

\*NOT INCLUDED IN KIT-A

DESCRIPTION	PART NO.	QTY	DESCRIPTION	PART NO.	QTY
<b>KIT A, 348U, 350U, 357U</b>	10013		<b>KIT B</b>	10004	
Plunger	▲	1	White Washer, 1/2" ID	▲	8
O-Ring, 1-117	▲	2	Valve Assembly	▲	4
Seal Ring, 1-124	▲	2	O-Ring, 1-116	▲	4
Plunger Guide	▲	2	Retainer Plate	*	2
Support Ring, 1-116	▲	4	Pump Head	*	2
U-Cup	▲	2	Pump Manifold	*	1
O-Ring, 1-024	▲	4			

(▲) Sold only as part of a kit. | (\*) Not part of a kit, for identification only.

**A DOWNLOADABLE VERSION OF THE PARTS LIST AND DISSASSEMBLY/REASSEMBLY INSTRUCTIONS IS AVAILABLE UNDER THE DOWNLOADABLE DOCUMENTS TAB.**

1. Remove pump from motor using a 3/16" hex wrench for Model 348U, and use 5/16" hex wrench for Models 350U and 357U. Remove bolts at each end of pump. Turn pump over so manifold is facing upward. Place manifold to side as a reference for reassembly.

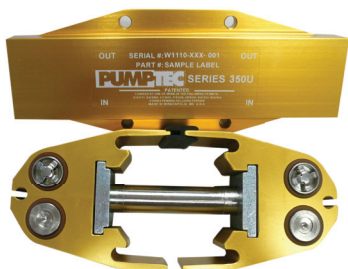


Figure 1

2. Holding each head, pull them apart to remove plunger. Remove retaining plate from pump head. Remove internal seal parts with finger. Discard parts, keeping the head and retainer plate.

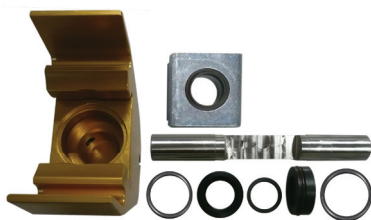


Figure 2

3. Clean the head with a rag or towel inspect for damage or excess corrosion. If the head is damaged, do not rebuild. Note the order and orientation of repair parts prior to installation.

4. Place one O-ring support, u-cup and u-cup support ring into bore. Verify that u-cup support ring is flush with top of u-cup. Place guide O-ring around guide and lightly grease. Press guide with O-ring installed into bore. Place retainer O-ring into recessed area around top of bore.

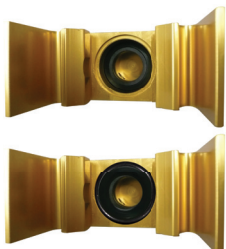


Figure 3

5. Place vacuum seal O-ring around vacuum seal. Lightly grease O-ring and press into recess in retaining plate. Be careful to apply even pressure and eliminate bulges in O-ring.

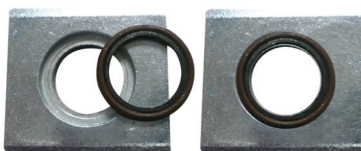


Figure 4

6. Grease edge of retaining plate and slide into place. If large retainer O-ring dislodges, do not slide plate, but push O-ring back into place before sliding into place completely.

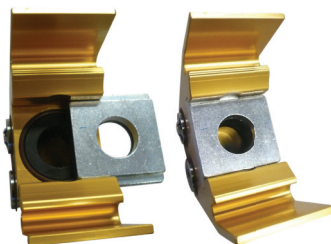


Figure 5

7. Repeat the previous steps 3-5 with the other head.

8. Lightly grease the plunger with provided grease in small clear tube. Slide plunger into one head assembly and then slide the other head onto plunger. Place head and plunger assembly on work surface with valves facing upward.

9. Adjust plunger slot position towards center and have slot facing work surface. Replace all valves, O-rings and white washers. Refer to image and manifold label to understand proper orientation.

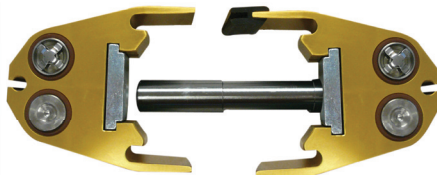


Figure 6

10. Place manifold on top of plunger and head assembly. It may be necessary to move heads on plunger to have valves align with valve pockets on manifold. Be careful to not lose the white washers in the manifold during reassembly.



Figure 7

11. Turn assembly over and place shorter bolt and washer assembly into heads and tighten finger tight. DO NOT tighten completely at this time.

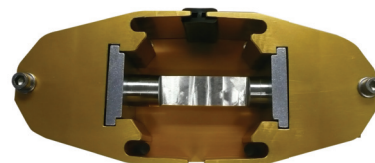


Figure 8

12. Install black grease from included packet into corners and center of plunger slot as shown.

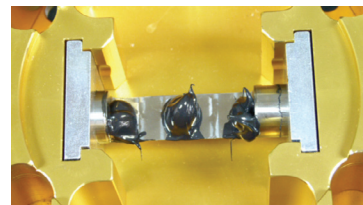


Figure 9

13. Mount pump back onto motor and tighten mounting bolts to 14 in/lbs. of torque. Tighten head bolts to 14 in/lbs. of torque.