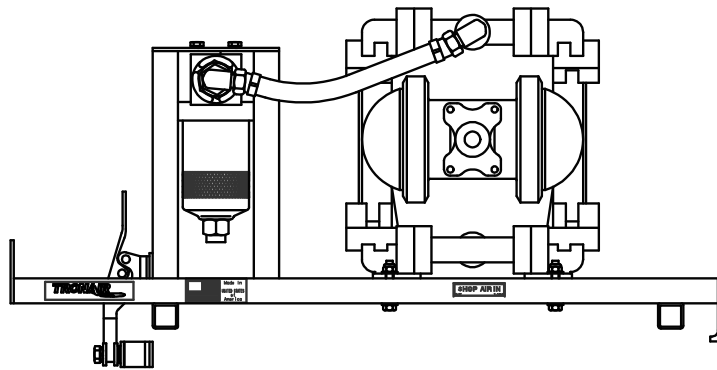




Operation & Service Manual



Model: 06T5024-3800 Barrel Pump With Totalizer

03/2011 - Rev. 01

Includes Illustrated Parts List

**Model: 06T5024-3800
Barrel Pump With Totalizer**

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APPENDIX I Lincoln Pump Service & Operating Manual

**Model: 06T5024-3800
Barrel Pump With Totalizer**

REVISION	DATE	TEXT AFFECTED
01	03/2011	Original release

**Model: 06T5024-3800
Barrel Pump With Totalizer**

This product can not be modified without the written approval of Tronair, Inc. Any modifications done without written approval voids all warranties and releases Tronair, Inc., its suppliers, distributors, employees, or financial institutions from any liability from consequences that may occur. Only Tronair OEM replacement parts shall be used.

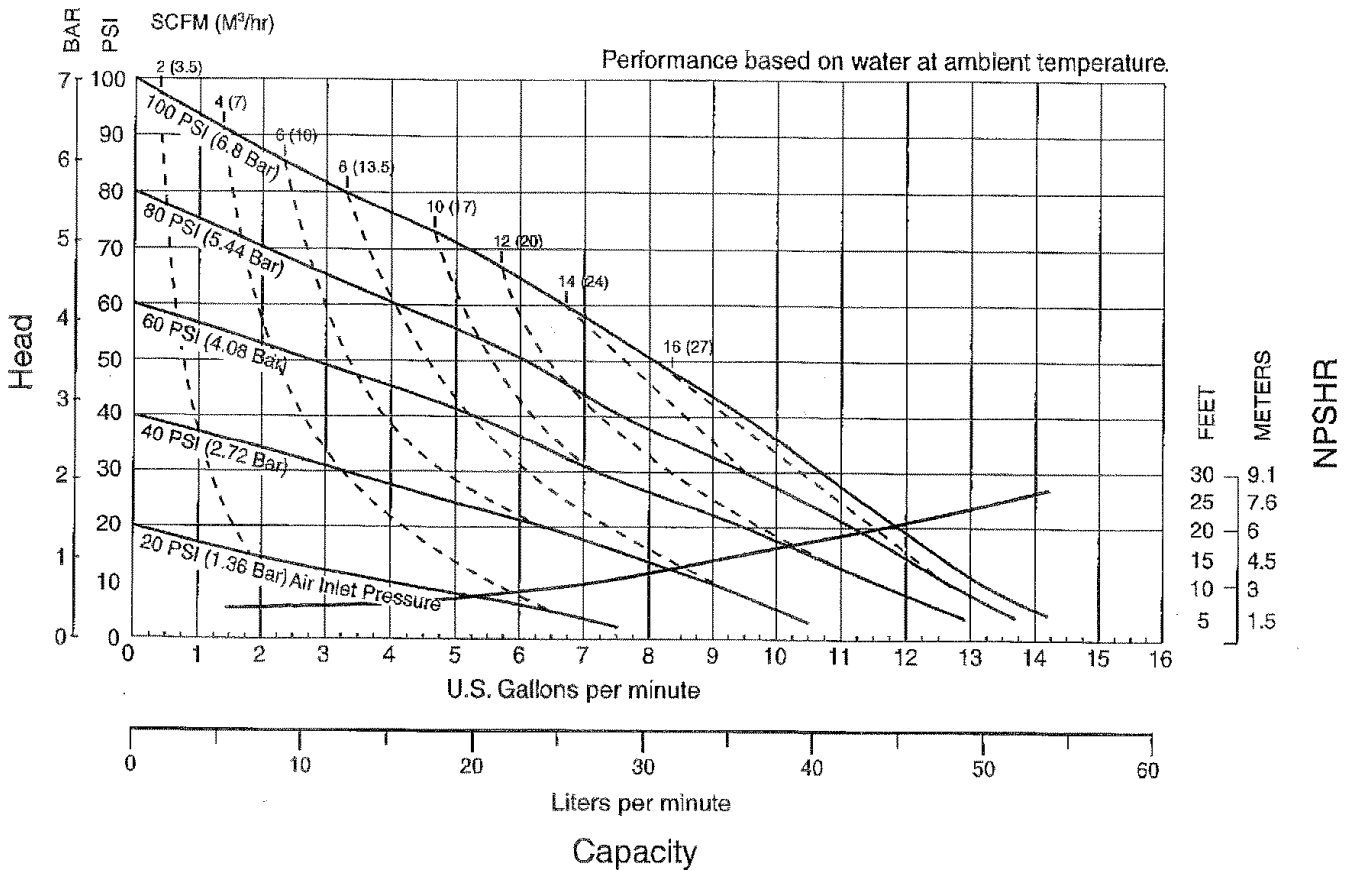
1.0 GENERAL DESCRIPTION

The Tronair Barrel Pump is a compact unit primarily designed to provide a source of clean fluid for filling reservoirs. It is not intended for performing any pressure testing tasks.

2.0 SPECIFICATIONS

- Fluid:** MIL-L-23699, MIL-PRF-87257
- Maximum Air Supply Pressure:** 100 psi (6.9 bar)
- Filter:** 2 Micron
- Dimensions:**
 - Length:** 28.25 in (71.8 cm)
 - Width:** 9 in (22.9 cm)
 - Height:** 15 in (38.1 cm) High
 - Weight:** 29 pounds (13.2 kg)
- Pump Displacement:** See Chart

Performance Curve



3.0 FEATURES

- 15 foot (4.6 m) hose
- Securely attaches to top of barrel
- 2 micron main filter
- Pick-up tube with filtered breather, directly screws into top of barrel
- Fluid totalizer in quarts



03/2011 - Rev. 01

**Model: 06T5024-3800
Barrel Pump With Totalizer**

4.0 PREPARATION FOR USE

The unit is shipped fully assembled, and only the following steps are required to make it operational:

NOTE: *On 06T5024-3800 Series units, apply appropriate fluid label to barrel pump frame.*



CAUTION!

Only use the type of fluid for which the unit is designed. Using other fluids will cause contamination and seal deterioration.

1. Attach unit to top of barrel.
2. Screw pick-up tube into barrel.
3. Connect pump to pick-up tube via quick disconnect coupling.
4. Connect shop air to inlet port (maximum line pressure 100 psi/6.9 bar).

5.0 OPERATION

To Use the Barrel Pump:

1. Securely attach hose to reservoir.
2. Open hand valve to fill aircraft.

When Service Has Been Completed:

1. Turn hand valve to closed position.
2. Disconnect hose from reservoir.
3. Replace protective cap on hose end to prevent dirt ingestion.

6.0 MAINTENANCE

6.1 FILTER

The filter is of a non-bypass design. This means if the filter becomes clogged, no fluid will pass to the reservoir. If this happens, service the filter. **Do not increase input pressure.**

6.2 SERVICE

The main filter is replaceable and should be serviced annually unless otherwise noted.

6.3 TROUBLE SHOOTING

Reference Appendix I - Lincoln Pump Service & Operating Manual.

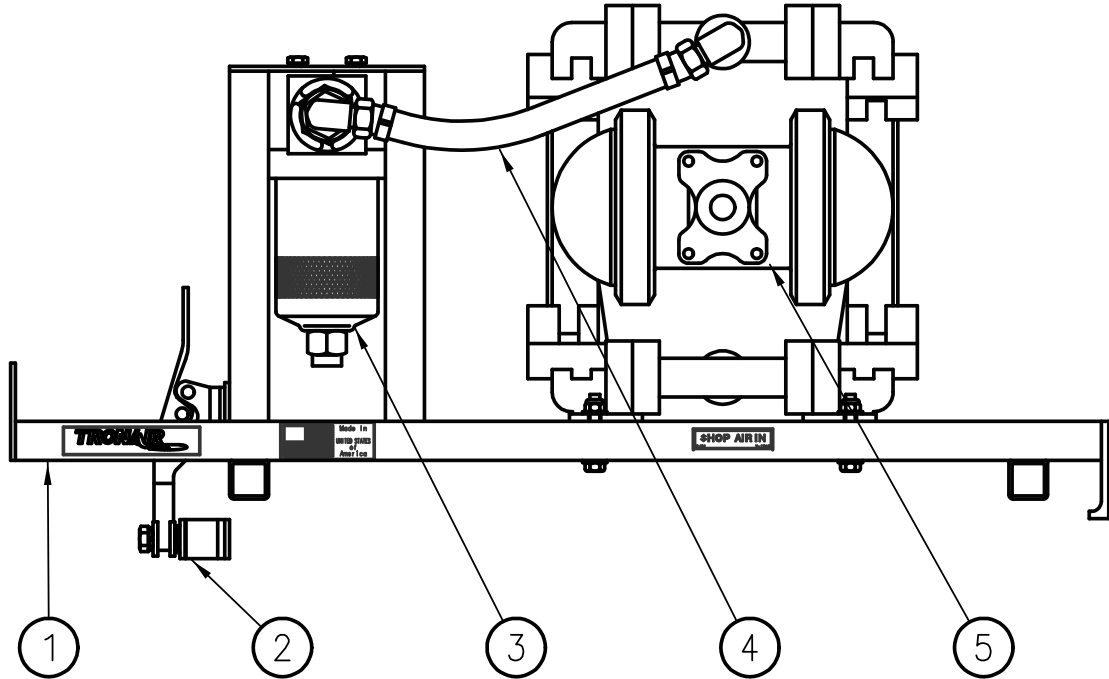
7.0 PARTS LIST

Reference Pages 3 – 5 for ordering information of Replacement Parts and Kits.

