

DESCRIPTION	PN	QTY	DESCRIPTION	QTY
<b>KIT A, 112T, BUNA</b>	10001		<b>KIT B, BUNA</b>	10004
<b>KIT A, 112T, VITON</b>	10005		<b>KIT B, VITON</b>	10008
Plunger	▲	1	White Washer, 1/2" ID	▲ 8
O-Ring, 1-117	▲	2	Valve Assembly	▲ 4
			O-Ring, 1-116	▲ 4
			Retainer Plate	* 2
			Pump Head	* 2
			Pump Manifold	* 1

(▲) Sold only as part of a kit. | (\*) Not part of a kit, for identification only.

1. Remove pump from motor using a 3/16" hex wrench. Remove bolts from pump. Turn pump over so manifold is facing upward. Place manifold to side as a reference for reassembly.

Figure 1 shows pump separate from motor. Manifold facing upward and set to side.



Figure 1

2. Holding each head, pull them apart to remove plunger. Remove retaining plate from pump head. Remove internal seal parts with finger. Discard parts, but keep head and retaining plate. Figure 2 shows pump heads pulled apart showing plunger, retaining plate and internal seal.

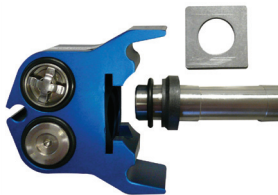


Figure 2

3. Clean the head with a rag or towel. Inspect for damage or excess corrosion. If the head is damaged, do not rebuild. (Note the order and orientation of repair parts prior to installation). Figure 3 shows repair parts in order and in correct orientation.



Figure 3

4. Place O-ring around seal and gently put into seal bore with both thumbs.

5. Place guide into seal bore, level above the O-ring seal assembly. Apply even downward pressure to guide to install seal and guide into seal bore. Remove guide and verify that O-ring and seal are properly installed without bulges or creasing. Slide the retaining plate back into place.



Figure 4

6. Repeat the previous steps 2-5 with the other head.

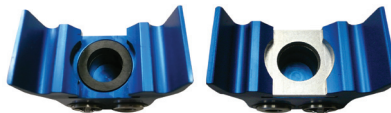


Figure 5

7. Lightly grease the plunger with the clear grease provided in small grey tube. Slide plunger into one head assembly and then slide the other head onto plunger. Place head and plunger assembly on work surface with valves facing upward. Figure 6 shows plunger in one head assembly with other head in position above plunger.

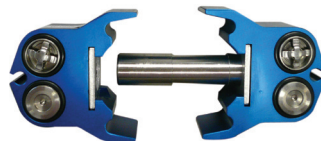


Figure 6

8. Adjust plunger slot position towards center and have slot facing work surface. Replace all valves, O-rings, and 1/2" ID white washers. Refer to image and manifold label to understand proper orientation. Figure 7 shows proper orientation with valves, O-rings and 1/2" ID white washers in place.



Figure 7

9. Place manifold on top of plunger and head assembly. It may be necessary to move heads on plunger to have valves align with valve pockets on manifold. Be careful not to lose the O-rings and valves or the white gaskets in the manifold during reassembly. Figure 8 shows moving heads on plunger to align with valve pockets. You may hear a click when everything is aligned.

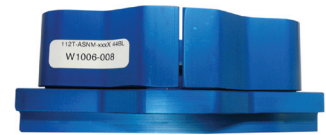


Figure 8

10. Turn assembly over, and place shorter bolts and washer assembly into heads and tighten finger tight. DO NOT tighten completely at this time. Figure 9 shows assembly turned over and shorter bolt and washer in place.

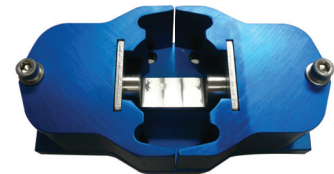


Figure 9

11. Apply **black grease** from supplied packet into corners and center of plunger slot.

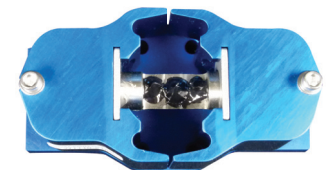


Figure 10

12. Mount pump back onto motor and tighten mounting bolts to 14 in/lbs. of torque. Tighten head bolts to 14 in/lbs. of torque.