

Pump Expansion Kits

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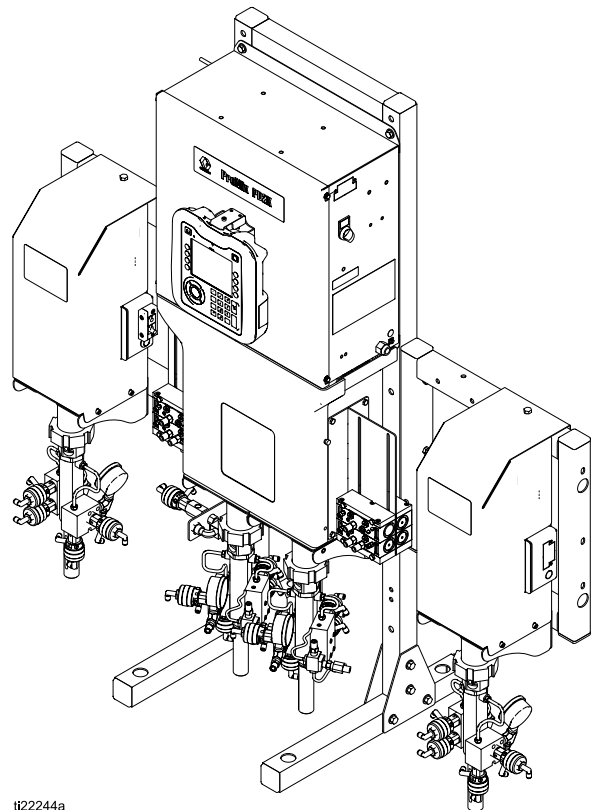
To add a third or fourth pump to a ProMix® PD2K Proportioner. Each kit includes one pump and associated parts. PD2K is shown with two kits added. For professional use only.



Important Safety Instructions

Read all warnings and instructions in this manual and in your PD2K manual. **Save these instructions.**

See page 3 for model part numbers and approvals information.



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Related Manuals

Manual No.	Description
3A2800	PD2K Proportioner Repair-Parts Manual, Manual Systems
332457	PD2K Proportioner Installation Manual
332562	PD2K Proportioner Operation Manual, Manual Systems
3A2801	Mix Manifold Instructions-Parts Manual

Manual No.	Description
332339	Pump Repair-Parts Manual
332454	Color Change Valve Repair-Parts Manual
332455	Color Change Kits Instructions-Parts Manual

Models

Kit Part No.	Series	Description	Maximum Fluid Working Pressure
24R968	A	70 cc Low Pressure Color Pump Kit	300 psi (2.068 MPa, 20.68 bar)
24R969	A	70 cc High Pressure Color Pump Kit	1500 psi (10.34 MPa, 103.4 bar)
24R970	A	35 cc Low Pressure Color or Catalyst Pump Kit	300 psi (2.068 MPa, 20.68 bar)
24R971	A	35 cc High Pressure Color or Catalyst Pump Kit	1500 psi (10.34 MPa, 103.4 bar)



















ProMix® PD2K				EXPANSION PUMP		
PART NO.	SERIES	SERIAL	MFG. YR.	MAX AIR WPR		
				.7	7	100
				MPa	bar	PSI
 GRACO INC. P.O. Box 1441 Minneapolis, MN 55440 U.S.A.				 MAX TEMP 50°C (122°F)		
Artwork No. 294116 Rev. B				MAX FLUID WPR 10.34 103.4 1500 MPa bar PSI		

Figure 1 . Pump Expansion Kit Identification Label

Warnings

The following warnings are for the setup, use, grounding, maintenance and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbol refers to procedure-specific risks. When these symbols appear in the body of this manual or on warning labels, refer back to these Warnings. Product-specific hazard symbols and warnings not covered in this section may appear throughout the body of this manual where applicable.





 WARNING	
   	FIRE AND EXPLOSION HAZARD <p>Flammable fumes, such as solvent and paint fumes, in work area can ignite or explode. To help prevent fire and explosion:</p> <ul style="list-style-type: none"> • Use equipment only in well ventilated area. • Eliminate all ignition sources; such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static arc). • Keep work area free of debris, including solvent, rags and gasoline. • Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present. • Ground all equipment in the work area. See Grounding instructions. • Use only grounded hoses. • Hold gun firmly to side of grounded pail when triggering into pail. Do not use pail liners unless they are antistatic or conductive. • Stop operation immediately if static sparking occurs or you feel a shock, Do not use equipment until you identify and correct the problem. • Keep a working fire extinguisher in the work area.
  	SKIN INJECTION HAZARD <p>High-pressure fluid from gun, hose leaks, or ruptured components will pierce skin. This may look like just a cut, but it is a serious injury that can result in amputation. Get immediate surgical treatment.</p> <ul style="list-style-type: none"> • Do not spray without tip guard and trigger guard installed. • Engage trigger lock when not spraying. • Do not point gun at anyone or at any part of the body. • Do not put your hand over the spray tip. • Do not stop or deflect leaks with your hand, body, glove, or rag. • Follow the Pressure Relief Procedure when you stop spraying/dispensing and before cleaning, checking, or servicing equipment. • Tighten all fluid connections before operating the equipment. • Check hoses and couplings daily. Replace worn or damaged parts immediately.