Model: 06T5024-3800
 Barrel Pump With Totalizer

Parts List

****When ordering replacement parts/kits, please specify model, serial number and color of your unit.****



ITEM	PART NUMBER	DESCRIPTION	QTY
1	Z-2100-01	Frame	1
2	Z-2101	Clamp	1
3	HC-1826	Filter	1
4	N-2026-05-B	Swivel, JIC 37 degree	2
	TF-1105-08*07.5	Hose, 1/2	1
5	Z-5678	Pump, Pneumatic (Mineral Base/Modified)	1
<i>Not Shown</i>	HK-3709	Kit, Pump Seal Repair	1
<i>Not Shown</i>	HK-3710	Kit, Air End Repair	1
<i>Not Shown</i>	HC-2197	Meter, Totalizer	1

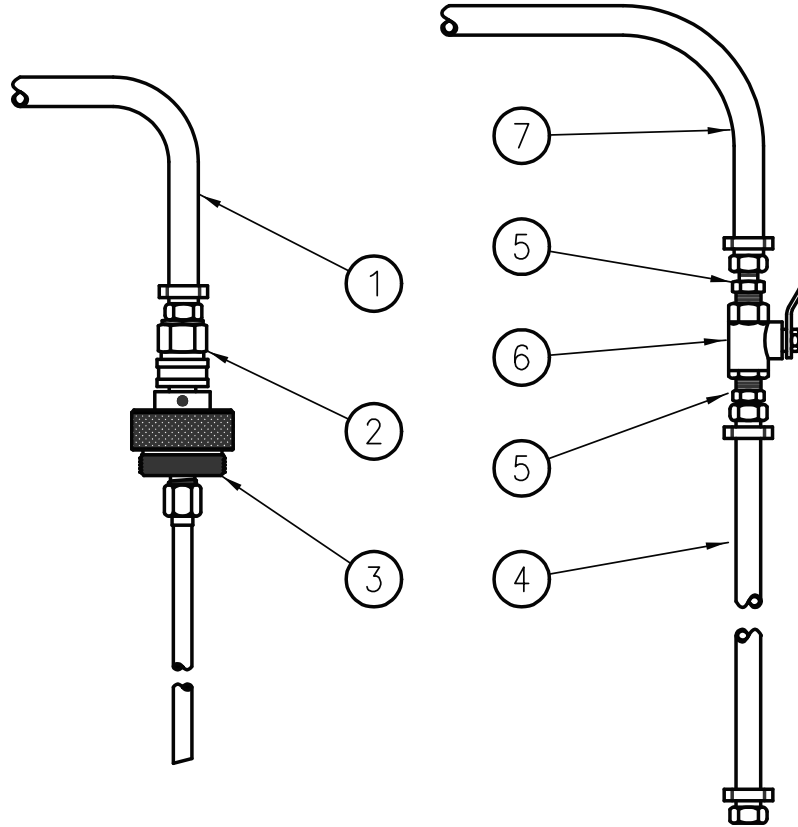
TRONAIR

03/2011 - Rev. 01

Model: 06T5024-3800
Barrel Pump With Totalizer

Parts List

****When ordering replacement parts/kits, please specify model, serial number and color of your unit.****

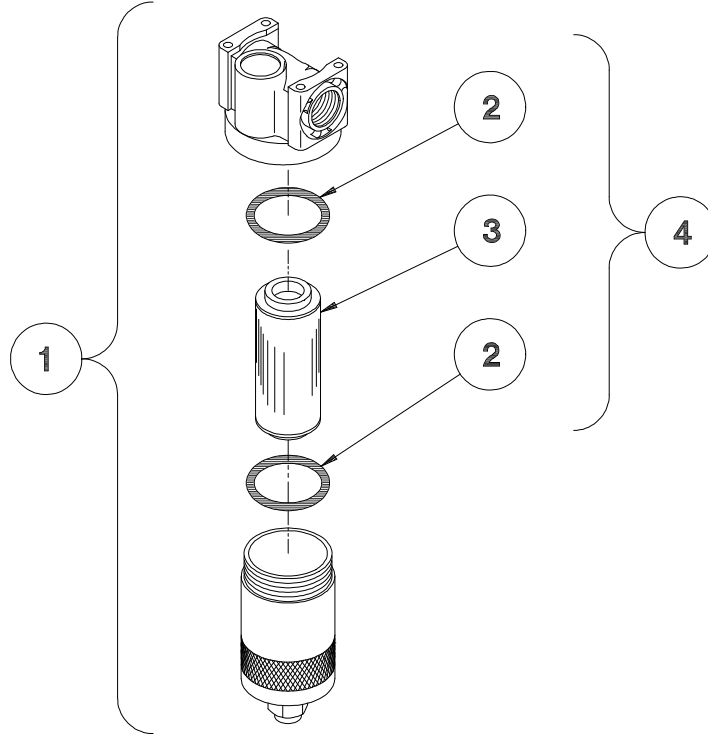


ITEM	PART NUMBER	DESCRIPTION	QTY
2	N-2230-0808	Coupling, Quick Disconnect	1
3	Z-2163-01	Barrel Pick-Up	1
5	N-2009-10-S	Connector, Male	2
6	HC-1425-02	Valve, Ball	1
1	N-2026-05-B	Swivel, JIC 37 degree	2
	TF-1105-08*36.0	Hose, 1/2	1
4	N-2026-03-B	Swivel, JIC 37 degree	2
	TF-1105-06*180	Hose, 3/8 Gray	1
7	N-2026-03-B	Swivel, JIC 37 degree	2
	TF-1105-06*25.0	Hose, 3/8 Gray	1
Not Shown	N-2052-06	Expander, Tube	1

Model: 06T5024-3800
 Barrel Pump With Totalizer

Filter Assembly

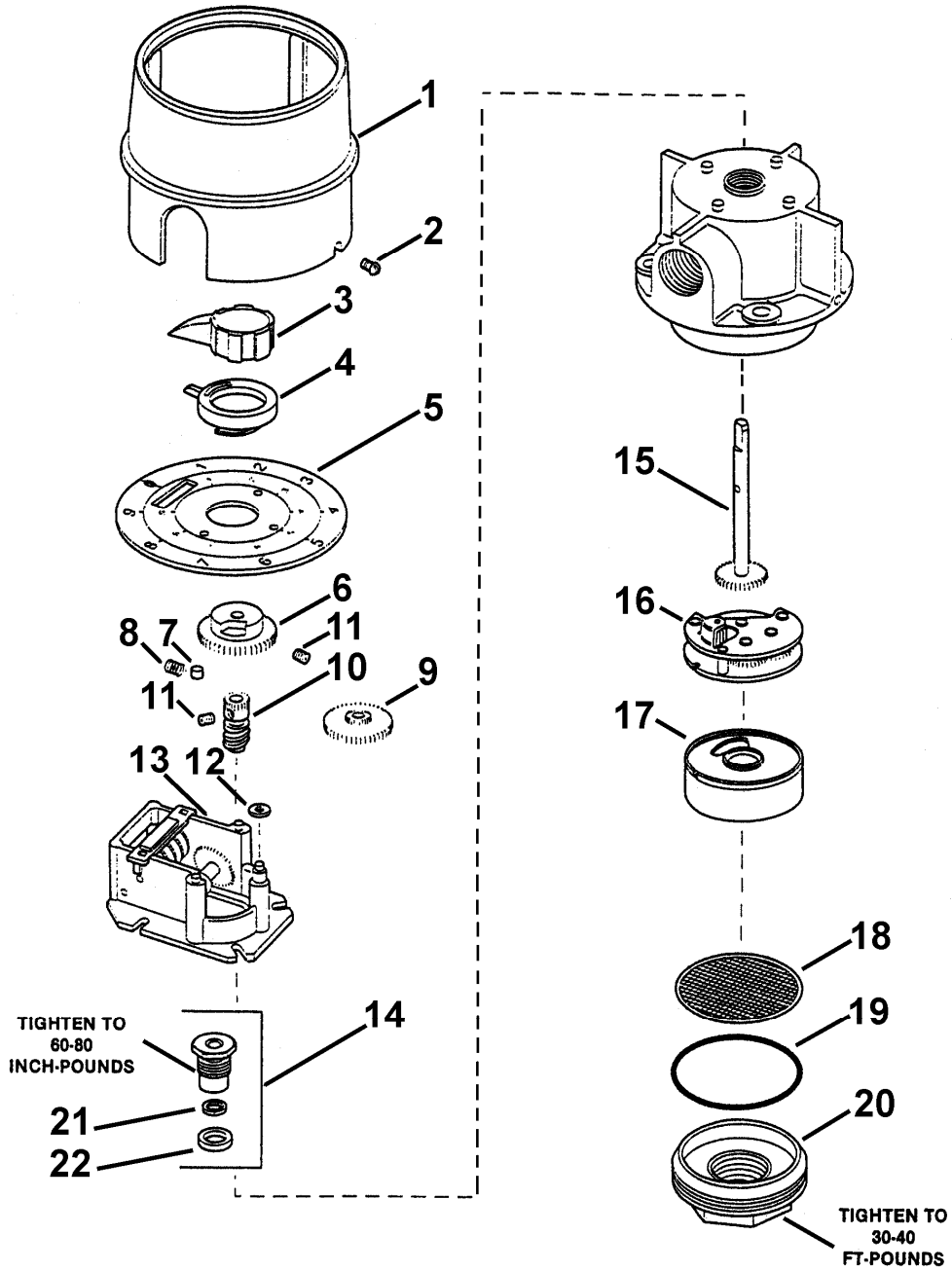
****When ordering replacement parts/kits, please specify model, serial number and color of your unit.****



ITEM	PART NUMBER	DESCRIPTION	QTY
1	HC-1826	Assembly, Filter	1
4	K-3098	Kit, Filter Element; consists of:	
3	HC-1482	Element, Filter (Mineral Base)	1
2	HC-2007-142	O-ring, Series 2	2

Filter Assembly – Totalizer Option

When ordering replacement parts/kits, please specify model, serial number and color of your unit.



**Model: 06T5024-3800
Barrel Pump With Totalizer**

Parts List - Totalizer Option

When ordering Replacement Parts/Kits, please specify Model & Serial Number of your product.

