

ALEMITE

SERVICE INSTRUCTIONS
Major Tube Repair Kit
For Models 7785-A5 and 7785-B5
High-Pressure Lubricant Pumps

398988-2**DESCRIPTION**

Major Repair Kit 398988-2 contains the necessary parts to overhaul both the pump tube and the body and upper packing group for the 7785-A5 and 7785-B5 Lubricant pumps.

These instructions are to be used for this kit only. Refer to the instructions supplied with the specific model for further service information.

398988-2 Kit Contents

Part No.	Description	Qty.
18850	Elastic Stop Nut, 1/4-28	1
50666	Gasket, 3/4" I.D. x 7/8" O.D. x 1/32" thick	1
131398-1	Valve Seat	1
131402	Gasket, 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
171032-12	Roll Pin, 3/32" O.D. x 0.937" long	1
171700-32	Ball, 1/2" Diameter	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
172190-7	Seal, 1-3/8" O.D. and 5/16" thick	1
172190-8	Seal, 1-61/64" O.D. x 1/4" thick	1
323419	Washer, 7/8" I.D. x 1-19/64" O.D.	1
323693	Aluminum Gasket, 1-29/32" O.D.	2
323743	Adapter	1
323738	Valve Body	1
324274	Bushing	1
324648	Spring Clip	4
337361	Washer, 1-35/64" O.D.	1
337362	Brass Lantern Ring	1
337363	Steel Spacer, 1-1/16" O.D. x 5/16" thick	1
337376	Steel Spacer, 1-1/2" O.D. x 11/32" Thick	1
337377	Bearing	1
337378	Nylon Washer, 1/2" I.D. x 59/64" O.D.	2
337379	Wear Ring	1

SERVICE

NOTE: The following instructions for servicing the pump tube are to be considered typical and may not be complete for any one particular unit. Refer to instructions supplied with model for further information.

CAUTION: Before beginning service or attempting to disassemble 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.

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2. Remove upper spring clip from upper coupling and detach piston rod.
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 from body of air-motor assembly.
2. Remove washer 323419 and bushing 324274 from adapter.
3. Unscrew three screws and pull body 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, second gasket 323693 and spacer.

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 this repair kit.

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 SAE No. 10 oil or light machine oil. Protect all seals and sealing surfaces from damage and scratches in any way possible.

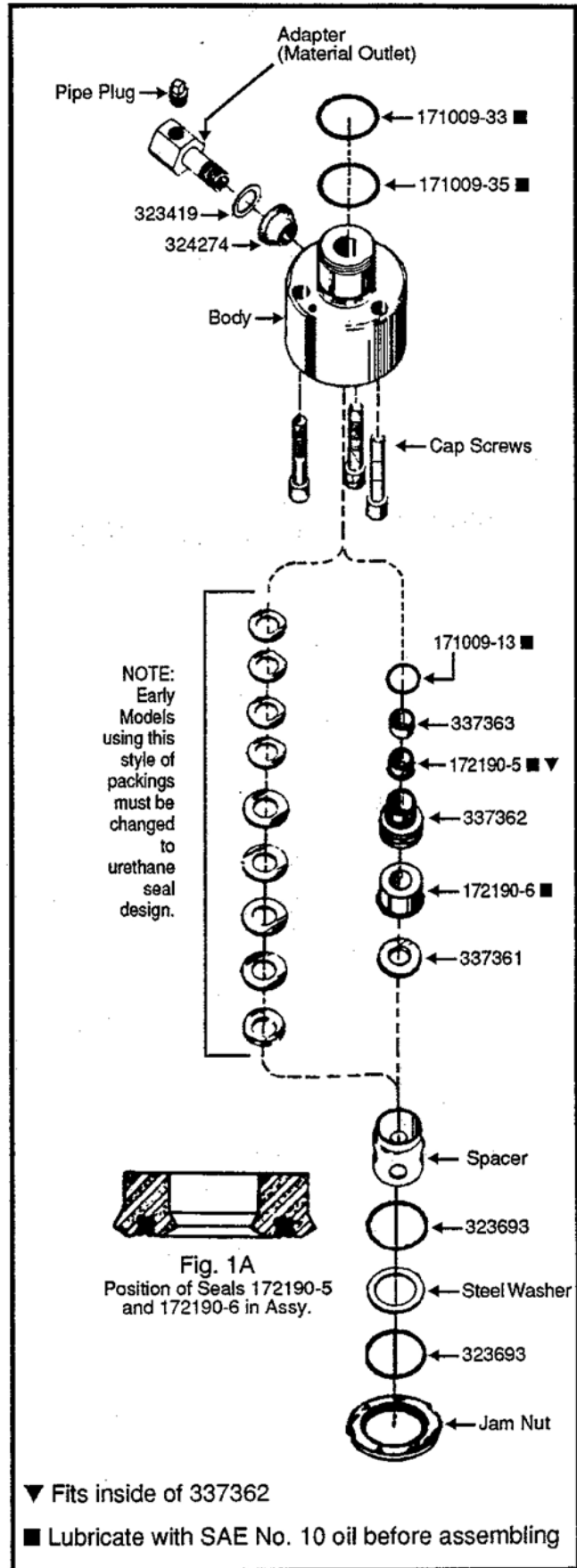


Figure 1: Body and Upper Packing Group

SERVICING PUMP-TUBE ASSEMBLY:
(Figure 2)

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

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

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

3. Remove primer body from pump-tube adapter.

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

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

6. Remove valve body 323738 with attached parts.

7. Unscrew packing nut from valve body 323738 and remove packings (early models) or two washers 337378 and seal 172190-8 (later models).

