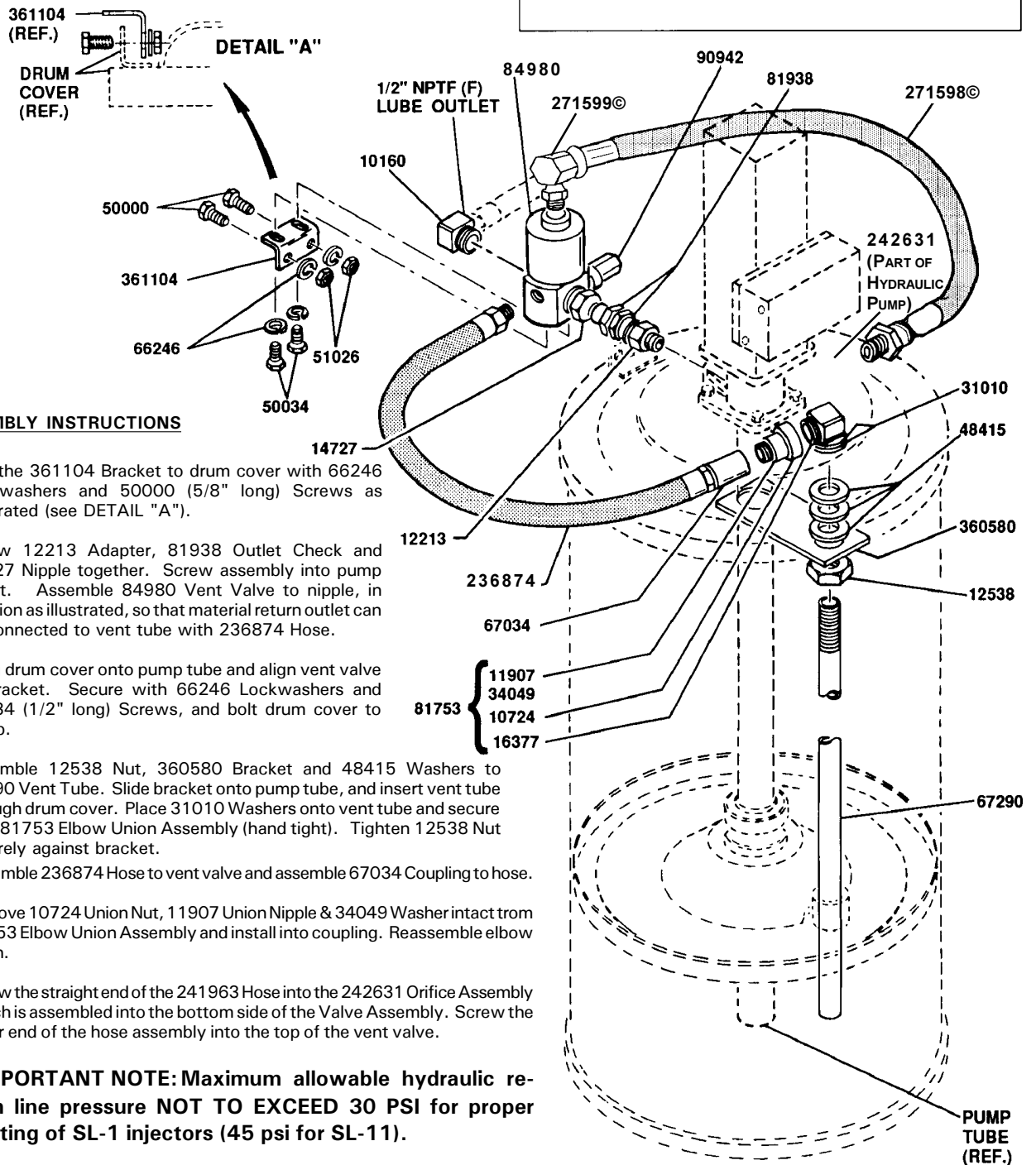


FOR OFF-HIGHWAY TYPE MINING MACHINERY 120 LB. DRUM

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 (45 psi for SL-11).
- 8) Screw 10160 Elbow & 90942 Safety Unloader into vent valve.