ITEM	FLUID	PART NUMBER	DESCRIPTION
1	N/A	66871-13	Shroud
2	N/A	66871-5	Screw (2)
3	N/A	242912	Knob Assembly
4	N/A	66871-53	Pointer
5	N/A	68410-26	Dial Assembly
6	N/A	66871-50	Cam
7	N/A	66871-4	Clutch Roller
8	N/A	66871-3	Spring
9	N/A	66871-17	Gear
10	N/A	66871-54	Worm
11	N/A	50541	Set Screw (2)
12	N/A	69304-23	Spacer
13	N/A	69795-3	Totalizer
14	MIL-L-23699, MIL-PRF-87257	N/A	N/A
15	N/A	66871-111	Spindle
16	N/A	66871-136	Gear Train Assembly
17	N/A	66871-25	Chamber Assembly
18	N/A	66871-92	Screen
19	MIL-L-23699, MIL-PRF-87257	HC-2007-223	O-ring
20	N/A	41204	Housing Cap
21	MIL-L-23699, MIL-PRF-87257	HC-2007-008	O-ring
22	MIL-L-23699, MIL-PRF-87257	HC-2007-001	O-ring



APPENDIX I

Lincoln Pump Service & Operating Manual

SERVICE & OPERATING MANUAL



**Models 85626, 85622, 85623
1/2" Air-Powered Diaphragm Pump**

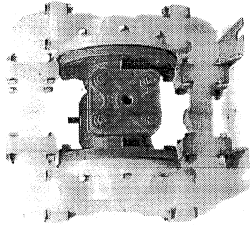
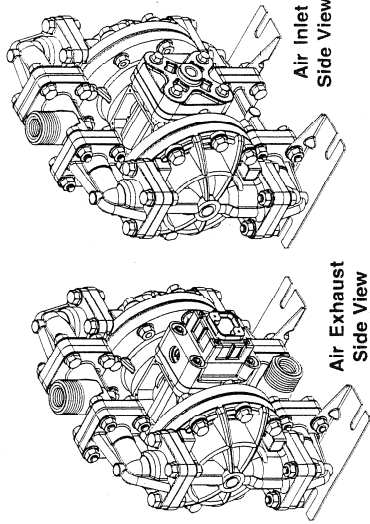


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Principle of Pump Operation	5	Air Distribution Valve Assembly Parts List	12
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Models 85626, 85622, 85623

Air-Powered Double-Diaphragm Pump

U.S. Patent #
5,996,627; 6,241,487
Other U.S. Patents
Applied for



ENGINEERING, PERFORMANCE
& CONSTRUCTION DATA

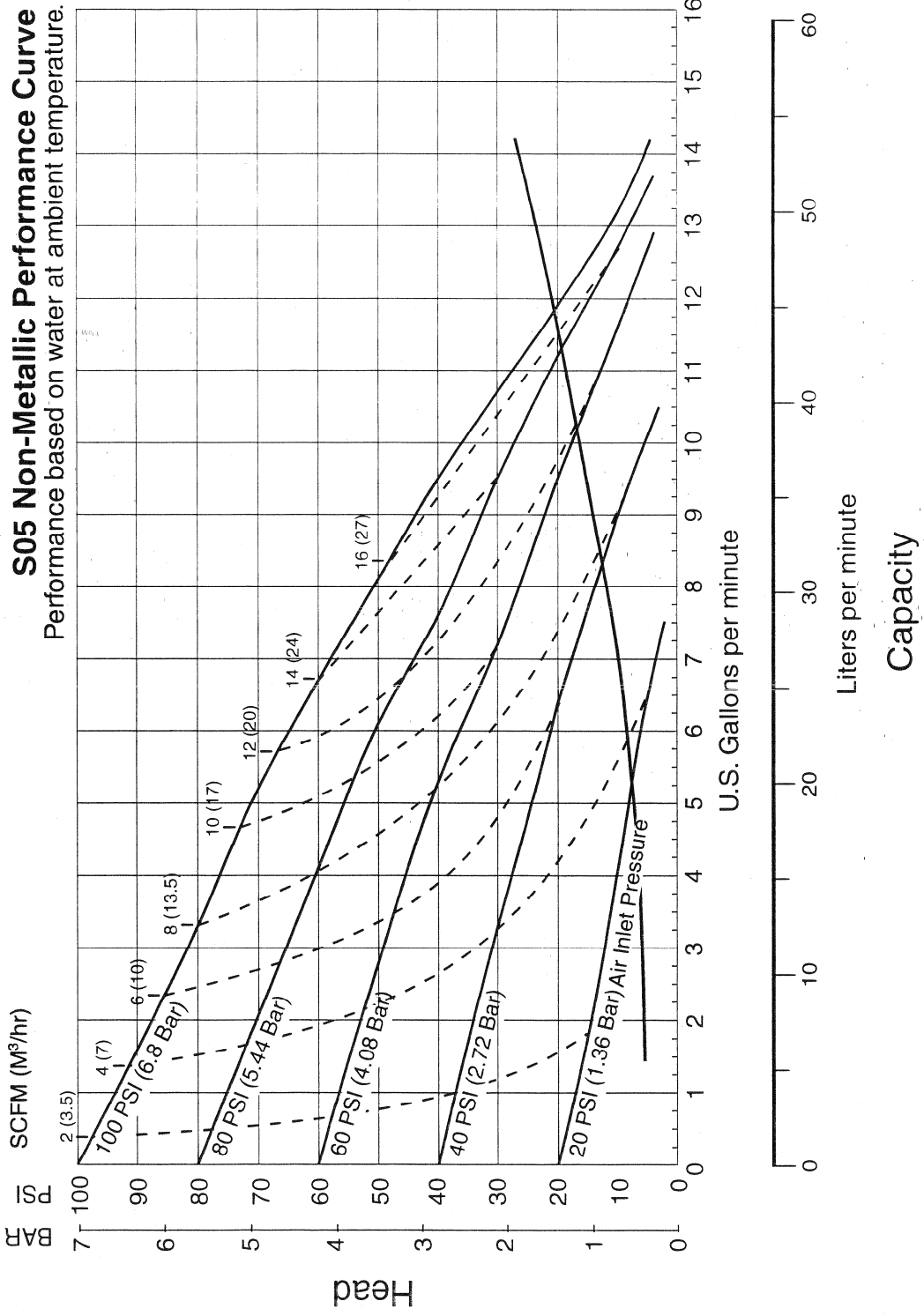
INTAKE/DISCHARGE PIPE SIZE 1/2" NPT (Internal) or 1/2" BSPT (Tapered) 1" NPT (External) or 1" BSPT (Tapered)	CAPACITY 0 to 14 gallons per minute (0 to 52 liters per minute)	AIR VALVE No-lube, no-stall design	SOLIDS-HANDLING Up to .125 in. (3mm)	HEADS UP TO 100 psi or 231 ft. of water (7 kg/cm ² or 70 meters)	DISPLACEMENT/STROKE .026 Gallon / .098 liter
CAUTION! Operating temperature limitations are as follows:					
MATERIALS					
<p>Buna: General purpose, oil-resistant. Shows good solvent, oil, water and hydraulic fluid resistance. Should not be used with highly polar solvents like acetone and MEK, ozone, chlorinated hydrocarbons and nitro hydrocarbons.</p> <p>Conductive Acetal:</p> <p>Nylon:</p> <p>PVDF:</p> <p>Virgin PTFE: Chemically inert, virtually impervious. Very few chemicals are known to react chemically with PTFE, molten alkali metals, turbulent liquid or gaseous fluorine and a few fluoro-chemicals such as chlorine trifluoride or oxygen difluoride which readily liberate free fluorine at elevated temperatures.</p> <p>Polyurethane: High tensile material with excellent abrasion resistance. A general purpose material with excellent resistance to most oils.</p> <p>Polpropylene:</p> <p>Santoprene®: Injection molded thermoplastic elastomer with no fabric layer. Long mechanical flex life. Excellent abrasion resistance.</p>					
			Operating Temperatures		
			Maximum*		Optimum**
			190° F 88° C	-10° F -23° C	50° to 140° F 10° to 60° C
			180° F 82° C	-20° F -28° C	
			120° F 48° C	32° F 0° C	
			200° F 93° C	10° F -13° C	50° to 212° F 10° to 100° C
			212° F 100° C	-35° F -37° C	50° to 212° F 24° to 100° C
			210° F 99° C	-40° F -40° C	-40° to 210° F -40° to 99° C
			150° F 65° C	40° F 5° C	
			212° F 100° C	-10° F -23° C	50° to 212° F 10° to 100° C

*Definite reduction in service life.
**Minimal reduction in service life at ends of range.

For specific applications, always consult "Chemical Resistance Chart" Technical Bulletin

Lincoln pumps are designed to be powered only by compressed air.

