

SERVICE KIT

637028

637029

637034

637035

RELEASED: 8-15-68
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(REV. D)

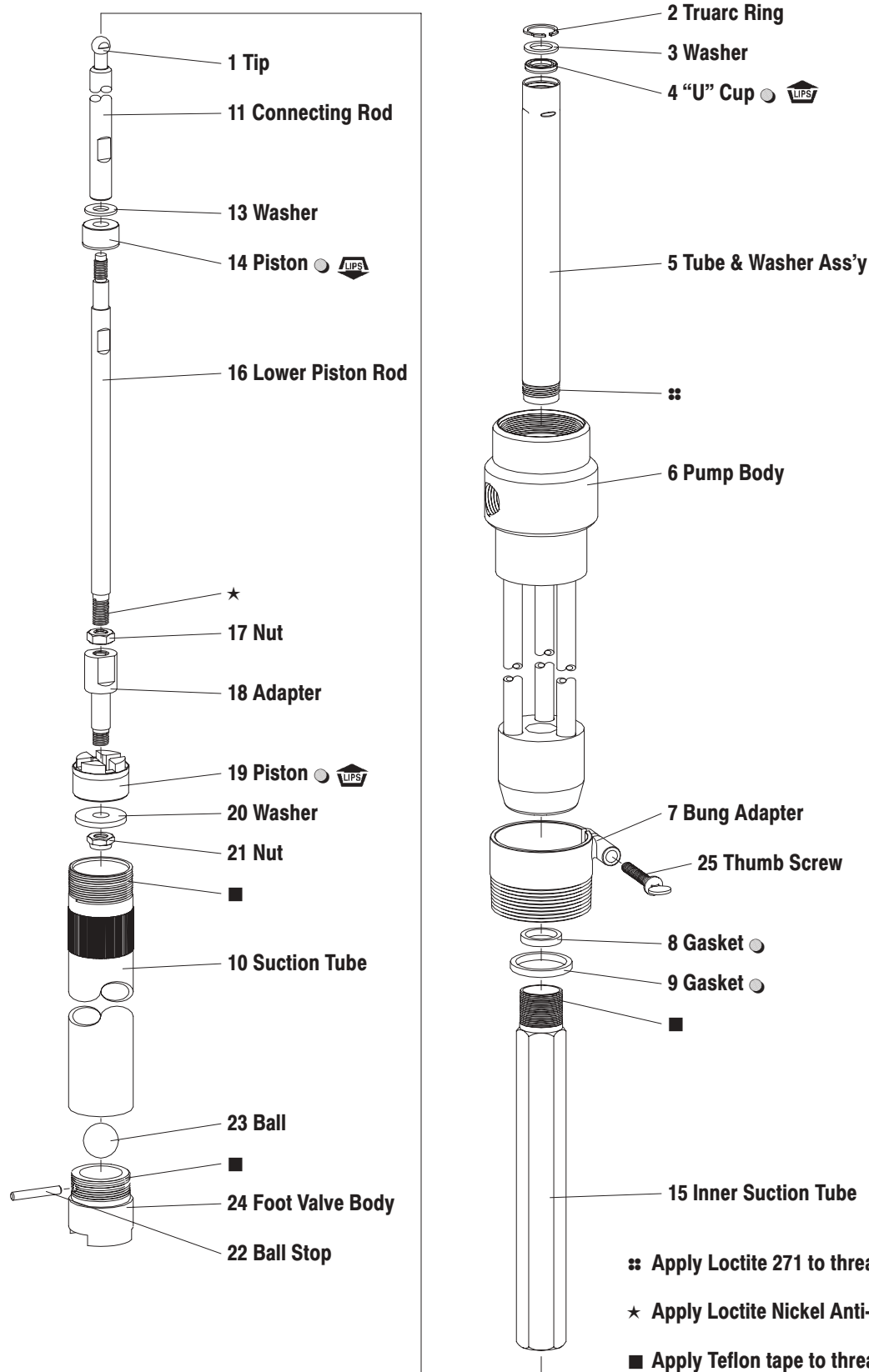


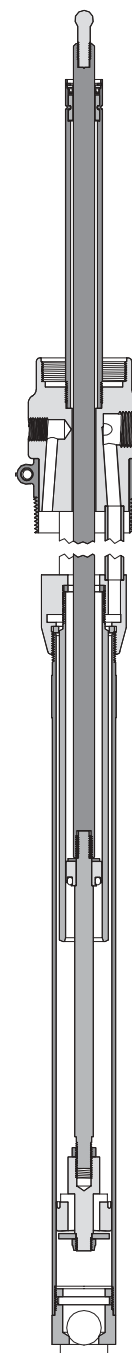
Figure 1

⌘ Apply Loctite 271 to threads.