 <h1>WARNING</h1>	
 	MOVING PARTS HAZARD Moving parts can pinch, cut or amputate fingers and other body parts. <ul style="list-style-type: none"> • Keep clear of moving parts. • Do not operate equipment with protective guards or covers removed. • Pressurized equipment can start without warning. Before checking, moving, or servicing equipment, follow the Pressure Relief Procedure and disconnect all power sources.
 	TOXIC FLUID OR FUMES Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled, or swallowed. <ul style="list-style-type: none"> • Read MSDSs to know the specific hazards of the fluids you are using. • Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines. • Always wear chemically impermeable gloves when spraying, dispensing, or cleaning equipment.
	PERSONAL PROTECTIVE EQUIPMENT Wear appropriate protective equipment when in the work area to help prevent serious injury, including eye injury, hearing loss, inhalation of toxic fumes, and burns. This protective equipment includes but is not limited to: <ul style="list-style-type: none"> • Protective eyewear, and hearing protection. • Respirators, protective clothing, and gloves as recommended by the fluid and solvent manufacturer.
 	EQUIPMENT MISUSE HAZARD Misuse can cause death or serious injury. <ul style="list-style-type: none"> • Do not operate the unit when fatigued or under the influence of drugs or alcohol. • Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See Technical Data in all equipment manuals. • Use fluids and solvents that are compatible with equipment wetted parts. See Technical Data in all equipment manuals. Read fluid and solvent manufacturer's warnings. For complete information about your material, request MSDS from distributor or retailer. • Do not leave the work area while equipment is energized or under pressure. • Turn off all equipment and follow the Pressure Relief Procedure when equipment is not in use. • Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only. • Do not alter or modify equipment. Alterations or modifications may void agency approvals and create safety hazards. • Make sure all equipment is rated and approved for the environment in which you are using it. • Use equipment only for its intended purpose. Call your distributor for information. • Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces. • Do not kink or over bend hoses or use hoses to pull equipment. • Keep children and animals away from work area. • Comply with all applicable safety regulations.



Important Isocyanate (ISO) Information

Isocyanates (ISO) are catalysts used in two component materials.




Isocyanate Conditions

				
<p>Spraying or dispensing materials containing isocyanates creates potentially harmful mists, vapors, and atomized particulates.</p> <p>Read material manufacturer's warnings and material MSDS to know specific hazards and precautions related to isocyanates.</p> <p>Prevent inhalation of isocyanate mists, vapors, and atomized particulates by providing sufficient ventilation in the work area. If sufficient ventilation is not available, a supplied-air respirator is required for everyone in the work area.</p> <p>To prevent contact with isocyanates, appropriate personal protective equipment, including chemically impermeable gloves, boots, aprons, and goggles, is also required for everyone in the work area.</p>				

Material Self-ignition

				
<p>Some materials may become self-igniting if applied too thick. Read material manufacturer's warnings and material MSDS.</p>				

Keep Components A and B Separate

				
<p>Cross-contamination can result in cured material in fluid lines which could cause serious injury or damage equipment. To prevent cross-contamination:</p> <ul style="list-style-type: none"> • Never interchange component A and component B wetted parts. • Never use solvent on one side if it has been contaminated from the other side. 				

Moisture Sensitivity of Isocyanates

Exposure to moisture (such as humidity) will cause ISO to partially cure; forming small, hard, abrasive crystals, which become suspended in the fluid. Eventually a film will form on the surface and the ISO will begin to gel, increasing in viscosity.

NOTICE				
<p>Partially cured ISO will reduce performance and the life of all wetted parts.</p> <ul style="list-style-type: none"> • Always use a sealed container with a desiccant dryer in the vent, or a nitrogen atmosphere. Never store ISO in an open container. • Keep the ISO pump wet cup or reservoir (if installed) filled with appropriate lubricant. The lubricant creates a barrier between the ISO and the atmosphere. • Use only moisture-proof hoses compatible with ISO. • Never use reclaimed solvents, which may contain moisture. Always keep solvent containers closed when not in use. • Always lubricate threaded parts with an appropriate lubricant when reassembling. 				

NOTE: The amount of film formation and rate of crystallization varies depending on the blend of ISO, the humidity, and the temperature.

Changing Materials




NOTICE

Changing the material types used in your equipment requires special attention to avoid equipment damage and downtime.

- When changing materials, flush the equipment multiple times to ensure it is thoroughly clean.
- Always clean the fluid inlet strainers after flushing.
- Check with your material manufacturer for chemical compatibility.
- When changing between epoxies and urethanes or polyureas, disassemble and clean all fluid components and change hoses. Epoxies often have amines on the B (hardener) side. Polyureas often have amines on the A (resin) side.






Installation

Before Installing the Kit

				
<ul style="list-style-type: none"> • Servicing the electrical control box exposes you to high voltage. To avoid electric shock, turn off power at the main circuit breaker before opening the enclosure. • All electrical wiring must be done by a qualified electrician and comply with all local codes and regulations. • Do not substitute or modify system components as this may impair intrinsic safety. 				



Follow the Pressure Relief Procedure in your PD2K manual whenever you see this symbol.

				
<p>This equipment stays pressurized until pressure is manually relieved. To help prevent serious injury from pressurized fluid such as skin injection, splashing fluid, and moving parts, follow the Pressure Relief Procedure in your system manual when you stop spraying and before cleaning, checking, or servicing the equipment.</p>				