Performance Curve

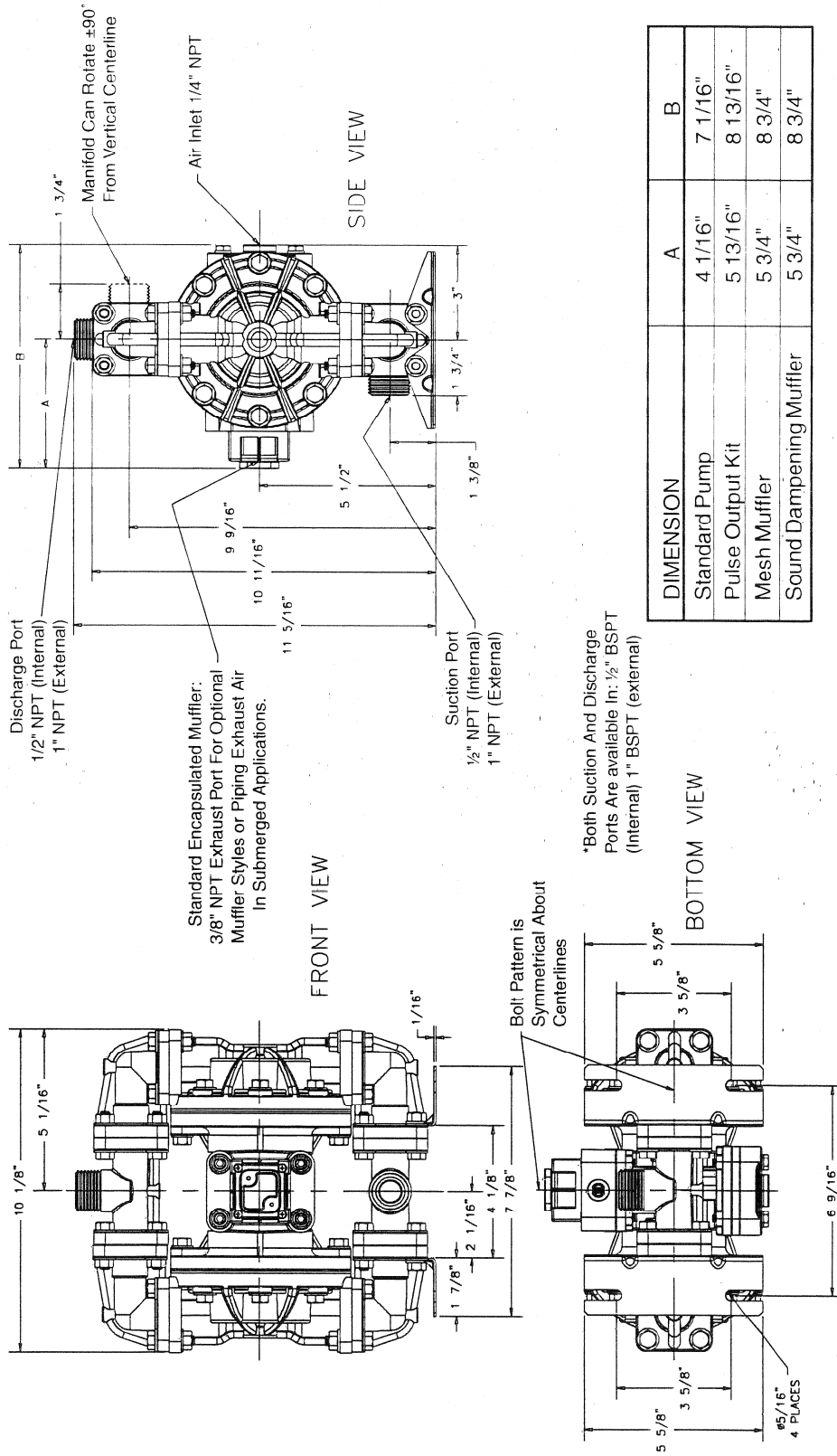


NPSHR

FEET METERS
 30 9.1
 25 7.6
 20 6
 15 4.5
 10 3
 5 1.5

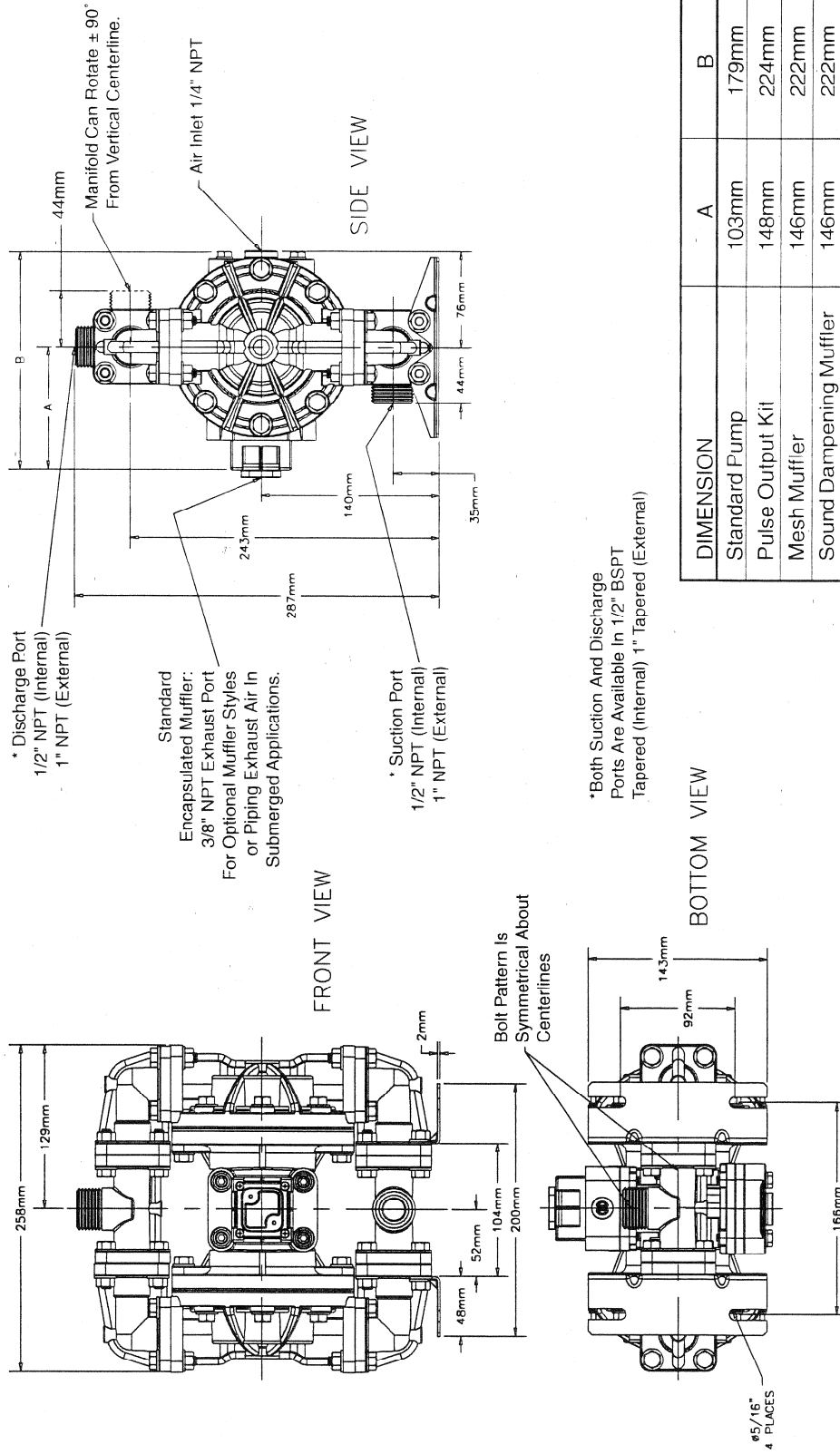
Dimensions:

Dimensions in Inches
Dimensional tolerance: $\pm 1/8"$



Metric Dimensions:

Dimensions in millimeters
Dimensional tolerance: $\pm 3\text{mm}$



PRINCIPLE OF PUMP OPERATION

This ball type check valve pump is powered by compressed air and is a 1:1 ratio design. The inner side of one diaphragm chamber is alternately pressurized while simultaneously exhausting the other inner chamber. This causes the diaphragms, which are connected by a common rod secured by plates to the centers of the diaphragms, to move in a reciprocating action. (As one diaphragm performs the discharge stroke the other diaphragm is pulled to perform the suction stroke in the opposite chamber.) Air pressure is applied over the entire inner surface of the diaphragm while liquid is discharged from the opposite side of the diaphragm. The diaphragm operates in a balanced condition during the discharge stroke which allows the pump to be operated at discharge heads over 200 feet (61 meters) of water.

For maximum diaphragm life, keep the pump as close to the liquid being pumped as possible. Positive suction head in excess of 10 feet of liquid (3.048 meters) may require a back pressure regulating device to maximize diaphragm life.

Alternate pressurizing and exhausting of the diaphragm chamber is performed by an externally mounted, pilot operated, four way spool type air distribution valve. When the spool shifts to one end of the valve body, inlet pressure is applied to one diaphragm chamber and the other diaphragm chamber exhausts. When the spool

shifts to the opposite end of the valve body, the pressure to the chambers is reversed. The air distribution valve spool is moved by a internal pilot valve which alternately pressurizes one end of the air distribution valve spool while exhausting the other end. The pilot valve is shifted at each end of the diaphragm stroke when a actuator plunger is contacted by the diaphragm plate. This actuator plunger then pushes the end of the pilot valve spool into position to activate the air distribution valve.

The chambers are connected with manifolds with a suction and discharge check valve for each chamber, maintaining flow in one direction through the pump.

INSTALLATION AND START-UP

Locate the pump as close to the product being pumped as possible. Keep the suction line length and number of fittings to a minimum. Do not reduce the suction line diameter.

For installations of rigid piping, short sections of flexible hose should be installed between the pump and the piping. The flexible hose reduces vibration and strain to the pumping system. A Warren Rupp Tranquillizer® surge suppressor is recommended to further reduce pulsation in flow.

AIR SUPPLY

Air supply pressure cannot exceed 125 psi (8.6 bar). Connect the pump air inlet to an air supply of sufficient capacity and pressure required for desired performance. When the air

supply line is solid piping, use a short length of flexible hose not less than 1/2" (13mm) in diameter between the pump and the piping to reduce strain to the piping. The weight of the air supply line, regulators and filters must be supported by some means other than the air inlet cap. Failure to provide support for the piping may result in damage to the pump. A pressure regulating valve should be installed to insure air supply pressure does not exceed recommended limits.

AIR VALVE LUBRICATION

The air distribution valve and the pilot valve are designed to operate WITHOUT lubrication. This is the preferred mode of operation. There may be instances of personal preference or poor quality air supplies when lubrication of the compressed air supply is required. The pump air system will operate with properly lubricated compressed air supply. Proper lubrication requires the use of an air line lubricator (available from Warren Rupp) set to deliver one drop of SAE 10 non-detergent oil for every 20 SCFM (9.4 liters/sec.) of air the pump consumes at the point of operation. Consult the pump's published Performance Curve to determine this.

AIR LINE MOISTURE

Water in the compressed air supply can create problems such as icing or freezing of the exhaust air, causing the pump to cycle erratically or stop operating. Water in the air supply can be reduced by using a point-of-use air dryer

to supplement the user's air drying equipment. This device removes water from the compressed air supply and alleviates the icing or freezing problems.

AIR INLET AND PRIMING

To start the pump, open the air valve approximately 1/2" to 3/4" turn. After the pump primes, the air valve can be opened to increase air flow as desired. If opening the valve increases cycling rate, but does not increase the rate of flow, cavitation has occurred. The valve should be closed slightly to obtain the most efficient air flow to pump flow ratio.

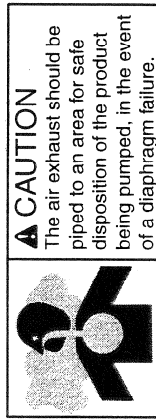
BETWEEN USES

When the pump is used for materials that tend to settle out or solidify when not in motion, the pump should be flushed after each use to prevent damage. (Product remaining in the pump between uses could dry out or settle out. This could cause problems with the diaphragms and check valves at restart.) In freezing temperatures the pump must be completely drained between uses in all cases.



