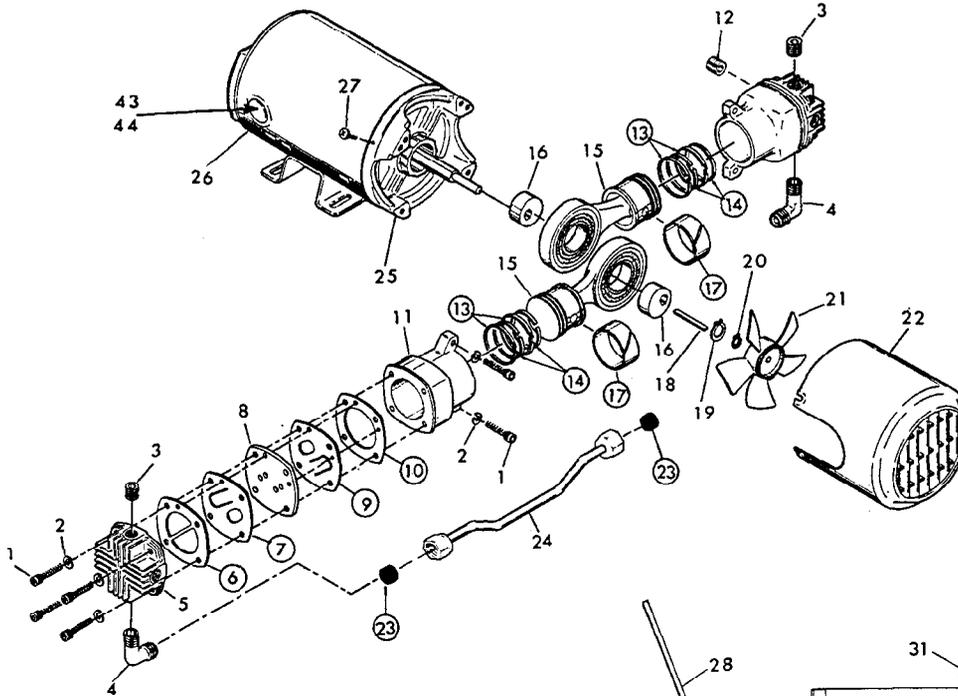




# SERVICE PARTS LIST

**BULLETIN NO.**  
54-34-0140

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
120V VACUUM PUMP ASSEMBLY			Sept. '90
CATALOG NO. 49-50-0140	STARTING SERIAL NO. 2 81	WIRING INSTRUCTION	



**NOTE:**  
All circled items are included in kit 14-46-0110 and are not available as individual parts.

Refer to back page of this bulletin for assembly details

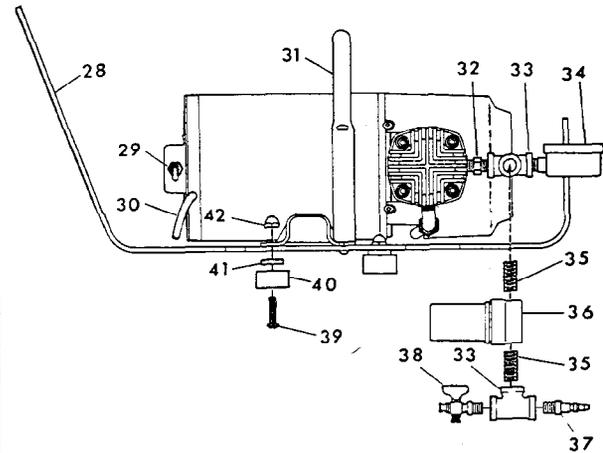
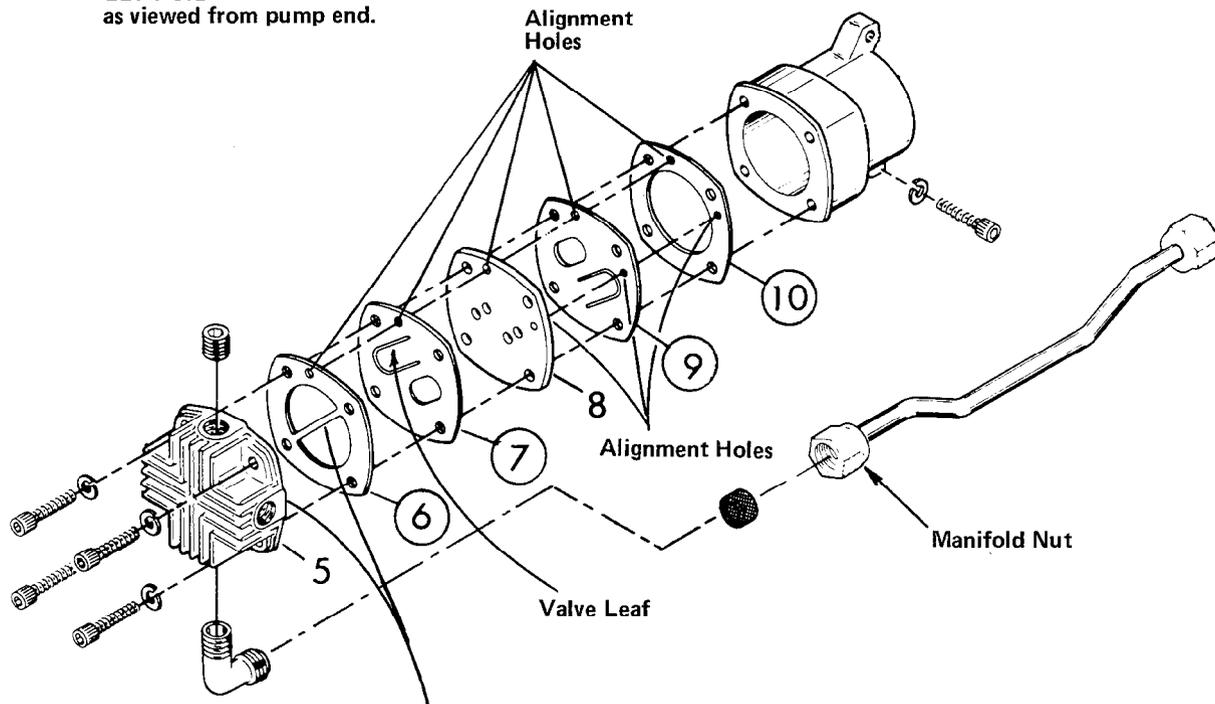


