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PARTS LIST / 66M3X0-XXX-C FLUID SECTION

① 637467-XX Fluid section service kit includes: Balls (see Ball Option, refer to -XX in chart below), Diaphragms (see Diaphragm Option, refer to -XX in chart below) and items 2, 3, 19 and 196 (listed below) plus 93706-1 Key-Lube grease packet (page 6).

SEAT OPTIONS 66M3X0-XXX-C				BALL OPTIONS 66M3X0-XXX-C			
"21"				① "22" (2-1/2" diameter)			
-XXX	Seat	Qty	Mtl	-XXX	Ball	Qty	Mtl
-1XX	97067	(4)	[A]	-X2X	93358-2	(4)	[B]
				-XCX	93358-C	(4)	[H]
				-XEX	93358-A	(4)	[Sp]

MATERIAL CODE
[A] = Aluminum
[B] = Nitrile
[C] = Carbon Steel
[Co] = Copper
[E] = E.P.R.
[H] = Hytrel
[Sp] = Santoprene
[SS] = Stainless Steel
[T] = PTFE
[V] = Viton

DIAPHRAGM OPTIONS 66M3X0-XXX-C

-XXX	① Service kit -XX = (Ball) -XX = (Diaphragm)	① "7"			① "3" (1/8" x 1" o.d.)			① "19" (3/16" x 5" o.d.)		
		Diaphragm	Qty	Mtl	"O" Ring	Qty	Mtl	"O" Ring	Qty	Mtl
-XX2	637467-X2	96475-G	(2)	[B]	Y325-210	(2)	[B]	Y325-350	(4)	[B]
-XX9	637467-X9	96475-C	(2)	[H]	Y327-210	(2)	[V]	Y327-350	(4)	[V]
-XXB	637467-XB	96475-A	(2)	[Sp]	Y328-210	(2)	[T]	94115	(4)	[E]

COMMON PARTS

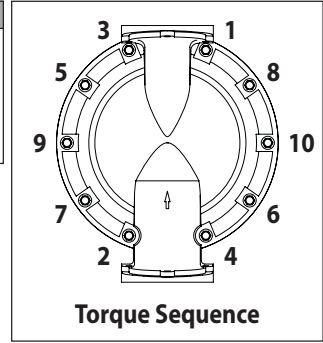
Item	Description (size)	Qty	Part No.	Mtl	Item	Description (size)	Qty	Part No.	Mtl
② 1	Rod	(1)	97070	[C]	61	Outlet manifold			
① 2	"O" Ring (3/32" x 1" o.d.)	(1)	Y330-117	[B]		(models 66M300-XXX-C, NPTF)	(1)	96428-1	[A]
5	Washer (air side)	(2)	94831-1	[C]		(models 66M320-XXX-C, BSP)	(1)	96428-2	[A]
② 6	Washer (fluid side)	(2)	94802	[A]	182	Side Screen	(2)	96575	[A]
9	Washer (13/16" i.d. x 2" o.d. x 5/32")	(2)	Y13-12-T	[SS]	183	Top Plate Screen	(1)	97062	[A]
14	Screw (3/4" - 16 x 3-1/4")	(2)	Y5-134-T	[SS]	184	Base Plate Screen	(1)	97061	[A]
15	Fluid Cap	(2)	96430	[A]	185	Lock Nut (M10 x 1.5 - 6h)	(4)	97060	[C]
26	Screw (M12 x 1.75 - 6g x 45 mm)	(12)	94412-1	[C]	186	Button Head Screw (M10 x 1.5 - 6g x 35 mm)	(4)	97059	[C]
27	Screw (M12 x 1.75 - 6g x 60 mm)	(20)	94991-1	[C]	187	Washer (M10)	(4)	96756	[C]
29	Nut (M12 x 1.75 - 6h)	(20)	95053-1	[C]	188	Button Head Screw (M10 x 1.5 - 6g x 25 mm)	(6)	96741	[C]
43	Ground Lug (see page 7)	(1)	93004	[Co]	① 196	Cushion	(2)	94631	[Sp]
60	Inlet manifold				280	Handle	(2)	97057	[C]
	(models 66M300-XXX-C, NPTF)	(1)	96429-1	[A]	281	Bracket	(4)	97055	[C]
	(models 66M320-XXX-C, BSP)	(1)	96429-2	[A]					

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② "Smart Parts", keep these items on hand in addition to the service kits for fast repair and reduction of down time.