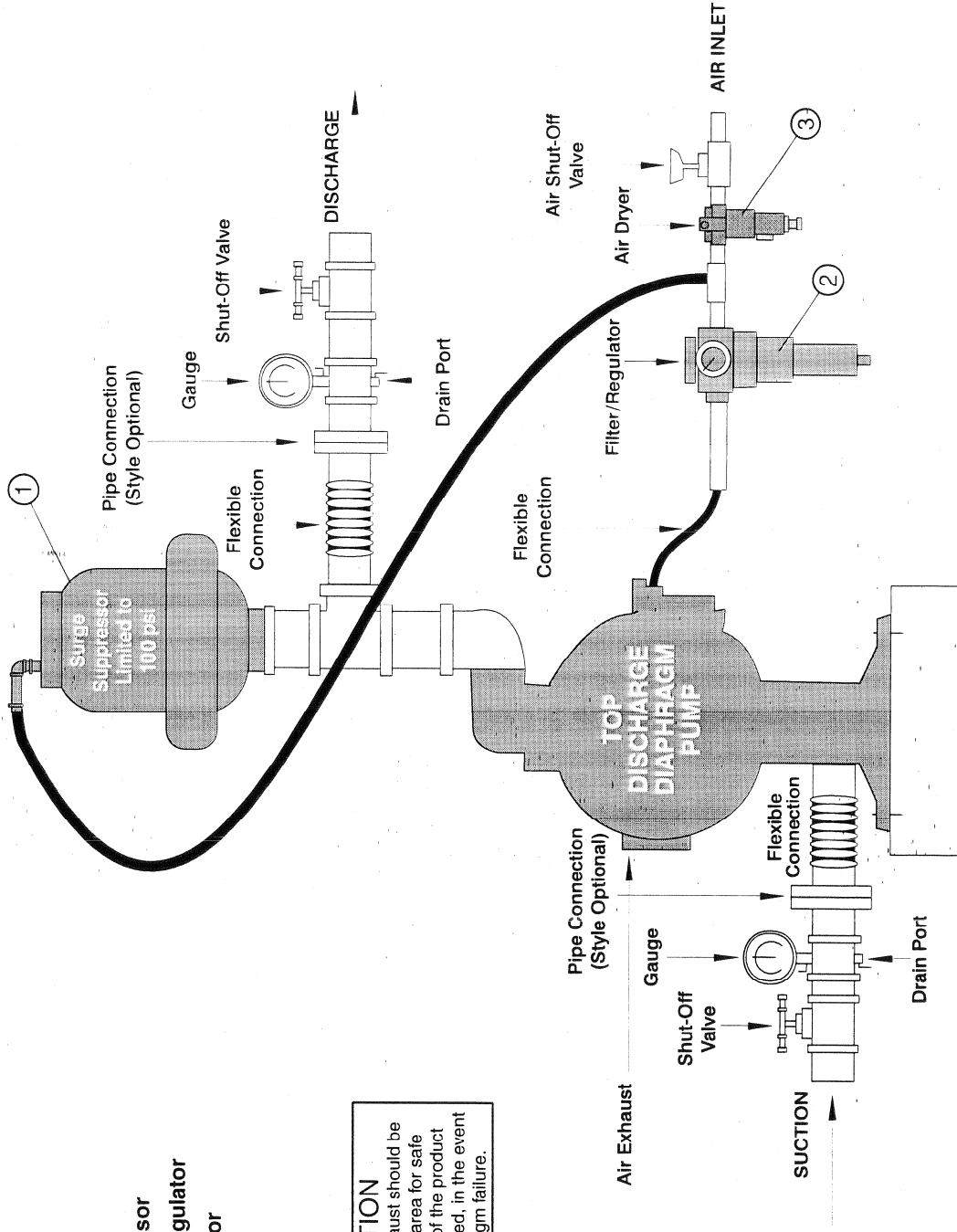
Available from
Warren Rupp

- ① DA05 Surge Suppressor
- ② 020-049-000 Filter/Regulator
- ③ 020-049-001 Lubricator



CAUTION

The air exhaust should be piped to an area for safe disposition of the product being pumped, in the event of a diaphragm failure.



TROUBLESHOOTING

Possible Symptoms:

- Pump will not cycle.
- Pump cycles, but produces no flow.
- Pump cycles, but flow rate is unsatisfactory.
- Pump cycle seems unbalanced.
- Pump cycle seems to produce excessive vibration.

What to Check: Excessive suction lift in system.

Corrective Action: For lifts exceeding 20 feet (6 meters), filling the pumping chambers with liquid will prime the pump in most cases.

What to Check: Excessive flooded suction in system.

Corrective Action: For flooded conditions exceeding 10 feet (3 meters) of liquid, install a back pressure device.

What to Check: System head exceeds air supply pressure.

Corrective Action: Increase the inlet air pressure to the pump. Most diaphragm pumps are designed for 1:1 pressure ratio at zero flow.

What to Check: Air supply pressure or volume exceeds system head.

Corrective Action: Decrease inlet air pressure and volume to the pump as calculated on the published PERFORMANCE CURVE. Pump is cavitating the fluid by fast cycling.

What to Check: Undersized suction line.

Corrective Action: Meet or exceed pump connection recommendations shown on the DIMENSIONAL DRAWING.

What to Check: Restricted or undersized air line.

Corrective Action: Install a larger air line and connection. Refer to air inlet recommendations shown in your pump's SERVICE MANUAL.

What to Check: Check ESADS, the Externally Serviceable Air Distribution System of the pump.

Corrective Action: Disassemble and inspect the main air distribution valve, pilot valve and pilot valve actuators. Refer to the parts drawing and air valve section of the SERVICE MANUAL. Check for clogged discharge or closed valve before reassembly.

What to Check: Rigid pipe connections to pump.

Corrective Action: Install flexible connectors and a Warren Rupp Tranquillizer® Surge Suppressor.

What to Check: Blocked air exhaust muffler.

Corrective Action: Remove muffler screen, clean or de-ice and reinstall. Refer to the Air Exhaust section of your pump SERVICE MANUAL.

What to Check: Pumped fluid in air exhaust muffler.

Corrective Action: Disassemble pump chambers. Inspect for diaphragm rupture or loose diaphragm plate assembly. Refer to the Diaphragm Replacement section of your pump SERVICE MANUAL.

What to Check: Suction side air leakage or air in product.

Corrective Action: Visually inspect all suction side gaskets and pipe connections.

What to Check: Obstructed check valve.

Corrective Action: Disassemble the wet end of the pump and manually dislodge obstruction in the check valve pocket. Refer to the Check Valve section of the pump SERVICE MANUAL for disassembly instructions.

What to Check: Worn or misaligned check valve or check valve seat.

Corrective Action: Inspect check valves and seats for wear and proper seating. Replace if necessary. Refer to Check Valve section of the pump SERVICE MANUAL for disassembly instructions.

What to Check: Blocked suction line.

Corrective Action: Remove or flush obstruction. Check and clear all suction screens and strainers.

What to Check: Blocked discharge line.

Corrective Action: Check for obstruction or closed discharge line valves.

What to Check: Blocked pumping chamber.

Corrective Action: Disassemble and inspect the wetted chambers of the pump. Remove or flush any obstructions. Refer to the pump SERVICE MANUAL for disassembly instructions.

What to Check: Entrained air or vapor lock in one or both pumping chambers.

Corrective Action: Purge chambers through tapped chamber vent plugs. PURGING THE CHAMBERS OF AIR CAN BE DANGEROUS! Contact the Technical Services Department before performing this procedure. Any model with top-ported discharge will reduce or eliminate problems with entrained air. If your pump continues to perform below your expectations, contact your local Distributor or factory Technical Services Group for a service evaluation.

Recycling

Many components of Non-Metallic AODD pumps are made of recyclable materials (see chart on page 10 for material specifications). We encourage pump users to recycle worn out parts and pumps whenever possible, after any hazardous pumped fluids are thoroughly flushed.

Important Safety Information



IMPORTANT

Read these safety warnings and instructions in this manual completely, before installation and start-up of the pump. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.



WARNING

Take action to prevent static sparking. Fire or explosion can result, especially when handling flammable liquids. The pump, piping, valves, containers or other miscellaneous equipment must be grounded.



WARNING

This pump is pressurized internally with air pressure during operation. Always make certain that all bolting is in good condition and that all of the correct bolting is reinstalled during assembly.



CAUTION

Before pump operation, inspect all gasketed fasteners for looseness caused by gasket creep. Re-torque loose fasteners to prevent leakage. Follow recommended torques stated in this manual.



WARNING

When used for toxic or aggressive fluids, the pump should always be flushed clean prior to disassembly.



WARNING

Before maintenance or repair, shut off the compressed air line, bleed the air line from the pump, and disconnect the discharge line. The discharge line may be pressurized and must be bled of its pressure.



WARNING

Before doing any maintenance on the pump, be certain all pressure is completely vented from the pump, suction, discharge, piping, and all other openings and connections. Be certain the air supply is locked out or made non-operational, so that it cannot be started while work is being done on the pump. Be certain that approved eye protection and protective clothing are worn all times in the vicinity of the pump. Failure to follow these recommendations may result in serious injury or death.



WARNING

In the event of diaphragm rupture, pumped material may enter the air end of the pump, and be discharged into the atmosphere. If pumping a product which is hazardous or toxic, the air exhaust must be piped to an appropriate area for safe disposition.



WARNING

Airborne particles and loud noise hazards. Wear ear and eye protection.

