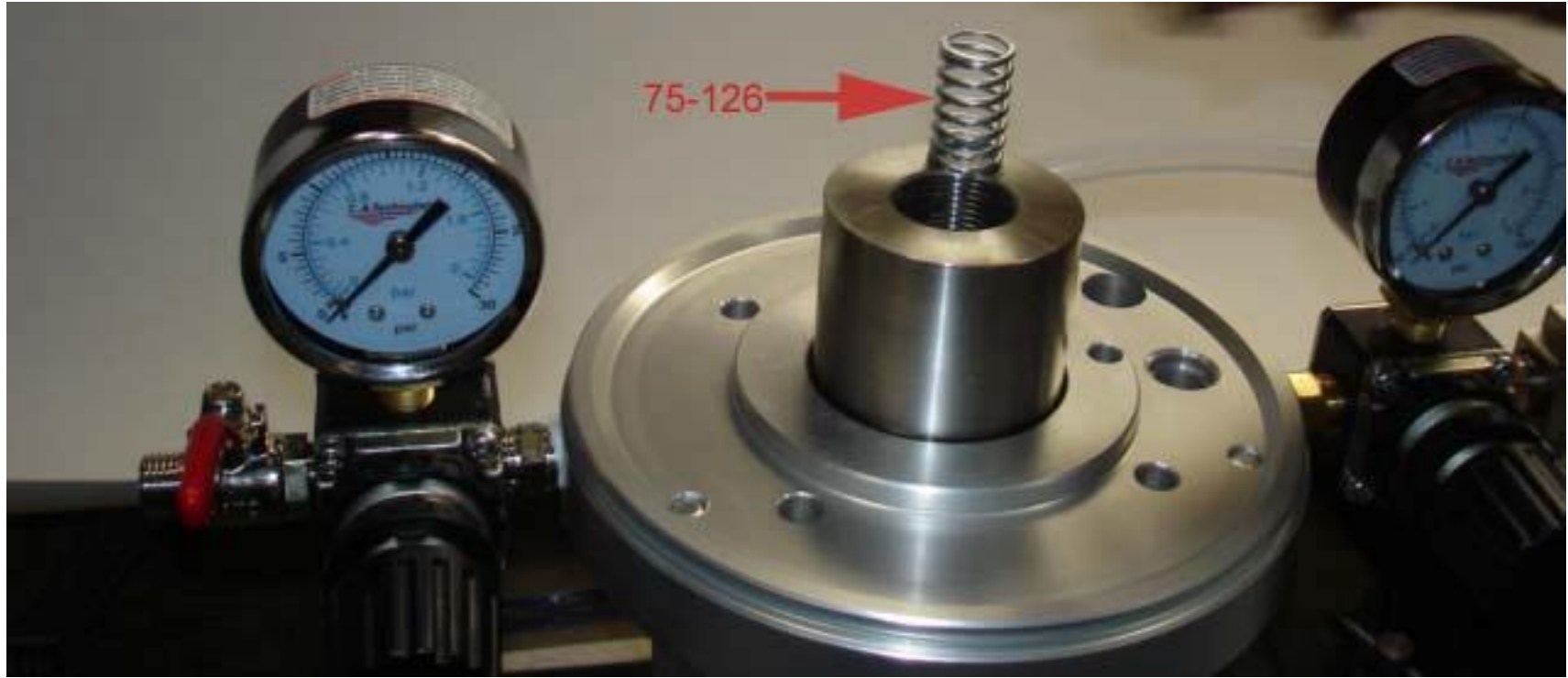




14:1 Air Assist Airless
Air Motor and Fluid section
Assembly Instructions









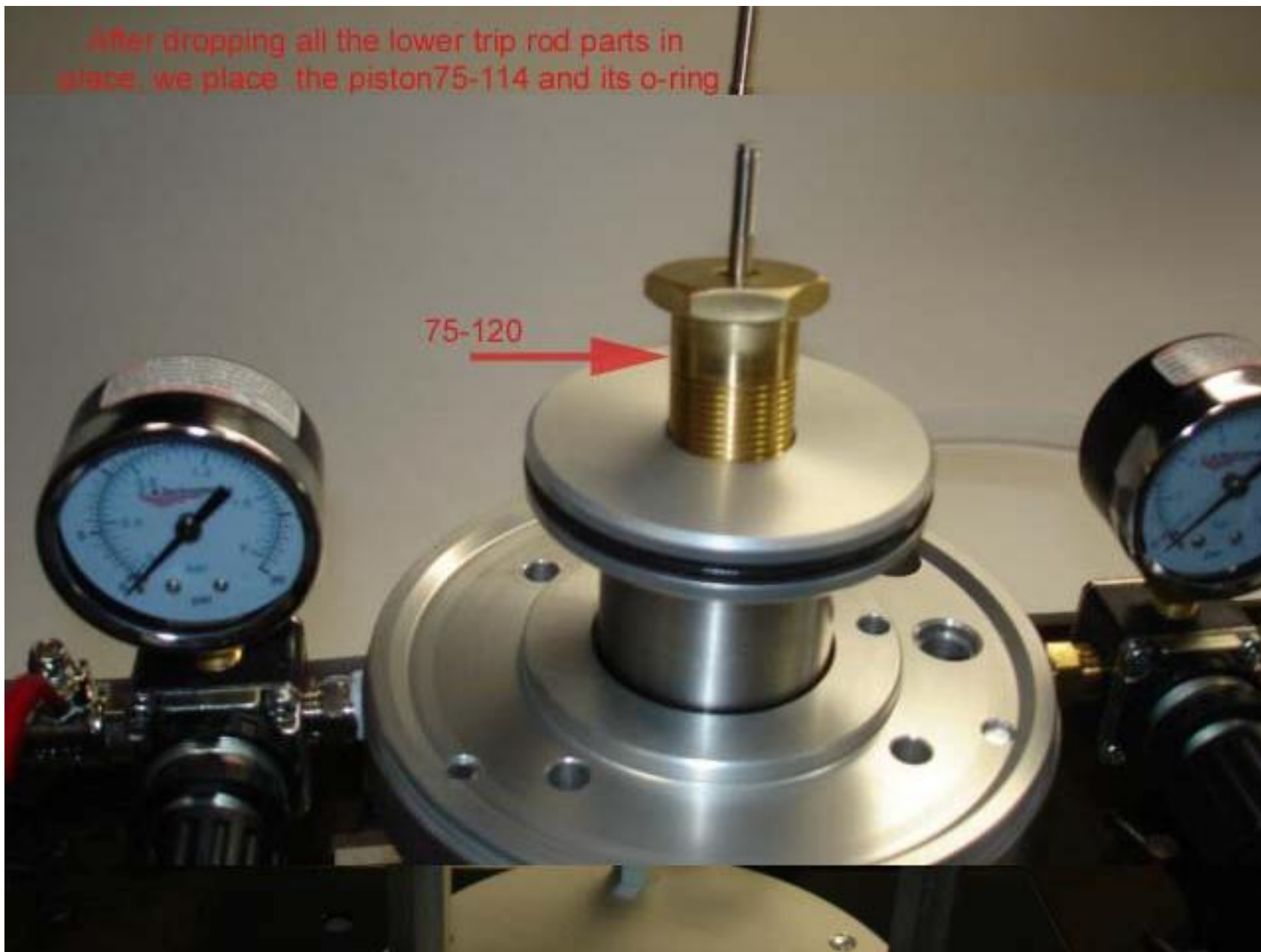
75-126
second spring (1 before the trip rod
and one after the trip rod 75-117 is put in place





after dropping all the lower trip rod parts in place, we place the piston 75-114 and its o-ring