★ Apply Loctite Nickel Anti-Seize to threads.

■ Apply Teflon tape to threads.

● Items included in service kit (see page 2).



Service Kit	Item 4 "U" Cup	Item 8 Gasket	Item 9 Gasket	Item 14 Piston	Item 19 Piston
637028	Y186-47	91419	91491	93848-1	91523
637029	Y186-47	91419	91491	93848-2	91484
637034	Y219-47	91419	91491	93848-1	91523
637035	Y219-47	91419	91491	93848-2	91484

LOWER PUMP DISASSEMBLY

Refer to figure 1, page 1.

NOTE: All threads are right hand.

1. Clamp the lower pump assembly in the vise on solid part of (6) pump body. **CAUTION: Clamp the pump so that the three small tubes connected to the lower end of (6) pump body are not being twisted.**
2. Place a pipe or strap wrench on the knurled part of the (10) suction tube and remove the (10) suction tube. **CAUTION: Do not place wrench any other place other than the knurled part of the (10) suction tube.**
3. Grasp the (16) lower piston rod and remove the rod and piston assembly by pulling straight out.
4. Place a socket wrench in the hex end of the (15) inner suction tube and remove. **CAUTION: Do not use any open end or adjustable wrench.**
5. Remove the (8 and 9) gaskets.
6. Loosen the vise and reclamp the pump on the (6) pump body in area of material outlet hole. **CAUTION: Do not clamp directly on outlet hole.**
7. Remove (5) tube and washer assembly with a strap wrench.
8. Remove the (2) Truarc ring using Truarc pliers.
9. Remove the (3) washer.
10. Remove the (4) "U" cup.
11. Clamp the (24) foot valve body on flats in vise.
12. Place a pipe wrench on the knurled portion of (10) suction tube. **CAUTION: Do not place wrench any other place other than the knurled part of the (10) suction tube.**
13. Remove (10) suction tube from (24) foot valve body.
14. Remove (24) foot valve body from vise.
15. Remove (22) ball stop.
16. Remove (23) ball.
17. Clamp the (16) lower piston rod in the vise on flats.
18. Place an open end or adjustable wrench on (11) connecting rod flats. Remove by turning counterclockwise.
19. Remove the (13) washer.
20. Remove the (14) piston.
21. Remove the (21) elastic stop nut.
22. Remove the (20) washer.
23. Remove the (19) piston.

LOWER PUMP REASSEMBLY

Refer to figure 1, page 1.

CAUTION: Apply Anti-seizing compound to all stainless steel threads unless the service manual calls for Loctite.

1. Clamp the (16) lower piston rod on flats in vise. Put the (19) piston in place as shown (lips up).
2. Put the (20) washer and (21) elastic stop nut in place.
3. Place the (14) piston (lips down) on the (16) lower piston rod.
4. Place the (13) washer on the (16) lower piston rod.
5. Thread the (11) connecting rod to (16) lower piston rod and tighten.
6. Clamp on (6) pump body below the three small tubes. Place the (8 and 9) gaskets in the (6) pump body.
7. Thoroughly grease the inside of the (15) inner suction tube and thread securely into the (6) pump body.
8. Thoroughly grease the (14 and 19) pistons. Insert the (11) connecting rod through the (15) inner suction tube and (6) pump body, (1) tip end first.
9. Thoroughly grease the inside of the (10) suction tube.
10. Insert the (10) suction tube over the (19) piston and thread into the (6) pump body.
11. Place the (23) ball into the (24) foot valve body.
12. Insert the (22) ball stop into the (24) foot valve body.
13. Thread the (24) foot valve body into the (10) suction tube.
14. Tighten the lower pump section by placing a bar in the bottom slot in the (24) foot valve body and turn clockwise.
15. Thoroughly grease and install the (4) "U" cup into the (5) tube and washer assembly.
16. Place the (3) washer into the (5) tube and washer assembly.
17. Insert the (2) Truarc ring into the (5) tube and washer assembly.
18. Insert the (5) tube and washer assembly over the (1) tip and thread into the (6) pump body.