PARTS LIST / 66M3X0-XXX-C FLUID SECTION

COLOR CODE		
Material	Diaphragm Color	Ball Color
Hytrek	Cream	Cream
Nitrile	Black	Red (-)
Santoprene	Tan	Tan (+) Dot



FOR THE AIR MOTOR SECTION, SEE PAGES 6 & 7.

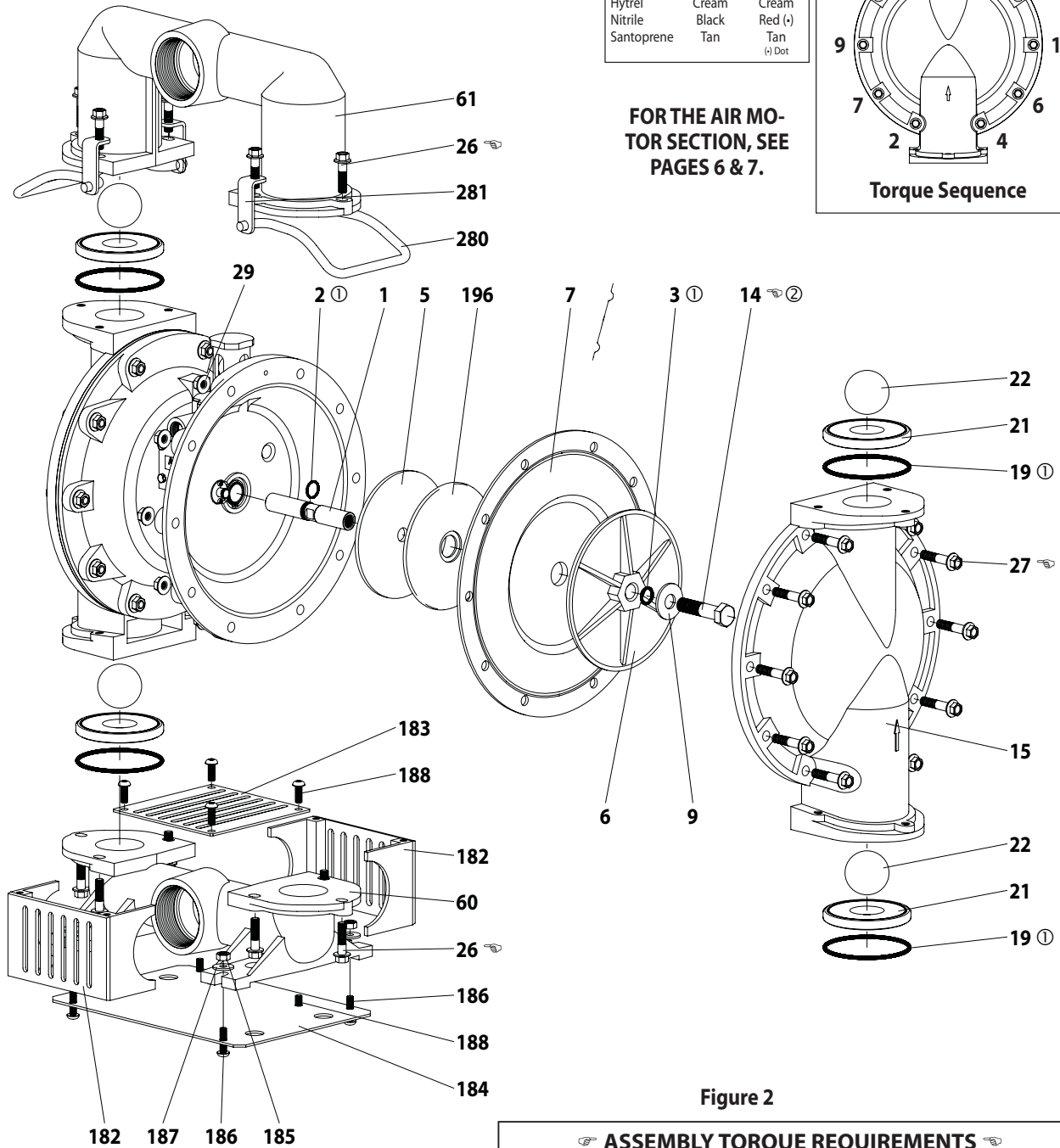


Figure 2

ASSEMBLY TORQUE REQUIREMENTS
 NOTE: DO NOT OVERTIGHTEN FASTENERS.
 ALL FASTENERS ARE METRIC.