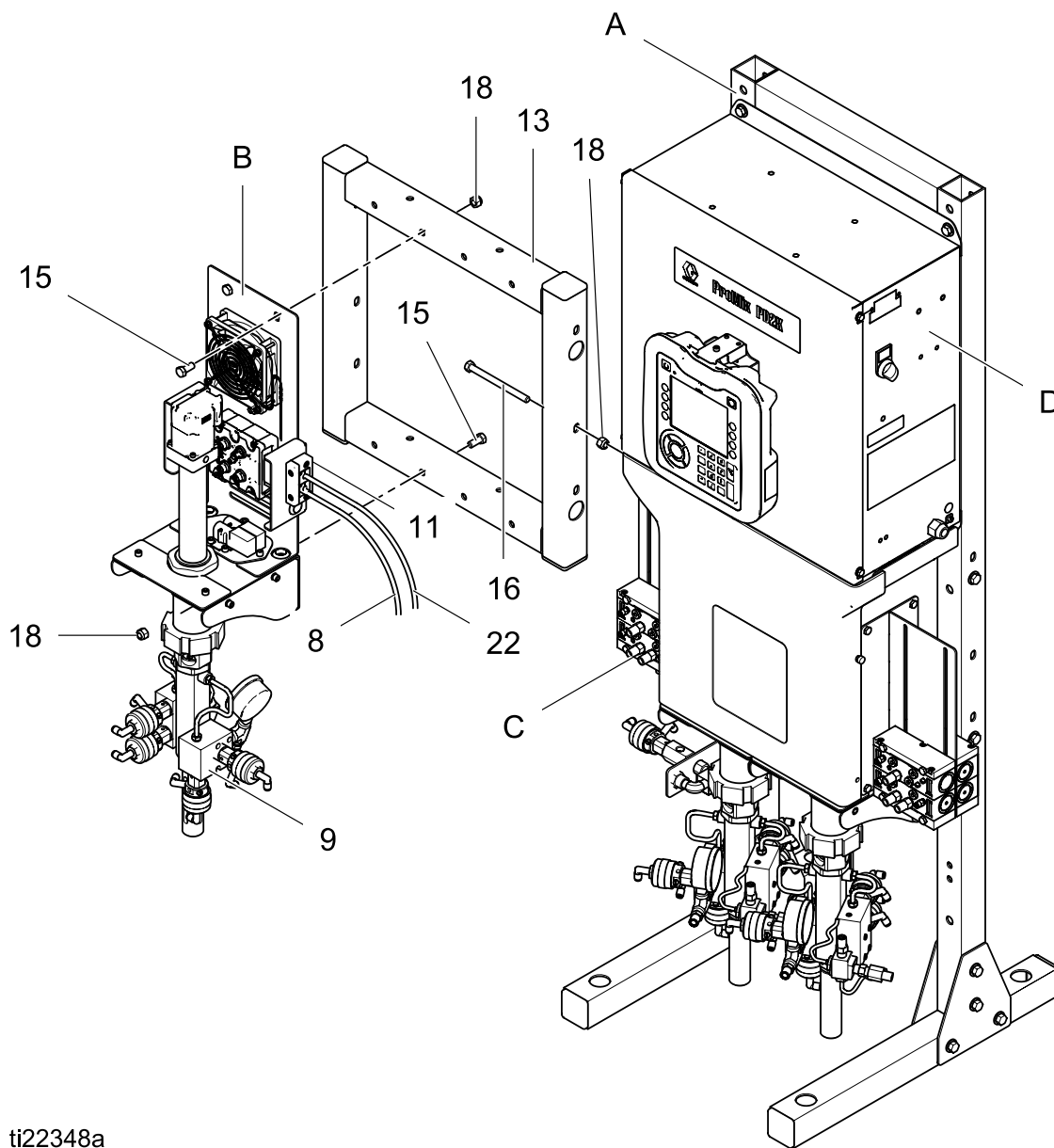
1. Flush the system as explained in your PD2K Operation Manual. Follow the Pressure Relief Procedure in your PD2K manual.
2. Close the main air shutoff valve on the air supply line.
3. Remove electrical power from the system.

Install the Frame

1. Follow the steps in [Before Installing the Kit, page 8](#).
2. Install the frame (13) to the upright of the PD2K stand (A) using three screws (16) and nuts (18).
3. Install the back panel/bracket assembly (B) in the outermost position on the frame (13), to allow clearance for the color change manifold (C). Fasten the panel to the frame (13) using four screws (15) and nuts (18). Install the top screws from the front and the bottom screws from the back.

NOTE: The illustration shows a resin (70cc) pump expansion kit being installed on the left (color) side of the PD2K proportioner. The pump control module and dual grommet (11) are preassembled at the factory so the cable (8) is facing to the right, allowing easier access to connections inside the PD2K electrical control box (D).

Install a catalyst (35cc) pump expansion kit on the right side of the proportioner, with the pump control module and dual grommet (11) preassembled in the opposite direction so the cable (8) is facing to the left.



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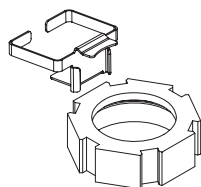
Figure 2 Install the Frame and Pump

TSL Cup Kit

Throat Seal Liquid (TSL) lubricates the pump throat packings and dosing valves. The TSL Cup Kit supplies TSL to the upper and lower throat cartridges of the pump, and to the four pump dosing valves.

NOTE: TSL must be ordered separately. Order Part No. 206995, 1 quart (0.95 liter).

1. Slide the kit mounting bracket onto any side of the pump's hex nut.



2. Place the TSL cup (73) into the bracket (73a).

NOTE: The pump's upper throat cartridge has three ports (two are plugged). Install the barbed fitting (73b) in the port closest to the TSL cup, by moving a plug if necessary.

3. Check that the o-ring is in place on the barbed fitting (73b). Apply low strength thread adhesive and install the fitting in the upper throat cartridge port.
4. Repeat for the lower throat cartridge.
5. If you are lubricating the dosing valves, remove the plug and gasket from the valve port closest to the TSL cup. Check that the o-ring is in place on the barbed fitting (73b). Apply low strength thread adhesive and install the fitting in the valve port.

NOTE: If you are not lubricating the dosing valves, remove the unused barbed fittings (73b) from the bottom of the TSL cup (73). Apply low strength thread adhesive and install the plugs and gaskets supplied with the kit.

6. Cut the tubing (73c) to length as required. Connect the TSL cup fittings to the fittings on the pump and valves. TSL is gravity-fed from the cup to the pump and valves; position the fittings and tubing to prevent kinks and enable the TSL to flow freely.
7. Fill the cup with TSL.

