

**Major Kit 394747-1 Contents**

Part No.	Description	Qty.
18850	Elastic Stop Nut, 1/4 - 28 UNF	1
46584	Aluminum Gasket, 9/16" I.D. x 41/64" O.D.	1
131398-1	Valve Seat	1
131402	Aluminum Gasket, 1-1/2" I.D. x 1-11/16" O.D.	4
171009-13	"O" Ring, 1-3/16" I.D. x 1-5/16" O.D.	1
171009-33	"O" Ring, 1-13/16" I.D. x 2" O.D.	1
171009-35	"O" Ring, 1-15/16" I.D. x 2-1/8" O.D.	1
171032-8	Roll Pin, 3/32" Dia. x 11/16" long	1
172190-5	Seal, 1-1/16" O.D. and 1/4" thick	1
172190-6	Seal, 1-9/16" O.D. x 3/8" thick	1
172190-13	Seal, 1" O.D. x 1/4" thick	1
172190-14	Seal, 1-5/16" O.D. x 5/16" thick	1
172270-9	Ball, 3/8" Diameter	1
323419	Washer, 7/8" I.D. x 1-19/64" O.D.	1
323693	Aluminum Gasket, 1-29/32" O.D.	2
324274	Bushing	1
324648	Spring Clip	4
326855	Adapter	1
337361	Washer, 1-35/64" O.D.	1
337362	Lantern Ring	1
337363	Steel Spacer, 1-1/16" O.D. x 5/16" thick	1
337462	Steel Spacer, 1-1/2" O.D.	1
337463	Brass Bearing, 1-15/64" O.D.	1
337464	Back-up Ring	1
337465	Wear Ring, 3/8" thick	1
338422	Body	1

**Minor Kit 393623 Contents**

Part No.	Description	Qty.
18850	Elastic Stop Nut	1
46584	Aluminum Gasket	1
131402	Aluminum Gasket	4
171032-8	Roll Pin	1
172190-13	Seal, 21/32" I.D.	1
172190-14	Seal, 15/16" I.D.	1
323693	Aluminum Gasket	2
337463	Brass Bearing	1
337464	Back-up Ring	1
337465	Wear Ring	1

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**DESCRIPTION**

Major Repair Kit 394747-1 contains the necessary parts to overhaul the entire pump tube for the 7775 Series (discontinued) and 7786 Series Lubricant pumps.

Minor Repair Kit 393623 contains parts for the pump-piston and primer-rod sections only.

**SERVICE**

**CAUTION:** Before beginning service on any part of the unit, shut off air supply, reduce material pressure to zero, disconnect air and material supply lines, and remove entire pump from container or system.

**SEPARATING PUMP TUBE FROM BODY AND UPPER PACKING GROUP:**

(Figure 2)

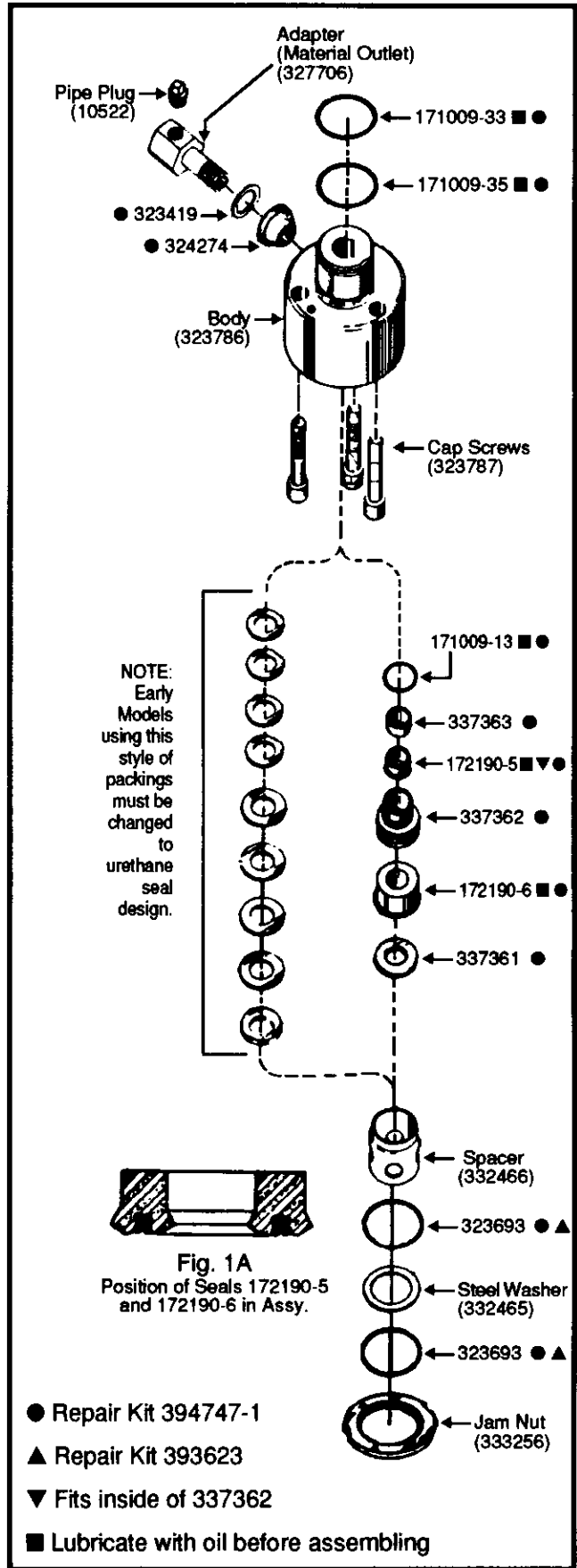
1. Loosen jam nut and unscrew pump-tube assembly from the air-motor to expose upper coupling.
2. Remove upper spring clip from upper coupling.
3. Separate pump tube from body and upper packing group.