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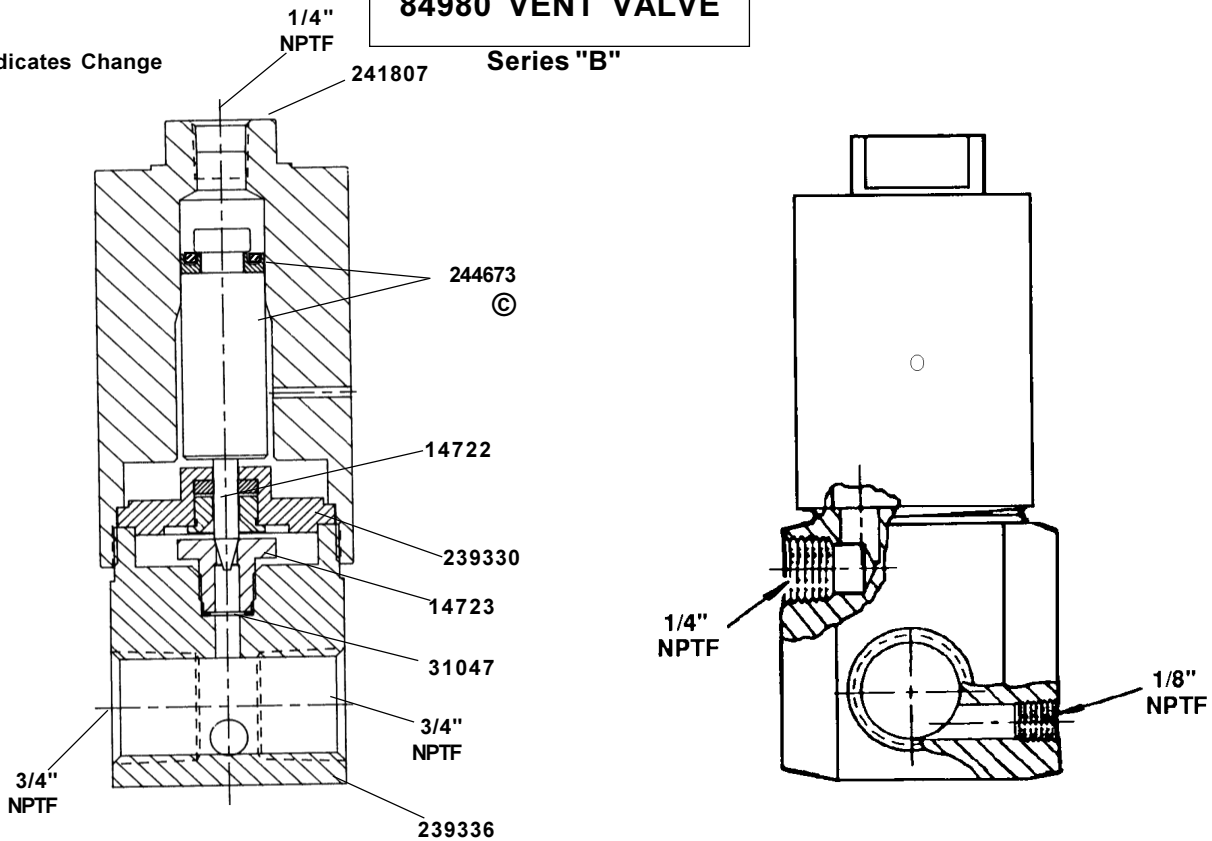
Section -C8

Page -246G

84980 VENT VALVE

Series "B"

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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	244673*	1	Piston & U-Cup Assy.
34049	1	Washer	360580	1	Bracket
48415	3	Washer (steel)	271598©	1	Hose assembly
50000	2	Screw	271599©	1	Adapter Elbow
50034	2	Screw	361104	1	Bracket
51026	2	Nut			

*Sold only as an assembly. Individual parts not available.

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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.