
15A	Bearing Cup (Outboard)	1	794131
15B	Bearing Cup (Inboard)	1	794731
16	Crankshaft Assembly (w\ 18A,18B,19,96B)	1	794708
18A	Bearing Cone (Outboard)	1	794130
18B	Bearing Cone (Inboard)	1	794730
19	Orifice	2	792146

Ref	Description	Qty	Part No
20	Bearing Cover Plate	1	794716
21	Oil Seal	1	794732
22A	Bearing Adjustment Shim Kit	1	794733
30	Oil Filter Fitting	1	794725
60A	Gasket - Oil Screen *	1	792136
60B	Gasket - Oil Screen Plug *	1	792123
60C	Gasket - Inspection Plate *	1	794122
60D	Gasket - Bearing Carrier Assembly *	1	794720
60L	Gasket - Oil Pump Cover *	1	794721
61A	O-Ring - Oil Screen *	1	792175
61D	O-Ring - Oil Bayonet *	1	792174
63C	Capscrew - Hex Hd	6	793116
63D	Capscrew - Soc Hd	4	790559
63E	Capscrew - Hex Hd	4	790484
63U	Capscrew - Hex Hd	8	792093
73A	Pipe Plug	1	790024
96A	Pipe Plug	1	790488
96B	Pipe Plug	2	790309

\* Included in Gasket Sets



**Oil Pump Detail for Models:**

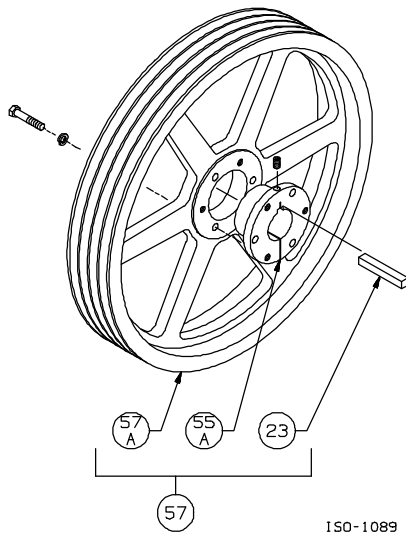
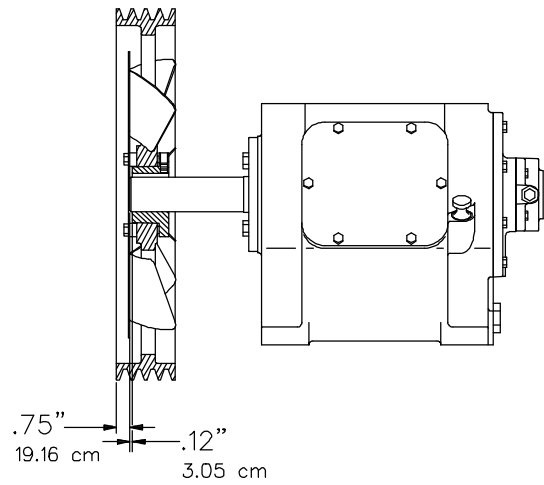
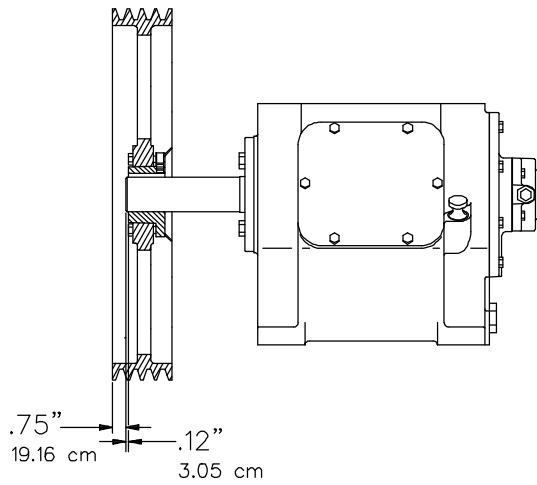
HD161C, HD161B, HD162C, HD162B, HD163C, HD163B,  
 HD172C, HD172B, HD173C, HD173B,  
 HDL341B, HDL342B, HDL343B, HDL341C, HDL342C, HDL343C,  
 HD361C, HD361B, HD362C, HD362B, HD363C, HD363B  
 HDL361B, HDL362B, HDL363B, HDL361C, HDL362C, HDL363C,  
 HD372C, HD372B, HDL372C, HDL372B, HD373C, HD373B, HDL373C, HDL373B,  
 HD601B, HD602B, HD603B, HDL601B, HDL602B, HDL603B,  
 HD612B, HDL612B, HD613B, HDL613B,  
 HD942A and HDL942A

