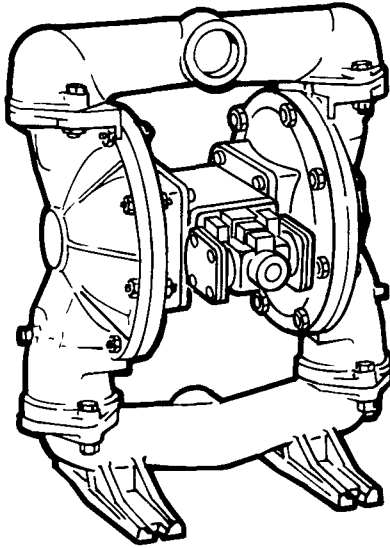


**OPERATING INSTRUCTIONS, SERVICE MANUAL
AND REPAIR PARTS LIST****OPERATING AND
SERVICE INSTRUCTIONS****WARNING****HAZARD WARNING
POSSIBLE EXPLOSION**

HAZARD can result if 1, 1, 1, -Trichloroethane, Methylene Chloride or other Halogenated Hydrocarbon solvents are used in pressurized fluid systems having Aluminum or Galvanized wetted parts. Death, serious bodily injury and/or property damage could result. Consult with the factory if you have questions concerning Halogenated Hydrocarbon solvents.

**WARNING**

Do not use for pumping flammable materials. Build up and discharge of static electricity may result in a fire and/or explosion causing personal injury and loss to property.

Principle of Operation

The pump is powered by compressed air which alternately pressurizes the inner sides of the two diaphragm cham-

bers while simultaneously exhausting the opposite inner chambers causing the diaphragms, which are connected by a shaft, to move endwise. Since air pressure is applied over the entire surface of the diaphragm which is forcing liquid to be discharged by its other side, the diaphragm is operating under a balanced condition during the discharge stroke. This allows the unit to be operated at discharge heads over 200 feet (61 meters) of water head.

Alternate pressurizing and exhausting of the diaphragm chamber is performed by an externally mounted, pilot-operated, four way, spool type air distribution valve. When the spool is at one end of the valve body, inlet air pressure is connected to one diaphragm chamber and the other diaphragm chamber is connected to the exhaust. When the spool is moved to the opposite end of the valve body, the porting of chambers is reversed. The air distribution valve spool is moved from one end position to the other in the valve body by means of an internal pilot valve which alternately pressurizes the ends of the air distribution valve spool while simultaneously exhausting the other ends. The pilot valve is positively shifted at each end of the diaphragm stroke by the diaphragm plate's coming in contact with the end of the pilot valve spool and pushing it into position for shifting of the air distribution valve. The chambers are manifolded together with a suction and discharge check valve for each chamber to maintain flow in one direction through the pump.

**INSTALLATION
PROCEDURES**

Position the pump as close as possible to the source of the liquid to be pumped. Avoid long or undersize suction lines and use the minimum number of fittings.

For permanent installation involving rigid piping, install short flexible sections of hose between the pump and piping. This reduces strains and permits easier removal of the pump for service when required. **At time of installation, inspect all external gasketed fasteners for looseness caused by**

gasket creep. Tighten loose fittings securely to prevent leakage.

AIR SUPPLY

Do not connect the unit to an air supply in excess of 125 PSI (8.61 bars). Install a shutoff valve in the air supply line to permit removal of the unit for servicing. When connecting an air supply of rigid piping, mount a section of flexible line to the pump to eliminate piping strain. In permanent installations, an air line filter is recommended. **The weight of the air supply line and of the filter must be supported by some means other than the air valve cap. Failure to provide support may result in damage to the pump.**

OPERATION

Your pump has been tested prior to shipment and is ready for use as received. It is completely self-priming and no initial filling with fluid is required.

If the unit is to be totally submerged, the air exhaust must be piped above liquid level to prevent the liquid and foreign material from entering the air distribution valve mechanism.