Material Codes

The Last 3 Digits of Part Number

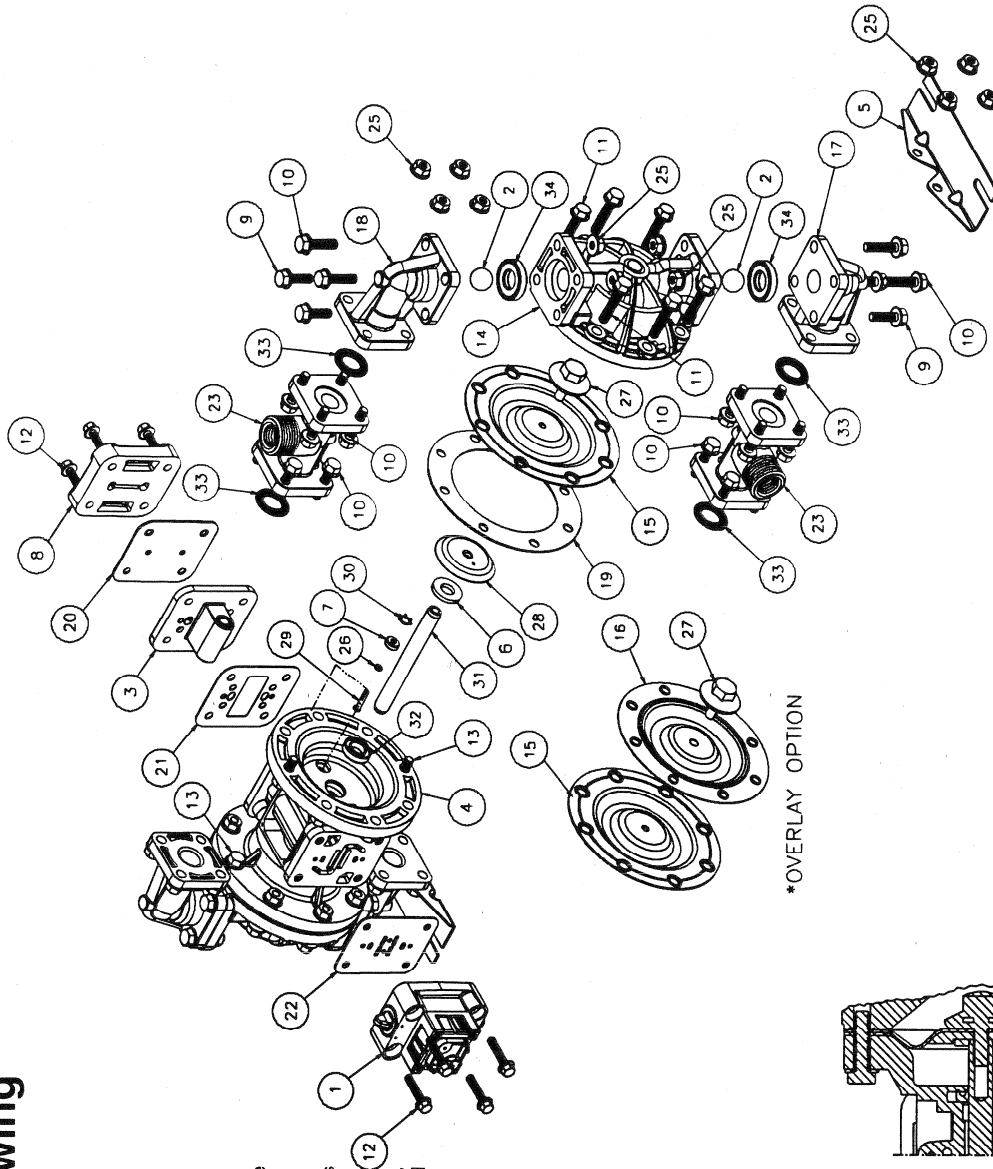
000	Assembly, sub-assembly, and some purchased items	
010	Cast Iron	
012	Powdered Metal	
015	Ductile Iron	
020	Ferritic Malleable Iron	
025	Music Wire	
080	Carbon Steel, AISI B-1112	
100	Alloy 20	
110	Alloy Type 3-6 Stainless Steel	
111	Alloy Type 316 Stainless Steel (Electro Polish ^{td})	
112	Alloy "C" (Hastelloy equivalent)	
113	Alloy Type 316 Stainless Steel (Hand Polished)	
114	303 Stainless Steel	
115	302/304 Stainless Steel	
117	440-C Stainless Steel (Martensitic)	
120	416 Stainless Steel (Wrought Martensitic)	
123	410 Stainless Steel (Wrought Martensitic)	
148	Hardcoat Anodized Aluminum	
149	2024-T4 Aluminum	
150	6061-T6 Aluminum	
151	6063-T6 Aluminum	
152	2024-T4 Aluminum (2023-T351)	
154	Almag 35 Aluminum	
155	356-T6 Aluminum	
156	356-T6 Aluminum	
157	Die Cast Aluminum Alloy #380	
158	Aluminum Alloy SR-319	
159	Anodized Aluminum	
162	Brass, Yellow, Screw Machine Stock	
165	Cast Bronze, 85-5-5-5	
166	Bronze, SAE 660	
170	Bronze, Bearing Type, Oil Impregnated	
175	Die Cast Zinc	
180	Copper Alloy	
305	Carbon Steel, Black Epoxy Coated	
306	Carbon Steel, Black PTFE Coated	
307	Aluminum, Black Epoxy Coated	
308	Stainless Steel, Black PTFE Coated	
309	Aluminum, Black PTFE Coated	
310	Kynar Coated	
330	Zinc Plated Steel	
331	Chrome Plated Steel	
332	Aluminum, Electroless Nickel Plated	
333	Carbon Steel, Electroless Nickel Plated	
335	Galvanized Steel	
336	Zinc Plated Yellow Brass	
337	Silver Plated Steel	
340	Nickel Plated	
342	Filled Nylon	
353	Geolast; Color: Black	
354	Injection Molded #203-40 Santoprene; Duro 40D +/-5; Color: RED	
355	Thermal Plastic	
356	Hytrel	
357	Injection Molded Polyurethane	
358	Urethane Rubber (Some Applications) (Compression Mold)	
359	Urethane Rubber	
360	Buna-N Rubber, Color coded: RED	
361	Buna-N	
363	Viton (Fluorel), Color coded: YELLOW	
364	E.P.D.M. Rubber, Color coded: BLUE	
365	Neoprene Rubber, Color coded: GREEN	
366	Food Grade Nitrile	
368	Food Grade EPDM	
370	Butyl Rubber, Color coded: BROWN	
371	Phithane (Turthane)	
374	Carboxylated Nitrile	
375	Fluorinated Nitrile	
378	High Density Polypropylene	
405	Cellulose Fibre	
408	Cork and Neoprene	
425	Compressed Fibre	
426	Blue Gard	
440	Vegetable Fibre	
465	Fibre	
500	Delrin 500	
501	Delrin 570	
502	Conductive Acetal, ESD-830	
503	Conductive Acetal, Glass-Filled	
505	Acrylic Resin Plastic	
506	Delrin 150	
520	Injection Molded PVDF Natural color	
540	Nylon	
541	Nylon	
542	Nylon	
544	Nylon Injection Molded	
550	Polyethylene	
551	Glass Filled Polypropylene	
552	Unfilled Polypropylene	
553	Unfilled Polypropylene	
555	Polyvinyl Chloride	
556	Black Vinyl	
570	Rulon II	
580	Ryton	
590	Valox	
591	Nylatron G-S	
592	Nylatron NSB	
600	PTFE (virgin material) Tetrafluorocarbon (TFE)	
601	PTFE (Bronze and moly filled)	
602	Filled PTFE	
603	Blue Gylon	
604	PTFE	
607	Envelon	
606	PTFE	
610	PTFE Encapsulated Silicon	
611	PTFE Encapsulated Viton	
632	Neoprene/Hytrel	
633	Vilon/PTFE	
634	EPDM/PTFE	
635	Neoprene/PTFE	
637	PTFE, Viton/PTFE	
638	PTFE, Hytrel/PTFE	
639	Buna-N/TFE	
643	Santoprene [®] /EPDM	
644	Santoprene [®] /PTFE	
656	Santoprene Diaphragm and Check Balls/EPDM Seats	
661	EPDM/Santoprene	

Delrin, Viton and Hytrel are registered trademarks of E.I. DuPont.
 Gylon is a registered trademark of Garlock, Inc.
 Nylatron is a registered trademark of Polymer Corp.
 Santoprene is a registered trademark of Monsanto Corp.
 Rulon II is a registered trademark of Dixon Industries Corp.
 Hastelloy-C is a registered trademark of Cabot Corp.
 Rylon is a registered trademark of Phillips Chemical Co.
 Valox is a registered trademark of General Electric Co.

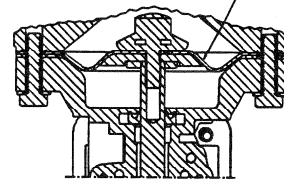
Composite Repair Parts Drawing

Available Service And Conversion Kits

- | | |
|-------------|--|
| Updated TBA | AIR END KIT
Seals, O-ring, Gaskets, Retaining Rings, Air Valve Assembly, and Pilot Valve Assembly |
| 271871 | WET END KIT
Buna Diaphragms, Buna Check Balls, PTFE Seats and PTFE Seals |
| 271873 | WET END KIT
Santoprene Diaphragms, Nitrile Spacer Gaskets, Santoprene Check Balls, PTFE Seats and PTFE Seals |
| 271872 | WET END KIT
Santoprene Diaphragms, PTFE Overlay Diaphragm, PTFE Check Balls, PTFE Seats and PTFE Seals |



*OVERLAY OPTION



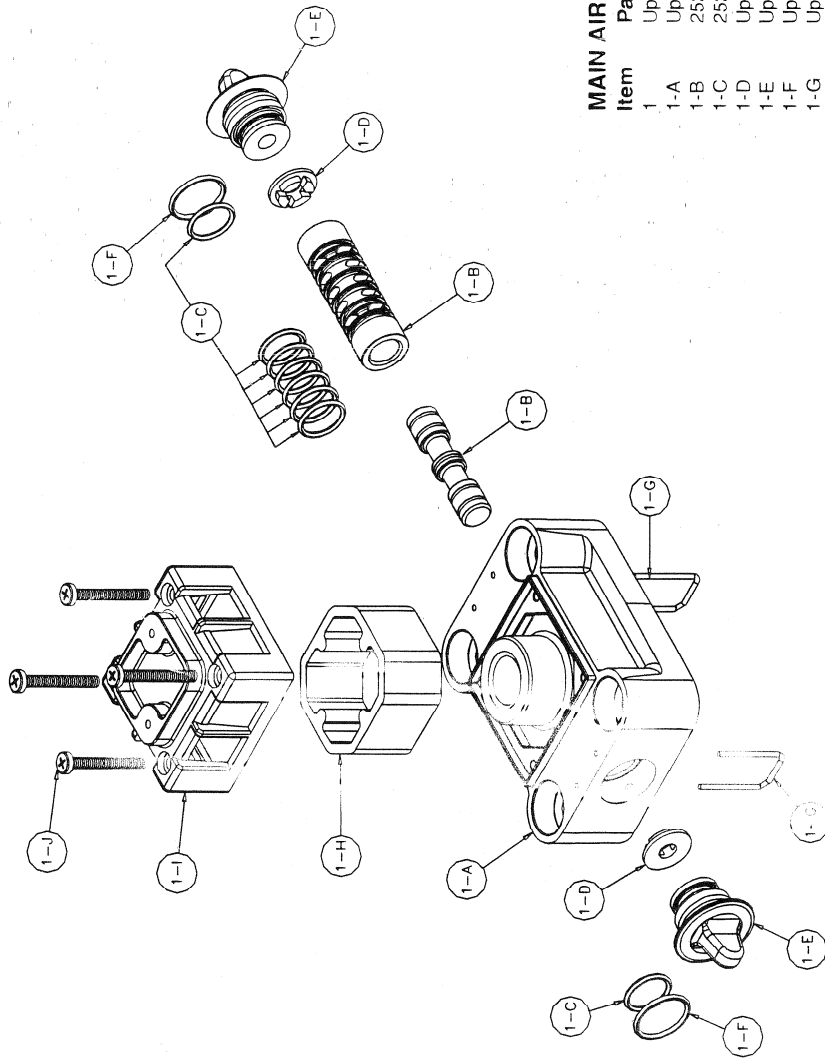
DIAPHRAGM CONFIGURATION DETAIL

NOTE TO ASSEMBLY
THE DIAPHRAGMS FOR BOTH
CONFIGURATIONS SHOWN ABOVE ARE TO BE
INSTALLED WITH CHECK BALLS FACING
TOWARDS CENTER OF PUMP.