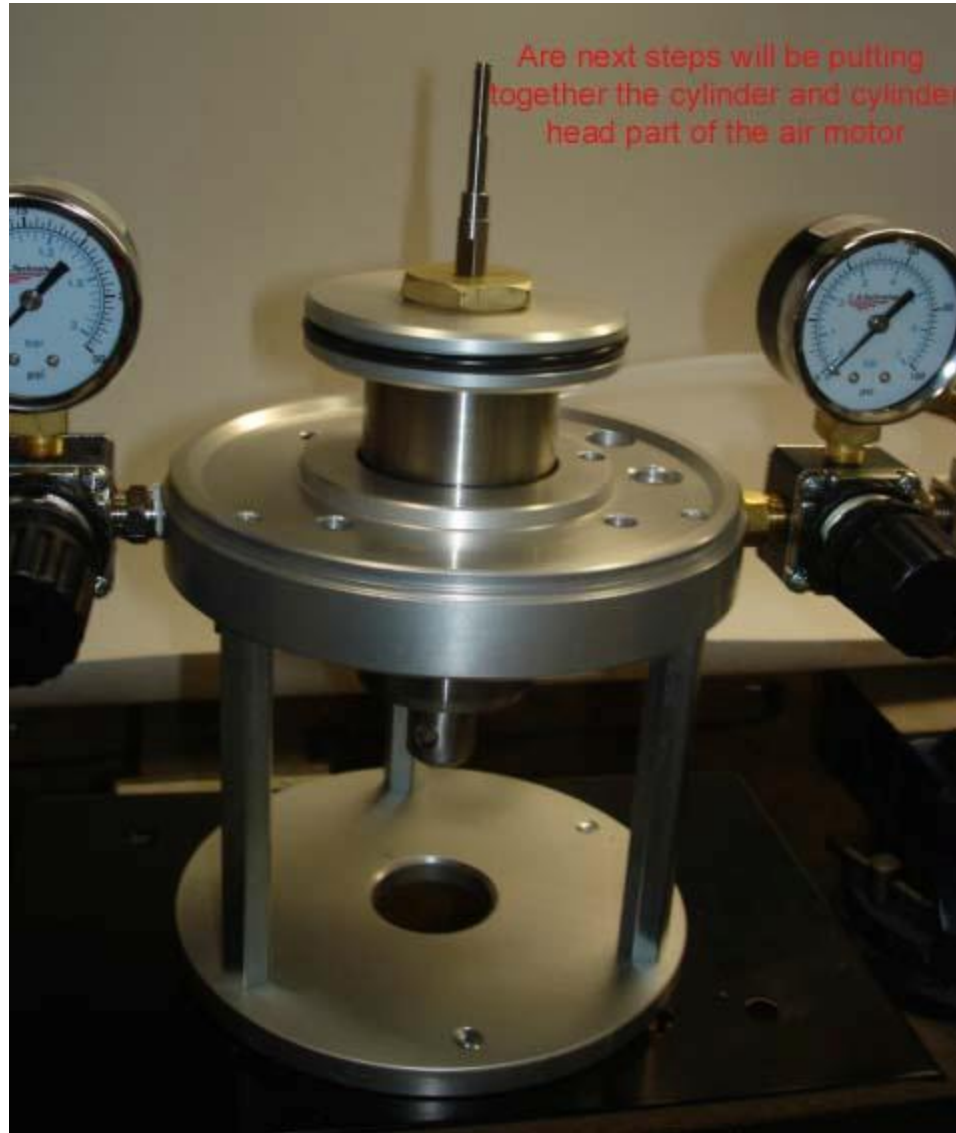
75-120



Once all parts are in place tighten up the 75-120 pistonretainer with a crescent wrench. This should be snug



Are next steps will be putting together the cylinder and cylinder head part of the air motor

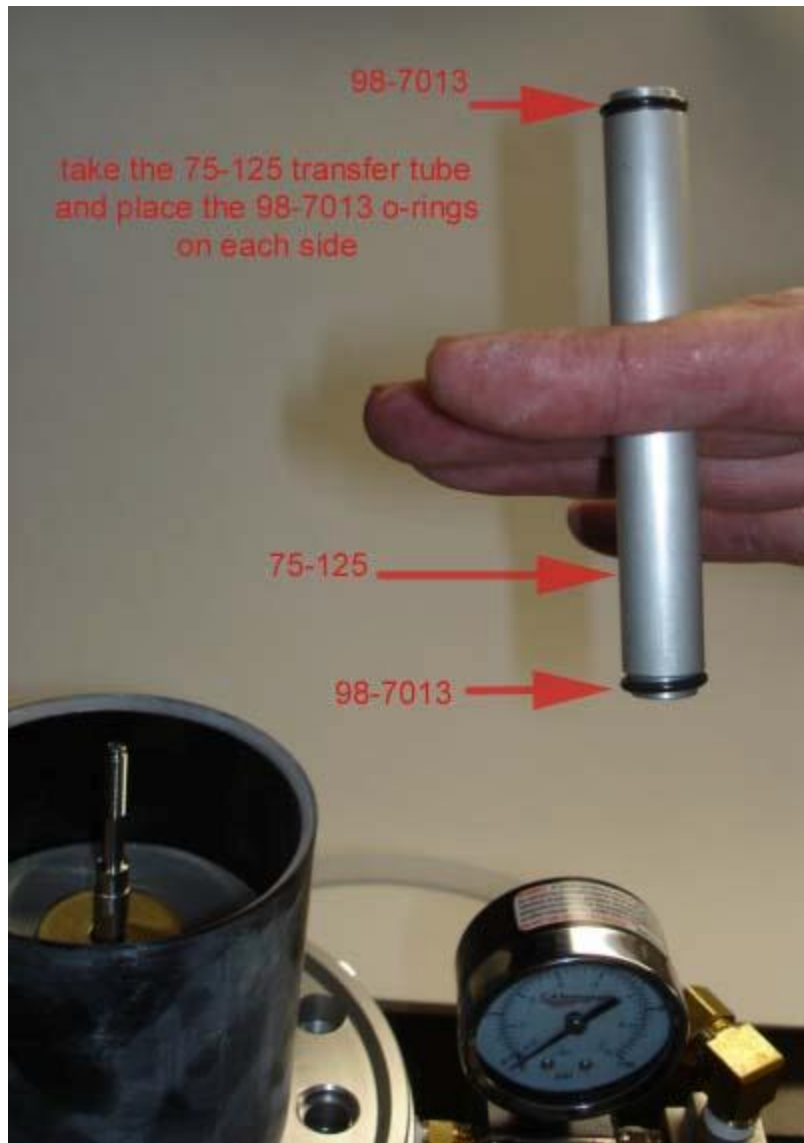






Make sure 75-111 cylinder is completely over the 98-7042 o-ring.



