

FKXXXX Fluid Section Repair Kit

For FDA-Compliant Diaphragm Pumps

406649C

ENG



Important Safety Instructions

Read all warnings and instructions in manual 311879. Refer to repair kit matrix in manual 311879 for kit numbers. Save those instructions.

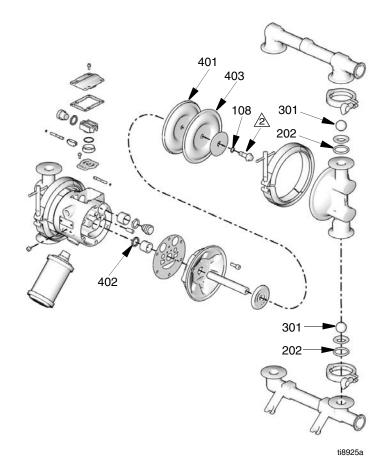
Standard Diaphragm Kits

Ref.	Description	Qty.
108	O-RING	2
202	O-RING, seat	4
301	BALL, check	4
401	DIAPHRAGM, backer	<u>/\</u> 2
402	PACKING, u-cup	
403	DIAPHRAGM	2
	ADHESIVE, blue thread lock	<u> </u>
	(not shown)	/

⚠ Not included in all repair kits

Apply blue thread locking adhesive to shaft bolt threads

Note that heavy duty diaphragms must use new plate. If a bolt-through diaphragm was in use you must purchase the new plate. Part numbers are noted in manual 311879.



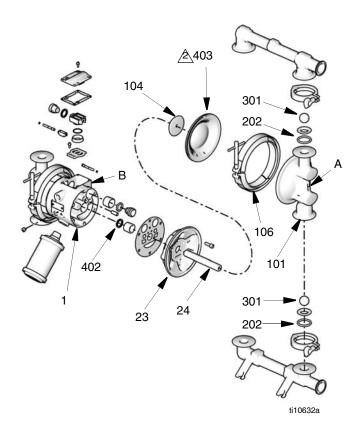
Graco Inc. P.O. Box 1441 Minneapolis, MN 55440-1441

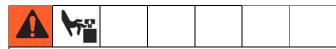
406649 Rev, C 3/2011. Original instructions. This manual contains English. Copyright 2006, Graco Inc. is registered to ISO 9001

Heavy-Duty Diaphragm Kits

Ref.	Description	Qty.
202	O-RING, seat	4
	BALL, check	4
402	PACKING, u-cup	2
403	DIAPHRAGM	2
	ADHESIVE, blue thread lock	1
	(not shown)	

Apply blue thread locking adhesive to shaft bolt threads





To reduce the risk of serious injury, including amputation, do not put your fingers or hand between the air cover and the diaphragm.

- 1. Install the shaft u-cup packings (402*) so the lips face *out* of the housing (1). Lubricate the packings.
- Assemble the air-side plate (104) onto the diaphragm (403). The wide, radiused side of the plate must face the diaphragm. Apply medium-strength (blue) thread locking adhesive to the threads of the diaphragm assembly. Screw the assembly into the shaft (24) hand tight.
- Grease the length and ends of the diaphragm shaft (24). Insert the shaft/diaphragm assembly into one side of the pump. Assemble the fluid cover (101) and clamp (106) so the arrow (A) on the cover faces the same direction as the air valve (B). Securely tighten the clamp.
- 4. Assemble the other diaphragm assembly to the shaft as explained in step 2. This diaphragm will be lifted off the air cover at this point.
- Supply the pump with low pressure air (less than 7 psi [.05 MPa, 0.5 bar]). The diaphragm will very slowly pull onto the air cover (23). Find the pressure that keeps the diaphragm close enough to clamp, but does not let it contact the pilot pin.

NOTICE

Do not deform the diaphragm manually. The diaphragm needs uniform pressure to deform properly for maximum life.

6. Assemble the fluid cover (101) and clamp (106) so the arrow (A) on the cover faces the same direction as the air valve (B). Securely tighten the clamp or torque bolts per specifications.

NOTE: If the diaphragm contacts the pilot pin and is forced away from the air cover, try Step 5 again. If necessary, return to Step 3.

7. Reassemble the ball check valves and manifolds as explained in your pump manual.

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