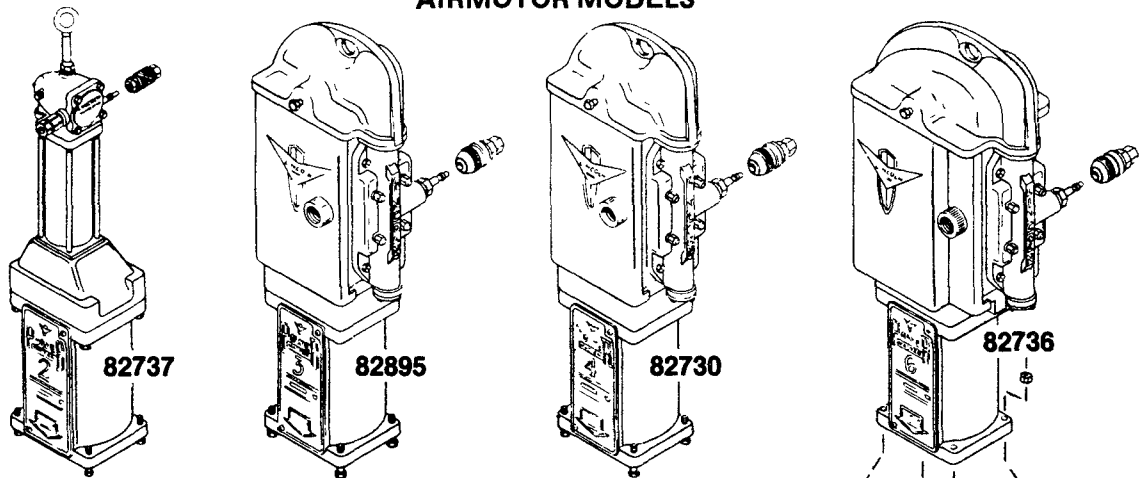


POWER-MASTER STUB PUMPTUBE

Model 84481

Series "B"

AIRMOTOR MODELS



ATTACHING AIRMOTOR TO PUMPTUBE

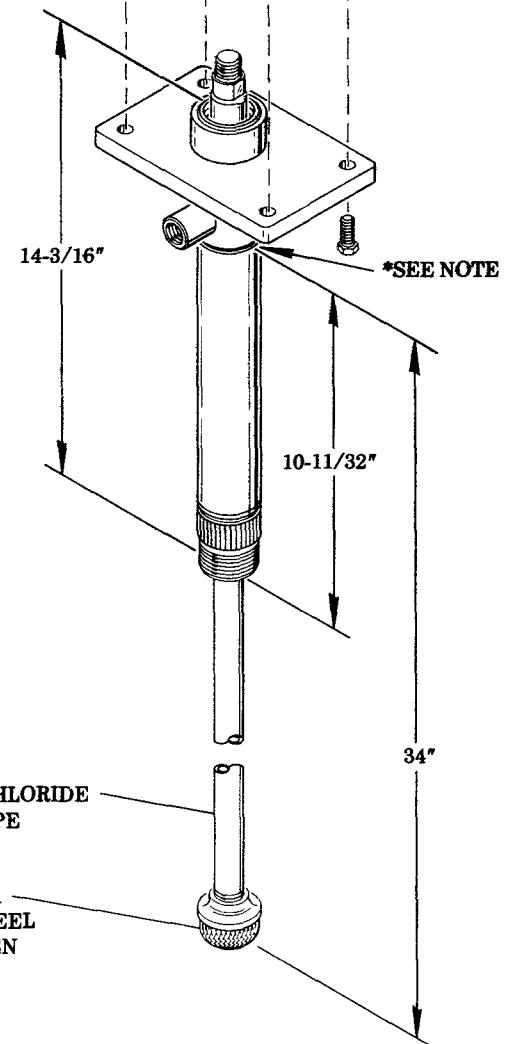
- 1- Tightly connect airmotor coupling nut to pump plunger.
- 2- Attach airmotor to the pump outlet body flange with the four bolts and nuts (hand tight) supplied with airmotor.
- 3- Slowly cycle the pump several times, using just enough air pressure to operate the pump without stalling.
- 4- Stop the pump on an "up" stroke and tighten the four bolts & nuts to securely fasten the airmotor to the pumptube.

AIRMOTOR SELECTION

Airmotor	Diameter	Series	Ratio
82737	2-1/2"	40	4:1
82895	3"	56	6:1
82730	4-1/4"	115	12:1
82736	6"	225	24:1

*NOTE

PUMP MAY BE BUNG MOUNTED BY USING A 69894 RETAINING RING, A 40430 BUNG BUSHING AND A 66130 THUMB SCREW.