(14) screw, 65 - 70 ft lbs (88.1 - 94.9 Nm).
 (26) screw, 60 - 70 ft lbs (81.3 - 94.9 Nm).
 (27) screw, 60 - 70 ft lbs (81.3 - 94.9 Nm).

LUBRICATION / SEALANTS

① Apply Key-Lube grease to all "O" rings, "U" cups and mating parts.
 ② Apply Loctite® 271™ to threads.

PARTS LIST / 66M3X0-XXX-C AIR MOTOR SECTION

③ Indicates parts included in 637434 air section service kit.

AIR MOTOR PARTS

Item	Description (size)	Qty	Part No.	Mtl
101	Motor Body	(1)	96427	[A]
③ 102	"O" Ring (1/16" x 1-1/4" o.d.)	(2)	Y325-24	[B]
② 103	Sleeve	(1)	94528	[D]
③ 104	Retaining Ring (1-5/32" i.d.)	(2)	Y145-26	[C]
105	Screw / Lockwasher (1/4" - 20 x 5/8")	(8)	93860	[C]
107	Plate	(2)	96424	[SS]
③ 108	Gasket (with notch)	(1)	96426	[B/Ny]
② 109	Piston	(1)	96422	[D]
③ 110	"U" Cup (3/16" x 2-1/8" o.d.)	(1)	Y186-55	[B]
② 111	Spool	(1)	96421	[A]
② 112	Washer (2.055" o.d.)	(5)	93251	[GPS]
③ 113	"O" Ring (1/8" x 1-3/4" o.d.)	(5)	Y325-222	[B]
③ 114	"O" Ring (3/32" x 2-1/16" o.d.)	(6)	Y325-134	[B]
② 115	Spacer	(4)	93250	[GPS]
② 116	Spacer	(1)	96420	[D]
③ 117	Gasket	(1)	96425	[B/Ny]
118	Pilot Rod	(1)	93309-2	[C]
③ 119	"O" Ring (1/8" x 3/4" o.d.)	(4)	93075	[U]
120	Spacer	(3)	115959	[Z]

Item	Description (size)	Qty	Part No.	Mtl
121	Sleeve Bushing	(2)	98723-2	[Bz]
③ 122	"O" Ring (3/32" x 9/16" o.d.)	(2)	94820	[U]
③ 123	Screw (#8 - 32 x 3/8")	(4)	Y154-41	[C]
126	Pipe Plug (3/4 - 14 PTF x 17/32")	(1)	Y227-6-L	[C]
127	Nipple (1-1/4 - 11-1/2 NPT x 1-5/8")	(1)	Y27-7-C	[I]
127	Pipe Fitting (1-1/4 - 11-1/2 NPT x 1-1/2 - 11-1/2 NPT) (optional) (not shown)	(1)	96451	[C]
128	Pipe Plug (1/8 - 27 PTF x 1/4")	(1)	Y227-2-L	[C]
197	Button Head Screw (1/4" - 20 x 1/4")	(2)	94987	[SS]
198	Button Head Screw (1/4" - 20 x 3/8")	(1)	94987-1	[SS]
201	Exhaust Check Housing	(1)	97116	[A]
201	Muffler Kit (includes item 127) (optional) (not shown)	(1)	67389	
282	Ball (1.500" diameter)	(1)	97110-2	[B]
① ③	Key-Lube "O" Ring Lubricant	(1)	93706-1	
	10 Pak of Key-Lube	(10)	637175	

② "Smart Parts", keep these items on hand in addition to the service kits for fast repair and reduction of down time.