Open the inlet air valve at least one turn to allow sufficient cycling rate for the pump to prime (30 to 60 cycles per minute). After pumping starts, adjust the inlet air valve for the desired pumping capacity. When further opening of the inlet air valve increases cycling rate without increasing the flow rate, the pump is being starved of liquid due to suction limitations. Further opening of the air inlet valve will waste compressed air. Set the inlet air valve for lowest cycling rate that does not decrease flow rate for most efficient operation.

FREEZING OR ICING OF EXHAUST

Icing of the air exhaust can occur under certain conditions of temperature and humidity on compressed air power equipment. When pump performance suffers because of icing, a non-sticky anti-freeze lubricant such as KILFROST, in an air line lubricator, will solve the problem. Icing is more likely to occur at high discharge pressures.

AIR EXHAUST

The pumps can be submerged if the materials of construction are compatible with the liquid and the exhaust is piped above the liquid level. (See **OPERATION**, above.) Piping used for the exhaust should not be smaller than 1" pipe size. Reduced pipe size can restrict the exhausted air and reduce pump performance.

CAUTION

If a diaphragm fails, the pumped product or fumes can enter the air side of the pump. This side is exhausted through the exhaust port (muffler).

When the product is a hazardous or toxic material, the exhaust should be piped to an appropriate area for safe disposition.

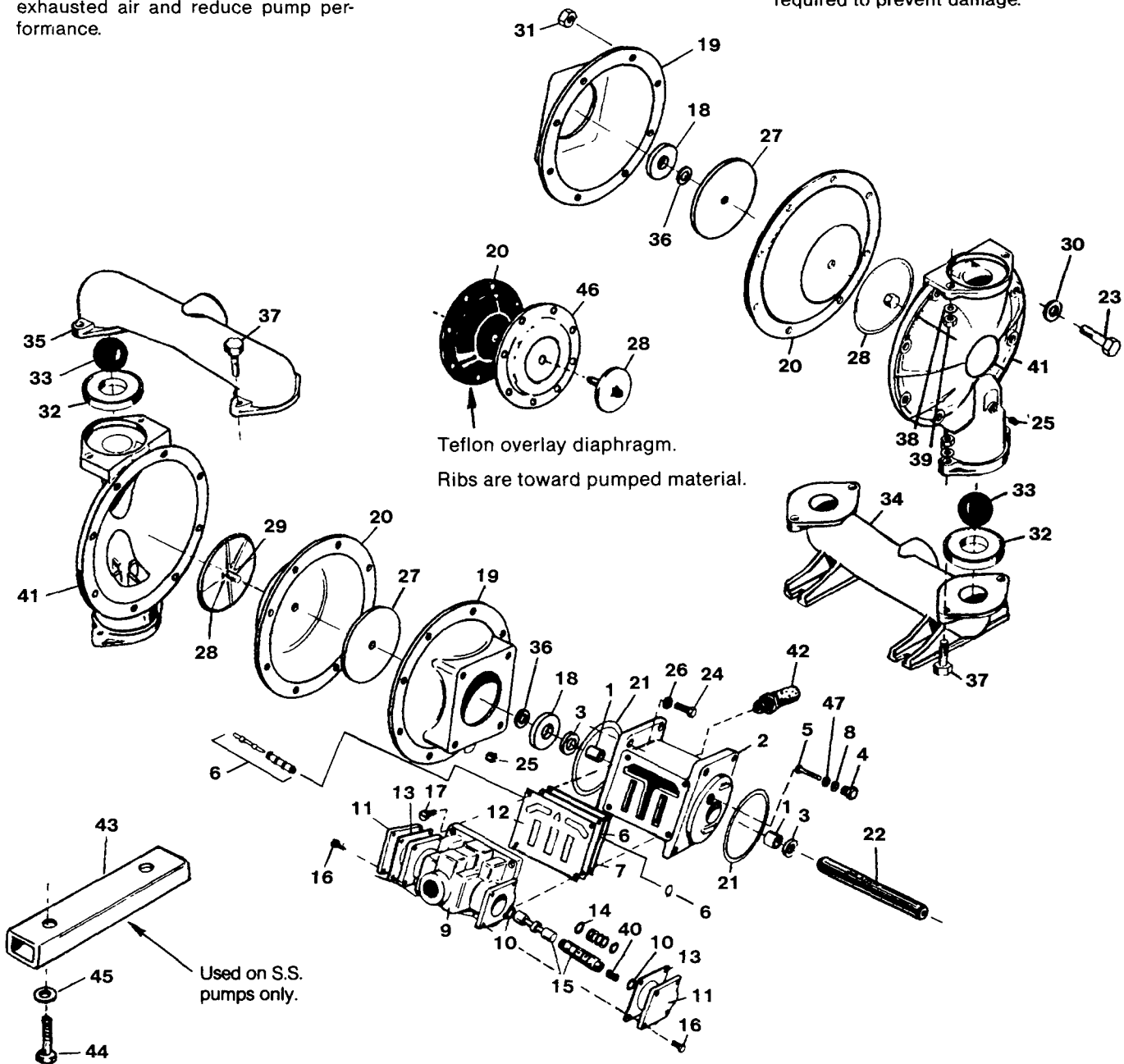
When the product source is at a higher level than the pump (flooded suction), the exhaust should be piped to a higher level than the product to prevent spills caused by siphoning.

