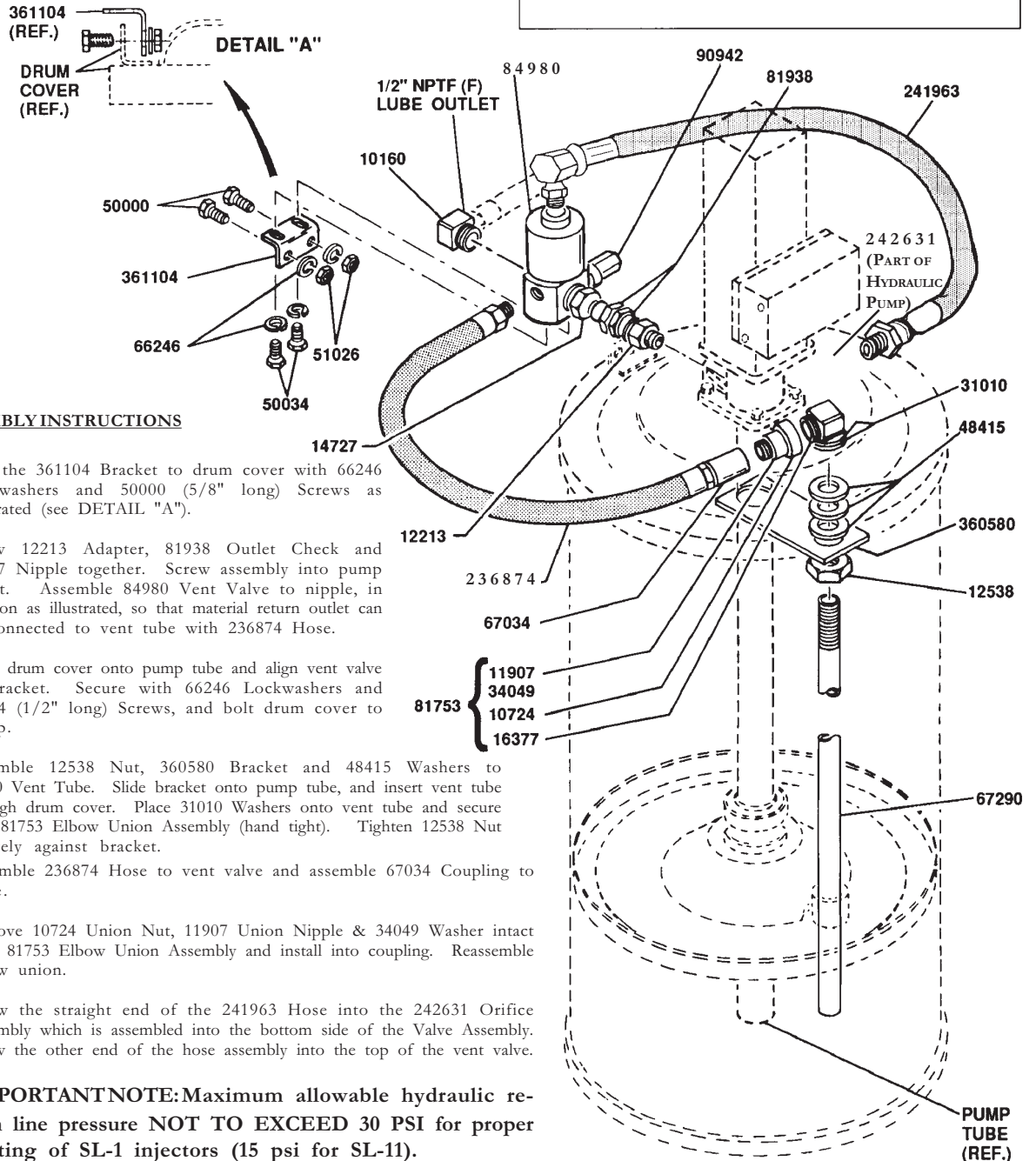


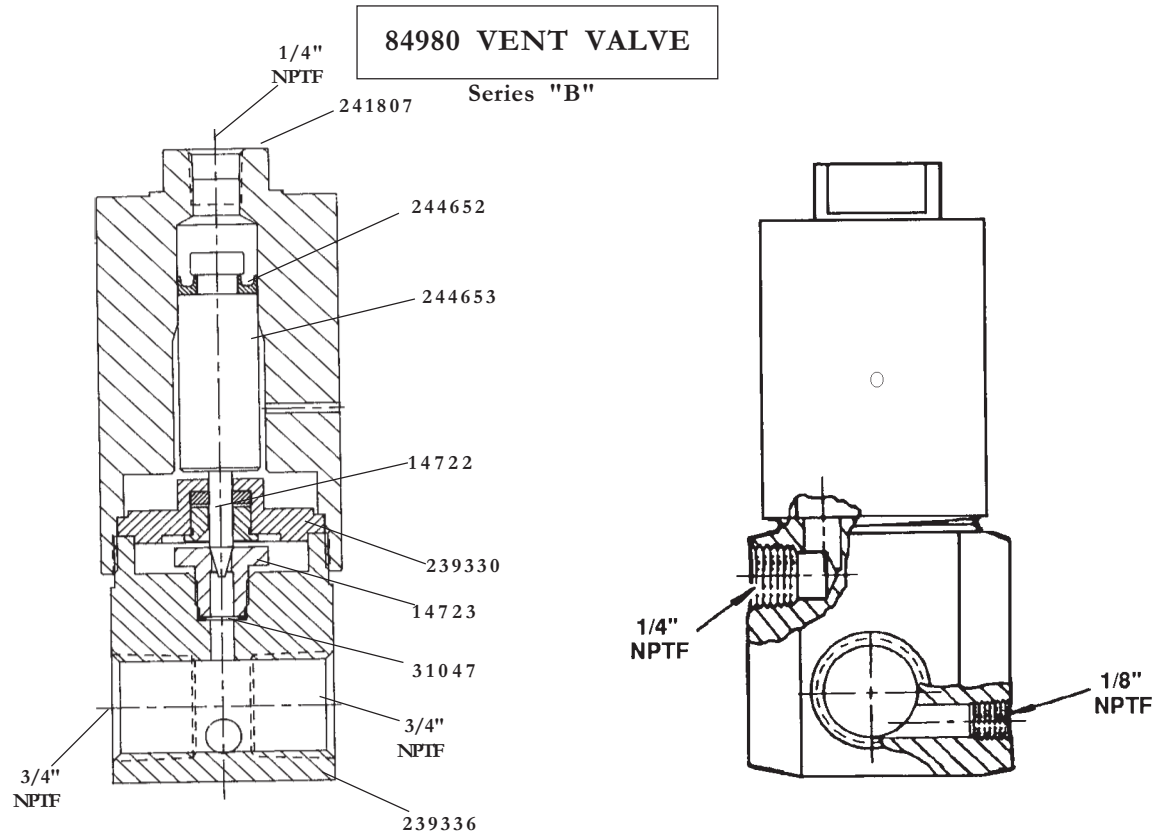
**IMPORTANT**  
MAXIMUM HYDRAULIC OIL TEMPERATURE: 210° F.



**ASSEMBLY INSTRUCTIONS**

- 1) Bolt the 361104 Bracket to drum cover with 66246 Lockwashers and 50000 (5/8" long) Screws as illustrated (see DETAIL "A").
  - 2) Screw 12213 Adapter, 81938 Outlet Check and 14727 Nipple together. Screw assembly into pump outlet. Assemble 84980 Vent Valve to nipple, in position as illustrated, so that material return outlet can be connected to vent tube with 236874 Hose.
  - 3) Bring drum cover onto pump tube and align vent valve to bracket. Secure with 66246 Lockwashers and 50034 (1/2" long) Screws, and bolt drum cover to pump.
  - 4) Assemble 12538 Nut, 360580 Bracket and 48415 Washers to 67290 Vent Tube. Slide bracket onto pump tube, and insert vent tube through drum cover. Place 31010 Washers onto vent tube and secure with 81753 Elbow Union Assembly (hand tight). Tighten 12538 Nut securely against bracket.
  - 5) Assemble 236874 Hose to vent valve and assemble 67034 Coupling to hose.
  - 6) Remove 10724 Union Nut, 11907 Union Nipple & 34049 Washer intact from 81753 Elbow Union Assembly and install into coupling. Reassemble elbow union.
  - 7) Screw the straight end of the 241963 Hose into the 242631 Orifice Assembly which is assembled into the bottom side of the Valve Assembly. Screw the other end of the hose assembly into the top of the vent valve.
- © **IMPORTANT NOTE:** Maximum allowable hydraulic return line pressure NOT TO EXCEED 30 PSI for proper venting of SL-1 injectors (15 psi for SL-11).