**NOTE:** Watch for falling parts from bottom of body.

**SERVICING BODY & UPPER PACKING GROUP:**

(Figure 1)

1. Unscrew and remove adapter 327706 from body of air-motor assembly.
2. Remove washer 323419 and bushing 324274 from adapter.
3. Unscrew three screws 323787 and pull body 323786 from air-motor assembly.
4. Remove "O" rings 171009-33 and 171009-35 from body.
5. From bottom of body, remove gasket 323693, steel washer 332465, second gasket 323693 and spacer 332466.



**Figure 1: Body and Upper Packing Group**

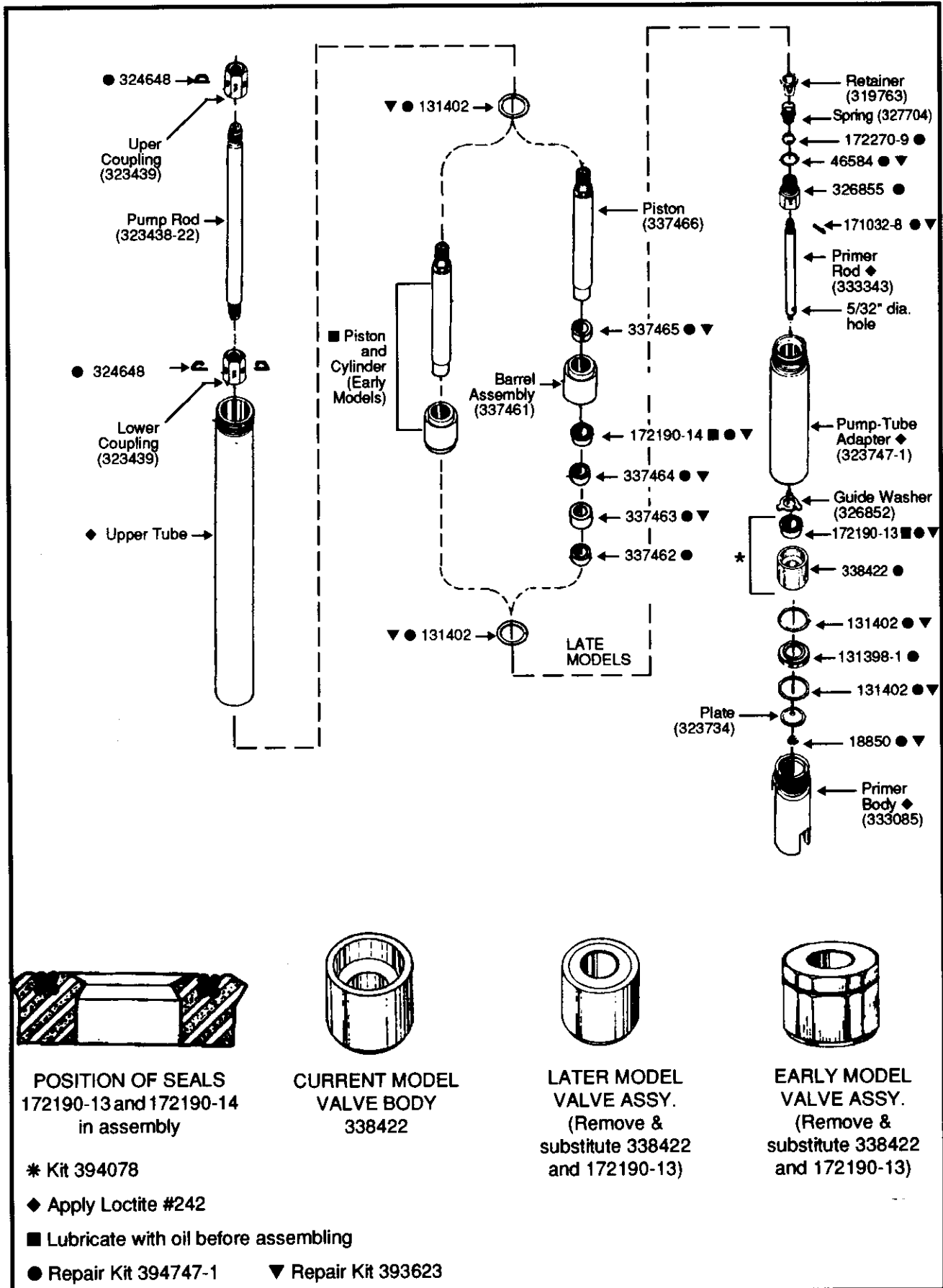


Figure 2: Components of Pump-Tube Assembly

6. Early Models:

Remove the bearing, four packings, the lantern ring, two packings and block "V" packing through the bottom of body.

**NOTE:** Early models using this old style of packings must be changed to the urethane seal design that is supplied in repair kit 394747-1.

6. Later Models:

Remove washer 337361, seal 172190-6, lantern ring 337362, seal 172190-5, spacer 337363, and "O" ring 171009-13 through bottom of body.

**NOTE:** At reassembly, lips of seals 172190-5 and 172190-6 must face downward as shown in Figure 1A.

7. Clean and inspect all parts for wear and damage. Make replacements as required, using repair-kit parts.

8. Reassemble by reversing the above steps.

**IMPORTANT:** Prior to reassembly, lubricate all "O" rings and packings with a light machine oil. Protect all seals and sealing surfaces from damage and scratches in any way possible.

**SERVICING PUMP-TUBE ASSEMBLY:**  
(Figure 2)

**IMPORTANT:** Prior to reassembly, apply Loctite 242 to the threads of upper tube, pump-tube adapter, and primer body.

1. After detaching pump tube from air-motor, remove lower spring clip 324648 from upper coupling 323439 and unscrew coupling from pump rod 323438-22. Place upper tube in a vise, unscrew pump-tube adapter 323747-1 and pull free from assembly.

2. Disengage lower spring clip 324648 from lower coupling 323439 and unscrew from piston-and-cylinder assembly (early models) or piston 337466 (later models).