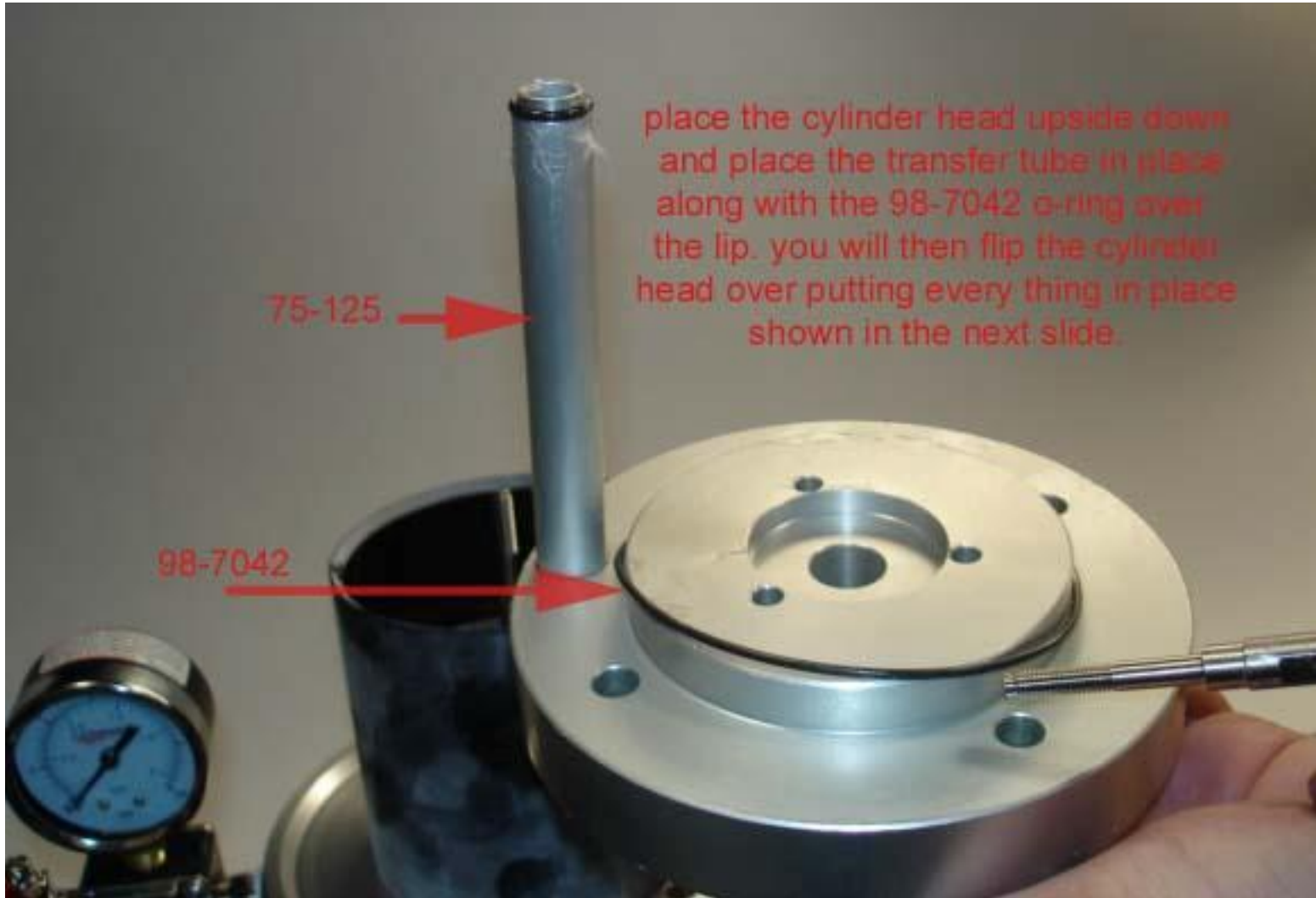


take the 75-125 transfer tube
and place the 98-7013 o-rings
on each side

98-7013

75-125

98-7013



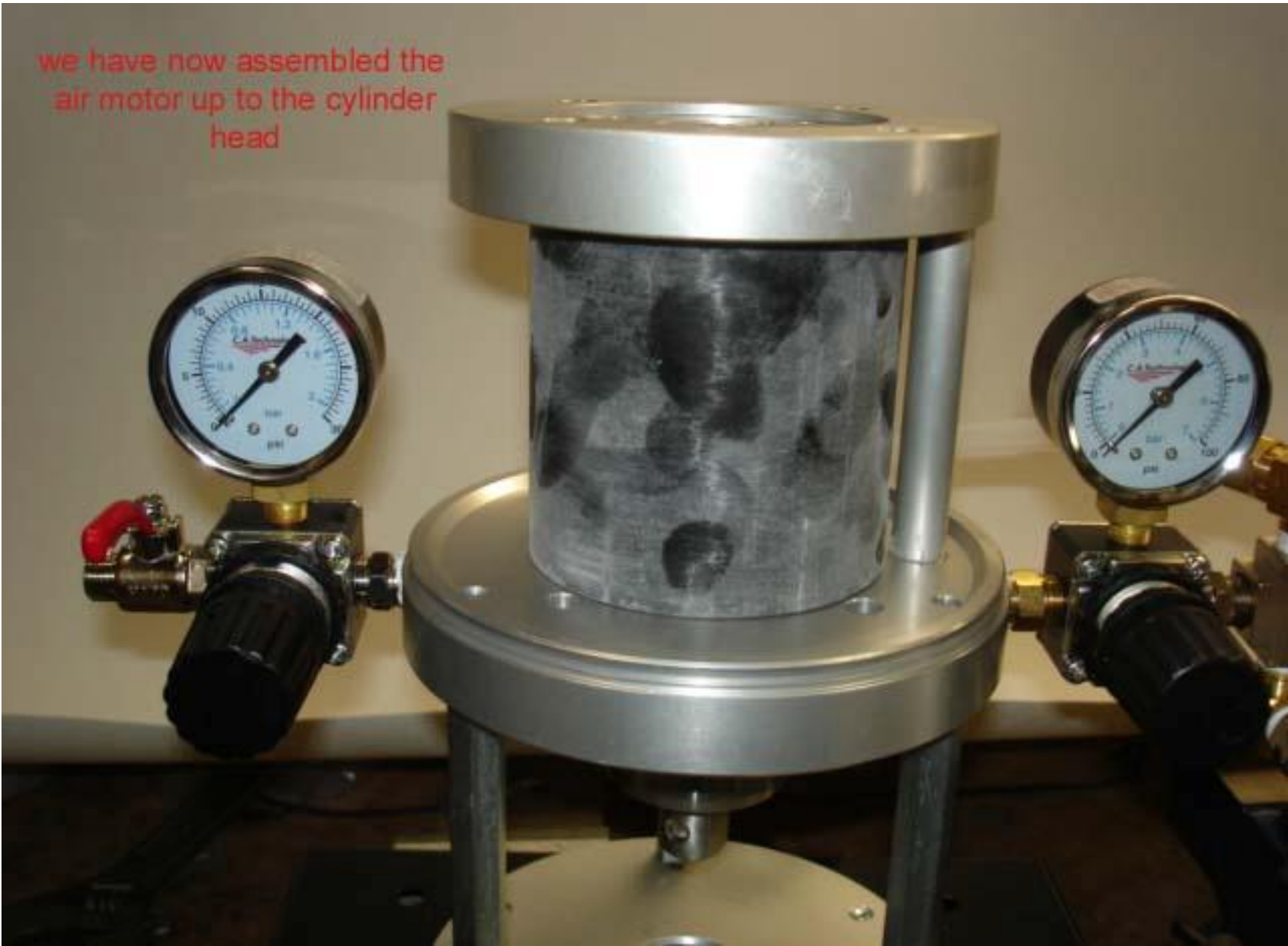
place the cylinder head upside down and place the transfer tube in place along with the 98-7042 o-ring over the lip. you will then flip the cylinder head over putting every thing in place shown in the next slide.

75-125

98-7042

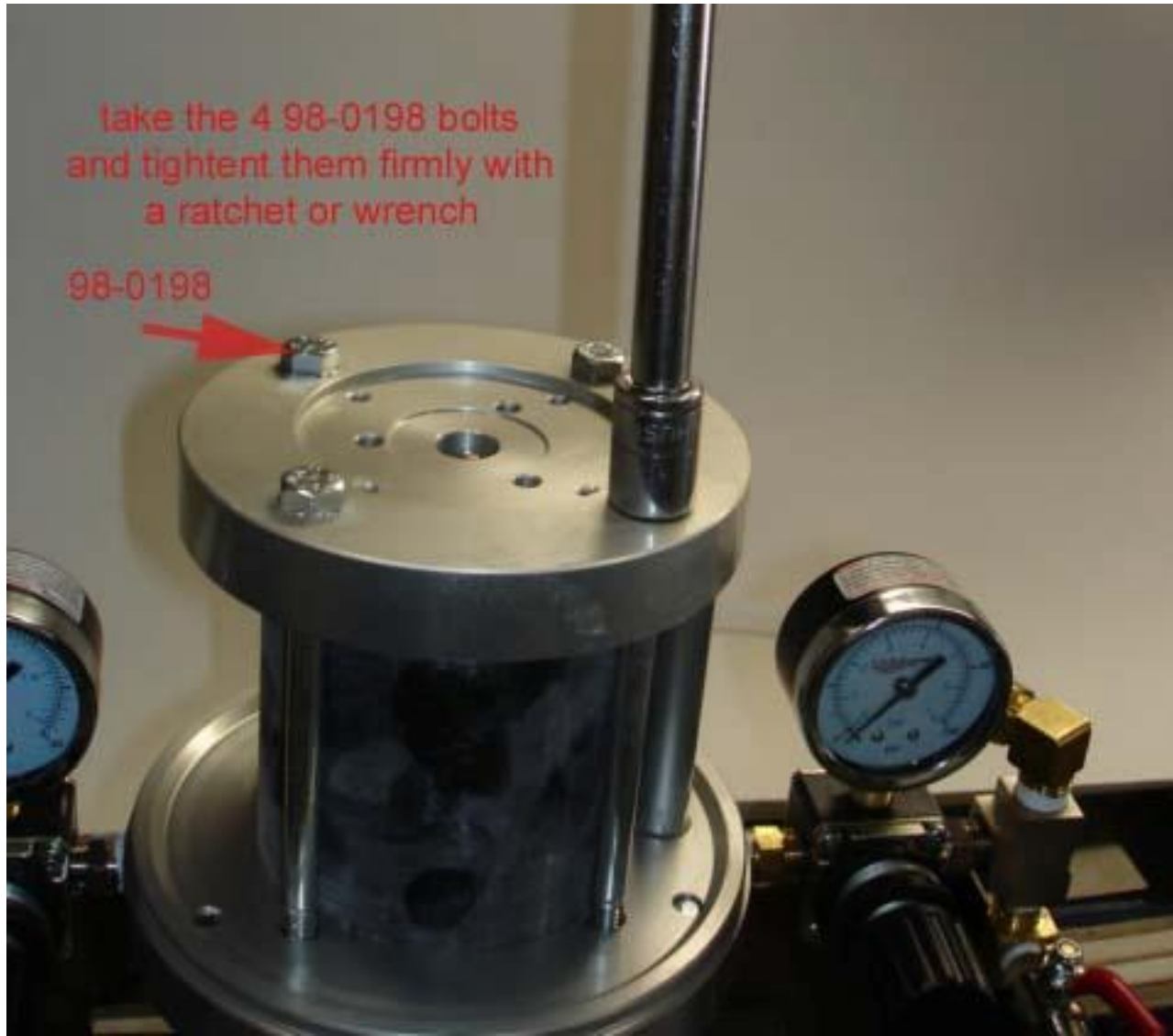


we have now assembled the
air motor up to the cylinder
head



take the 4 98-0198 bolts
and tightent them firmly with
a ratchet or wrench

98-0198



in order to work on the upper part of the air motor
we need to place the pump in the up position we accomplish
this by pushing up on the 75-116 motor rod as shown