MATERIAL CODE

[A] = Aluminum	[I] = Iron
[B] = Nitrile	[Ny] = Nylon
[Bz] = Bronze	[SS] = Stainless Steel
[C] = Carbon Steel	[U] = Polyurethane
[D] = Acetal	[Z] = Zinc
[GPS] = Glass filled Polyphenylene Sulfide	

AIR MOTOR SECTION SERVICE

Service is divided into two parts - 1. Pilot Valve, 2. Major Valve.
GENERAL REASSEMBLY NOTES:

- Air Motor Section service is continued from Fluid Section repair.
- Inspect and replace old parts with new parts as necessary. Look for deep scratches on metallic surfaces, and nicks or cuts in "O" rings.
- Take precautions to prevent cutting "O" rings upon installation.
- Lubricate "O" rings with Key-Lube.
- Do not over-tighten fasteners. Refer to torque specification block on view.
- Re-torque fasteners following restart.

PILOT VALVE DISASSEMBLY

1. Remove (104) retaining ring.
2. Remove (123) screws and (122) "O" rings.
3. Remove (118) piston rod, (121) sleeve bushing, (119) "O" rings and (120) spacers from the (101) motor body.
4. Remove (103) sleeve and (102) "O" rings.

PILOT VALVE REASSEMBLY

1. Replace two (102) "O" rings, if worn or damaged, and reinstall (103) sleeve.
2. Install one of the (121) sleeve bushings, (119) "O" rings, (120) spacers and the remaining (121) bushing.
3. Carefully push (118) pilot rod into bushings etc. and retain on each end with the two (122) "O" rings. Retain with (123) screws.
4. Replace (104) retaining rings.