8. Remove guide washer.

9. Pull primer rod with piston still attached, through bottom of adapter to expose roll pin 171032-12

10. Drive roll pin out of adapter 323743 with drift pin.

11. Unscrew adapter from piston and remove ball 171700-32, gasket 50666, spring and retainer.

12. Pull cylinder (early models) or barrel assembly (later models) from piston and remove both gaskets 131402. Remove spacer 337376, bearing 337377, seal 172190-7 and wear ring 337379 from barrel assembly.

13. 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 337380. If old piston is not worn, it may be used with the poly-seal barrel. If old piston needs to be replaced, order piston 332246. All other new part numbers are interchangeable with the old parts that they replace.

14. Clean and inspect parts for damage and wear. Make replacements as required.

15. Reassemble by reversing steps 1-12.

PARTS CHANGES SINCE LAST PRINTING

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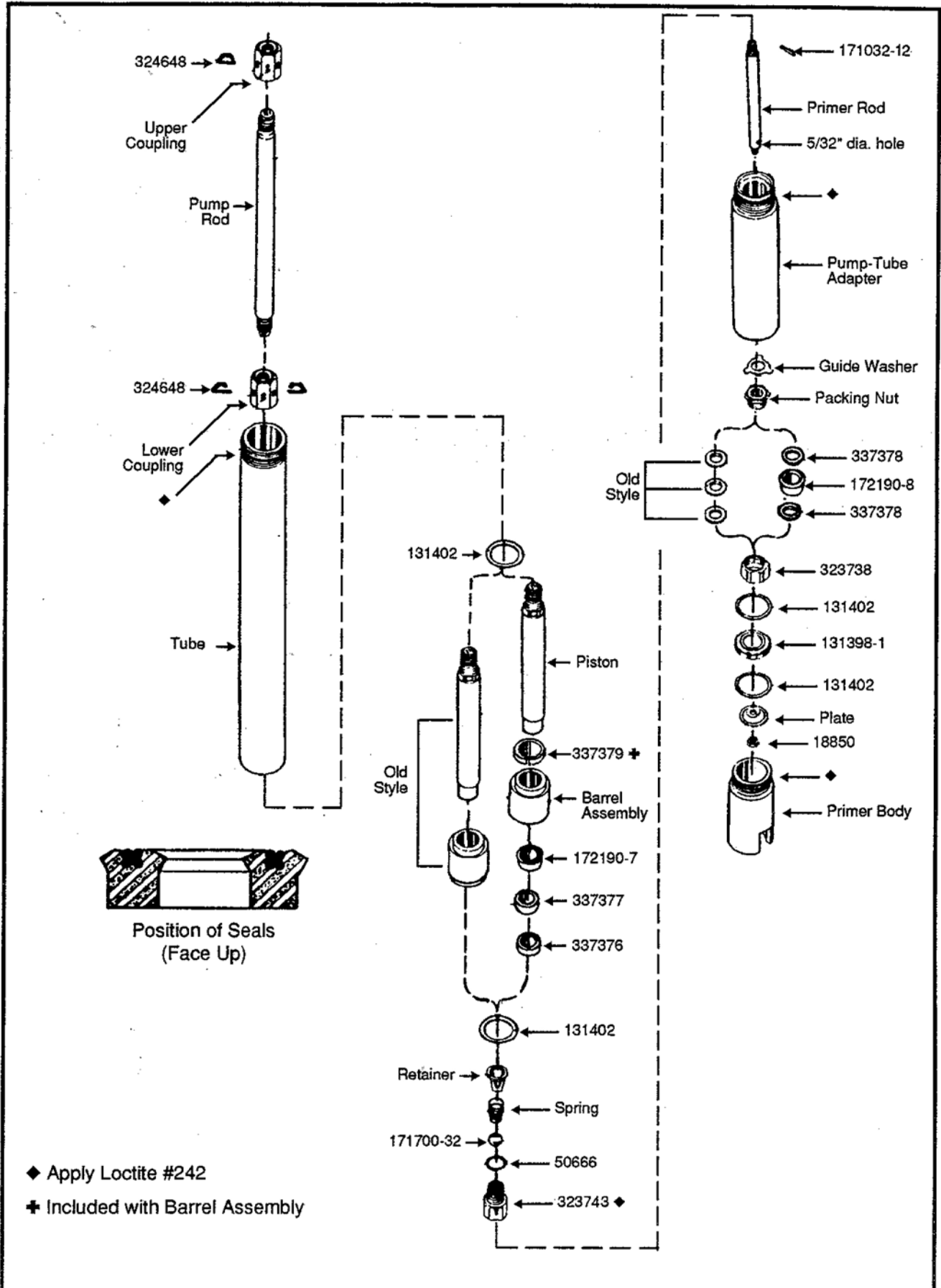


Figure 2: Components of Pump-Tube Assembly