ISO1083

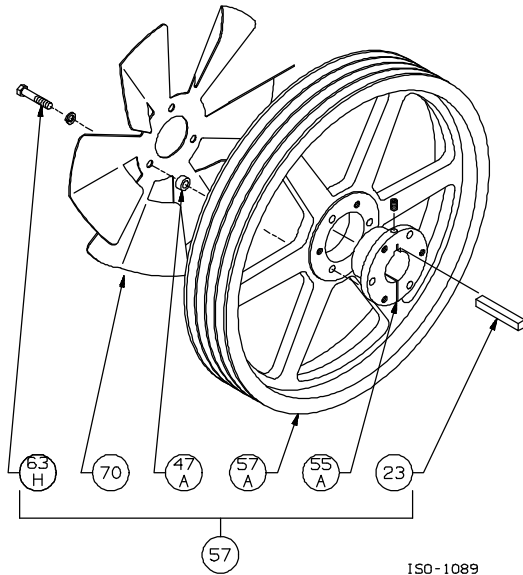
Ref	Description	Qty	Part No
2B	Oil Filter	1	794726
5A	Oil Pump Kit (w/ 6, 9F, 60L)		794760
6	Oil Pump Cone	1	794750
7	Oil Pressure Gauge	1	790012
8A	Oil Pressure Adj. Ball	1	792154
9A	Oil Pressure Adj. Spring	1	792153
9F	Oil Pump Spring	1	794751
10	Oil Pressure Adj. Screw	1	792148
10A	Locknut	1	792152

Ref	Description	Qty	Part No
14	Oil Pump Cover Assembly - For Filter	1	794764
	with 17A, 96B		
	Oil Pump Cover Assembly - w\ 17A, 96B		794763
17A	Roll Pin	1	794753
30	Oil Filter Fitting	1	794725
60L	Gasket - Oil Pump Cover *	1	794721
61C	O-Ring - Adjusting Screw *	1	792168
63D	Capscrew - Soc. Hd	4	790559
96B	Pipe Plug	2	790309