3. Remove primer body 333085 from pump-tube adapter.

4. Remove stop nut 18850 and plate 323734. Use drift pin in 5/32" hole in primer rod 333343.

5. Remove gasket 131402, valve seat 131398-1 and second gasket 131402.

6. Early and Later Models:

Remove valve assembly and discard.

**NOTE:** Replace with valve body 338422 and seal 172190-13 from the repair kit. See lower portion of Figure 2 (Major Kit only).

6. Current Models:

Remove valve body 338422 and seal 172190-13.

7. Remove guide washer 326852.

8. Pull primer rod 333343 with piston 337466 still attached, through bottom of pump-tube adapter 323747-1 to expose roll pin 171032-8.

9. Drive roll pin out of adapter/insert assembly 326855 with drift pin.

10. Unscrew adapter from piston 337466 and remove ball 172270-9, gasket 46584, spring 327704 and retainer 319763.

11. Pull cylinder (early models) or barrel 337461 (later models) from piston and remove both gaskets 131402. Remove spacer 337462, bearing 337463, back-up ring 337464, seal 172190-14 and wear ring 337465 from barrel assembly 337461.

12. Inspect piston and cylinder for excessive wear. If either piston or cylinder is worn or scored, it will be necessary to convert the discontinued lap-fit piston-and-cylinder model to the poly-seal barrel design used in models produced since 1983.

**NOTE:** To convert the lap-fit cylinders to the poly-seal design, order barrel assembly 337461. If old piston is not worn, it may be used with the poly-seal barrel. If old piston needs to be replaced, order piston 337466. All other new part numbers are interchangeable with the old parts that they replace.

13. Clean and inspect parts for damage and wear. Make replacements as required, using entire kit contents.

14. Reassemble by reversing steps 1-11

**IMPORTANT:** Prior to reassembly, lubricate all "O" rings and packings with a light machine oil. Protect all seals and sealing surfaces from damage and scratches in any way possible.

**PARTS CHANGES SINCE LAST PRINTING**

Mailing address