

SEQUENCER VALVE BODY**1. ISSUE**

Cracking in some [REDACTED] valve bodies. While not a widespread issue, this Service Bulletin is provided as an alert to a possible issue, to help reduce diagnostic time, and to promote awareness of an easy warranty-based solution.

2. SCOPE

This service bulletin applies to [REDACTED] models with serial numbers between # [REDACTED] and # [REDACTED].

3. SERVICE DETAIL

A few dealers have reported finding a crack in Sequencer Valve bodies causing leaks in the [REDACTED] compartment. This may have been caused by over tightening in the factory and aggravated by the stress of shipment and installation.

**4. SOLUTION**

If you discover a leak in the [REDACTED] compartment, you should first check closely for small crack(s) in the Sequencer Valve body. If you discover a crack in any of these Sequencer Valve bodies, all Sequencer Valves in the spa should be replaced – even if they appear to be OK. This will preclude future problems of this nature and avoid any further interruptions for the customer.

If you discover any cracked Sequencer Valves, contact the [REDACTED] Service Department immediately for further guidance on warranty replacement of these Sequencer Valves. They may be reached by calling [REDACTED] or on the web at [http://www.\[REDACTED\]](http://www.[REDACTED])

Replacing a Sequencer Valve

- Turn off the spa power at the GFCI and drain the spa.
- Snip the plastic fasteners as close as possible to the compartment and unscrew the unions.
- Once the Sequencer Valve is free, remove the solenoid from the valve body by holding the solenoid on top of the valve and unscrew the valve to remove it from the solenoid. This process allows you to reuse the solenoid and avoid disconnecting and reconnecting the solenoid wiring.
- Take a replacement Sequencer Valve (clearly identified by “the black marker line on the male union end”) and screw it on to the solenoid.
- Reconnect the unions.
- Repeat these steps for all Sequencer Valves in the compartment.

[Note: [REDACTED] has 2 compartments with a total of 12 valves, the [REDACTED] and [REDACTED] each have 1 compartment with 6 total valves.]

- Refill the spa.
- Check for leaks.
- Return the old Sequencer Valves to: [REDACTED]



Do not replace Sequencer Valves merely as a “Peace of Mind” measure.

[REDACTED] does not warranty Sequencer Valve replacements that do not involve at least one cracked Sequencer Valve body.

[REDACTED]
Service Manager