Composite Repair Parts List

ITEM	DESCRIPTION	QTY	MODEL 85623	MODEL 85622	MODEL 85626
1	Air Valve Assembly	1	Updated TBA	Updated TBA	Updated TBA
2	Ball, Check	4	252896 PTFE	252895 Santoprene	272208
3	Pilot Valve Assembly	1	252897	252897	252897
4	Intermediate Assembly	1	271986	271986	271986
5	Bracket, Mounting	2	271996	271996	271996
6	Bumper, Diaphragm	2	252900	252900	252900
7	Bushing, Plunger	2	252901	252901	252901
8	Cap, Air Inlet	1	271987	271987	271987
9	Capscrew, Flanged 5/16-18 x 1.00	8	271988	271988	271988
10	Capscrew, Flanged 5/16-18 x 1.25	24	271989	271989	271989
11	Capscrew, Flanged 5/16-18 x 1.50	12	271990	271990	271990
12	Capscrew, Flanged 1/4-20 x 1.25	8	271991	271991	271991
13	Capscrew, Flanged 5-16-18 x .88	4	271992	271992	271992
14	Chamber, Outer	2	271985	271985	271985
15	Diaphragm	2	252907	252907	271865
16	Diaphragm, Overlay	2	252908		
17	Elbow, Suction	2	252909	252909	252909
18	Elbow, Discharge	2	271994	271994	271994
19	Gasket, Spacer	2	252910	252910	252910
20	Gasket, Air Inlet	1	252911	252911	252911
21	Gasket, Pilot Valve	1	252912	252912	252912
22	Gasket, Air Valve	1	252913	252913	252913
23	Manifold	2	252914	252914	252914
25	Nut, Hex 5/16-13"	36	271993	271993	271993
26	O-Ring	2	240655	240655	240655
27	Plate, Outer Diaphragm	2	240768	240768	240768
28	Plate, Inner Diaphragm	2	252917	252917	252917
29	Plunger, Actuator	2	252918	252918	252918
30	Ring, Retaining	2	240717	240717	240717
31	Rod, Diaphragm	1	252920	252920	252920
32	Seal, Diaphragm Rod	2	252921	252921	252921
33	Seal, Manifold	4	252922	252922	252922
34	Seat, Check Valve	4	271995	271995	271995

Air Distribution Valve Assembly Drawing



MAIN AIR VALVE ASSEMBLY PARTS LIST

Item	Part Number	Description	Qty
1	Updated TBA	Air Valve Assembly	1
1-A	Updated TBA	Body, Air Valve	1
1-B	252929	Sleeve and Spool Set	1
1-C	252927	O-Ring	8
1-D	Updated TBA	Bumper	2
1-E	Updated TBA	End Cap	2
1-F	Updated TBA	O-Ring	2
1-G	Updated TBA	End Cap Retainer	2
1-H	Updated TBA	Muffler	1
1-I	252931	Muffler Cap	1
1-J	252932	Self-Tapping Screw	4

AIR DISTRIBUTION VALVE SERVICING

To service the air valve first shut off the compressed air, bleed pressure from the pump, and disconnect the air supply line from the pump.

Step #1: See COMPOSITE REPAIR PARTS DRAWING.

Using a 3/8" wrench or socket, remove the four hex flanged capscrews (item 12). Remove the air valve assembly from the pump.

Step #2: Disassembly of the air distribution valve.

To access the internal air valve components first remove the two end cap retainers (item 1-G) by inserting a small flat screwdriver into the two slotted grooves on the valve body and gently lifting the retainers out.

Next remove the two end caps (item 1-E) by grasping the pull tab with finger and thumb or pliers and tugging. Inspect the two o-rings (items 1-C and 1-F) on each end cap for wear or cuts. Replace the o-rings if necessary.

Remove the two bumpers (items 1-D) and inspect for wear or damage. Be careful not to scratch or damage the outer diameter of the spool. Wipe spool with a soft cloth and inspect for scratches or wear.

Remove the spool (part of item 1-B) from the sleeve. Be careful not to scratch or damage the outer diameter of the spool. Wipe the spool with a soft clean cloth and inspect for scratches or abrasive wear.

Inspect the inner diameter of the sleeve (part of item 1-B) for dirt, scratches, or other contaminants. Remove the sleeve if needed and replace with a new sleeve and spool set (item 1-B). **Note:** The sleeve and spool set is match-ground to a specified clearance. Sleeves and spools cannot be interchanged.

Step #3: Reassembly of the air distribution valve.

Install one bumper (item 1-D) and one end cap with o-rings (items 1-E, 1-C, and 1-F) into one end of the air valve body (item 1-A). Insert one end cap retainer (item 1-G) into the two smaller holes, align with groove in the end cap, and push until the closed end of the retainer is below the flat surface of the valve body.

Remove the new sleeve and spool set (item 1-B) from the plastic bag. Carefully remove the spool from the sleeve. Install the six o-rings (item 1-C) into the six grooves on the sleeve. Apply a light coating of grease to the o-rings before installing the sleeve into the valve body, align the slots in the sleeve with the slots in the valve body. Insert the spool into the sleeve. Be careful not to scratch or damage the spool during installation. Push the spool in until it touches the bumper on the opposite end.

Install the remaining bumper, end cap with o-rings, and retainer.

Fasten the air valve assembly (item 1) and gasket (item 22) to the pump, using the four hex flanged capscrews (item 12).

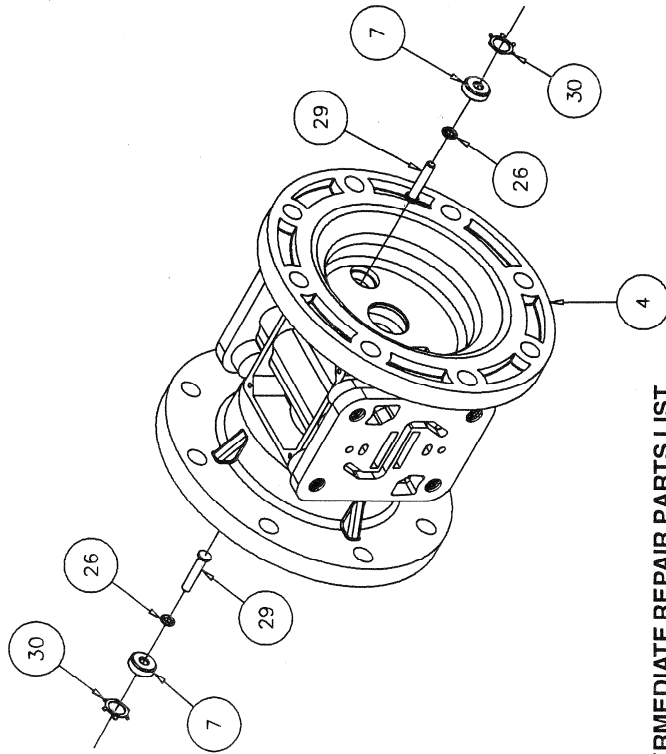
Connect the compressed air line to the pump. The pump is now ready for operation.

IMPORTANT



Read these instructions completely, before installation and start-up. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.

Intermediate Assembly Drawing



INTERMEDIATE REPAIR PARTS LIST

Item	Part Number	Description	Qty
4	271986	Bracket, Intermediate	1
7	252901	Bushing, Plunger	2
26	240655	O-Ring	2
29	252918	Plunger, Actuator	2
30	240717	Ring, Retaining*	2

*Note: It is recommended that when plunger components are serviced, new retaining rings be installed.

Intermediate Assembly Servicing

ACTUATOR PLUNGER SERVICING

To service the actuator plunger first shut off the compressed air supply, bleed the pressure from the pump, and disconnect the air supply line from the pump.

Step #1: See PUMP ASSEMBLY DRAWING.

Using a 3/8" wrench or socket, remove the four capscrews (items 12). Remove the air inlet cap (item 8) and air inlet gasket (item 20). The pilot valve assembly (item 3) can now be removed.

Step #2: Servicing the actuator plungers.

See PUMP ASSEMBLY DRAWING. The actuator plungers (items 29) can be reached through the stem cavity of the pilot valve in the intermediate bracket (item 4). To service bushings, o-rings and retaining rings, see Intermediate Drawing.

Remove the plungers (items 29) from the bushings (item 7) in each end of the intermediate cavity. Inspect for wear or damage. Replace plunger as needed. Apply a light coating of grease to each o-ring and re-install the plungers in to the bushings. Push the plungers in as far as they will go.

Step #3: Re-install the pilot valve assembly into the intermediate assembly.

Be careful to align the ends of the stem between the plungers when inserting the stem of the pilot valve into the cavity of the intermediate.

Re-install the gasket (item 20), air inlet cap (item 8) and capscrews (items 12).

Connect the air supply to the pump. The pump is now ready for operation.

PLUNGER BUSHING, O-RING, AND RETAINING RING SERVICING

To service the plunger bushing components first remove the two retaining rings (items 30) using a small flat screwdriver. *Note: It is recommended that new retaining rings be installed.

Next remove the two plunger bushings (items 7). Inspect the bushings for wear or scratches. Replace the bushings as necessary.

Inspect the two o-rings (26) for cuts and/or wear.

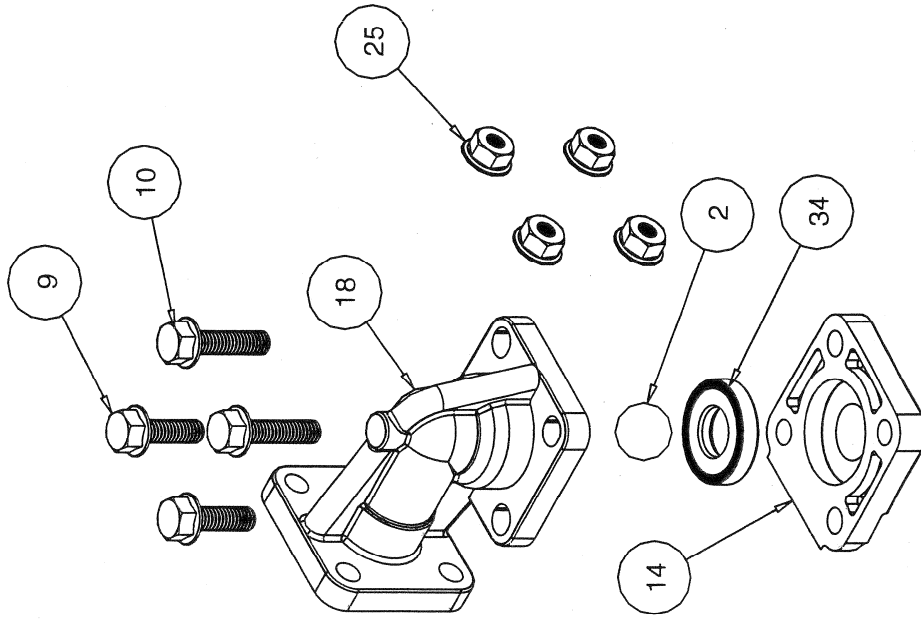


IMPORTANT

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Check Ball Valve Drawing



MODULAR CHECK BALL VALVE SERVICING

Before servicing the check valves, first shut off the suction line and then the discharge line to the pump. Next, shut off the compressed air supply, bleed air pressure from the pump, and disconnect the air supply line from the pump. Drain any remaining fluid from the pump. The pump can now be removed for service.

To access the modular check valve, remove the elbows (items 17 and 18 from pump composite repair parts drawing). Use a 1/2" wrench or socket to remove the fasteners. Once the elbows are removed, the modular check valves can be seen in the cavities of the outer chamber (items 14).

Inspect the check balls (items 2) for wear, abrasion, or cuts on the spherical surface. The check valve seats (items 34) should be inspected for cuts, abrasive wear, or embedded material on the surfaces of both the external and internal chamfers. The spherical surface of the check balls must seat flush to the surface of the inner chamfer on the check valve seats for the pump to operate to peak efficiency. Replace any worn or damaged parts as necessary.