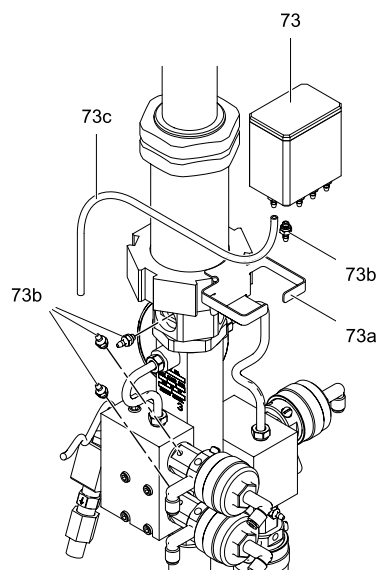


Figure 3 Install TSL Cup Kit

Air Connections

NOTE: A 6 ft (1.83 m) length of 1/4 in. (6 mm) OD polyethylene tubing (35) is supplied with the kit to supply air to the expansion pump's solenoid manifold (3).

1. See the PD2K Repair-Parts Manual. Remove the PD2K fluid panel cover to expose the air supply tubing to the two existing solenoid manifolds.
2. Cut the air supply tubing upstream of the Y-fitting.
3. Install the Y-fitting (36) supplied in the kit as shown, to restore the air supply to the two existing solenoid manifolds.

4. Connect the supplied 1/4 in. (6 mm) OD tubing (35) between the open branch of the Y-fitting (36) and the air inlet of the solenoid manifold (3). This supplies air to the expansion pump solenoid manifold, as shown in the detail of the illustration.

NOTE: If you are installing a fourth pump, make a second splice in the main solenoid air supply line and plumb as explained above.

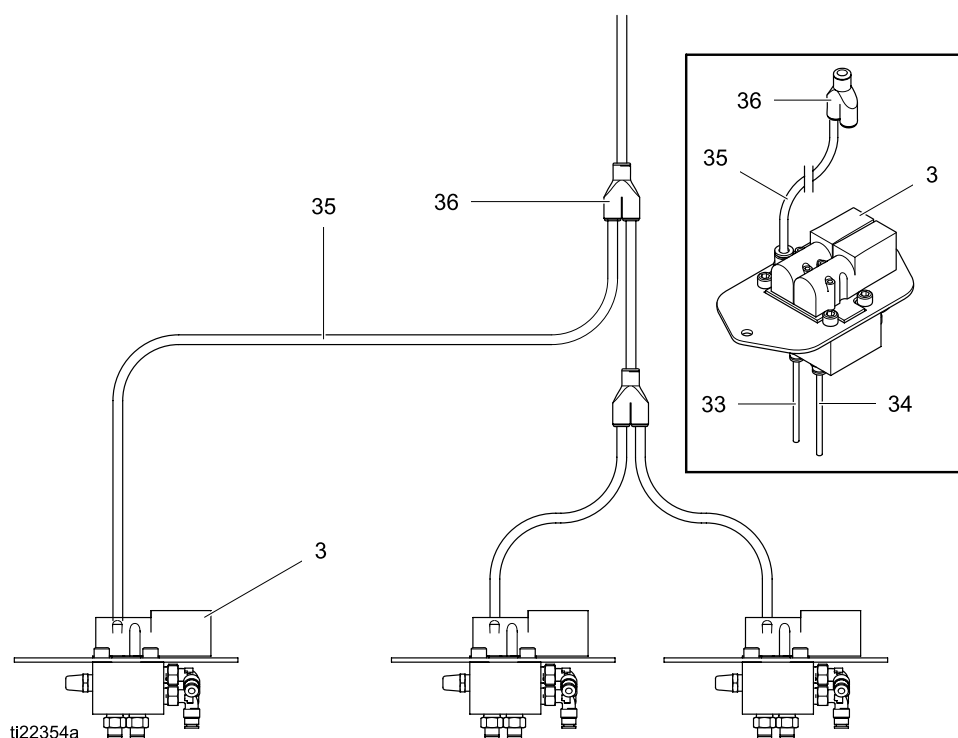


Figure 4 Supplying Air to the Expansion Pump Solenoid Manifold

Fluid Connections

1. Connect a 1/4 npt(f) fluid hose from the fluid source to the pump's fluid inlet fitting (S).
2. Connect a 1/4 npt(f) fluid outlet hose from the pump's fluid outlet fitting (R) to the gun's fluid supply.

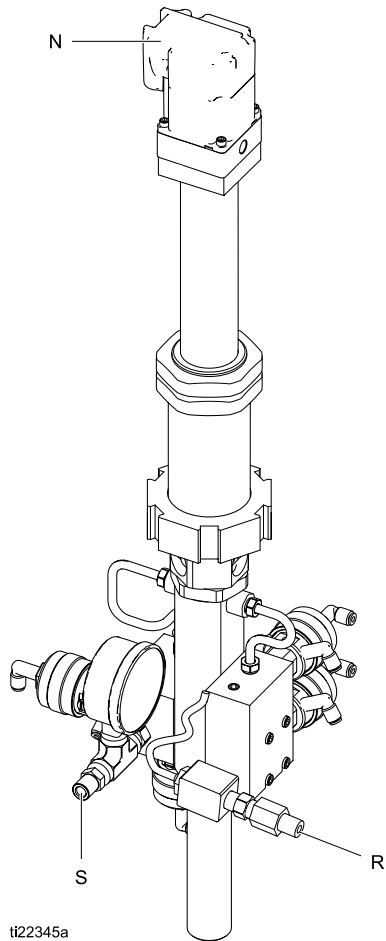


Figure 5 Pump Fluid Connections

Electrical Connections

NOTICE

To avoid electrical component damage, remove all system power before plugging any connectors.