MAINTENANCE AFTER USE

CAUTION

Before maintenance or repair, shut off the compressed air line, bleed the pressure, and disconnect the air line from the pump. The discharge line may be pressurized and must be bled of its pressure. When the pump is used for toxic or aggressive fluids, it should be flushed clean prior to disassembly.

When the pump is used for materials that tend to settle out or transform from liquid to solid form, care must be taken after each use or during idle time to remove them and flush the pump as required to prevent damage.



REPAIR KITS AVAILABLE

- ★ 86256 Air End Repair Kit - All Models.
- 86248 Buna-N Wet End Repair Kit - Model 84870.
- 86249 Teflon Wet End Repair Kit - Model 84871.

SERVICE PARTS

Item	Description	Qty.	Model 84870	Model 84871
1	Bearing, sleeve	2	240922	240922
2	Bracket, intermediate	1	240923 (AL)	240923 (AL)
3	Seal, U-cup	2	★243134	★243134
4	Bushing, threaded, w/O-ring	2	★244588	★244588
5	Plunger, actuator	2	★240892	★240892
6	Assembly, pilot valve	1	★244590	★244590
7	Gasket, valve body	1	★240926	★240926
8	O-ring	2	240655 (BN)	240655 (BN)
9	Body, valve	1	240927 (AL)	240927 (AL)
10	Bumper, valve spool	2	240928	240928
11	Cap, end	2	240929 (AL)	240929 (AL)
12	Gasket, valve body	1	★240930	★240930
13	Gasket, end cap	2	★240931	★240931
14	O-ring	6	★240932 (BN)	★240932 (BN)
15	Sleeve & spool set	1	★244591	★244591
16	Capscrew, hex head	8	240934	240934
17	Capscrew, hex head	4	240754	240754
18	Bumper, diaphragm	2	240935 (BN)	240935 (BN)
19	Chamber, inner	2	240936 (AL)	240936 (AL)
20	Diaphragm	2	●240900 (BN)	■240899 (NE)
21	O-ring	2	240937 (BN)	240937 (BN)
22	Rod, diaphragm	1	240895	240895
23	Capscrew, hex head	16	240957	240957
24	Capscrew, hex head	8	240919	240919
25	Plug, pipe	4	240747	240747
26	Washer, lock	8	240938	240938
27	Plate, diaphragm	2	240939	240939
28	Plate, outer	2	240896 (AL)	240896 (AL)
29	Stud	2	240835	240835
30	Washer, flat	16	240910	240910
31	Nut, hex	16	240911	240911
32	Seat, valve	4	●240901 (BN)	■240902 (TF)
33	Ball, check valve	4	●240903 (BN)	■240904 (TF)
34	Manifold, suction	1	240905 (AL)	240905 (AL)
35	Manifold, discharge	1	240907 (AL)	240907 (AL)
36	Stat-O-Seal	2	240940	240940
37	Capscrew, hex head	8	240912	240912
38	Washer, lock	8	240913	240913
39	Nut, hex	8	240914	240914
40	Spring	1	★240945	★240945
41	Chamber, outer	2	240915 (AL)	240915 (AL)
42	Muffler, exhaust	1	240941	240941
43	Foot, mounting	2	----	----
44	Capscrew, hex head	4	----	----
45	Washer, flat	4	----	----
46	Overlay diaphragm	2	----	■240920 (TF)
47	Bumper	2	240921	240921

