



FOR 19875-00 PUMPS:

1. Set UF-118 in cylinder.
2. Set P/N APS-128 in body.
3. Lubricate P/N 13867-44 and install in groove of UF-118.
4. Install P/N APS-119.
5. Gently set P/N P33-11 through P/N 18289-00 Tie Rods and push down square and firm until it sets down over cylinder O-Ring.
6. Continue holding P33-11 down, install 4 P/N 7734-12 Lock Washers and hand thread 4 P/N 7733-17 Nuts.
7. Tighten P/N 7733-17 in a criss-cross pattern until tight.
8. Lubricate P/N 21595-00 Seal (inside of P/N 21440-00 housing).
9. Gently push down over Pump Shaft P/N 21599-00 and set flush to P/N 18227-00 Pump Head.
10. Re-install pump in reverse order of removal.

MATERIAL PUMP TROUBLESHOOTING CHART

- Use this chart when trying to diagnose off ratio or poor mix conditions.
- Use only after verifying the following information.
 1. Transfer pump filters (when used) are clean.
 2. Gun filters are clean.
 3. Auxiliary filters (when used) are clean.
 4. Porting in the gun are clean and proper alignment is checked.
 5. If transfer pumps are used;
 - a. spring loaded pumps: pump set at 100 psi fluid pressure (Aro 2:1)
 - b. unloaded pumps: not to exceed 100 psi fluid pressure (50 psi on Aro 2:1)
- Remove side blocks from gun.
- Set main pump air regulator at 0 psi.
- Heat settings normal.
- Transfer pumps at recommended setting.

Fig. 1

- Pump loses pressure on up stroke.
- Upper ball/seat damaged or debris caught in seat.
 - Inner cylinder seal damaged.
- Pump loses pressure on down stroke.
- Lower ball/seat damaged or debris caught in seat.
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