- 8) Screw 10160 Elbow & 90942 Safety Unloader into vent valve.

© Indicates Change



### SERVICE PARTS

| Part  | Qty. | Description       | Part   | Qty. | Description          |
|-------|------|-------------------|--------|------|----------------------|
| 10160 | 1    | Elbow             | 66246  | 4    | Lockwasher           |
| 10724 | 1    | Union nut         | 67034  | 1    | Coupling             |
| 11907 | 1    | Union nipple      | 67290  | 1    | Vent tube            |
| 12213 | 1    | Adapter           | 81753  | 1    | Elbow union assembly |
| 12538 | 1    | Nut               | 81938  | 1    | Outlet check         |
| 14722 | 1    | Needle            | 90942  | 1    | Safety unloader      |
| 14723 | 1    | Valve seat        | 236874 | 1    | Hose                 |
| 14727 | 1    | Nipple            | 239330 | 1    | Packing assembly     |
| 16377 | 1    | Check housing     | 239336 | 1    | Valve body           |
| 31010 | 2    | Washer (copper)   | 241807 | 1    | Cylinder             |
| 31047 | 1    | Check seat gasket | 241963 | 1    | Hose assembly        |
| 34049 | 1    | Washer            | 244652 | 1    | U-cup (Buna N)       |
| 48415 | 3    | Washer (steel)    | 244653 | 1    | Piston               |
| 50000 | 2    | Screw             | 360580 | 1    | Bracket              |
| 50034 | 2    | Screw             | 361104 | 1    | Bracket              |
| 51026 | 2    | Nut               |        |      |                      |

**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.