(AL) Aluminum, (BN) Buna-N, (NE) Neoprene, (TF) Teflon

In freezing temperatures the pump must be completely drained when idle. This model must be tilted to allow the liquid from the chambers to run out of the discharge port.

SERVICE INSTRUCTIONS: TROUBLESHOOTING

- 1. Pump will not cycle**
 - A. Check to make sure the unit has enough pressure to operate and that the air inlet valve is open.
 - B. Check the discharge line to insure that the discharge line is neither closed nor blocked.
 - C. If the spool in the air distribution valve is not shifting, check the main spool. It must slide freely.
 - D. Excessive air leakage in the pump can prevent cycling. This condition will be evident. Air leakage into the discharge line indicates a ruptured diaphragm. Air leakage from the exhaust port indicates leakage in the air distribution valve. See further service instructions.
 - E. Blockage in the liquid chamber can impede movement of diaphragm.

- 2. Pump cycles but will not pump**
 - A. Suction side of pump pulling in air. Check the suction line for air leaks and be sure that the end of the suction line is submerged. Check flange bolting. Check valve flanges and manifold to chamber flange joints.
 - B. Make certain the suction line or strainer is not plugged. Restriction at the suction is indicated by a high vacuum reading when a vacuum gauge is installed in the suction line.
 - C. Check valves may not be seating properly. To check, remove the suction line and cover the suction port with your hand. If the unit does not pull a good suction (vacuum), the check valves should be inspected for proper seating.
 - D. Static suction lift may be too high. Priming can be improved by elevating the suction and discharge lines higher than the check valves and pouring liquid into the unit through the suction inlet. When priming at high suction lifts or with long suction lines operate the pump at maximum cycle rate.

- 3. Low performance**
 - A. Capacity is reduced as the discharge pressure increases, as indicated on the performance curve. Performance capability varies with available inlet air supply. Check air pressure at the pump inlet when the pump is operating to make certain that adequate air supply is maintained.

- B. Check vacuum at the pump suction. Capacity is reduced as vacuum increases. Reduced flow rate due to starved suction will be evident when cycle rate can be varied without change in capacity. This condition will be more prevalent when pumping viscous liquids. When pumping thick, heavy materials the suction line must be kept as large in diameter and as short as possible, to keep suction loss minimal.
- C. Low flow rate and slow cycling rate indicate restricted flow through the discharge line. Low flow rate and fast cycling rate indicate restriction in suction line or air leakage into suction.
- D. Unstable cycling indicates improper check valve seating on one chamber. This condition is confirmed when unstable cycling repeats consistently on alternate exhausts. Cycling that is not consistently unstable may indicate partial exhaust restriction due to freezing and thawing of exhaust air. Use of an anti-freeze lubricant in an air line lubricator should solve this problem.

CHECK VALVE SERVICING

Need for inspection or service is usually indicated by poor priming, unstable cycling, reduced performance or the pump's cycling but not pumping.