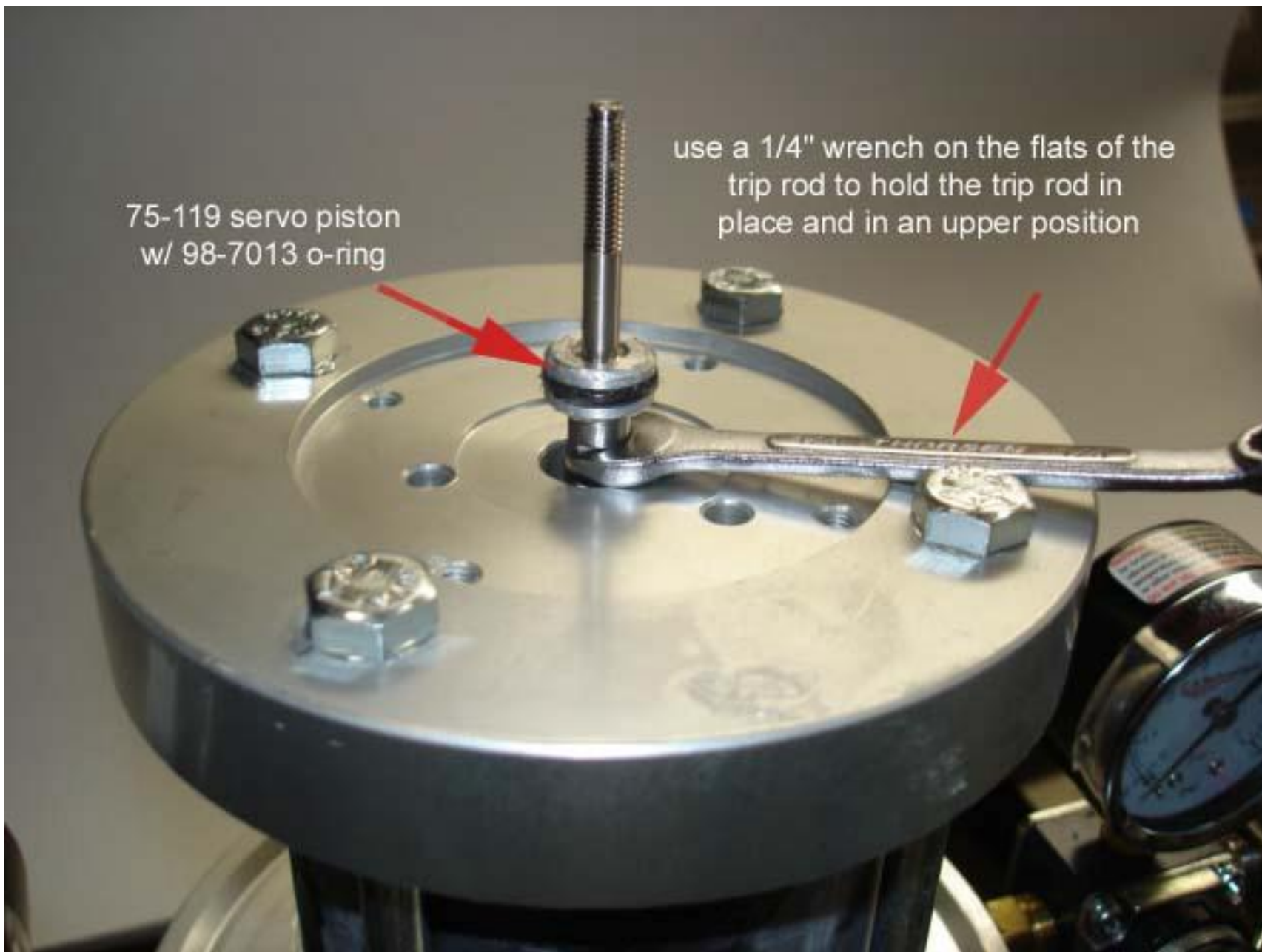


all of the assembly of the next parts will be placed directly on
the top of the trip rod (part #75-117)



75-119 servo piston
w/ 98-7013 o-ring

use a 1/4" wrench on the flats of the
trip rod to hold the trip rod in
place and in an upper position



75-134 spacer



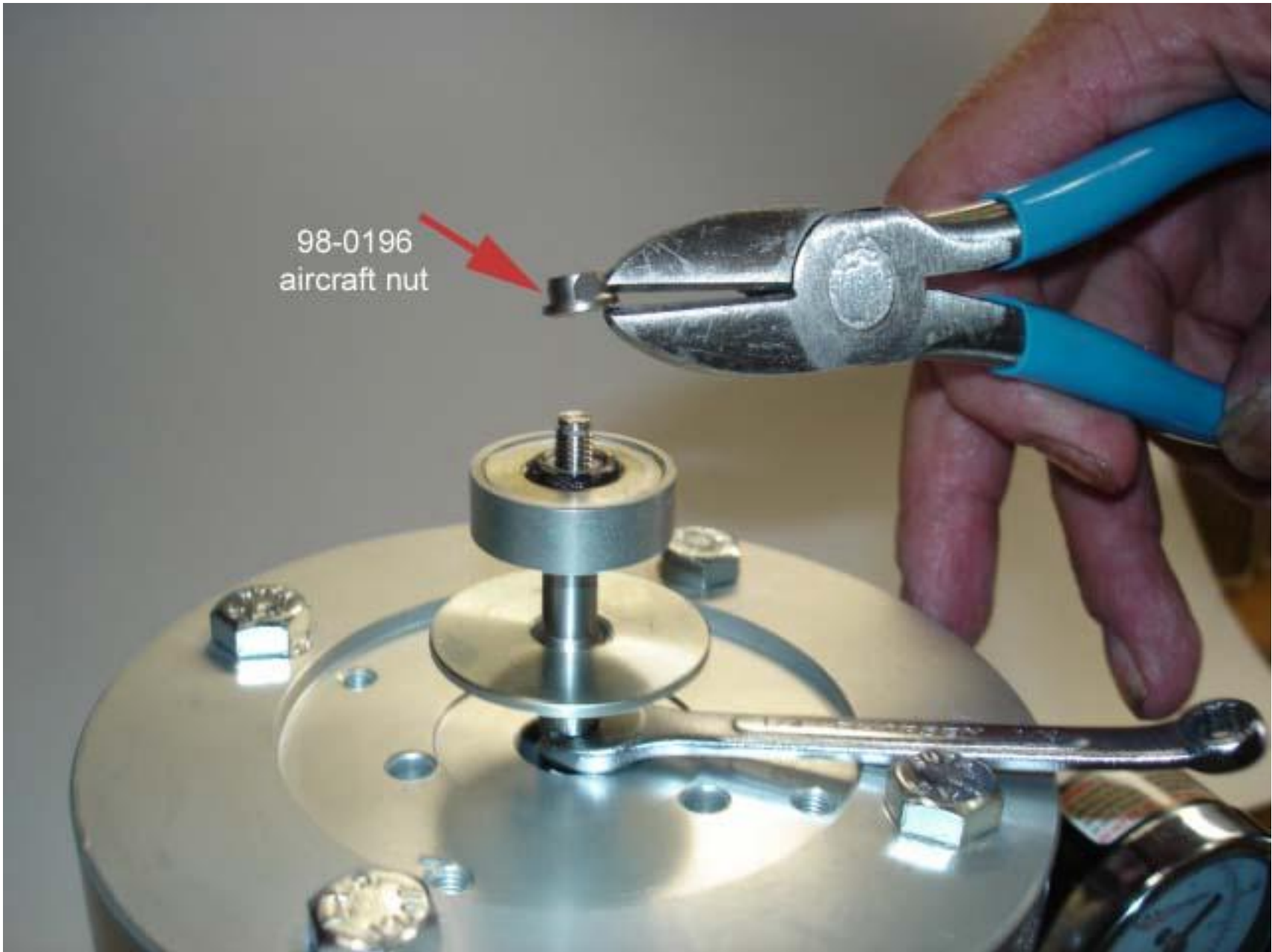
slide on 1 of the 75-133 valve plates



place the 2 98-6108 o-rings on each side of the 75-130 magnet assembly, then screw the magnet assembly onto the threaded part of the trip rod

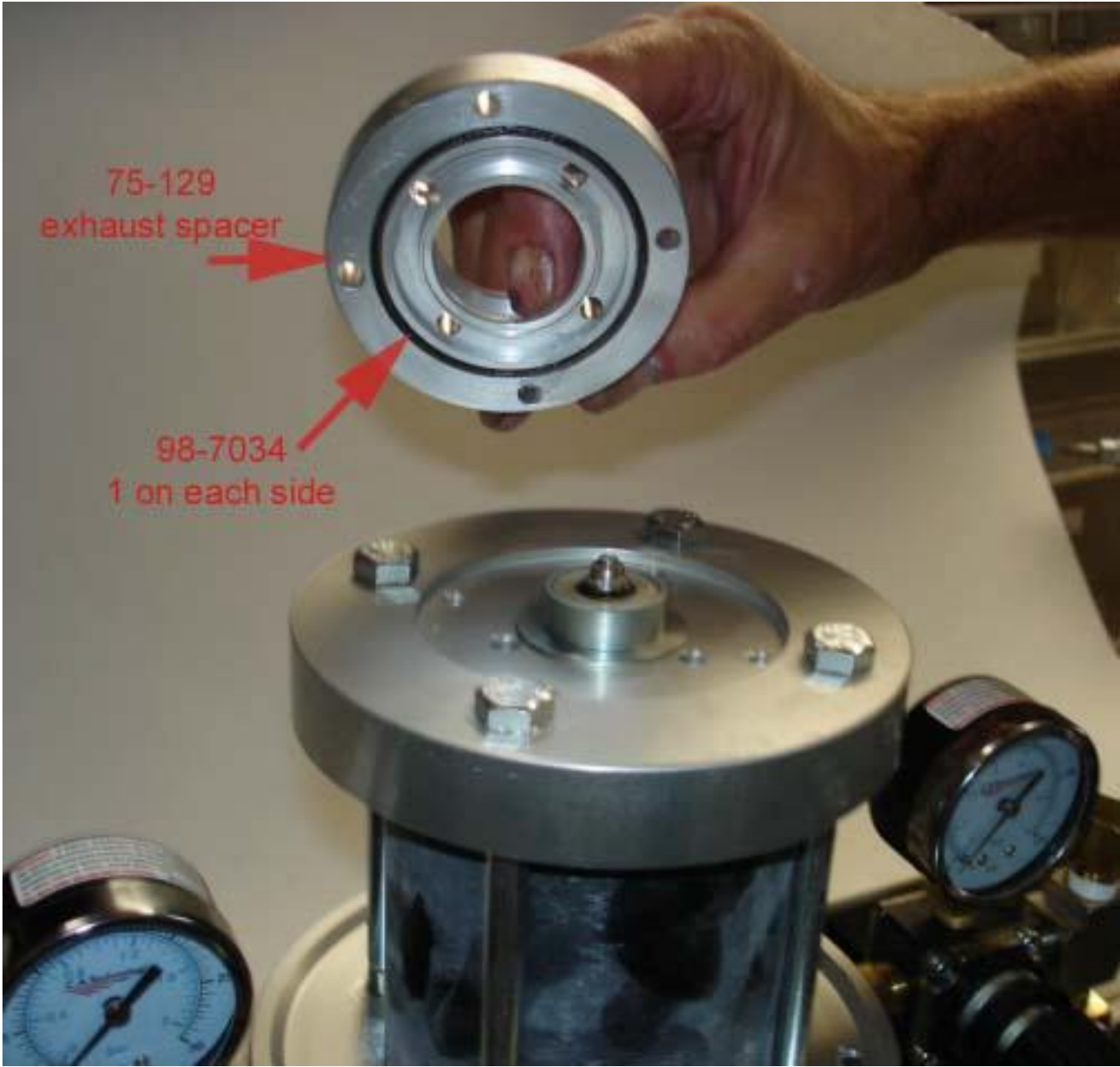


98-0196
aircraft nut



with a second 1/4" wrench, tighten
down the aircraft nut
so that it is snug against the
o-ring of the magnet assy