\* Included in Gasket Sets



ISO-1089



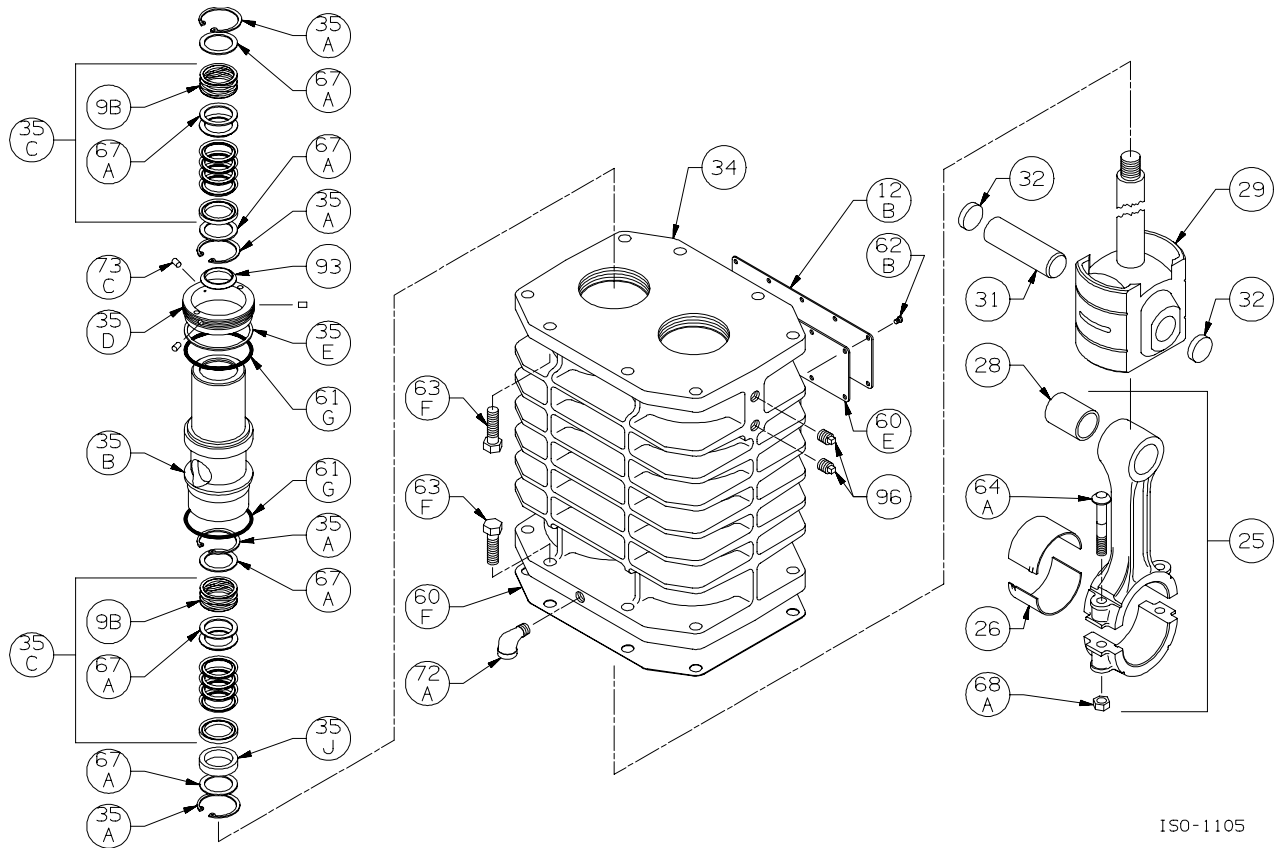
ISO-1089

**Standard Flywheel Assembly:  
Models HDL612B, HDL613B**

Ref	Description	Qty	Part No
23	Key	1	794267
55A	Hub	1	790149
57	Flywheel Assembly	1	794132
57A	Flywheel	1	790545

**Models HD612B, HD613B**

Ref	Description	Qty	Part No
23	Key	1	794267
47A	Spacer	3	793617
55A	Hub	1	790149
57	Flywheel Assembly	1	794145
57A	Flywheel	1	790545
63H	Capscrew - Hex Head	3	792095
70	Fan	1	793616



ISO-1105

Crosshead Assembly: HD602B, HDL602B, HDL642B, HD612B, HDL612B

ISO1105

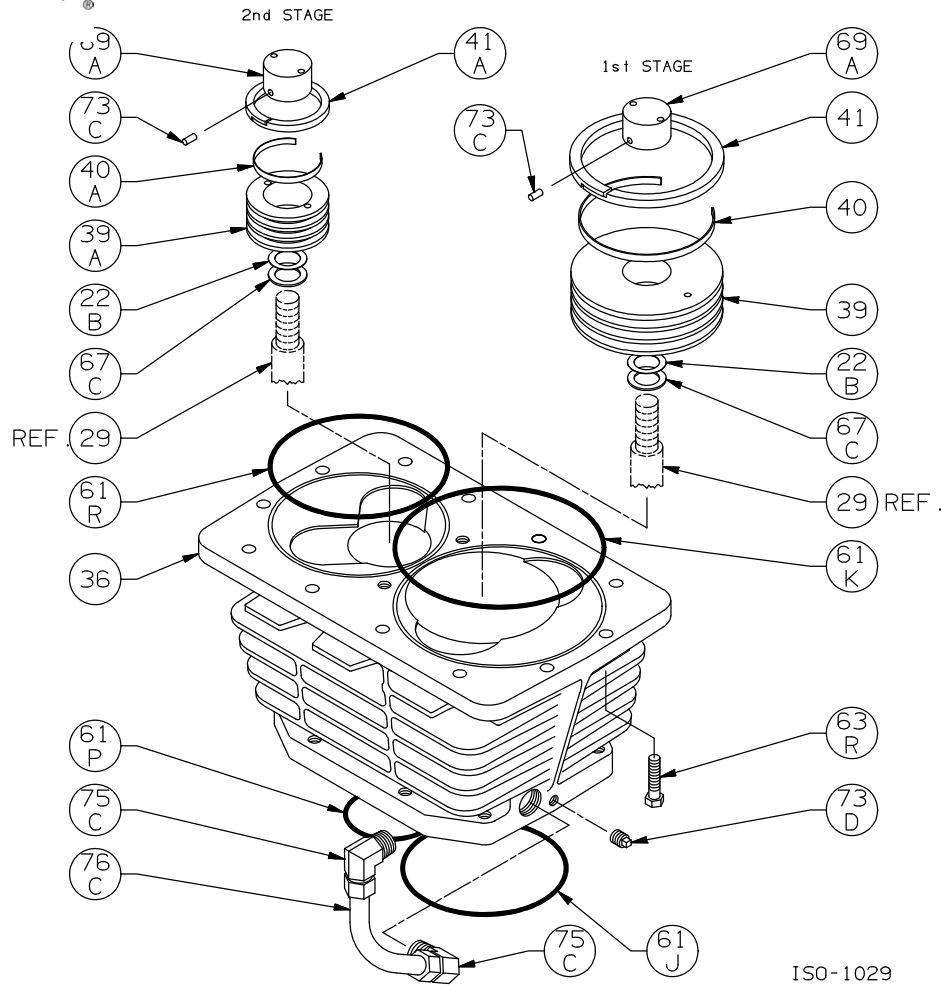
Ref	Description	Qty	Part No
9B	Packing Spring <sup>1</sup> Prior to SN 053771-P	4	794041 794083
12B	Inspection Plate	1	794093
25	Connecting Rod Assembly	2	794728
26	Connecting Rod Bearing	2	794710
28	Wrist Pin Bushing **	2	794749
29	Crosshead Assembly	2	794432
31	Wrist Pin	2	794727
32	Wrist Pin Plug	4	794724
34	Crosshead Guide	1	794430
35A	Retainer Ring	8	794080
35B	Packing Box Packing Box TNT-12 <sup>1</sup> Prior to SN 053771-P	2	794452 792885 NA
35C	Packing Set <sup>1</sup> Prior to SN 053771-P	4	794498 794499
35D	Hold-down Ring Hold-down Ring TNT-12	2	794220 792839
35E	Spacer Ring	2	794403

