

V-Packing Repair or Conversion Kits

406845D

Merkur™ Bellows Pumps

ENG

**Important Safety Instructions**

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

See reverse for parts illustration.

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

Ref.	Description	OD in. (mm)			Qty.
		24A655 (Standard) and 24J858 (Reinforced PTFE Seals)† for LB050x (50cc)	24A656 (Standard) and 24J859 (Reinforced PTFE Seals)† for LB100x (100cc)	24A657 (Standard) and 24J860 (Reinforced PTFE Seals)† for LB150x (150cc)	
101	SPRING, piston	1.7 (43)	2.2 (56)	2.6 (66)	1
102	GLAND, male, piston				1
103	V-PACKING, piston, UHMWPE				3
104	V-PACKING, piston, PTFE				2
105	GLAND, female, piston				1
106	O-RING, foot cap	1.8 (46)	2.4 (61)	2.7 (69)	1
107	SPRING, throat	1.3 (33)	1.6 (41)	1.9 (48)	1
108	GLAND, male, throat				1
109	V-PACKING, throat, UHMWPE				3
110	V-PACKING, throat, PTFE				2
111	GLAND, female, throat				1
112	O-RING, packing nut bottom	1.6 (41)	2.0 (51)	2.3 (58)	1
113	O-RING, packing nut top	1.9 (48)	1.9 (48)	1.9 (48)	1
114	O-RING, bellows chamber	2.5 (64)	2.5 (64)	2.5 (64)	1
115*	O-RING, piston	0.6 (15)	0.8 (20)	0.8 (20)	1
116†	PACKING, throat, reinforced PTFE	1.7 (43)	2.2 (56)	2.6 (66)	5
117†	PACKING, piston, reinforced PTFE	1.3 (33)	1.6 (41)	1.9 (48)	5

* May not be used. Piston and rod may separate during disassembly. If separated, always replace the o-ring before reassembly.

† Optional packing kit. See illustration on reverse. Use with materials that cause chemical compatibility concerns with UHMWPE, such as acid catalyst materials.

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Original instructions. This manual contains English. MM 406845

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Revised 06/2011

This diagram illustrates the assembly of a piston and cylinder, showing the following components and instructions:

- Optional Reinforced PTFE Packings:**
 - Throat packings:** Lips face down. Components 108, 110, 111, and 116 are shown.
 - Piston packings:** Lips face up. Components 102, 103, 104, 105, 106, 107, 117, and 118 are shown.
- Assembly Instructions:**
 - V-Packing Models:** Indicated for components 108, 109, 110, 111, 112, 113, 114, and 115.
 - U-Cup Models:** Indicated for components 102, 103, 104, 105, 106, 107, 108, 109, 110, 111, 112, 113, 114, and 115.
 - Lips face down:** Instruction for throat packings (108, 110, 111, 116).
 - Lips face up:** Instruction for piston packings (102, 103, 104, 105, 106, 107, 117, 118).

① Apply grease.

 Apply thread lubricant.

4 Torque to 54-66 ft-lb (73-89 N•m).

6 Torque to 91-109 ft-lb (123-148 N•m).

③ Torque to 100-120 in-lb (11-14 N•m).

5 Torque to 74-86 ft-lb (100-117 N•m).