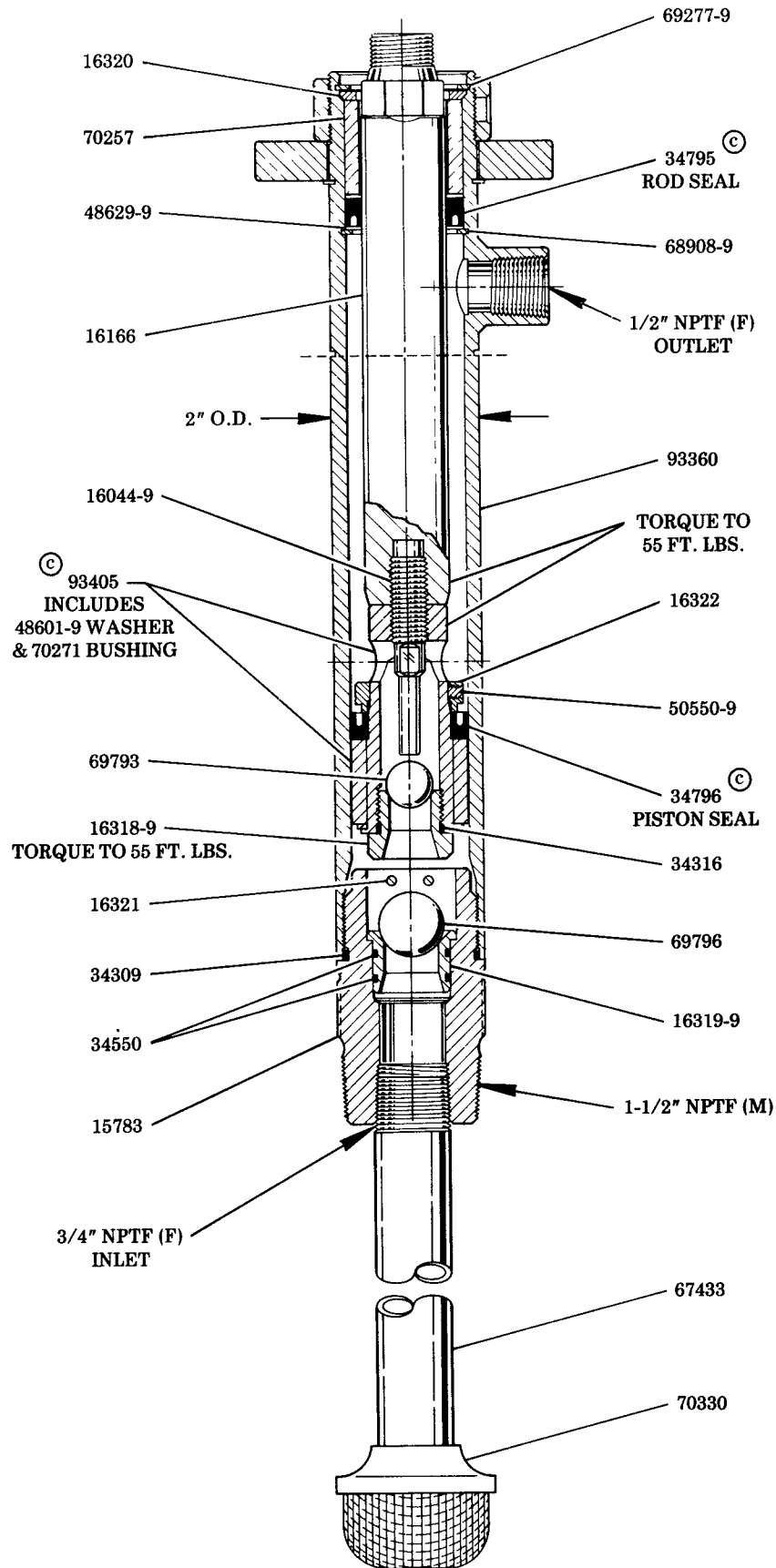


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One Lincoln Way St. Louis, Missouri 63120-1578
(314) 679-4200 Telex 44881

SECTION - **A50**
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ASSEMBLY INSTRUCTIONS



DISASSEMBLY INSTRUCTIONS

Unscrew 15783 Foot Valve Body from 93360 Pump Tube Assembly. 16166 Plunger Rod and 93405 Piston Assembly should drop out through bottom of pump tube.

To remove plunger rod from piston assembly, place the plunger rod in a vise on wrench flats. Loosen piston assembly using 7/8 inch wrench on wrench flats. To replace 34796 U-cup Packing, loosen two 50550-9 Set Screws and remove 16322 Retainer.