Ref	Description	Qty	Part No
35J	Packing Bushing <sup>1</sup> Not used prior to SN 053771-P	2	794043
60E	Gasket - Inspection Plate *	1	794092
60F	Gasket - Crankcase *	1	794121
61G	O-Ring (Buna-N) Std * O-Ring (FKM) * O-Ring (PTFE) * O-Ring (Neoprene) * O-Ring (Ethylene Propylene) *	4	794082 794213 794208 794090 794206
62B	Machine Screw - Inspection Plate	10	793096
63F	Capscrew - Hex Hd	16	794094
64A	Connecting Rod Bolt	4	794012
67A	Washer - Packing Box	12	794084
68A	Connecting Rod Bolt Nut	4	794013
72A	Elbow - Vent	1	790453
73C	Lock Plug *	6	794028
93	Oil Deflector Ring	2	794478
96	Pipe Plug	4	793498

\*Included in Gasket Sets

\*\* Must be honed after installing

Note 1: Effective with SN 053771-P (May 1994) the packing assembly, packing spring, and packing boxes were changed. The newer style packing, spring, and packing boxes cannot be intermixed with the older styles. However, newer packing boxes complete with new style packing may be used to replace packing boxes assemblies used prior to SN 053771-P if needed.



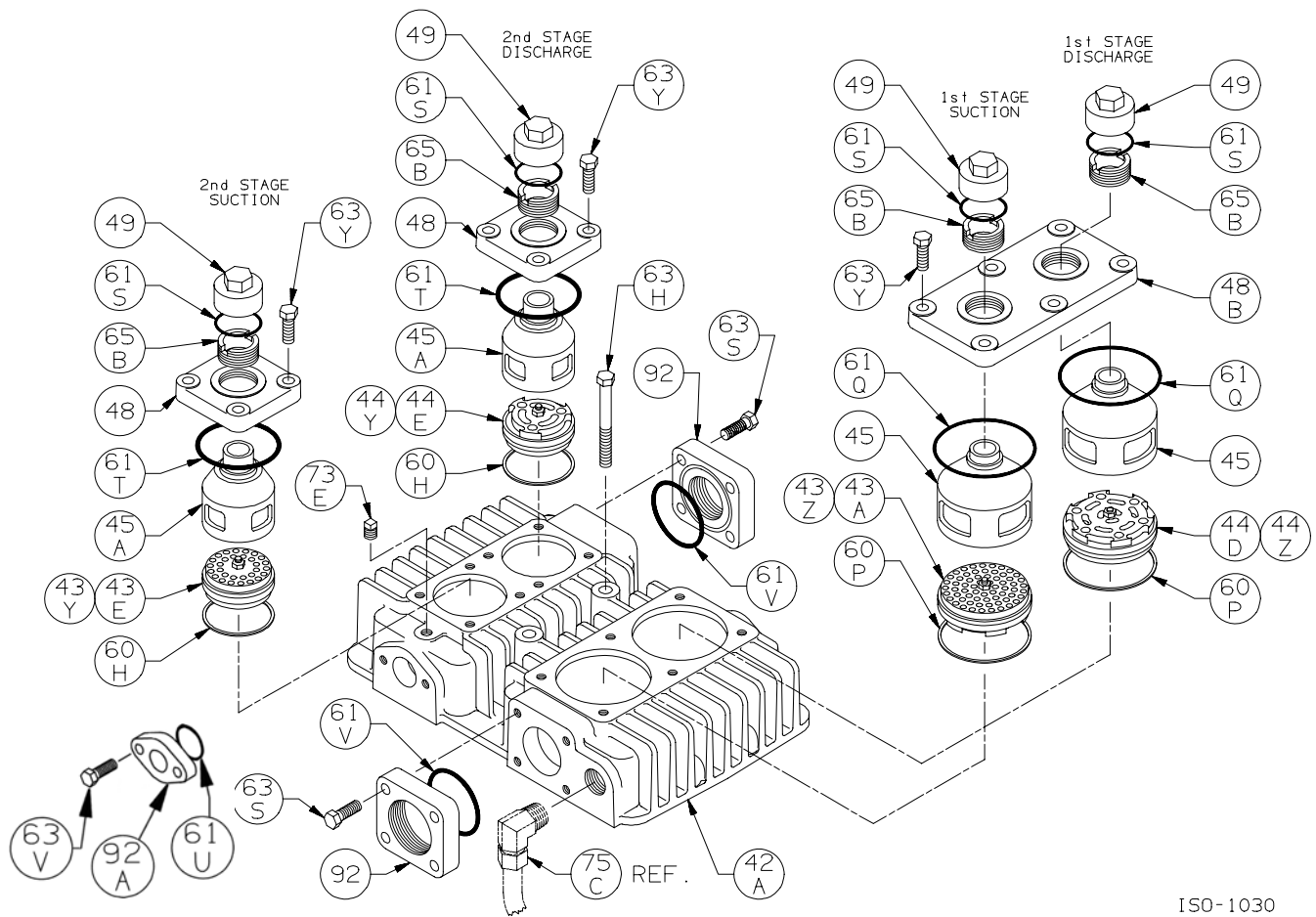
Cylinder Assembly: HD612C|B|A, HD613C|B

Ref	Description	Qty	Part No
22B	Piston Shim - 0.015	AR	794434
	Piston Shim - 0.007	AR	794436
36	Cylinder	1	794601
	Cylinder TNT-12		792845
39	Piston	1	794621
	Piston TNT-12		792848
39A	Piston	1	794622
	Piston TNT-12		792849
40	Expander	3	794614
40A	Expander	3	794615
41	Piston Ring - Glass/Moly Filled, Std	3	794610
	Piston Ring - Poly Filled		794612
41A	Piston Ring - Glass/Moly Filled, Std	3	794611
	Piston Ring - Poly Filled		794613
61J	O-Ring (Buna N) Std *	1	794661
	O-Ring (FKM) *		794663
	O-Ring (PTFE) *		794662
	O-Ring (Neoprene) *		794664
	O-Ring (Ethylene Propylene) *		794665

\* Included in Gasket Sets

ISO1029

Ref	Description	Qty	Part No
61K	O-Ring (Buna N) Std *	1	794631
	O-Ring (FKM) *		794633
	O-Ring (PTFE) *		794632
	O-Ring (Neoprene) *		794634
	O-Ring (Ethylene Propylene) *		794638
61P	O-Ring (Buna N) Std *	1	794651
	O-Ring (FKM) *		794653
	O-Ring (PTFE) *		794652
	O-Ring (Neoprene) *		794654
	O-Ring (Ethylene Propylene) *		794655
61R	O-Ring (Buna N) Std *	1	793631
	O-Ring (FKM) *		793633
	O-Ring (PTFE) *		793632
	O-Ring (Neoprene) *		793634
	O-Ring (Ethylene Propylene) *		793638
63R	Capscrew - Hex Hd	12	794097
67C	Thrust Washer	2	794433
69A	Piston Nut	2	794623
	Piston Nut TNT-12		792850
73C	Lock Plug *	4	794222
73D	Pipe Plug	1	793498
75C	Tube Elbow	2	790391
76C	Tube	1	790395



ISO-1030

Head Assembly: HD612C|B|A, HD613C|B

ISO1030

OVER.....