75-129
exhaust spacer

98-7034
1 on each side



75-133 valve plate
(2 of 2)



Tighten down exhaust cap with
98-0197 allen bolts

75-115
exhaust cap





Fluid section part 1
Pump rod and Upper Ball cage

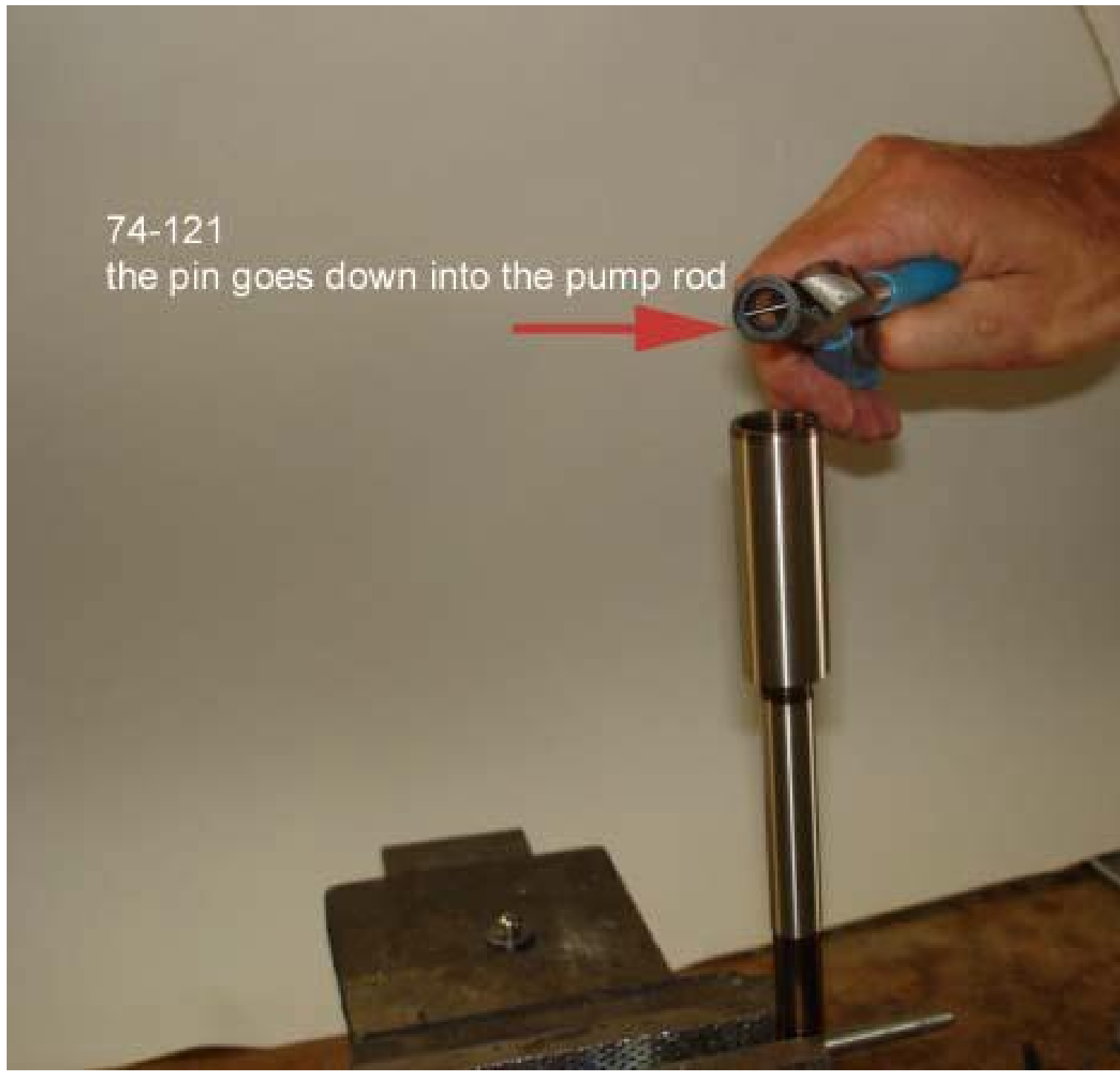
we will now assemble the upper ball cage of the AAA the upper ball cage is located in the bottom of the pump rod part # 74-126. we will turn the pump rod upside down to assemble.

75-126 →
pump rod



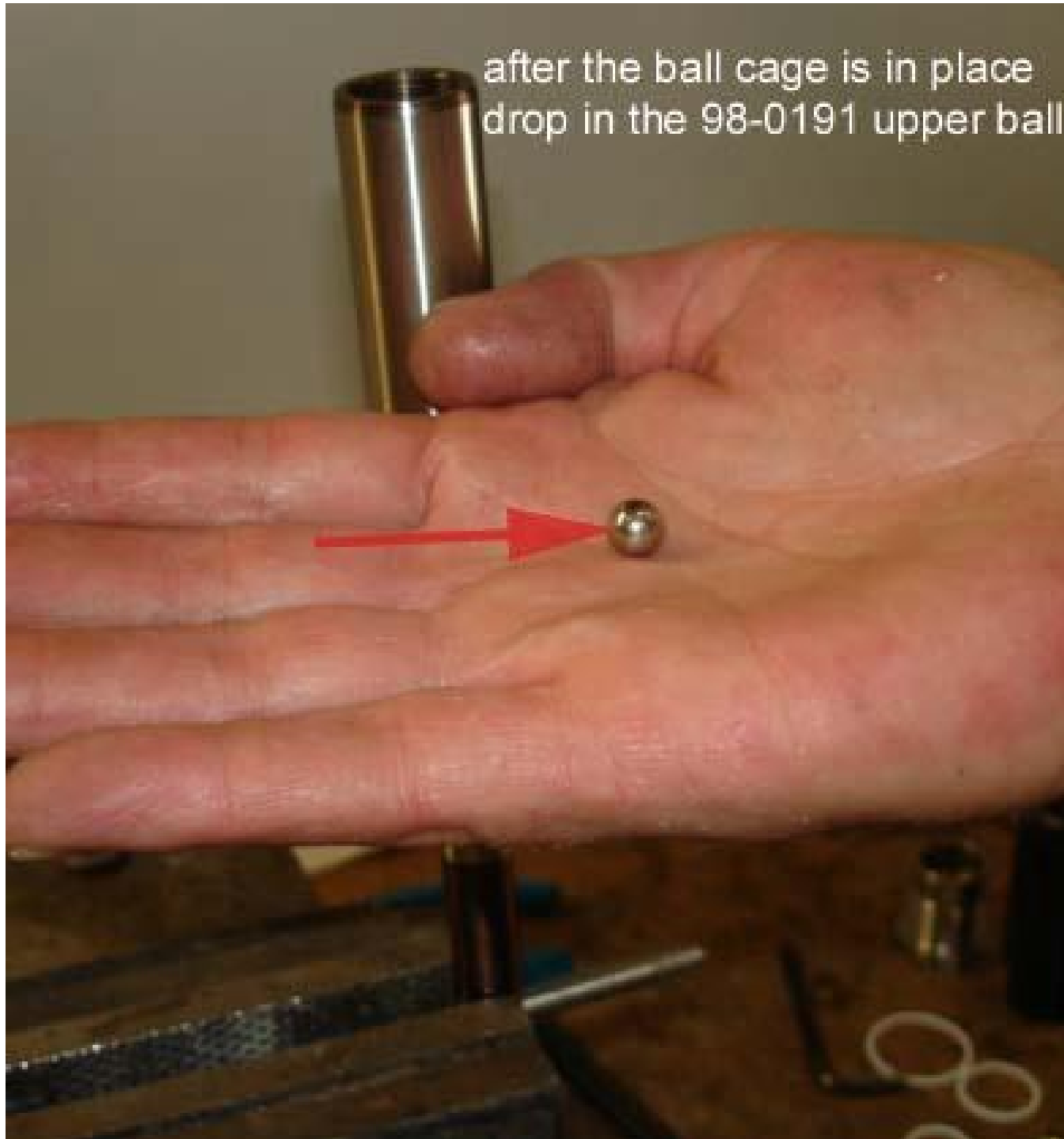
74-121

the pin goes down into the pump rod





after the ball cage is in place
drop in the 98-0191 upper ball



74-122





74-124
gasket

74-120

place the 74-122 gasket onto the flat part of the
74-120 seat retainer and screw into the pump rod
make sure all pieces that you put in before hand are
in straight and lined up correctly