To replace 70271 Bushing and 48601-9 Washer, Refer to Fig. 2 on back page. (93405 Piston is complete with 70271 Bushing and 48601-9 Washer.)

After removing two 16321 Pins and 69796 Ball, Refer to Fig. 3 on back page to replace 16319-9 Check Insert and 34550 O-rings.

Remove 69277-9 Retaining Ring and 16320 Spacer to replace 70257 Bushing and 34795 U-cup Packing in gland.

SERVICE PARTS

PART	QUAN.	DESCRIPTION	PART	QUAN.	DESCRIPTION
15783	1	Foot valve body	34796	1	U-cup (Buna-N)
16044-9	1	Ball stop	48629-9	1	Washer
16166	1	Plunger rod	50550-9	2	Set screw
16318-9	1	Check seat	67433	1	Extension pipe
16319-9	1	Check insert	68908-9	1	Retaining ring
16320	1	Spacer	69277-9	1	Retaining ring
16321	2	Pin	69793	1	Ball
16322	1	Retainer	69796	1	Ball
34309	1	O-ring	70257	1	Bushing
34316	1	O-ring	70330	1	Strainer
34550	2	O-ring	93360	1	Pump tube assembly
34795	1	U-cup (Buna-N)	93405	1	Piston assembly

SEAL	*BUNA-N	POLYURETHANE
ROD	34795	34401
PISTON	34796	34479

*Recommended for wash pump applications.

Lubricate I.D. of Bushing, I.D. & O.D. of U-cup Packing with light grease.

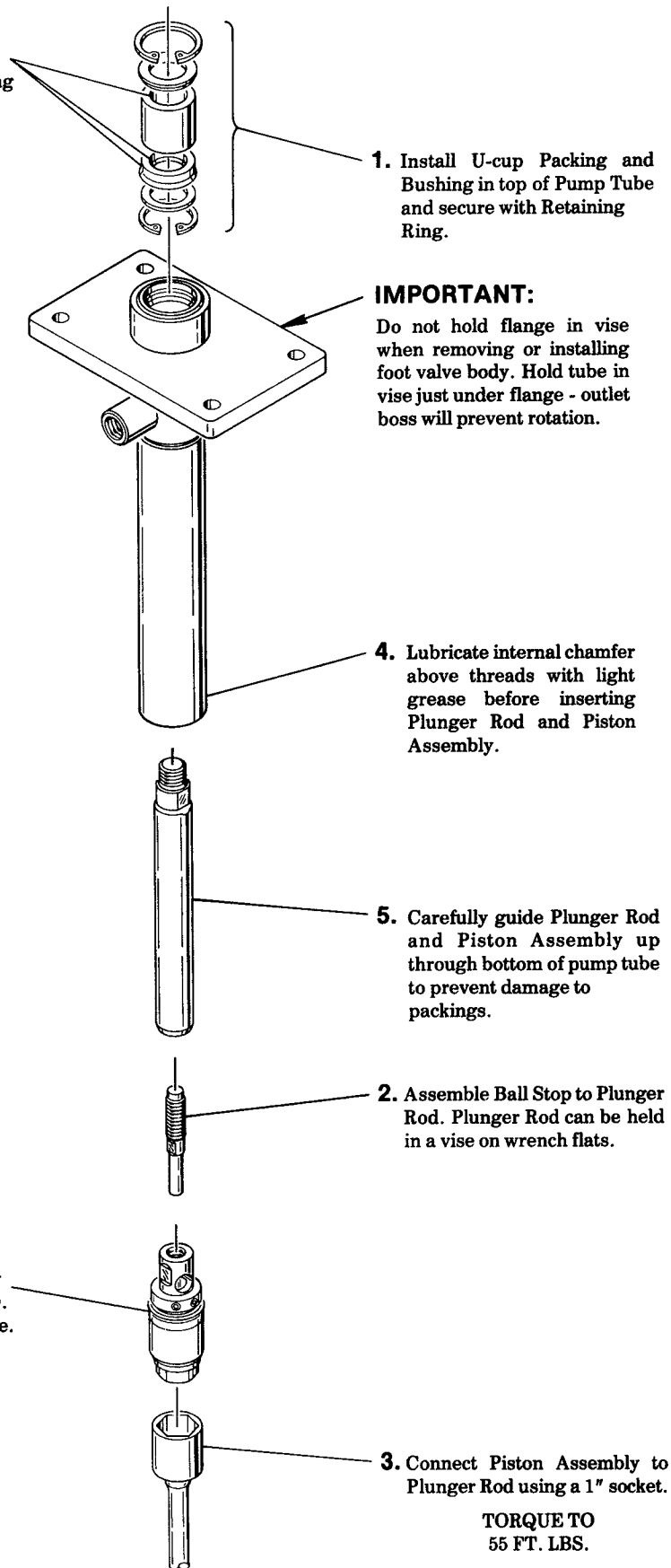


Fig. 1

1. Install U-cup Packing and Bushing in top of Pump Tube and secure with Retaining Ring.

IMPORTANT:
Do not hold flange in vise when removing or installing foot valve body. Hold tube in vise just under flange - outlet boss will prevent rotation.

