



U-Cup Repair or Conversion Kit

406846C

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 and assembly notes.

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

Kit 24E716, LB050x (50 cc) pumps
Kit 24E631, LB100x (100 cc) pumps
Kit 24E632, LB150x (150 cc) pumps

Kit 26A234, LB100C (100 cc) pumps - acid

Ref.	Description	OD in. (mm)			Qty.
		Kit 24E716	Kit 24E631	Kit 24E632	
101	BEARING, throat	1.3 (33)	1.6 (41)	1.9 (48)	1
102	U-CUP, throat	1.0 (25)	1.4 (36)	1.7 (43)	1
103	SPRING CLIP				1
104	BEARING, piston	1.7 (43)	2.2 (56)	2.6 (66)	1
105	U-CUP, piston	1.5 (38)	2.0 (51)	2.4 (61)	1
106	WASHER				1
107	O-RING, packing nut bottom	1.6 (41)	2.0 (51)	2.3 (58)	1
108	O-RING, packing nut top	1.9 (48)	1.9 (48)	1.9 (48)	1
109	O-RING, foot cap	1.8 (46)	2.4 (61)	2.7 (69)	1
110	O-RING, bellows chamber	2.5 (64)	2.5 (64)	2.5 (64)	1
111*	O-RING, piston	0.6 (15)	0.8 (20)	0.8 (20)	1

Ref.	Description	OD in. (mm)	Qty.
101	BEARING, throat		1
102	U-CUP, throat		1
103	SPRING CLIP		1
104	BEARING, piston		1
105	U-CUP, piston		1
106	WASHER, piston, 316 sst		1
107	O-RING, packing nut bottom	2.0 (51)	1
108	O-RING, packing nut top	1.9 (48)	1
109	O-RING, foot cap	2.4 (61)	1
110	O-RING, bellows chamber	2.5 (64)	1
111	O-RING, piston	0.99 (25)	2
112	BUSHING, bellows, 316 sst		1
113	O-RING, ptfе	0.88 (22)	1
114	BUSHING, snap, 316 sst		1
115	O-RING, packing	1.06 (27)	1
118	BELLOWS		1
119	SEAT, 17-4 sst	0.563 ID	1
120	BALL, sst		1
121	SPRING		1
122	BALL, metallic	9/16 in. (14)	1
123	SEAT, 17-4 sst	0.435 ID	1
124	FLOW-THROUGH NUT		1
125	O-RING, inlet	1.004 (25.5)	1
126	O-RING, outlet	0.59 (15)	1

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


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Original instructions. MM 406846

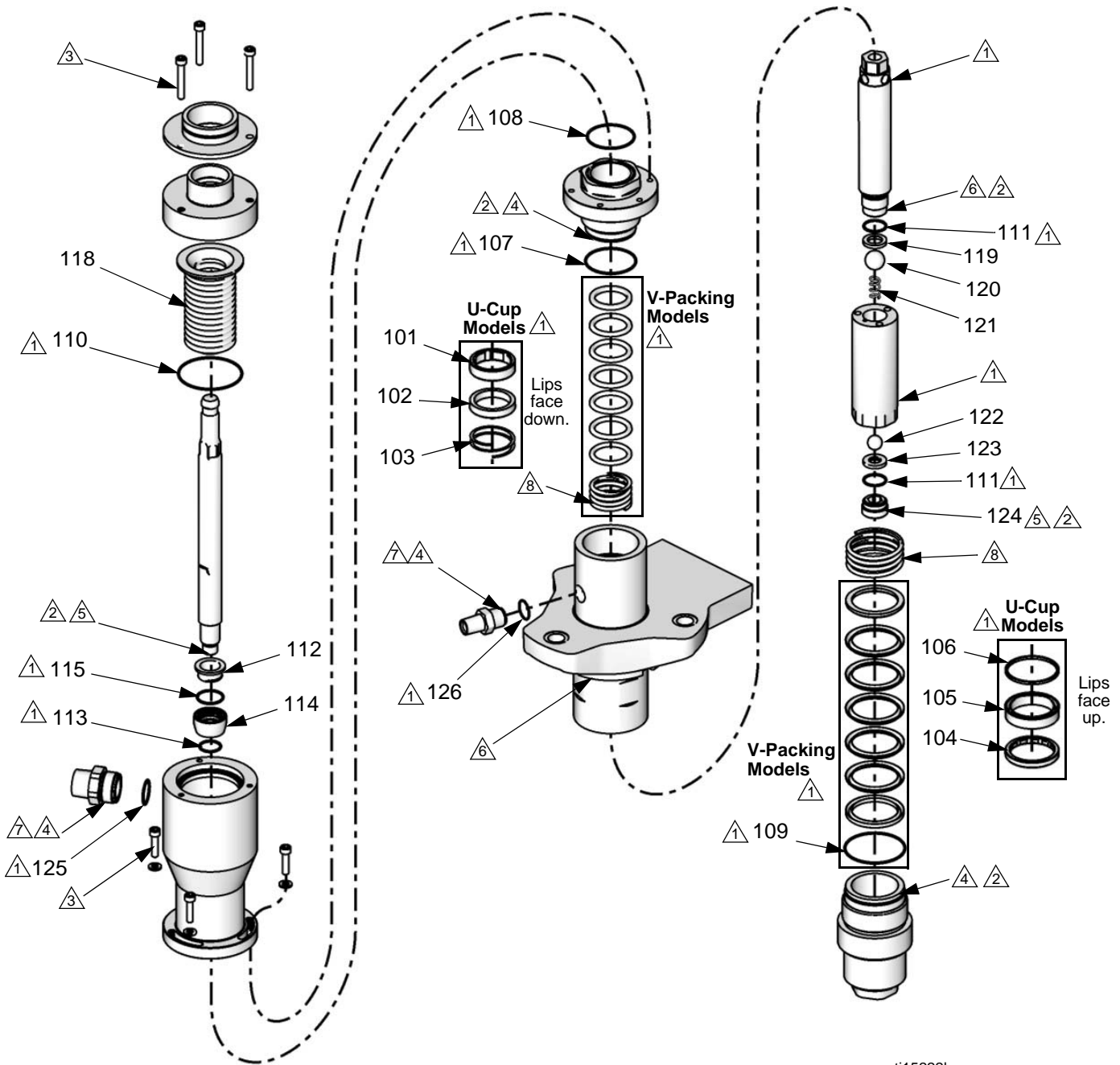
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Revision C, September 2016




NOTICE




To convert from v-packings to u-cup packings, you must **remove** the springs marked . Failure to remove the springs may result in damage to the pump or poor pump performance.



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



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-  Apply grease.
-  Apply thread lubricant.
-  Torque to 100-120 in-lb (11-14 N•m).

-  Torque to 54-66 ft-lb (73-89 N•m).
-  Torque to 74-86 ft-lb (100-117 N•m).
-  Torque to 91-109 ft-lb (123-148 N•m).

-  Apply high-strength thread locker.
-  To convert from v-packings to u-cup packings, you must **remove the springs**.