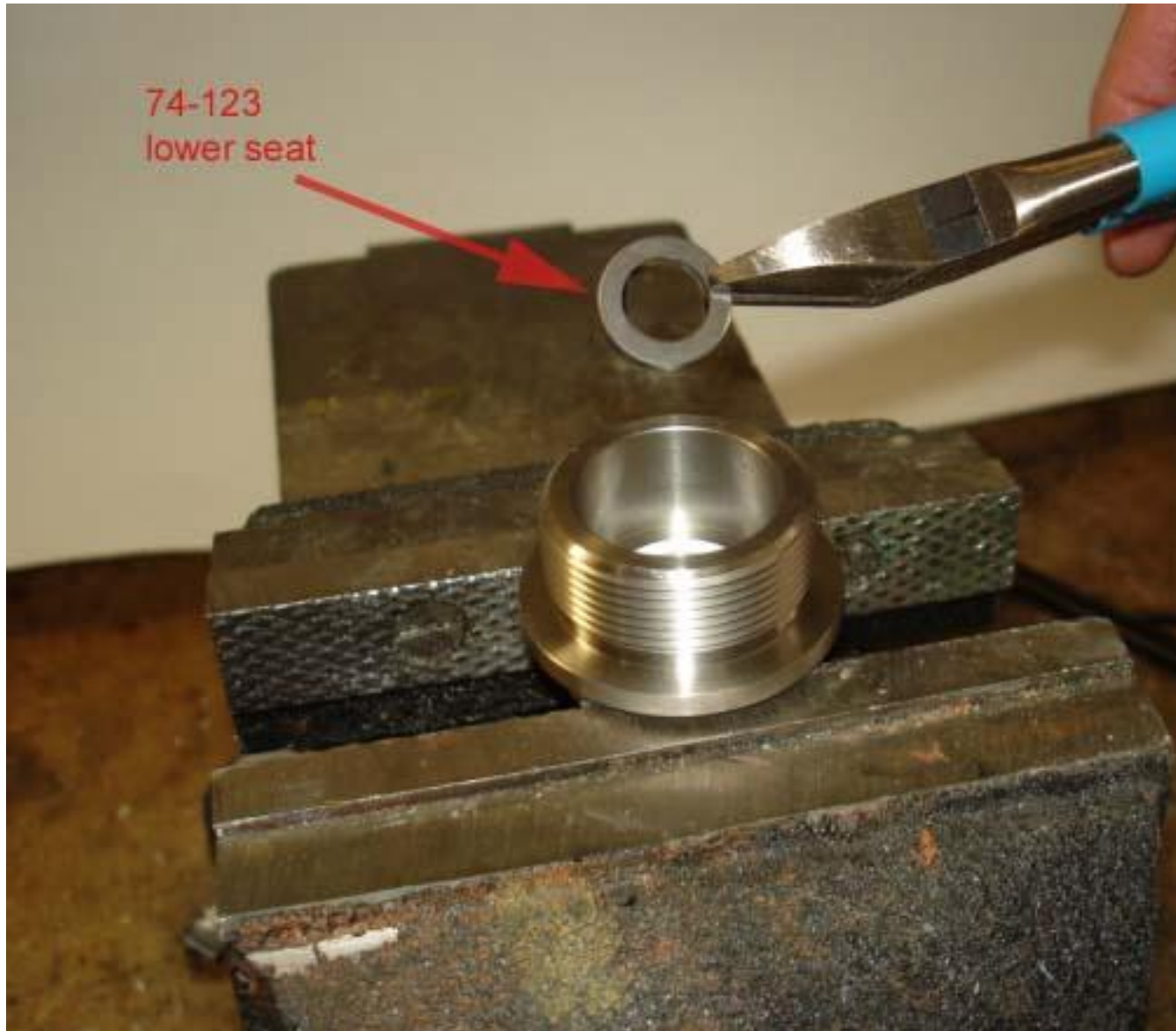


Fluid Section Part 2
Lower Ball Cage

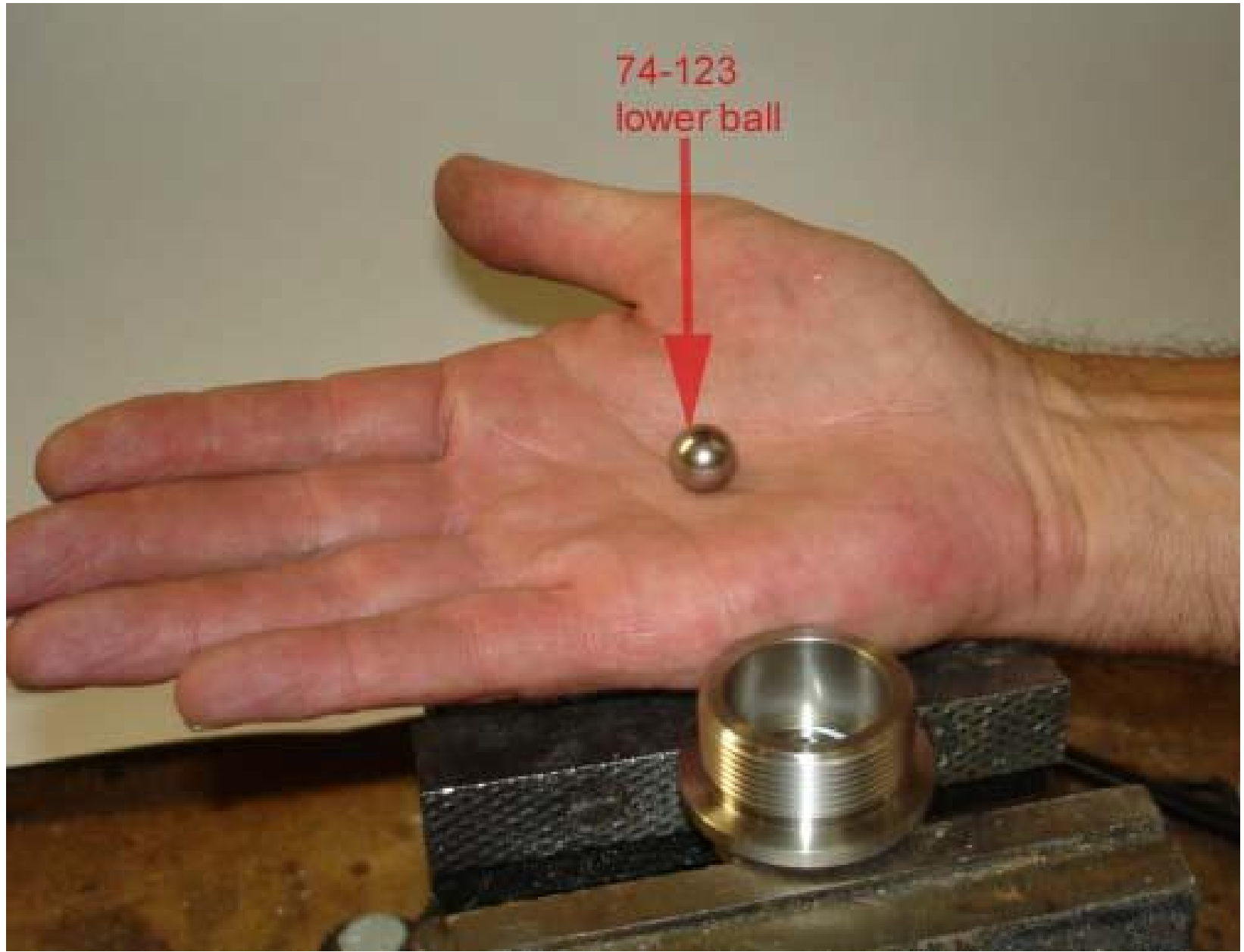
With the pump rod assembled we will now start assembling the fluid section of the pump. place the 74-118 in a vice if possible because we will be assembling the fluid section from this point up.



74-123
lower seat



74-123
lower ball



74-130
seal/guide
assy - lower



once the lower seal is in place we can now slide the pump rod into the upper part of the guide as shown