NOTE: See the [Electrical Schematics, page 21](#).

1. Verify that electrical power is removed from the system.
2. Remove the cover from the PD2K electrical control box.
3. Remove the knockout (K) from the side of the electrical control box.
4. Thread the cable into the electrical control box and connect to the appropriate connection port on the enhanced fluid control module (Pump 3 to P3 and Pump 4 to P4).

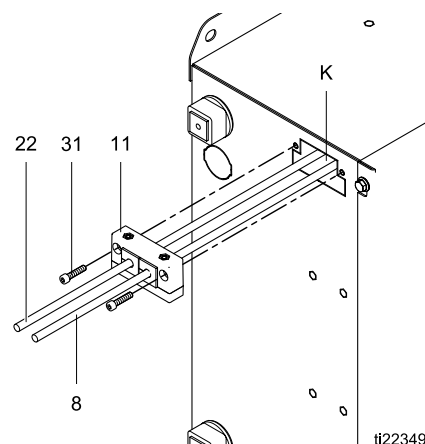


Figure 6 Install Grommet in Electrical Control Box

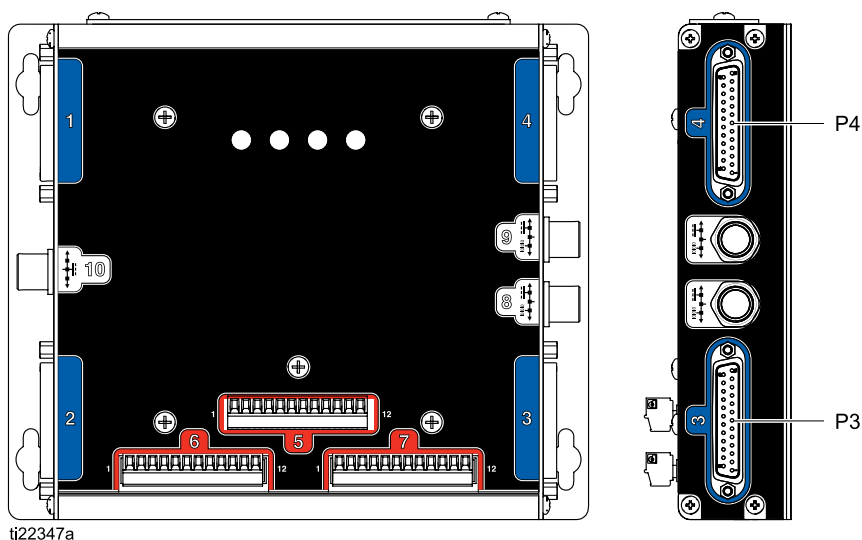


Figure 7 Enhanced Fluid Control Module Connection Points

Installation

5. The PD2K fluid panel cover was previously removed in [Air Connections, page 11](#). Thread the 2-wire cable (22) through the grommet (42) on the bottom of the fluid panel and up into the electrical box through an existing grommet and the wireway. Connect the cable (22) to the appropriate terminals on the top of the 48 Vdc power supply (P3 for pump 3, P4 for pump 4); red wire to + terminal, black wire to - terminal.
6. Install the dual grommet (11, shipped loose) on the free end of the D-SUB cable (8).
7. Fasten the grommet (11) to the side of the electrical control box, using two screws (31).
8. Reinstall the covers on the PD2K electrical control box and on the fluid panel.

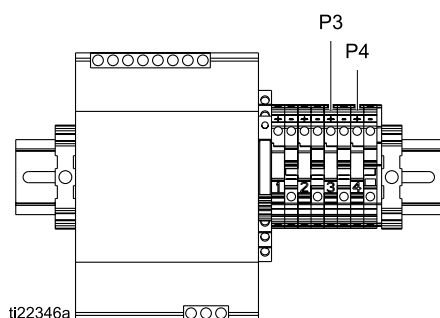
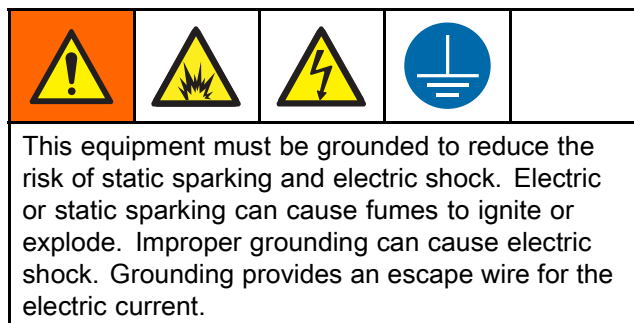


Figure 8 48 Vdc Power Supply Connection Points

Grounding



1. Verify that the PD2K base unit is properly grounded. See the PD2K installation manual for complete grounding instructions.
2. Ground the expansion kit pump(s) as follows:
 - a. **If the added pump is mounted to the PD2K main unit**, verify that the added pump is grounded by taking a resistance reading from the ground screw (7) on the added pump kit's back panel (2) to the system's true earth ground. Resistance must be less than 1 ohm.
 - b. **If the added pump is NOT mounted to the PD2K main unit**, connect a ground wire to the ground screw (7) on the added pump kit's back panel (2). Connect the other end of the ground wire to the **same** true earth ground that the main PD2K unit is connected to.

Verify that the added pump is grounded by taking a resistance reading from the ground screw (7) on the added pump kit's back panel (2) to the system's true earth ground. Resistance must be less than 1 ohm.