MAJOR VALVE DISASSEMBLY

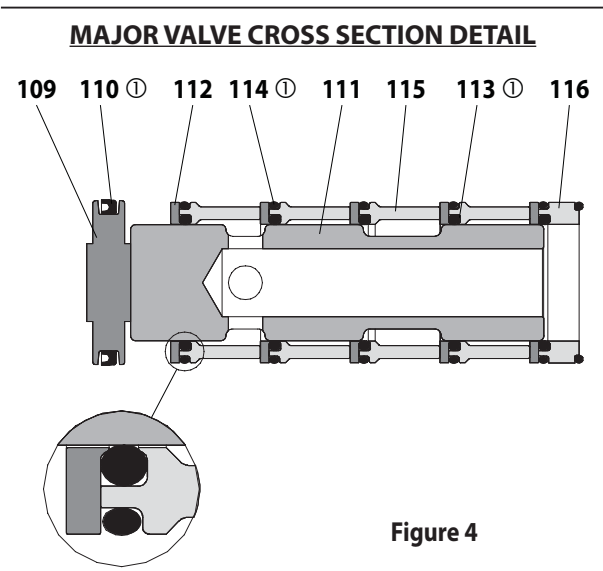
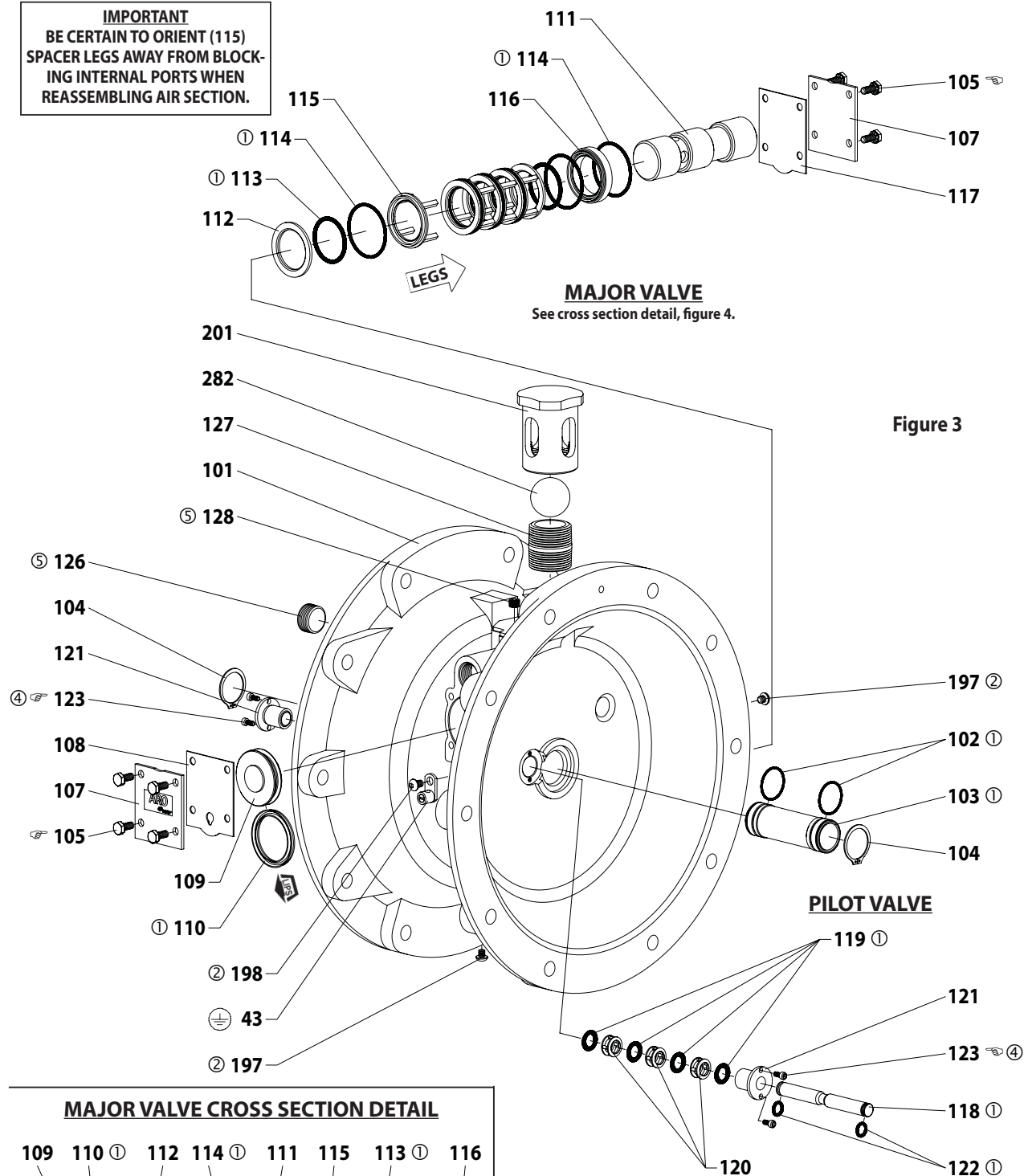
1. Remove (107) plate and (108 and 117) gaskets.
2. On the side opposite the air inlet, push on the inner diameter of (111) spool. This will force the (109) piston out. Continue pushing the (111) spool and remove. Check for scratches and gouges.
3. Reach into the air section (exhaust side) and remove (116) spacer, (115) spacers, (113) "O" rings, (114) "O" rings, (112) washers. etc. Check for damaged "O" rings.

MAJOR VALVE REASSEMBLY

1. Replace (112) washer, (114) "O" ring and (113) "O" ring onto (115) spacer and insert etc. **NOTE: Be careful to orient spacer legs away from blocking internal ports.**
2. Lubricate and carefully insert (111) spool.
3. Install (117) gasket and (107) plate.
4. Lubricate and install (110) packing cup and insert (109) piston into (air inlet side) cavity. The (110) packing cup lips should point outward.
5. Install (108) gasket and replace (107).

PARTS LIST / 66M3X0-XXX-C AIR MOTOR SECTION

IMPORTANT
BE CERTAIN TO ORIENT (115)
SPACER LEGS AWAY FROM BLOCK-
ING INTERNAL PORTS WHEN
REASSEMBLING AIR SECTION.



ASSEMBLY TORQUE REQUIREMENTS
NOTE: DO NOT OVERTIGHTEN FASTENERS.
(105) screw, 40 - 50 in. lbs (4.5 - 5.6 Nm).
(123) screw, 20 - 25 in. lbs (2.3 - 2.8 Nm).

LUBRICATION / SEALANTS

- ① Apply Key-Lube grease to all "O" rings, "U" cups and mating parts.
- ② Apply Loctite 271 to threads.
- ④ Apply Loctite 262™ to threads.
- ⑤ Apply Loctite 572™ to threads.