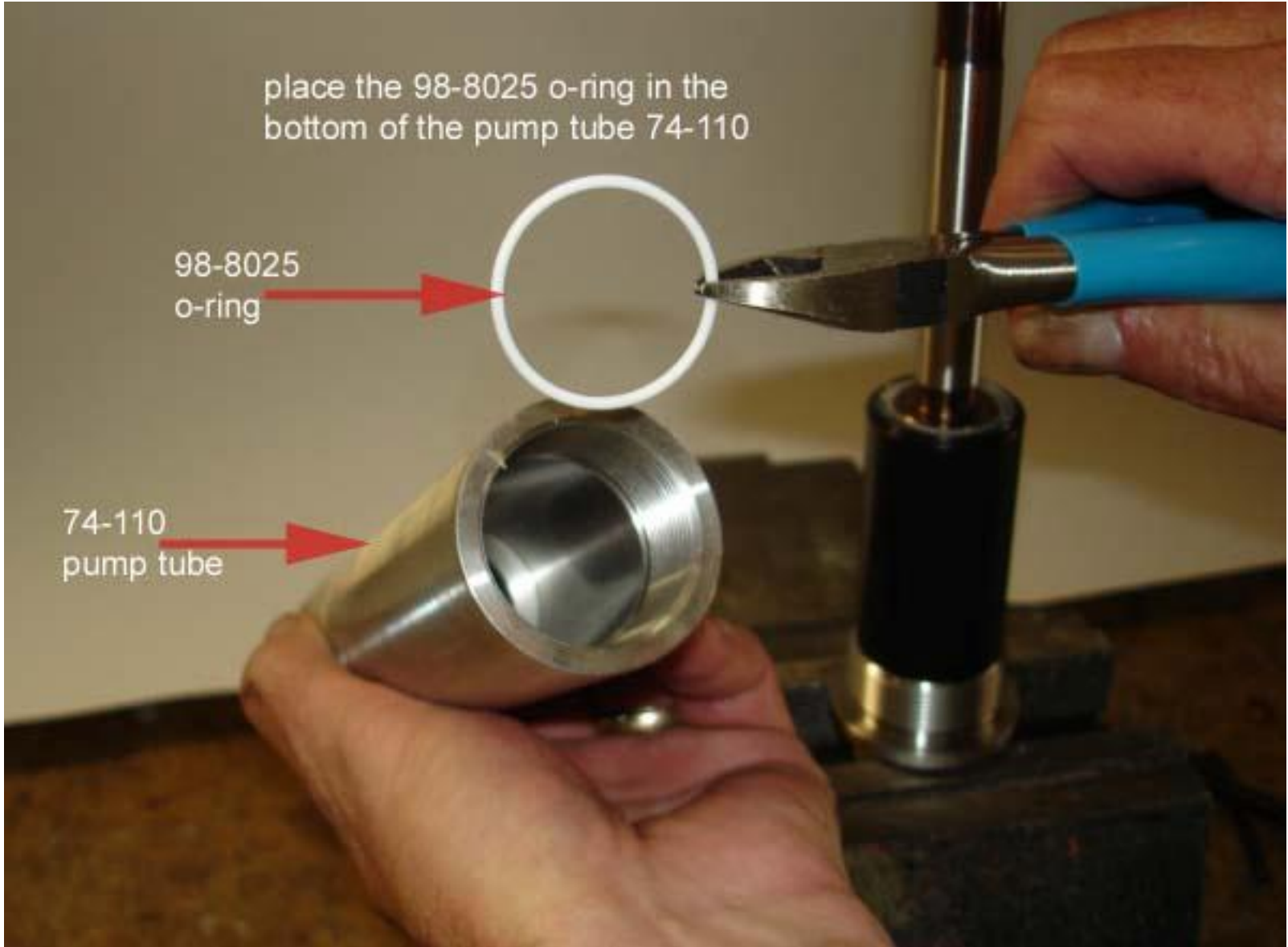




place the 98-8025 o-ring in the
bottom of the pump tube 74-110

98-8025
o-ring

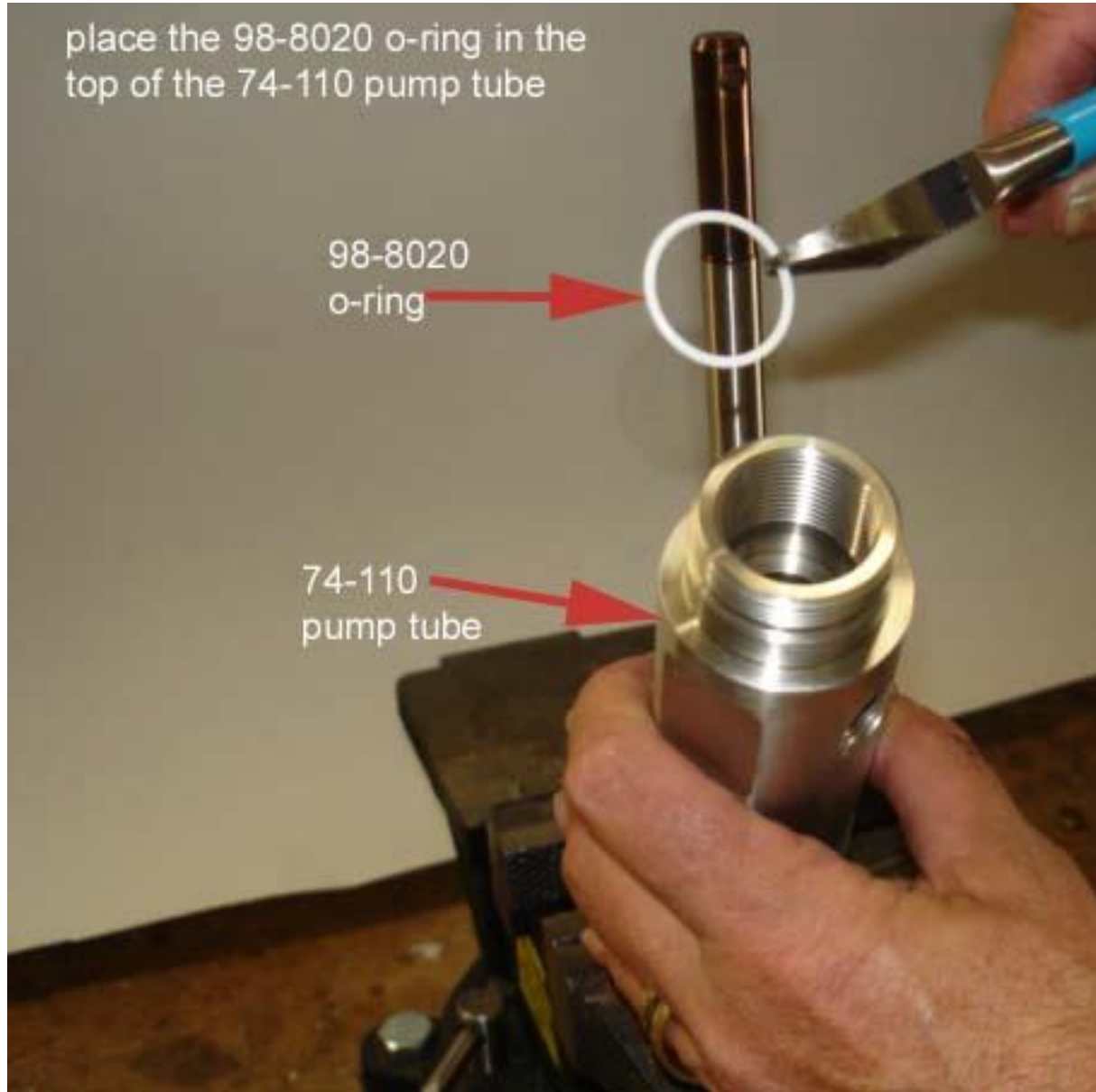
74-110
pump tube



place the 98-8020 o-ring in the top of the 74-110 pump tube

98-8020
o-ring

74-110
pump tube



place the pump tube over the pump rod assembly
and tighten down



make sure the seal is placed as shown with the u-cup toward the pump rod

74-111
packing nut

74-125
upper seal guide assy

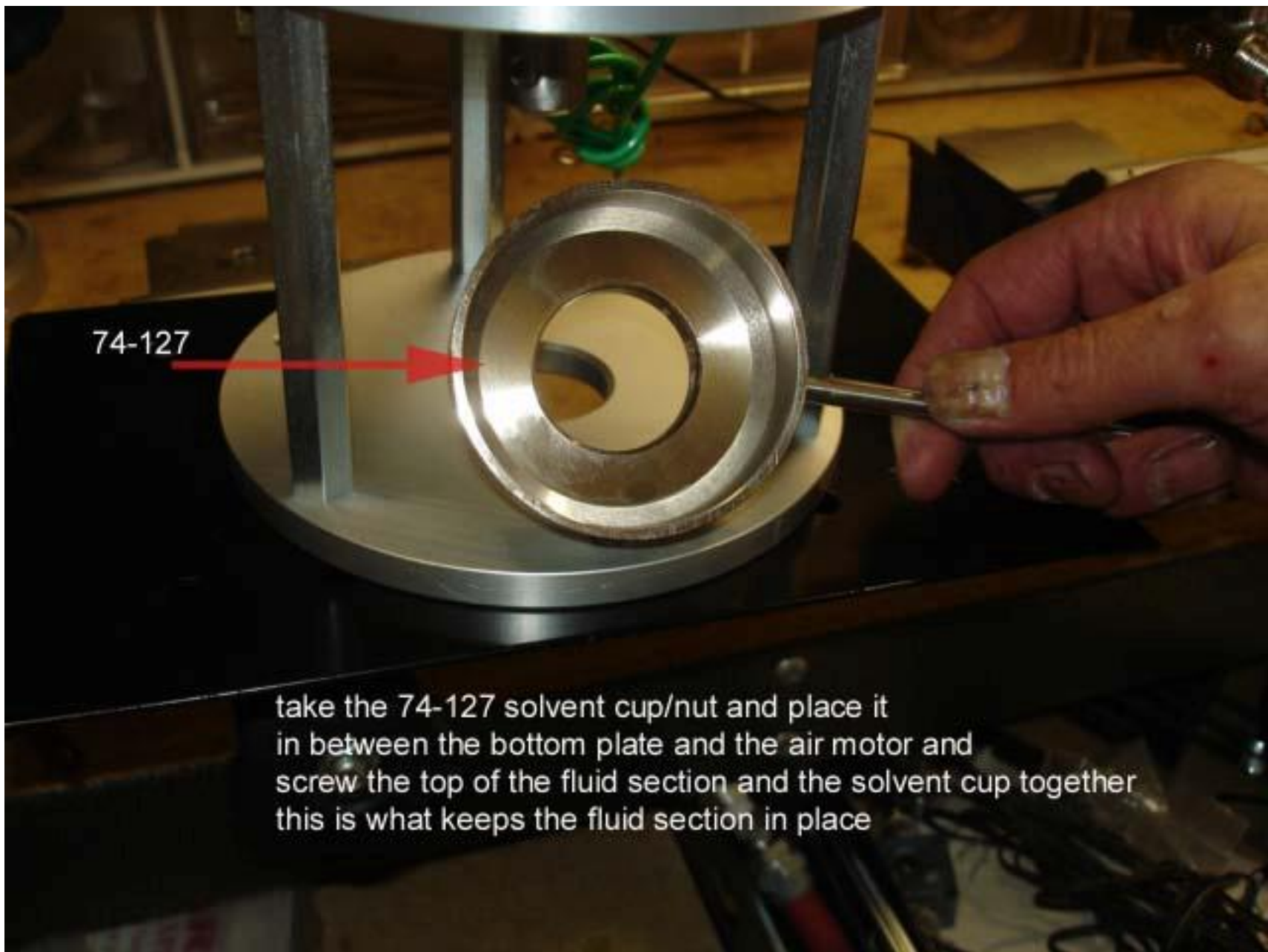


screw down the packing nut
and tighten down



98-7125
o-ring



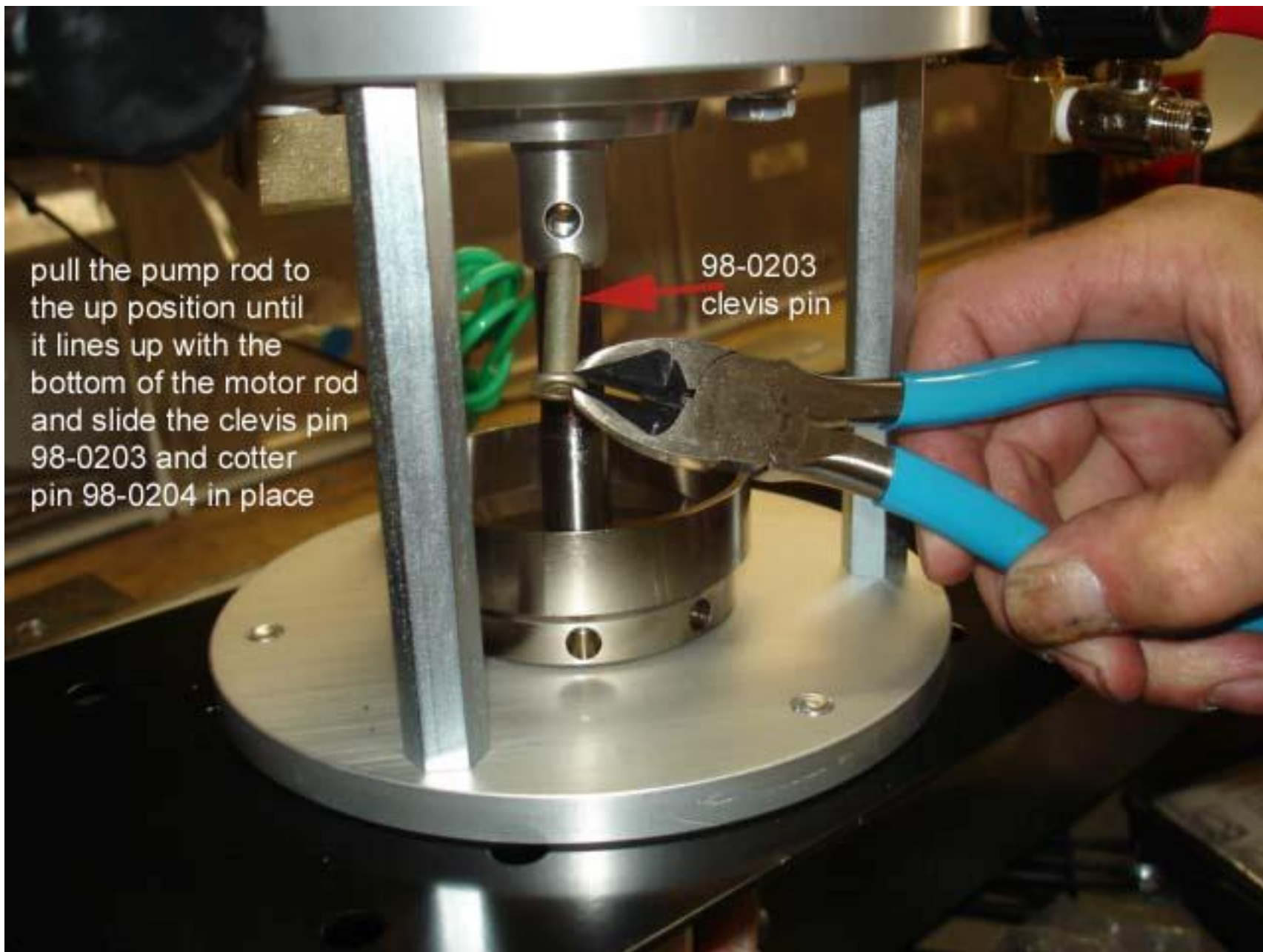