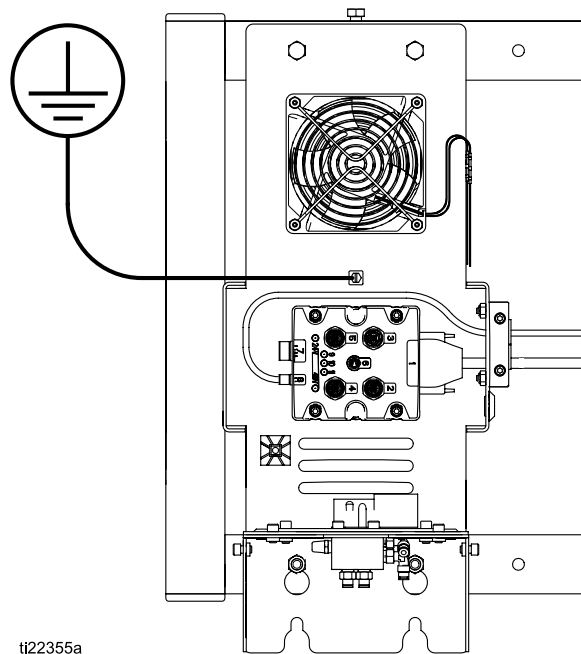


Figure 9 Grounding the Pump Expansion Kit

Complete the Installation

1. Install the cover (12) on the expansion kit, using the screw (37) and nut (18).

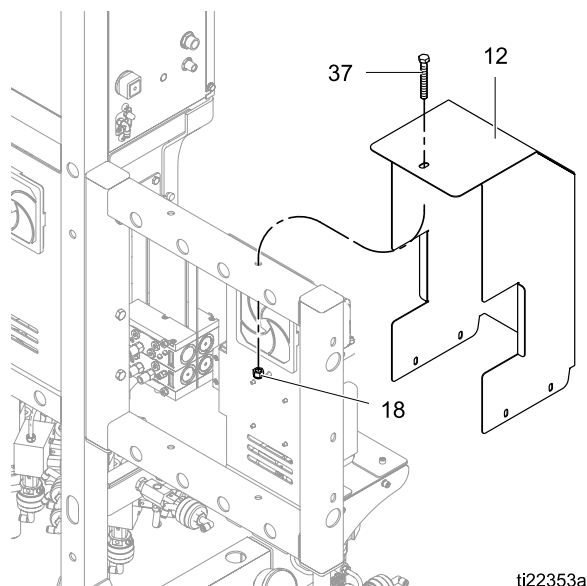



Figure 10 Install Expansion Kit Cover

2. Restore electrical power to the PD2K.

3. Turn on the control box power switch.

4. Press  and navigate to System Screen 1 on the Advanced Display Module. Change the number of Color Pumps and Catalyst Pumps as needed, based on the kit installation.

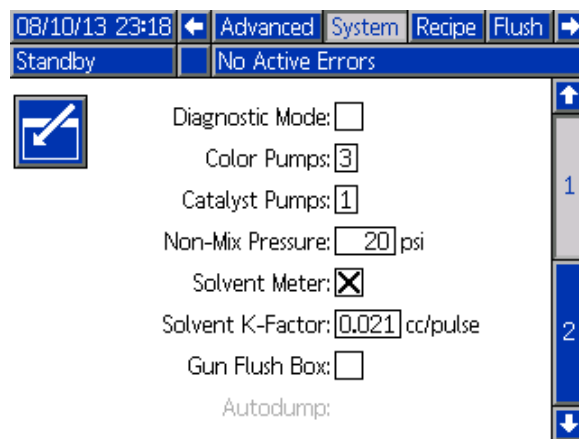


Figure 11 System Screen 1

- Go to the Pump Screens. The menu bar at the top of the screen will now show separate tabs for the added pump(s) 3 and 4. Each pump has three screens. Enter the required information, as explained in the PD2K Operation Manual.

NOTE: At a minimum, you must enter the Pump Size on Pump Screen 1 and transducer calibration data “Outlet Offset Factor” and “Outlet Sensitivity Factor” on Pump Screen 2 (see your PD2K Operation Manual). Also, create a recipe using the new material number, which can be found on Pump Screen 1 under Available Colors (or Catalysts).

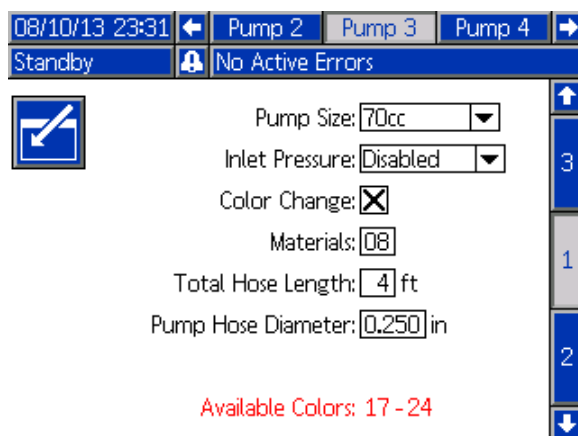


Figure 12 Third (Color) Pump Screen

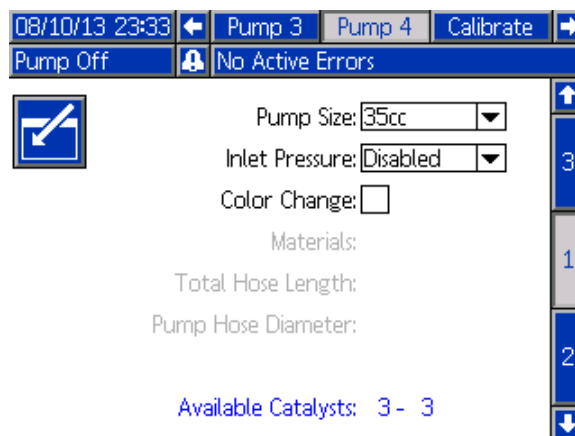


Figure 13 Fourth (Catalyst) Pump Screen

- The Home Screen will now show animations and information for the added pumps.

