

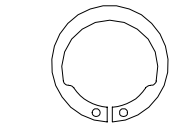
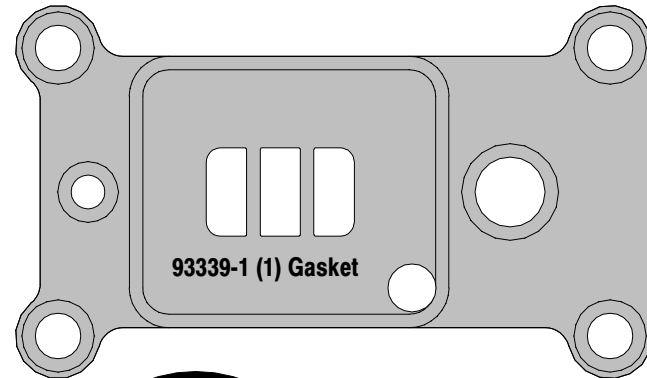
SERVICE KIT

637141

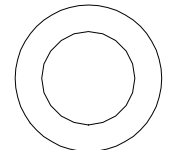
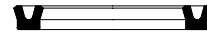
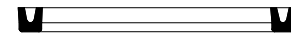
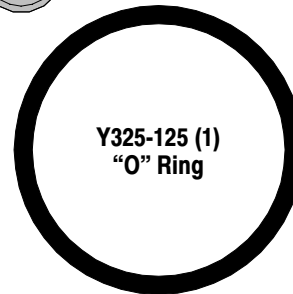
PARTS IDENTIFICATION

Air Section Repair Kit for 1/2" Diaphragm Pumps.

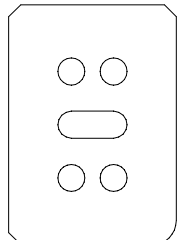
RELEASED: 10-3-97
REVISED: 2-18-05
(REV. C)



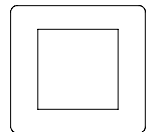
77802 (2) Snap Ring



93075 (4) "O" Ring



93275 (1) Valve Plate



93276 (1) Insert

PARTS LIST / AIR MOTOR SECTION

■ Indicates parts included in 637141 Air Section Service Kit.

Item	Description (size)	Qty	Part No.	Mtl	Item	Description (size)	Qty	Part No.	Mtl
101	Motor Body	(1)			133	Washer (9/32" i.d.)	(4)		
■ 102	"O" Ring (3/32" x 1" o.d.)	(2)	Y325-117	[B]	134	Bolt (1/4" - 20 x 5")	(4)		
103	Sleeve	(1)			135	Valve Block	(1)		
104	Retaining Ring	(2)			136	Plug	(1)		
111	Spool	(1)			■ 137	"O" Ring (3/32" x 1-1/2" o.d.)	(1)	Y325-125	[B]
118	Pilot Rod	(1)			■ 138	"U" Cup (1/8" x 1" o.d.)	(1)	94395	[U]
■ 119	"O" Ring (1/8" x 3/4" o.d.)	(4)	93075	[U]	■ 139	"U" Cup (1/8" x 1.427" o.d.)	(1)	93116	[B]
120	Spacer	(3)			■ 140	Valve Insert	(1)	93276	[CK]
■ 122	Snap Ring (1/2")	(2)	77802	[C]	■ 141	Valve Plate	(1)	93275	[CK]
129	Muffler Assembly	(1)			142	Washer	(2)		
■ 130	Gasket	(1)	93107	[SY]	143	Plate	(2)		
131	Bolt (5/16" - 18 x 1-1/4")	(8)				Keylube, "O" ring lubricant	(1)	93706-1	
■ 132	Gasket (see note #1)	(1)	93339-1	[B]	■				

Note 1: Part No.93339-1 One-Piece Gasket replaces the following parts (not shown) in models manufactured prior to October 1988, Y325-10 (4), Y325-12, 93093, 93094, Y325-8.

AIR MOTOR SECTION SERVICE

Service is divided into two parts - 1. Pilot Valve, 2. Major Valve.
• Air Motor Section Service is continued from Fluid Section repair.