Head Assy.: HD612C|B|A, HD613C|B

ISO1030

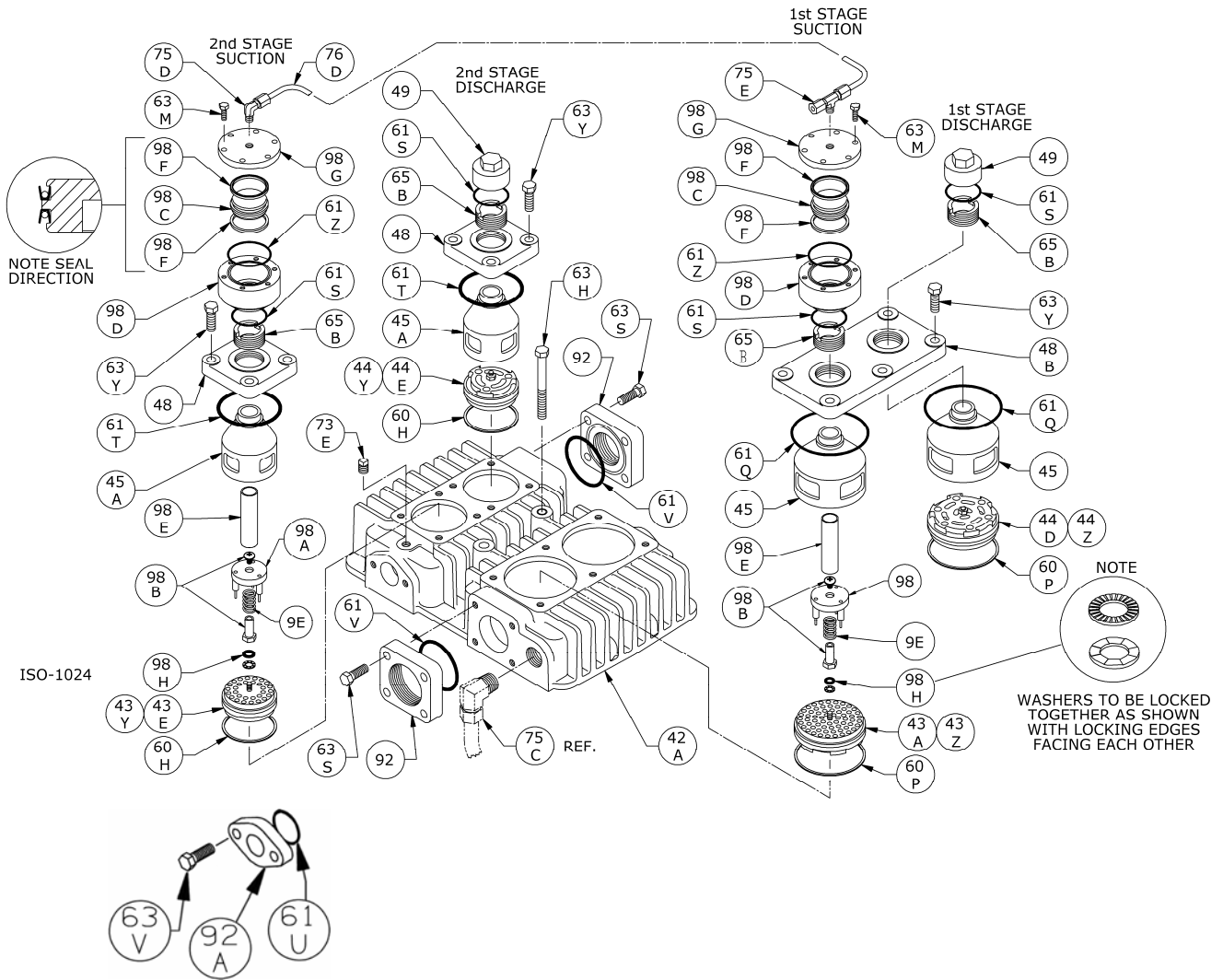
Ref	Description	Qty	Part No
42A	Head	1	794600
	Head TNT-12		792844
43A	Suction Valve Assembly	1	794659
	Suction Valve Assembly TNT-12		792874
	Suction Valve Assy, Stainless Steel		794629
43E	Suction Valve Assembly	1	793659
	Suction Valve Assembly TNT-12		792872
	Suction Valve Assy, Stainless Steel		793629
43Y	Valve Repair Kit - For 793659/793679		793660
	Valve Repair Kit - For 793629		793630
43Z	Valve Repair Kit - For 794659/794679		794660
	Valve Repair Kit - For 794629		794630
44D	Discharge Valve Assembly	1	794679
	Discharge Valve Assembly TNT-12		792875
	Discharge Valve Assy, Stainless Steel		794649
44E	Discharge Valve Assembly	1	793679
	Discharge Valve Assembly TNT-12		792873
44Y	Valve Repair Kit - For 793659/793679		793660
	Valve Repair Kit - For 793649		793650
44Z	Valve Repair Kit - For 794659/794679		794660
	Valve Repair Kit - For 794649		794650
45	Cage	2	794602
	Cage TNT-12		792846
45A	Cage	2	794620
	Cage TNT-12		792835
48	Valve Cover Plate	2	794284
	Valve Cover Plate TNT-12		792817
48B	Valve Cover Plate	1	794603
	Valve Cover Plate TNT-12		792847
49	Valve Cap	4	792003
	Valve Cap TNT-12		792804
60H	Gasket - Valve *	2	794198
60P	Gasket - Valve *	2	794616