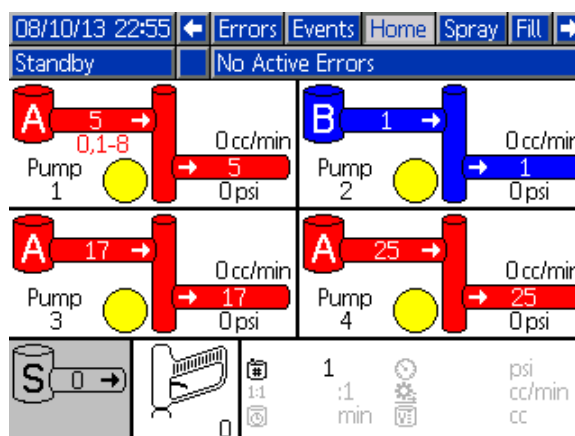


Figure 14 PD2K Home Screen (Advanced Display Module)

- See the PD2K Operation Manual to return the system to service.

Repair

Dose Valve Tubing Connections

NOTE: Red and green 5/32 in. (4 mm) tubing connects the solenoid manifold to the pump's dosing valves. See the Pump Tubing Schematic on the next page. Tubing lengths must be 18 in. \pm 1/2 in. (457 mm \pm 13 mm) for all connections. Always use equal lengths of tubing, to balance the timing of the valves. Lengths longer than 18 in. (457 mm) will increase valve response time.

1. On the bottom of the solenoid manifold are four ports with tube fittings: UP OPEN, UP CLOSED, DOWN OPEN, and DOWN CLOSED. These ports provide air to open and close the pump's inlet dosing valves.

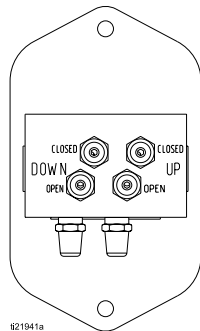


Figure 15 Tubing Connections at Solenoid Manifold, to Pump Inlet Manifold

- a. Connect green tubing (G) from the UP OPEN fitting to the 90° tube fitting on the side of the INLET UP dosing valve.
- b. Connect red tubing (R) from the UP CLOSED fitting to the 90° tube fitting on the end of the INLET UP dosing valve.
- c. Connect green tubing (G) from the DOWN OPEN fitting to the 90° tube fitting on the side of the INLET DOWN dosing valve.
- d. Connect red tubing (R) from the DOWN CLOSED fitting to the 90° tube fitting on the end of the INLET DOWN dosing valve.

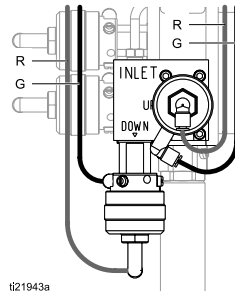


Figure 16 Inlet Manifold Tubing Connections

2. On the side of the solenoid manifold are four ports with 90° tube fittings (not shown): UP OPEN, UP CLOSED, DOWN OPEN, and DOWN CLOSED. These ports provide air to open and close the pump's outlet dosing valves.

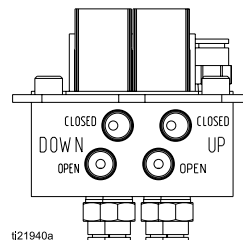


Figure 17 Tubing Connections at Solenoid Manifold, to Pump Outlet Manifold

- a. Connect green tubing (G) from the UP OPEN fitting to the 90° tube fitting on the side of the OUTLET UP dosing valve.
- b. Connect red tubing (R) from the UP CLOSED fitting to the 90° tube fitting on the end of the OUTLET UP dosing valve.

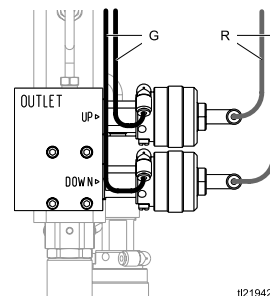


Figure 18 Outlet Manifold Tubing Connections

- c. Connect green tubing (G) from the DOWN OPEN fitting to the 90° tube fitting on the side of the OUTLET DOWN dosing valve.
 - d. Connect red tubing (R) from the DOWN CLOSED fitting to the 90° tube fitting on the end of the OUTLET DOWN dosing valve.
3. Repeat these steps for each pump in your system.

Table 1 Dose Valve Actuation

Pump Stroke	Up Inlet Valve	Down Inlet Valve	Up Outlet Valve	Down Outlet Valve
Up	Open	Closed	Open	Closed
Down	Closed	Open	Closed	Open

See the following table to understand the relationship between pump stroke and dose valve actuation.

