

Piston Kits

Merkur™ Bellows Pumps

406873B

ENG



Important Safety Instructions

Read all warnings and instructions in manuals 312793 and 312795. Save all instructions.

See reverse for parts illustration and assembly notes.

TIP: Some o-rings are close in size. Stack on bench to differentiate.

Kit 24F488, LB050x (50cc)

Kit 24F489, LB100x (100cc)

Kit 24F490, LB150x (150cc)

Insert Nylon Extrusions

Use a hammer to tap the **longer** extrusion into the **rod end** of the piston and the **shorter** extrusion into the **flow nut** end of the piston. Make sure extrusions are flush with the surface of the piston.

Ref.	Description	Size in. (mm)			Qty.
		24F488	24F489	24F490	
101	PISTON				1
102	O-RING, bellows chamber	2.5 (64)	2.5 (64)	2.5 (64)	1
103	O-RING, piston	0.6 (15)	0.8 (20)	0.8 (20)	2
104	O-RING, foot cap	1.8 (46)	2.4 (61)	2.7 (69)	1
105	O-RING, packing nut top	1.9 (48)	1.9 (48)	1.9 (48)	1
106	O-RING, packing nut bottom	1.6 (41)	2.0 (51)	2.3 (58)	1
107	EXTRUSION, nylon; for rod end of piston	0.515 (13) length	0.515 (13) length	0.515 (13) length	1
108	EXTRUSION, nylon; for flow nut end of piston	0.375 (10) length	0.375 (10) length	0.375 (10) length	1

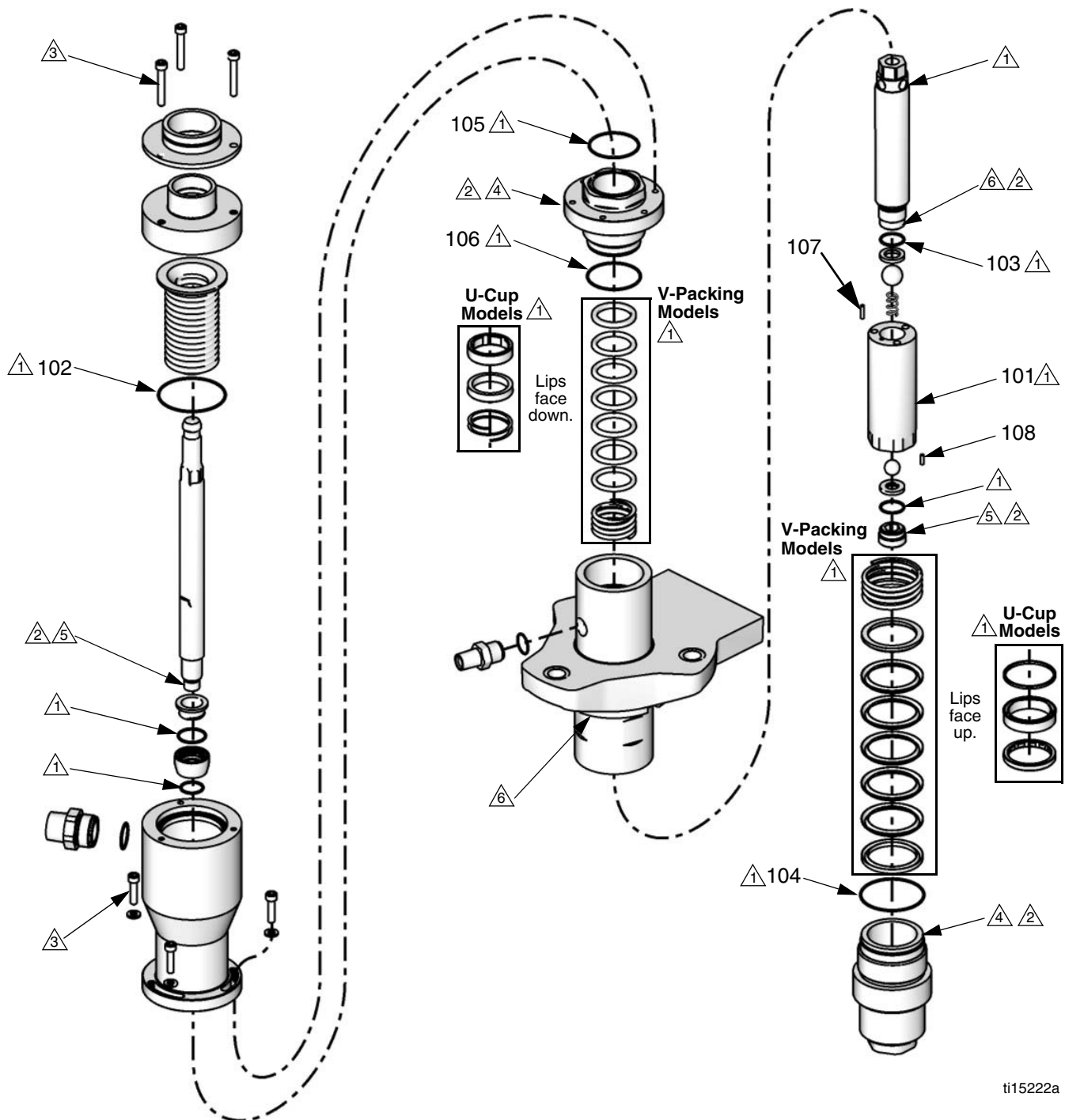
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Original instructions. MM 406873

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NOTE: Full disassembly shown. Disassemble only as far as needed for the parts being replaced.



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- △1 Apply grease.
- △2 Apply thread lubricant.
- △3 Torque to 100-120 in-lb (11-14 N•m).
- △4 Torque to 54-66 ft-lb (73-89 N•m).

- △5 Torque to 74-86 ft-lb (100-117 N•m).
- △6 Torque to 91-109 ft-lb (123-148 N•m).