\* Included in Gasket Sets

Ref	Description	Qty	Part No
61Q	O-Ring (Buna-N) Std *	2	794641
	O-Ring (FKM) *		794643
	O-Ring (PTFE) *		794642
	O-Ring (Neoprene) *		794644
61S	O-Ring (Ethylene Propylene) *	4	794645
	O-Ring (Buna-N) Std *		792306
	O-Ring (FKM) *		792308
	O-Ring (PTFE) *		792307
61T	O-Ring (Neoprene) *	2	792309
	O-Ring (Ethylene Propylene) *		792310
	O-Ring (Buna-N) Std *		792112
	O-Ring (FKM) *		792213
61U	O-Ring (PTFE) *	2	792210
	O-Ring (Neoprene) *		792110
	O-Ring (Ethylene Propylene) *		792206
	O-Ring (Buna-N) Std *		792412
61V	O-Ring (FKM) *	2	792413
	O-Ring (PTFE) *		792414
	O-Ring (Neoprene) *		792410
	O-Ring (Ethylene Propylene) *		792411
63H	Capscrew - Hex Hd	2	794115
63S	Capscrew - Hex Hd	8	794096
63V	Capscrew - Hex Hd	4	793094
63Y	Capscrew - Hex Hd	14	793094
65B	Valve Holddown Screw	4	792002
	Valve Holddown Screw TNT-12		792806
73E	Pipe Plug	1	793498
92	Flange-Inlet (2 NPT) Std	1	794117
	Flange-Inlet (2 NPT) TNT-12		792837
	Flange-Outlet (1.5 NPT) Std	1	794116
	Flange-Outlet (1.5 NPT) TNT-12		792836
	Flange (1.25 NPT)		794118
Flange (1.25 NPT) TNT-12	792866		
92A	Flange, 1" NPT - Intercooler	2	793602







Head Assembly with Unloaders: HD612C|B|A, HD613C|B ISO1024

Over.....

Head Assy. with Unloaders: HD612C|B|A, HD613C|B

ISO1024

Ref	Description	Qty	Part No
9E	Unloader Spring	2	793293
42A	Head Head TNT-12	1	794600 792844
43A	Suction Valve Assembly Suction Valve Assembly TNT-12 Suction Valve Assy, Stainless Steel	1	794659 792874 794629
43E	Suction Valve Assembly Suction Valve Assembly TNT-12 Suction Valve Assy, Stainless Steel	1	793659 792872 793629
43Y	Valve Repair Kit - For 793659/793679 Valve Repair Kit - For 793629		793660 793630
43Z	Valve Repair Kit - For 794659/794679 Valve Repair Kit - For 794629		794660 794630
44D	Discharge Valve Assembly Discharge Valve Assy TNT-12 Discharge Valve Assy, Stainless Steel	1	794679 792875 794649
44E	Discharge Valve Assembly Discharge Valve Assembly TNT-12 Discharge Valve Assy, Stainless Steel	1	793679 792873 793649
44Y	Valve Repair Kit - For 793659/793679 Valve Repair Kit - For 793649		793660 793650
44Z	Valve Repair Kit - For 794659/794679 Valve Repair Kit - For 794649		794660 794650
45	Cage Cage TNT-12	2	794602 792846
45A	Cage Cage TNT-12	2	794620 792835
48	Valve Cover Plate Valve Cover Plate TNT-12	2	794284 792817
48B	Valve Cover Plate Valve Cover Plate TNT-12	1	794603 792847
49	Valve Cap Valve Cap TNT-12	2	792003 792804
60H	Gasket - Valve *	2	794198
60P	Gasket - Valve *	2	794616
61Q	O-Ring (Buna-N) Std * O-Ring (FKM) * O-Ring (PTFE) * O-Ring (Neoprene) * O-Ring (Ethylene Propylene) *	2	794641 794643 794642 794644 794645
61S	O-Ring (Buna-N) Std * O-Ring (FKM) * O-Ring (PTFE) * O-Ring (Neoprene) * O-Ring (Ethylene Propylene) *	4	792306 792308 792307 792309 792310