4. Lubricate internal chamfer above threads with light grease before inserting Plunger Rod and Piston Assembly.

5. Carefully guide Plunger Rod and Piston Assembly up through bottom of pump tube to prevent damage to packings.

2. Assemble Ball Stop to Plunger Rod. Plunger Rod can be held in a vise on wrench flats.

3. Connect Piston Assembly to Plunger Rod using a 1 inch socket.

TORQUE TO 55 FT. LBS.

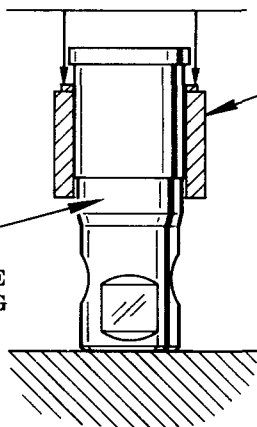
© Indicates change

**TO REPLACE
48601-9 WASHER & 70271 BUSHING**

WASHER & BUSHING
MUST BE PRESSED OFF

Fig. 2

CAUTION
U-CUP SEALING SURFACE
DO NOT DAMAGE DURING
PRESS OPERATION



Paint I.D. of 70271 Bushing and Piston O.D. with Locquic primer and allow to dry 5 minutes before assembly. Coat Bushing I.D. and Piston O.D. with Loctite 271 before assembly.

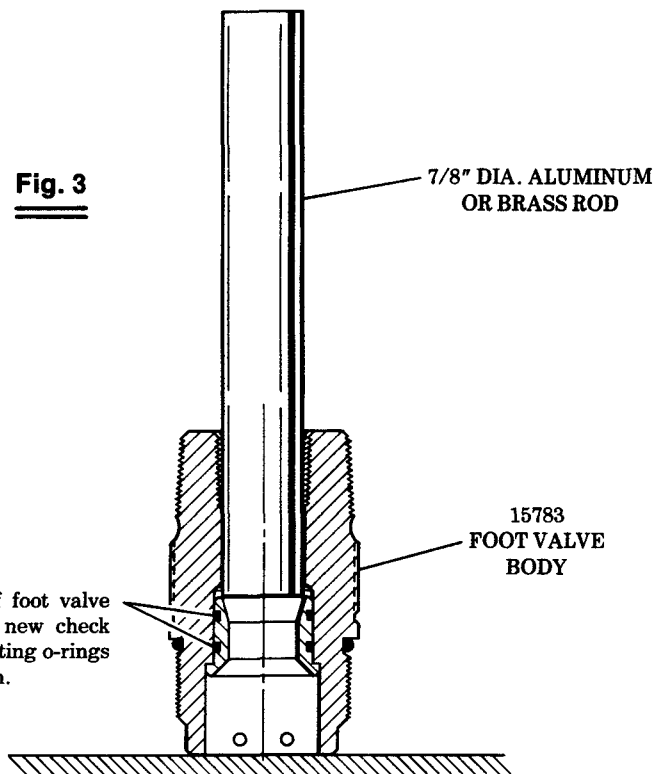
Remove excess Loctite after assembly.

IMPORTANT:
Bushings and Washer must be held securely against Piston shoulder with 20 lb. minimum force while Loctite cures.

**TO REPLACE
16319-9 CHECK INSERT & 34550 O-RINGS**

Fig. 3

Lubricate bore of foot valve body & O.D. of new check insert to avoid cutting o-rings during installation.



Invert 15783 Foot Valve Body and place on hard, flat surface. Tap 16319-9 Check Insert out using 7/8" Dia. aluminum or brass rod. New check insert should be tapped in with 1" or larger aluminum or brass rod.

RETAIN THIS INFORMATION FOR FUTURE REFERENCE

When ordering replacement parts, list: Part Number, Description, Model Number, and Series Letter.

LINCOLN provides a Distributor Network that stocks equipment and replacement parts.

A list of Authorized Service Departments will be furnished upon request.