RE-ASSEMBLE THE CHECK VALVE

Place a check ball (item 2) in the ball cage of either the discharge elbow or the outer chamber. Install a check valve seat in the counter on each end of the chamber. Refasten the elbows to the chamber.

IMPORTANT

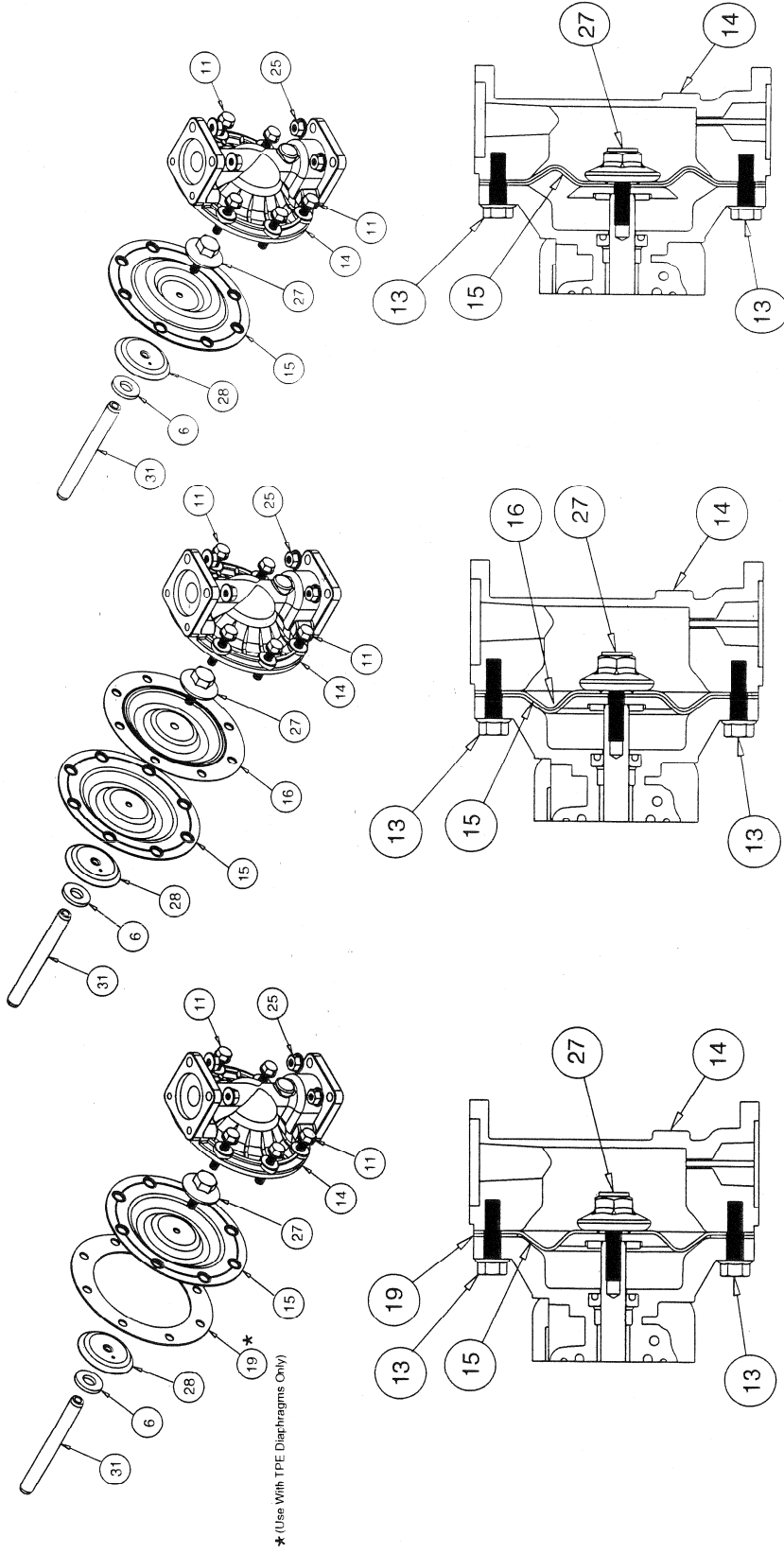


Read these instructions completely, before installation and start-up. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.

Diaphragm Service Drawing

**Diaphragm Service Drawing,
with Overlay**

**Diaphragm Service Drawing
with uniRupp®**



* (Use With TPE Diaphragms Only)

Diaphragm Orientation
Install diaphragm and spacer
as shown above.

Diaphragm Orientation
Install diaphragm and overlay
as shown above.

Diaphragm Orientation
Install diaphragm (286-095-650 only)
as shown above.

DIAPHRAGM SERVICING

To service the diaphragms first shut off the suction, then shut off the discharge lines to the pump. Shut off the compressed air supply, bleed the pressure from the pump, and disconnect the air supply line from the pump. Drain any remaining liquid from the pump.

Step #1: See the pump composite repair parts drawing, and the diaphragm servicing illustration.

Using a 1/2" wrench or socket, remove the 16 capscrews (items 9 & 10), and flanged nuts that fasten the elbows (items 17 and 18) to the outer chambers (items 14). Remove the elbows with the manifolds and spacers attached.

Step #2: Removing the outer chambers.

Using a 1/2" wrench or socket, remove the 16 capscrews (items 11 and 13), and flanged nuts that fasten the outer chambers, diaphragms, and intermediate (item 4) together.

Step #3: Removing the diaphragm assemblies.

Use a 3/4" (19mm) wrench or six pointed socket to remove the diaphragm assemblies (outer plate, diaphragm, and inner plate) from the diaphragm rod (item 31) by turning counterclockwise.

Insert a 6-32 set screw into the smaller tapped hole in the inner diaphragm plate (item 28). Insert the protruding stud and the 6-32 fastener loosely into a vise. Use a 3/4" wrench or socket to remove the outer diaphragm

plate (item 27) by turning counterclockwise. Inspect the diaphragm (item 15) for cuts, punctures, abrasive wear or chemical attack. Replace the diaphragms if necessary.

Step #4: Installing the diaphragms.

Push the threaded stud of the outer diaphragm plate through the center hole of the diaphragm. Thread the inner plate clockwise onto the stud. Insert the loose assembly with the above 6-32 fastener back into the vise. Use a torque wrench to tighten the diaphragm assembly together to 90 in lbs. (10.17 Newton meters) 120 in lbs. Santoprene (13.56 Newton meters). Allow a minimum of 15 minutes to elapse after torquing, then re-torque the assembly to compensate for stress relaxation in the clamped assembly.

Step #5: Installing the diaphragm assemblies to the pump.

Make sure the bumper (item 6) is installed over the diaphragm rod.

Thread the stud of the one diaphragm assembly clockwise into the tapped hole at the end of the diaphragm rod (item 31) until the inner diaphragm plate is flush to the end of the rod. Insert rod into pump.

Align the bolt holes in the diaphragm with the bolt pattern in the intermediate (item 4).

Fasten the outer chamber (item 14) to the pump, using the capscrews (items 11 and 13) and flanged nuts.

On the opposite side of the pump, pull the diaphragm rod out as far as

possible. Make sure the bumper (item 6) is installed over the diaphragm rod.

Thread the stud of the remaining diaphragm assembly clockwise into the tapped hole at the end of the diaphragm rod (item 31) as far as possible and still allow for alignment of the bolt holes in the diaphragm with the bolt pattern in the inner chamber. Install diaphragms with convolutions facing towards center of pump. See sectional view on previous page.

Fasten the remaining outer chamber (item 14) to the pump, using the capscrews (items 11 and 13) and flanged nuts.

Step #6: Re-install the elbow/spacer/manifold assemblies to the pump, using the capscrews (items 9 & 10) and flanged nuts.

The pump is now ready to be re-installed, connected and returned to operation.

OVERLAY DIAPHRAGM SERVICING

The overlay diaphragm (item 16) is designed to fit snugly over the exterior of the standard TPE diaphragm (item 15).

uniRupp® DIAPHRAGM SERVICING

Follow the same procedures described for the standard diaphragm for removal and installation. **Note:** The uniRupp diaphragm is installed in the direction as shown in the lower right illustration above.

! IMPORTANT



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PUMPING HAZARDOUS LIQUIDS

When a diaphragm fails, the pumped liquid or fumes enter the air end of the pump. Fumes are exhausted into the surrounding environment. When pumping hazardous or toxic materials, the exhaust air must be piped to an appropriate area for safe disposal. See illustration #1 at right.

This pump can be submerged if the pump materials of construction are compatible with the liquid being pumped. The air exhaust must be piped above the liquid level. See illustration #2 at right. Piping used for the air exhaust must not be smaller than 1" (2.54 cm) diameter. Reducing the pipe size will restrict air flow and reduce pump performance. When the pumped product source is at a higher level than the pump (flooded suction condition), pipe the exhaust higher than the product source to prevent siphoning spills. See illustration #3 at right.

CONVERTING THE PUMP FOR PIPING THE EXHAUST AIR

The following steps are necessary to convert the pump to pipe the exhaust air away from the pump.

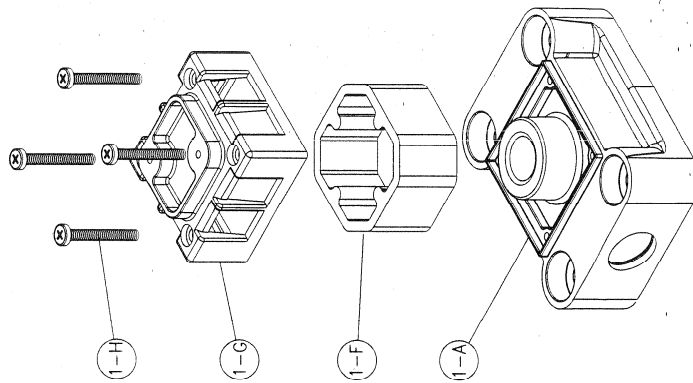
Use a #8 Torx or flat screwdriver to remove the four self-tapping screws (item 1-J) (Plastic Valves). Use a Phillips screwdriver to remove four machine screws (item 1-I) (Aluminum Valves).

Remove the muffler cap and muffler. The air distribution valve body has 1" NPT threads for installation of alternate mesh or sound dampening mufflers or piped exhaust.

IMPORTANT INSTALLATION NOTE:

The manufacturer recommends installing a flexible hose or connection between the pump and any rigid plumbing. This reduces stresses on the molded plastic threads of the air exhaust port. Failure to do so may result in damage to the air distribution valve body.

Any piping or hose connected to the pump's air exhaust port must be physically supported. Failure to support these connections could also result in damage to the air distribution valve body.



CONVERTED EXHAUST ILLUSTRATION

