



TECHNICAL SERVICE BULLETIN

Bulletin Number: DC-2205

Date: 11/28/2006

**Affected Model(s): Bare 282396, 3:1 and 84933, 5:1 Fluid Pumps
(Associated Configured Models)**

Subject: 230001 Fluid Piston Replacement Kit

We are pleased to announce an enhanced fluid piston assembly for our 282396 (3:1) and 84933 (5:1) bare pumps and all associated Series 25 and 40 models. The change is the result of ongoing research by our engineering department to provide enhanced performance of the pump assembly and increased reliability of the piston assembly. The major change to be recognized is that the old style plastic piston has been replaced by a steel unit. Our research determined that the plastic piston was more apt to swell or show other effects of pumping some more aggressive fluids. The other major enhancement is the replacement of the old style "check seat" (12758) with a more positive sealing "check ball and seat" configuration (230002 and 230003). A copy of our new service page, Section A6, Page 64 (form 402084) is attached for your review.

The kit should be available by the middle of December. The replacement pistons will be incorporated into pump production very soon also. All associated service pages and owner's manual will be updated accordingly to identify procedural changes. Here is a short preview of the steps required in converting from the old to new style piston assembly:

- Remove the 241511 lower tube,
- Remove the 12758 piston seat,
- Remove the 16635 plastic piston,
- Remove the 12337 spring stop,
- Remove the 16636 connecting rod

- Replace the 16636 connecting rod with the 230003 piston connector,
- Install the 230004 steel ball and 230002 piston assembly,
- Install new 261077 piston packings (same in both assemblies).
- Re-install 241511 lower tube.

Please note: Loctite 242 should be applied on the threads of the 230003 and 230002 prior to assembly and they should be tightened to 10 ft. lbs.

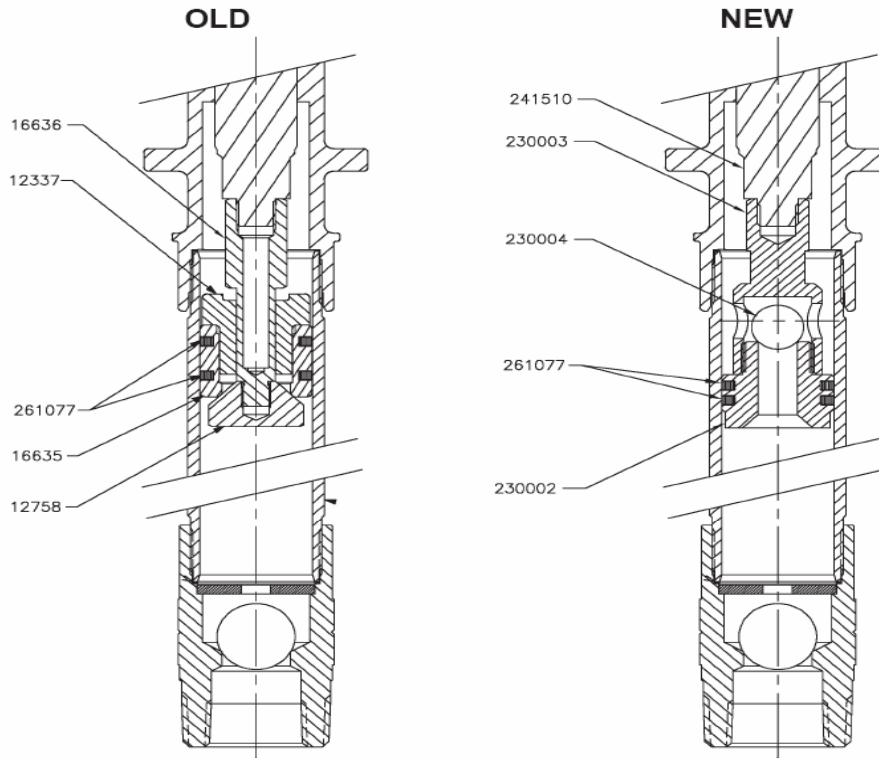
If you have questions or concerns please do not hesitate to call Lincoln Technical Services at 314/679-4200, ext. 4782, or fax us at 314/679-HELP (4357).

Regards,

Barry Frankum
Manager, Technical Service



MODEL 230001 Piston Replacement Kit



COMPONENT PART NO.	COMPONENT PART NO.	ASSOCIATED TORQUE (+/-1%)	LOCTITE REQ'D.
241510	230003	10 FT LBS	ONE DROP #242
230003	230002	10 FT LBS	ONE DROP #242

THE PREVIOUS PISTON ASSEMBLY CONSISTING OF PARTS 12768, 16636, 12337 AND 16635 WITH PACKINGS 261077 WILL BE REPLACED BY PISTON REPLACEMENT KIT PN 230001 WHICH INCLUDES 230004, 230003 AND 230002 WITH PACKINGS 261077.

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