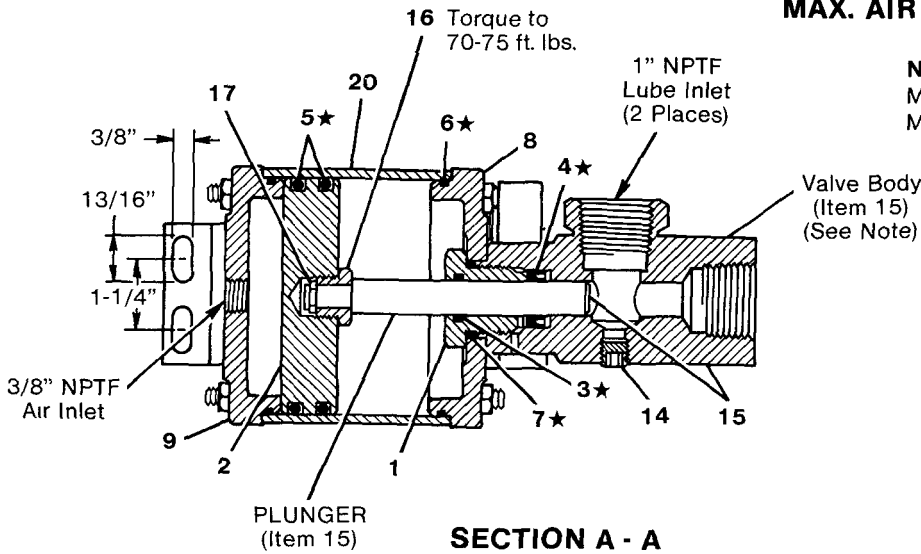
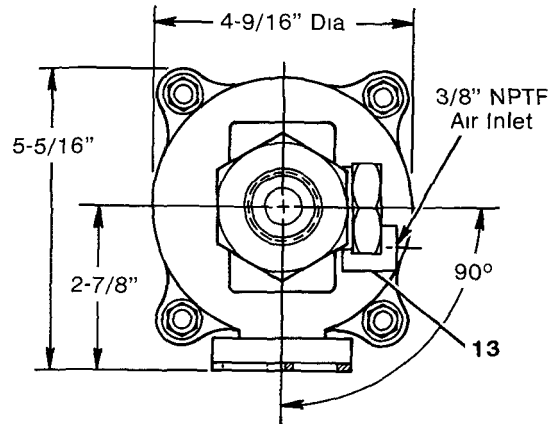
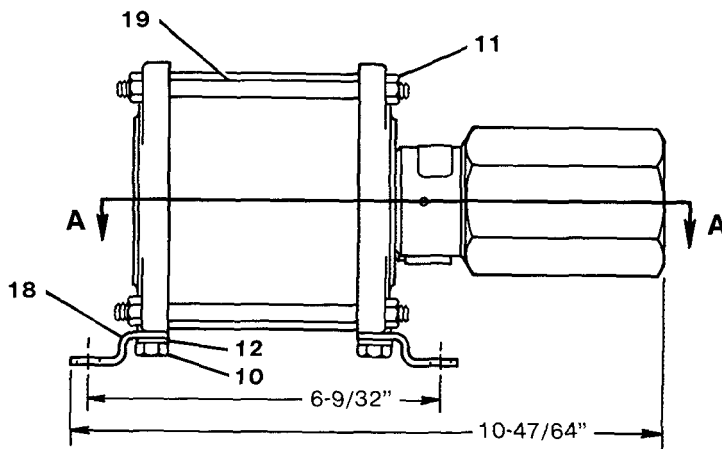
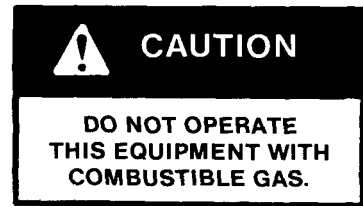


**MAX. OPERATING PRESSURE - 3500 PSI
MAX. AIR PRESSURE - 100 PSI**



NOTE:
Model 84631 shown
Model 84632 valve body rotated 180°.



ASSEMBLY INSTRUCTIONS

1. Assemble Plunger (Item 15) to Piston (Item 2).
2. Install O-ring (Item 3) into Packing Retainer (Item 1).
3. Slide Packing Retainer (Item 1) onto Plunger (Item 15)
4. Install O-ring (Item 7) onto Packing Retainer (Item 1).
5. Slide U-cup (Item 4) onto Plunger (Item 15).
6. Install O-ring (Item 6) into Cylinder Head (Item 8)
7. Slide Cylinder Head (Item 8) onto Packing Retainer (Item 1).
8. Assemble Cylinder Head to Valve Body (Item 15), inserting plunger into valve body followed by U-cup (Item 4) and Packing Retainer (Item 1) Use caution to avoid damaging U-cup (Item 4)

★ SOFT PARTS KIT

- Part No. 246114 Soft Parts Kit contains parts required for replacement of soft seals only
9. Install O-rings (Item 5) into Piston.
 10. Thoroughly grease I D of Air Cylinder (Item 20).
 11. Slide air cylinder onto Cylinder Head (Item 8).
 12. Place O-ring (Item 6) into Cylinder Head (Item 9)
 13. Install cylinder head into air cylinder.
 14. Secure with Tie Rods (Item 19) and Nuts (Item 11) Tighten uniformly.

SERVICE PARTS

Item No.	Part No.	Qty.	Description
1	16608	1	Packing retainer
2	16612	1	Piston
3	★	1	O-ring packing (Buna-N)
4	★	1	U-cup packing (Polyurethane)
5	★	2	O-ring (Buna-N)
6	★	2	O-ring (Buna-N)
7	★	1	O-ring (Buna-N)
8	40823	1	Cylinder head
9	40824	1	Cylinder head
10	50034	4	Screw, hex head
11	51002	8	Nut
12	66246	4	Lockwasher
13	67358	1	Ell
14	67359	1	Pipe plug
15	244992	1	Body & plunger set
16	236983	1	Retaining nut
17	236984	2	Keeper
18	361114	2	Mounting bracket
19	16609	4	Tie rod
20	61662	1	Air cylinder

★ Included in 246114 Soft Parts Kit
 Contains parts required for replacement of soft seals only

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.