PILOT VALVE DISASSEMBLY

1. Remove (122) and (104) snap rings.
2. Remove (143) plates.
3. Remove (103) sleeve and (102) "O" rings.
4. Remove (118) piston, (142) washers, (119) "O" rings and (120) spacers from (101) center body.

PILOT VALVE REASSEMBLY

1. Assemble (119) "O" rings, (120) spacers and (142) washers on (118) pilot rod.
2. Insert the stack into the (101) body. Sleeve (103) may be used to assist pressing stack into body.
3. Install (103) sleeve and (102) "O" rings into (101) body.
4. Install (143) plates and (122) and (104) snap rings.

MATERIAL CODE

[B] = Nitrile [CK] = Ceramic [U] = Polyurethane
[C] = Carbon Steel [SY] = Syn-Seal

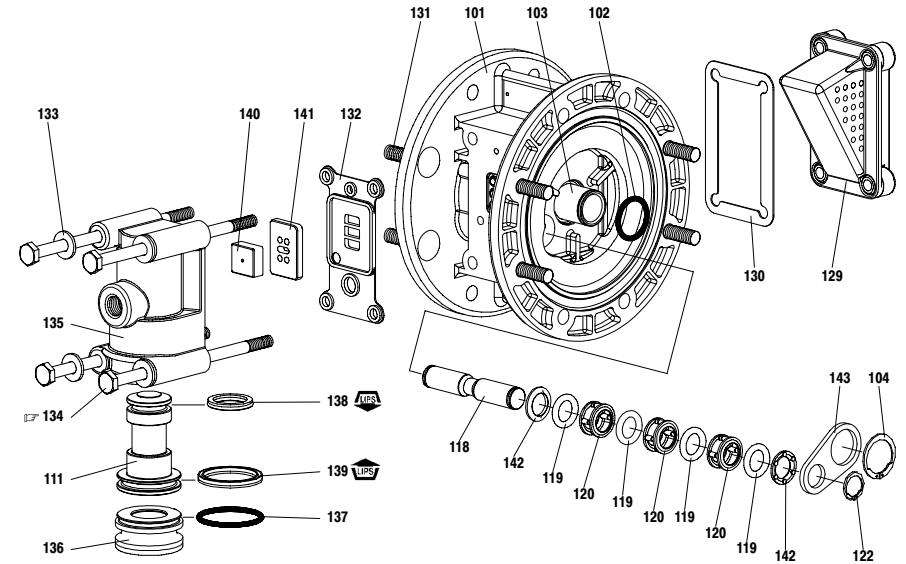
MAJOR VALVE DISASSEMBLY

1. Remove (129) exhaust cover and (130) gasket.
2. Pull (135) valve block assembly from (101) body.
3. Remove (134) bolts, (133) washers and (132) gasket from (135) valve block.
4. Remove (141) valve plate and (140) valve insert.
5. Remove (136) plug and (111) spool.

MAJOR VALVE REASSEMBLY

1. Install new (139) and (138) "U" cups on (111) spool - LIPS MUST FACE EACH OTHER.
2. Insert (111) spool into (135) valve block.
3. Install (137) "O" ring on (136) plug, insert plug into (135) valve block.
4. Install (140) valve insert and (141) valve plate into (135) valve block. Note: After 9/92, parts (140 and 141) are white (ceramic), the dished side of the (140) valve insert should be against the shiny face of (141) valve plate for best performance.
5. Replace (132) gasket and install valve block assembly on (101) body.

PARTS LIST / AIR MOTOR SECTION



MAJOR VALVE

PILOT VALVE

TORQUE REQUIREMENTS
NOTE: DO NOT OVERTIGHTEN FASTENERS.
(134) Torque to 15 - 20 in. lbs (1.7 - 2.3 Nm), wait 10 minutes, then re-torque to 15 - 20 in. lbs (1.7 - 2.3 Nm).
LUBRICATION / SEALANTS
Apply Keylube to all "O" rings, "U" Cups & mating parts.