\* Included in Gasket Sets

Ref	Description	Qty	Part No
61T	O-Ring (Buna-N) Std * O-Ring (FKM) * O-Ring (PTFE) * O-Ring (Neoprene) * O-Ring (Ethylene Propylene) *	2	792112 792213 792210 792110 792206
61U	O-Ring (PTFE) *	2	793626
61V	O-Ring (Buna-N) Std * O-Ring (FKM) * O-Ring (PTFE) * O-Ring (Neoprene) * O-Ring (Ethylene Propylene) *	2	792412 792413 792414 792410 792411
61Z	O-Ring (Buna-N) Std * O-Ring (FKM) * O-Ring (PTFE) * O-Ring (Neoprene) * O-Ring (Ethylene Propylene) *	2	792311 792313 792312 792314 792320
63H	Capscrew - Hex Hd	2	794115
63M	Capscrew - Hex Hd	12	790053
63S	Capscrew - Hex Hd	8	794096
63V	Capscrew - Hex Hd	4	793094
63Y	Capscrew - Hex Hd	14	793094
65B	Valve Holddown Screw Valve Holddown Screw TNT-12	4	792002 792806
73E	Pipe Plug	1	793498
75D	Tube Elbow	1	790355
75E	Tube Tee	1	790356
76D	Tube	1	790192
92	Flange-Inlet (2 NPT) Std Flange-Inlet (2 NPT) TNT-12 Flange-Outlet (1.5 NPT) Std Flange-Outlet (1.5 NPT) TNT-12 Flange (1.25 NPT) Flange (1.25 NPT) TNT-12	1	794117 792837 794116 792836 794118 792866
92A	Flange, 1" NPT - Intercooler	2	793602
98	Actuator Assembly - 1st Stage Act Asy - 1st St, for SS Valve	1	793296 794295
98A	Actuator Assembly - 2nd Stage Act Asy - 2nd St, for SS Valve	1	794296 794298
98B	Unloader Post w/bolt <sup>1</sup> Unloader Post w/bolt <sup>1</sup> , for SS Valve	2	793291 794291
98C	Unloader Piston	2	793288
98D	Unloader Body	2	793286
98E	Unloader Plunger	2	794290
98F	Unloader Seal	4	792284
98G	Unloader Cap	2	793287
98H	Lockwasher (2 piece)	2	793473

<sup>1</sup> Unloader Post with bolt replaces earlier style unloader post with retainer ring.



## Suggested Spare Parts for HD612B and HDL612B compressors:

Part #	Description	Qty./Unit	Comm. Qty.	Spare Qty.
794699	Gasket Set - Buna-N	1	1	1
794698	Gasket Set - PTFE *			
794697	Gasket Set - FKM *			
794696	Gasket Set - Neoprene *			
794695	Gasket Set - Ethylene Propylene *			
794660	St1 Suction Valve Repair Kit - PEEK	1		1
794630	St1 Suction Valve Repair Kit - Stainless Steel *			
793660	St2 Suction Valve Repair Kit - PEEK	1		
793630	St2 Suction Valve Repair Kit - Stainless Steel *			
794660	St1 Discharge Valve Repair Kit - PEEK	1		1
794650	St1 Discharge Valve Repair Kit - Stainless Steel *			
793660	St2 Discharge Valve Repair Kit - PEEK	1		1
793650	St2 Discharge Valve Repair Kit - Stainless Steel *			
792284	Unloader Seal *	4		4
794610	St1 Piston Ring - Standard	3	3	3
794612	St1 Piston Ring - Poly Filled *			
794614	St1 Piston Ring Expander	3	3	3
794611	St2 Piston Ring - Standard	3		3
794613	St2 Piston Ring - Poly Filled *			
794615	St2 Piston Ring Expander	3		3
794498	Packing Set (Units prior to SN 053771-P, use PN 794499)	4	4	4
794726	Oil Filter *	1		6
794727	Wrist Pin	2		2
794749	Wrist Pin Bushing	2	2	2
794710	Conrod Bearing	2	2	2
The following parts would normally be required only for major compressor overhaul.				
794730	Inboard Bearing Cone	1		1
794731	Inboard Bearing Cup	1		1
794130	Outboard Bearing Cone	1		1
794131	Outboard Bearing Cup	1		1
794432	Crosshead Assembly	2		2
794728	Conrod Assembly	2		
794760	Oil Pump Repair Kit	1		
794708	Crankshaft Assembly	1		
794733	Bearing Adjustment Shim Kit	1		
794601	Cylinder (HD612)	1		
792845	TNT-12 Treated Cyl. (HD612) *			
794701	Cylinder (HDL612)	1		
792852	TNT-12 Treated Cyl. (HDL612) *			

\* Optional Equipment on New Compressors