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
	1	06-75-3100 Head or Cylinder Screw	(12)
	2	06-97-4000 Lockwasher	(12)
	3	44-68-0150 Pipe Plug	(3)
	4	43-33-0170 Elbow Fitting	(2)
	5	43-64-0110 Cylinder Head	(2)
	6	- Head Gasket	(2)
	7	- Outlet Valve	(2)
	8	44-66-5310 Valve Plate	(2)
	9	- Inlet Valve	(2)
	10	- Cylinder Gasket	(2)
	11	42-98-0110 Cylinder	(2)
	12	43-31-0291 Muffler Orifice	(2)
	13	- Piston Ring	(4)
	14	- Piston Seal	(4)
	15	44-94-0190 Piston Rod Assembly	(2)
	16	43-16-0070 Eccentric	(2)
	17	- Rider Ring	(2)
	18	43-96-0080 Flat Key	(1)
	19	44-90-4205 Grip Ring	(1)
	20	44-90-4210 Retaining Ring	(1)
	21	22-84-0465 Fan	(1)
	22	45-12-0275 Schroud	(1)
	23	- Manifold Sleeve	(2)
	24	45-76-0175 Manifold Assembly	(1)
	25	42-36-0710 Bracket	(1)
	26	23-30-0130 Motor	(1)
	27	06-81-0061 Screw	(4)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
	28	42-36-0425 Pump Mounting Bracket	(1)
	29	23-66-0075 Switch & Mounting Bracket	(1)
	30	22-64-0385 Cord Set	(1)
	31	43-62-0530 Handle	(1)
	32	45-80-0140 Check Valve	(1)
	33	43-33-0200 Tee Fitting	(2)
	34	43-46-0100 Gauge	(1)
	35	43-33-0210 1/4" Close Nipple	(2)
	36	43-31-0310 Air Filter	(1)
	37	42-90-0110 Male Coupling	(1)
	38	45-80-0080 Air Cock Valve	(1)
	39	06-81-7850 1/4-20x1" Phil. Hd. Sem	(6)
	40	44-52-0110 Mounting Pad	(4)
	41	45-88-5247 Spacer	(4)
	42	06-55-1500 1/4-20 Nut	(6)
	43	22-56-0140 Cord Connector (Not Shown)	(1)
	44	44-76-0100 Cord Protector (Not Shown)	(1)

LEFT SIDE  
as viewed from pump end.



NOTE: Bar of cylinder head  
must align with bar  
of Head gasket

1. The valve leaf is pre-bent and should not be adjusted in any way.
2. **IMPORTANT:** Stack the valve components, using alignment holes (as shown) NOTE: Items 5 thru 10 are rotated 90 degrees clockwise on the right side of the unit.
3. Use lockwashers on all head screws.
4. Install one valve-head assembly to a cylinder. The exhaust ports in the cylinder head have been marked by omitting the ends of two of the fins. Do not tighten head screws at this time.
5. Install manifold nuts and manifold sleeves on the manifold and assemble into the elbow fitting, but do not tighten.
6. Install the second valve-head assembly to the outer cylinder and manifold.
7. Torque all head screws to 85-90 inch pound. Re-torque again.
8. Position manifold.
9. Tighten manifold nuts 1/2 to 3/4 turns beyond hand tight.

Do not use any chlorinated solvents to clean valves or any liquids to flush units. The stainless steel valves may be cleaned with water. All parts, except the valves, can be cleaned with any industrial non-flammable, non-toxic, cleaning solvent.