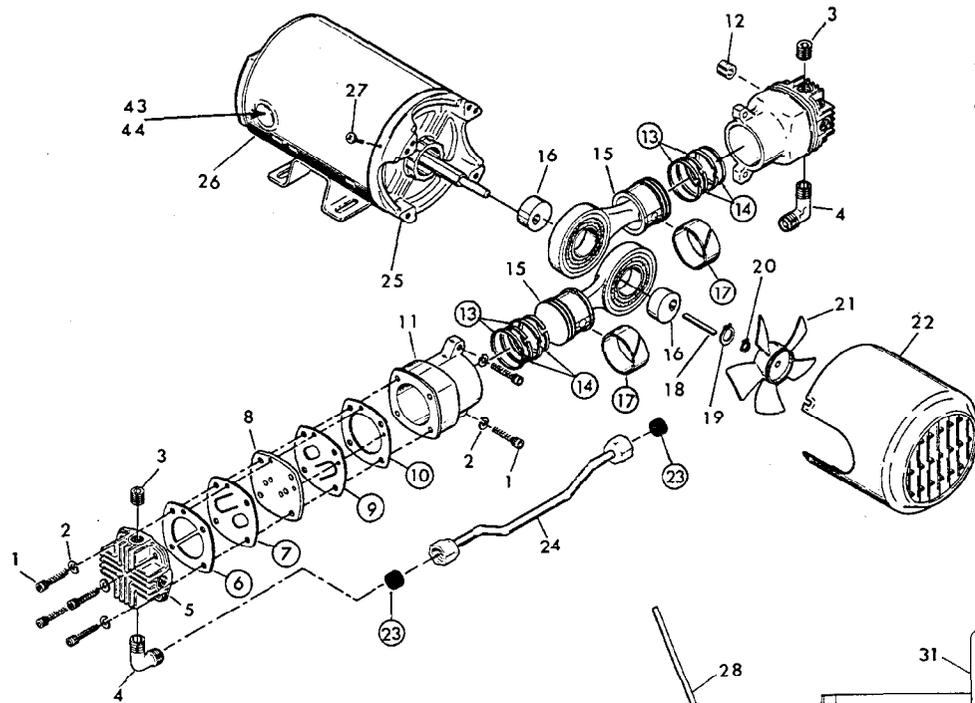




SERVICE PARTS LIST

BULLETIN NO.
54-34-0150

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
240V VACUUM PUMP ASSEMBLY			Sept. '90
CATALOG NO. 49-50-0150	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

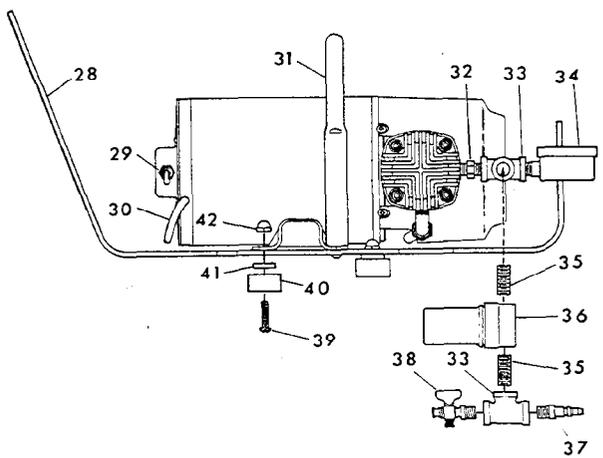
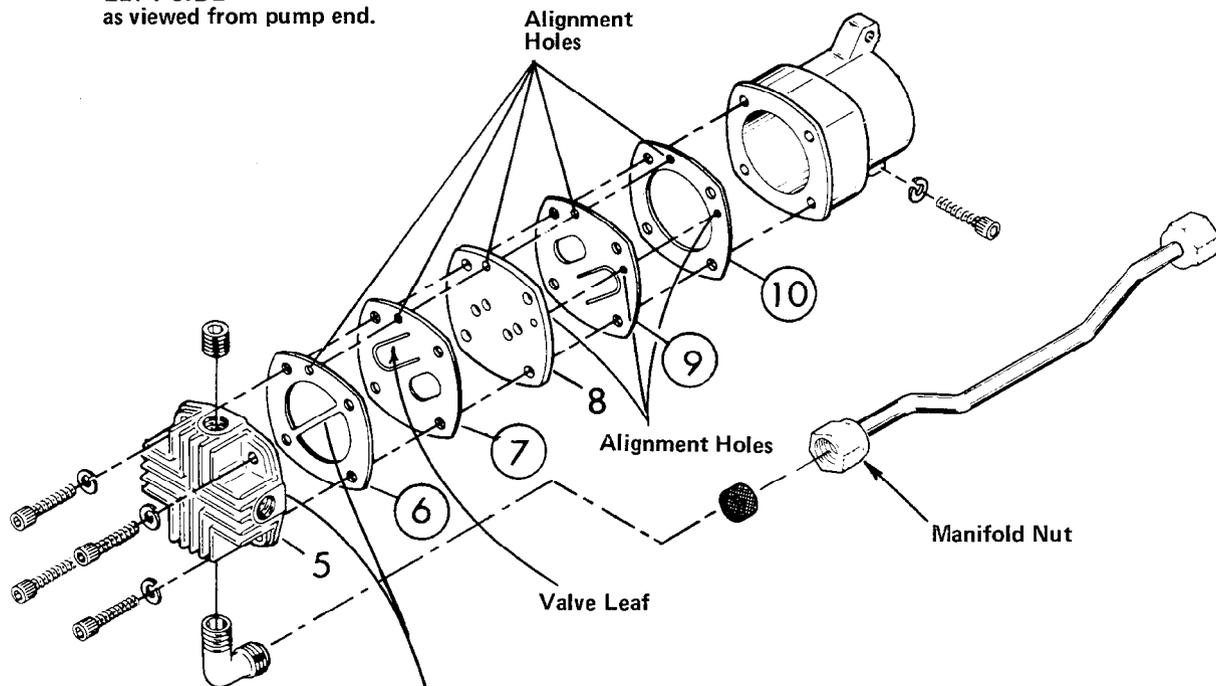


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	06-75-3100	Head or Cylinder Screw	(12)
2	06-97-4000	Lockwasher	(12)
3	44-68-0150	Pipe Plug	(3)
4	43-33-0170	Elbow Fitting	(2)
5	43-64-0110	Cylinder Head	(2)
6	-	Head Gasket	(2)
7	-	Outlet Valve	(2)
8	44-66-5310	Valve Plate	(2)
9	-	Inlet Valve	(2)
10	-	Cylinder 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	42-36-0711	Bracket	(1)
26	23-30-0136	Motor (Includes 42-36-0711 Bracket)	(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	22-64-4200	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	45-80-0030	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.