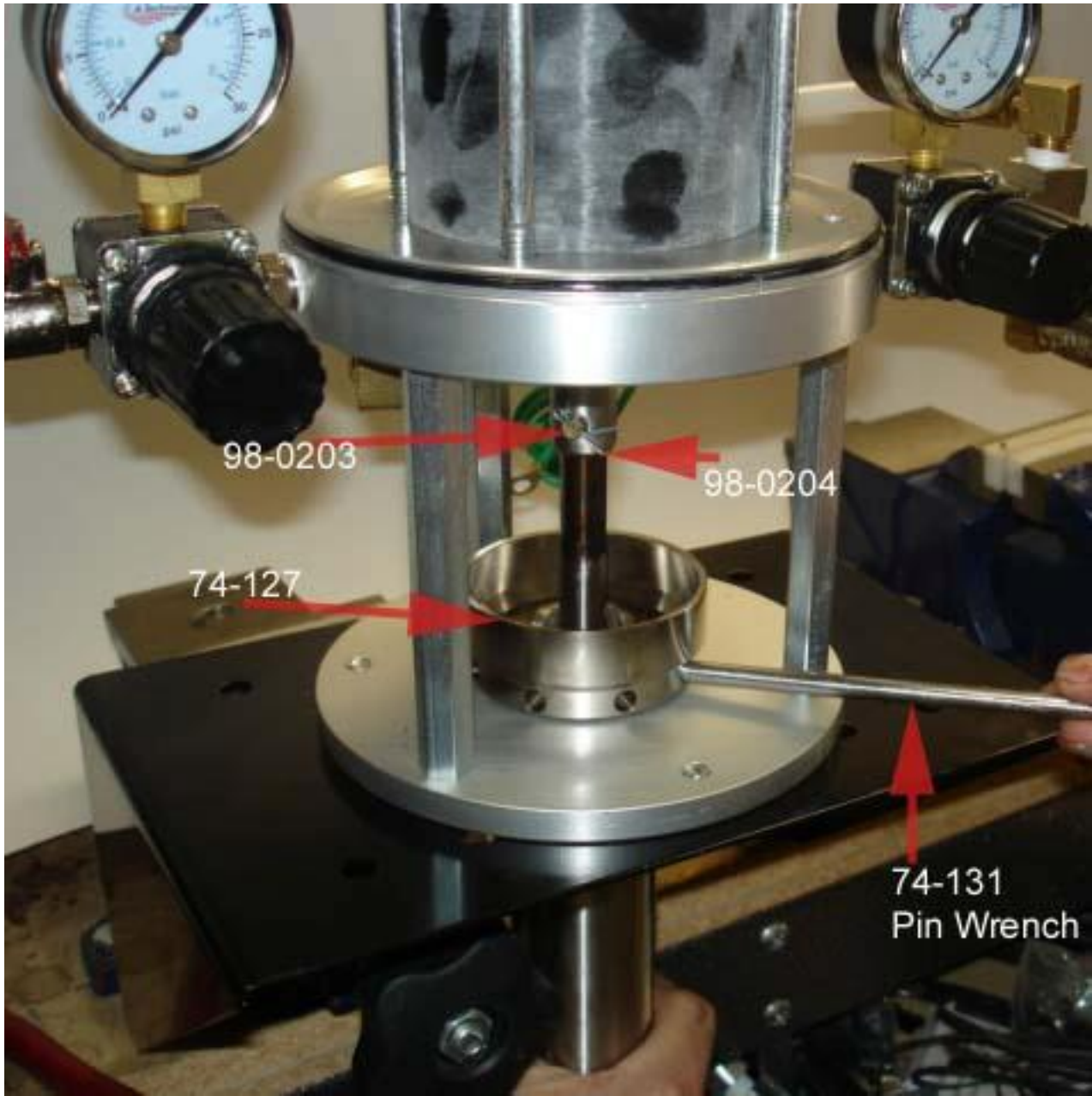
74-127

take the 74-127 solvent cup/nut and place it
in between the bottom plate and the air motor and
screw the top of the fluid section and the solvent cup together
this is what keeps the fluid section in place

pull the pump rod to the up position until it lines up with the bottom of the motor rod and slide the clevis pin 98-0203 and cotter pin 98-0204 in place

98-0203
clevis pin





98-0203

98-0204

74-127

74-131
Pin Wrench

put on the cover and screw in the allen bolt and the pump is now finished and ready for testing



98-0189

75-123

C.A. Technologies
USA

Finished C14 AAA Pump

CA Technologies
USA

