

**393550 Kit Contents**

Part No.	Description	Qty.
49801	Copper Crush Gasket, 1/2" O.D.	1
171001-43	"O" Ring, 1/4" I.D. x 7/16" O.D.	1
171009-35	"O" Ring, 1-15/16" I.D. x 2-1/8" O.D.	1
337984	Adapter, 2-41/64" Long	1
337985	Steel Plate	1

**DESCRIPTION**

Repair Kit 393550 contains all the parts necessary to convert the old style seal plate and adapter of air motors 318450, 322740, 332259 and 337140 in Series 7216, 7222 and 7880 pumps. These instructions are intended for use only with this kit. For more information on these pumps, refer to the specific pump instruction sheet.

**GENERAL SAFETY REQUIREMENTS**

Because these units are used in pressurized pumping systems, it is good practice to observe the following precautions at all times:

1. Protect all material and air lines against puncture or damage.
2. Check all hoses and connections for a weak or worn condition prior to daily operation, making certain that all connections and fittings are secure.
3. Never point dispensing device at anyone. Accidental discharge may result in serious injury.
4. Shut off completely and release all pressures before disassembly or removal of any part of pump or equipment attached to it.
5. Do not exceed the pressure rating of any component in the system.
6. Be sure to read ALL instruction sheets and any other explanatory material completely and thoroughly before attempting to assemble, disassemble or operate the pump.

**DISASSEMBLY**

(Figure 1)

**CAUTION:** Before servicing the pump, reduce air-supply and material pressure to zero, disconnect air hose from pump inlet and make sure that all pressures within the system have been relieved.

1. Remove air adapter.
2. Secure air motor on flats of adapter assembly with vise or wrench.
3. Remove cylinder assembly with strap wrench to expose valve and piston assemblies.
4. Remove "O" ring 171009-35 from adapter assembly.
5. Insert screwdriver in slots of screws and hold while unscrewing elastic stop nuts with wrench. Remove seal plate and spacers.
6. Remove screws and gaskets.
7. Grip piston on flats and unscrew adapter. Remove washer B, spacer, spring, washer A, thin washer, rubber packing and thick washer.

**CAUTION:** Do not scratch chrome finish of piston assembly.

8. Remove copper gasket 49801 from piston assembly.

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9. Discard old seal plate, adapter, copper gasket and "O" rings.

**REASSEMBLY**  
(Figure 1)

1. Lubricate new "O" ring 171001-43 and install onto button located on underside of new seal plate 337985 (Fig 1a).
2. Install thick washer, rubber packing, thin washer, washer A, spring, spacer, and washer B onto new adapter 337984.
3. Place the new copper gasket 49801 into the end of the piston assembly.
4. Screw new adapter 337984 into piston assembly.

**CAUTION:** Do not tighten adapter 337984 into piston assembly more than 1/8 turn after it bottoms out. Rubber packing and two washers should rotate freely on adapter.

5. Install seal plate 337985, screws, aluminum gaskets, spacers, and elastic stop nuts.

**NOTE:** Torque elastic stop nuts 23-27 in/lbs.

6. Lubricate new "O" ring 171009-35 with oil and install onto adapter assembly.

7. Screw cylinder assembly onto adapter assembly.

8. Reconnect material line and air supply.

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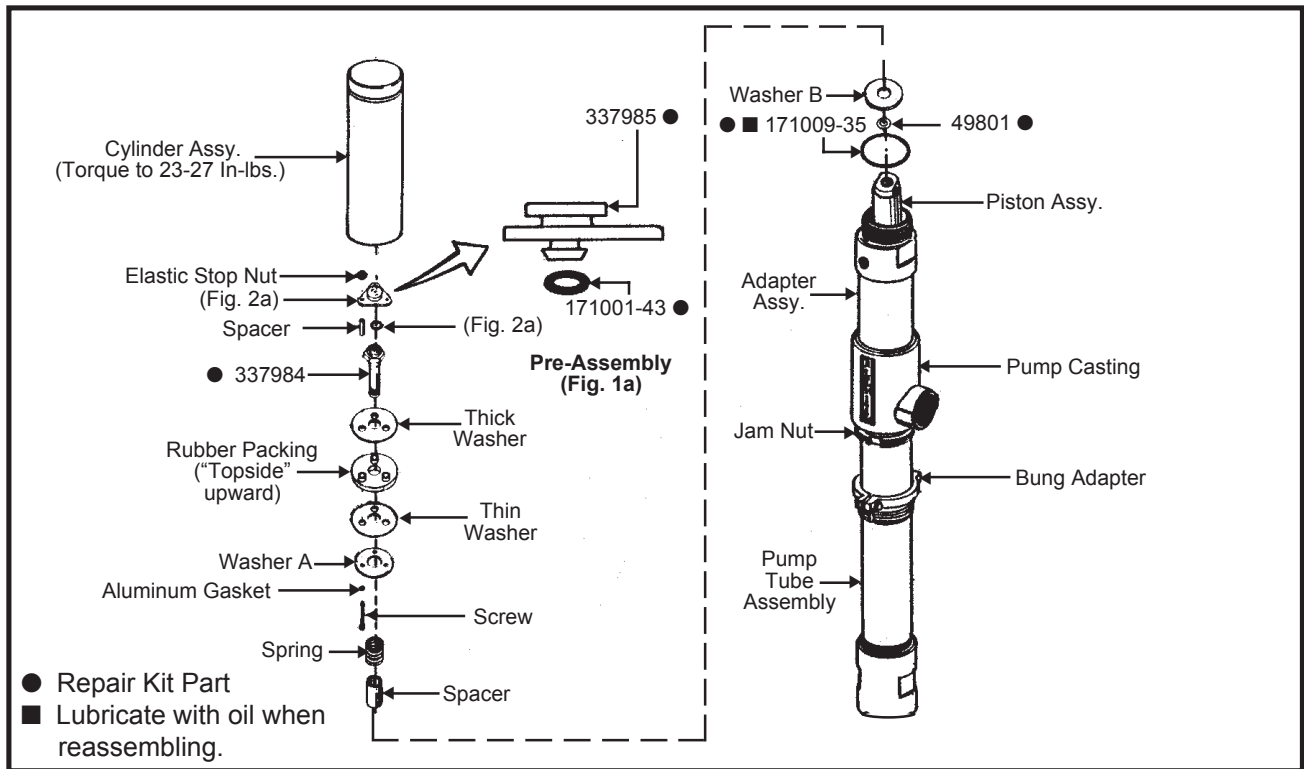


Figure 1: Air-Motor Conversion