DIAPHRAGM SERVICING

Remove the eight bolts (four each side) securing the manifold assemblies to the outer chambers. Remove the eight bolts securing the outer chamber to the inner chamber. Remove the diaphragm assembly (outer plate, diaphragm, inner plate) by turning the assembly counterclockwise using a 15/16" (2.38 cm) wrench on the outer plate lugs. To disassemble the diaphragm assemblies, secure in a vise and turn the outer plate counterclockwise using the 15/16" wrench.

Procedures for reassembling the diaphragms are the reverse of the above. The diaphragms must be installed with their natural bulge to the outside, toward the outer diaphragm plate. Install the inner plate with the flat face against the diaphragm.

After all components are in position in a vise and hand tight, tighten with a wrench to approximately 40 ft. lbs. (54.23 Newton meters) torque. After both diaphragm assemblies have been assembled, thread one assembly into the shaft (hold the shaft near the middle in a vise with soft jaws, to protect the finish). Install this sub assembly into the pump and secure by placing the outer chamber on the end with the diaphragm. This holds the assembly in place while the opposite side is installed. Torque the last diaphragm assembly to 30 ft. lbs. (40.67 Newton meters). This final torquing will lock the diaphragm assemblies together. Place the remaining outer chamber on the open end and loosely tighten the bolts. Replace the manifold assemblies to square the flanges before final tightening of the remaining bolts.

AIR DISTRIBUTION VALVE SERVICING

The spool and sleeve are rust and corrosion resistant brass and hardened stainless steel. The spool is closely sized to the sleeve and should slide freely. Accumulation of dirt and oils may prevent the pump from cycling. Remove the valve body from the center pump housing, remove the end caps, and push the spool out of the sleeve. Wash the parts in cleaning solvent or kerosene, and check the spool and sleeve for possible roughness, nicks or scratches. Use a fine stone or crocus cloth to carefully remove any irregular marks on the surfaces. When the spool slides freely on the sleeve, coat the parts with light oil and reassemble.

PILOT VALVE SERVICING

This assembly is reached by removing the air distribution valve body from the pump and lifting the pilot valve body out of the intermediate housing.

When reinserting an externally serviceable pilot valve, push both plungers out of the path of the pilot valve so that they and the pilot valve are not damaged.

Service Note: If a problem arises with the pilot valve, it is usually corrected by replacing only o-rings. Always grease the spool prior to inserting into the sleeve. If the sleeve is removed from the body, reinsertion must be from the

same side it was removed from, the chamfered side. Again, grease the o-rings so that it slides into the body. Make sure the retaining ring has securely been inserted around the sleeve.

PILOT VALVE ACTUATOR SERVICING

The bushings for the pilot valve actuators are threaded into the intermediate bracket from the outside. The plunger may be removed for inspection or replacement from the inside by removing the air distribution valve body and the pilot valve body from the pump. The plungers should be visible as you look into the intermediate from the top. Depending on their position, you may find it necessary to use a fine piece of wire to pull them out.

Under rare circumstances, it may become necessary to replace the o-ring seal. The bushing can be turned out through the inner chamber by removing the outer chamber assembly to reach the bushing.

A Note about Air Valve Lubrication

The Lincoln pump's pilot valve and main air valve assemblies are designed to operate WITHOUT lubrication. This is the preferred mode of operation. There may be instances of personal preference, or poor quality air supplies when lubrication of the compressed air supply is required. The pump air system will operate with properly lubricated compressed air supplies. Proper lubrication of the compressed air supply would entail the use of an air line lubricator (available from Lincoln) set to deliver one drop of 10 wt., non-detergent oil for every 20 SCFM of air the pump consumed at its point of operation. Consult the pump's published Performance Curve to determine this.

It is important to remember to inspect the sleeve and spool set routinely. It should move back and forth freely. This is most important when the air supply is lubricated. If a lubricator is used, oil accumulation will, overtime, collect any debris from the compressed air. This can prevent the pump from operating properly.

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.