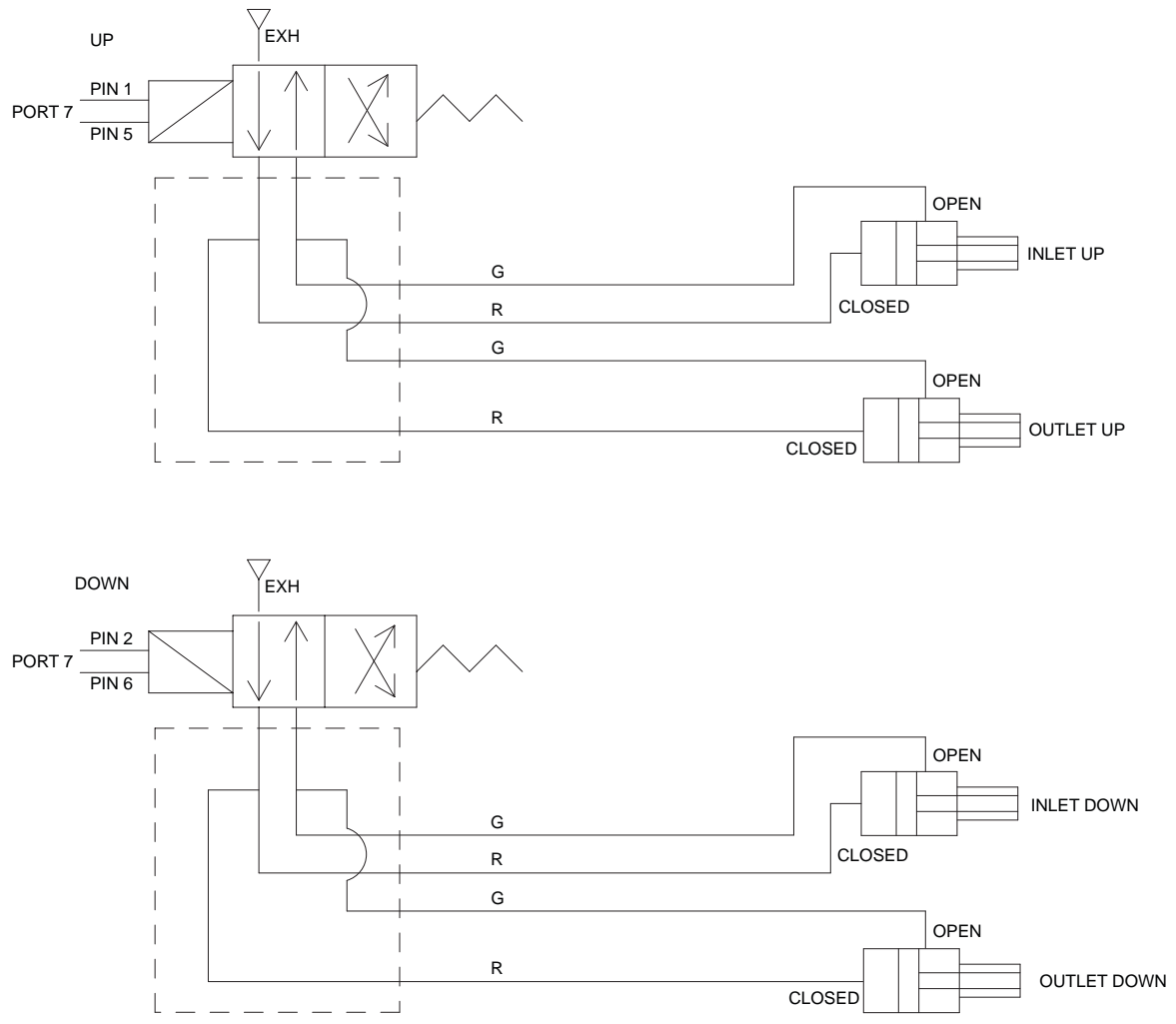


Figure 19 Pump Tubing Schematic

Replace Pump Control Module

If the pump control module needs replacement, install a new module as follows.

NOTICE

To avoid electrical component damage, remove all system power before plugging any connectors.

NOTE: See the [Electrical Schematics](#), page 21.

1. Connect the motor cable connectors (25) to connection ports 2 and 3 on the pump control module (5) and to the pump motor (N).

NOTE: The wire harness has two cables, one for the motor control and the other for encoder feedback. The connectors are keyed differently to ensure correct installation. Attach the two ground wires to the ground screw on the pump motor (N).

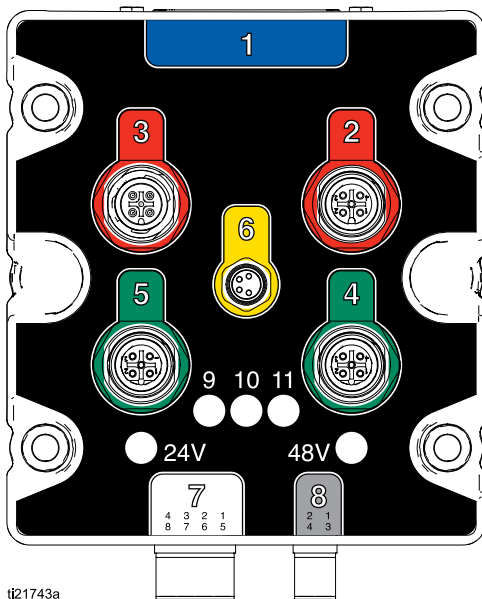


Figure 20 Pump Control Module Connection Points

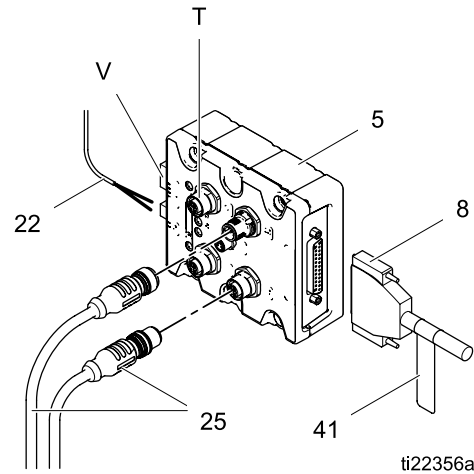


Figure 21 Pump Control Module Connections

2. Connect the 2-wire cable (22) to connection port 8 on the pump control module (5); red wire to pin 1 and black wire to pin 2.
3. Ensure that the pre-installed D-SUB Cable (8) is securely attached to connection port 1 on the pump control module (5).
4. Connect the pump's outlet pressure transducer (T) to port 5.
5. If an inlet pressure transducer (accessory) is used, connect it to port 4.
6. Install the valve wiring (V) in port 7. See [Electrical Schematics, page 21](#).

Electrical Schematics

NOTE: The electrical schematic illustrates all possible wiring expansions in a ProMix PD2K system. Some components shown are not included with all systems.

NOTE: See [Optional Cables and Modules](#) for a list of cable options.

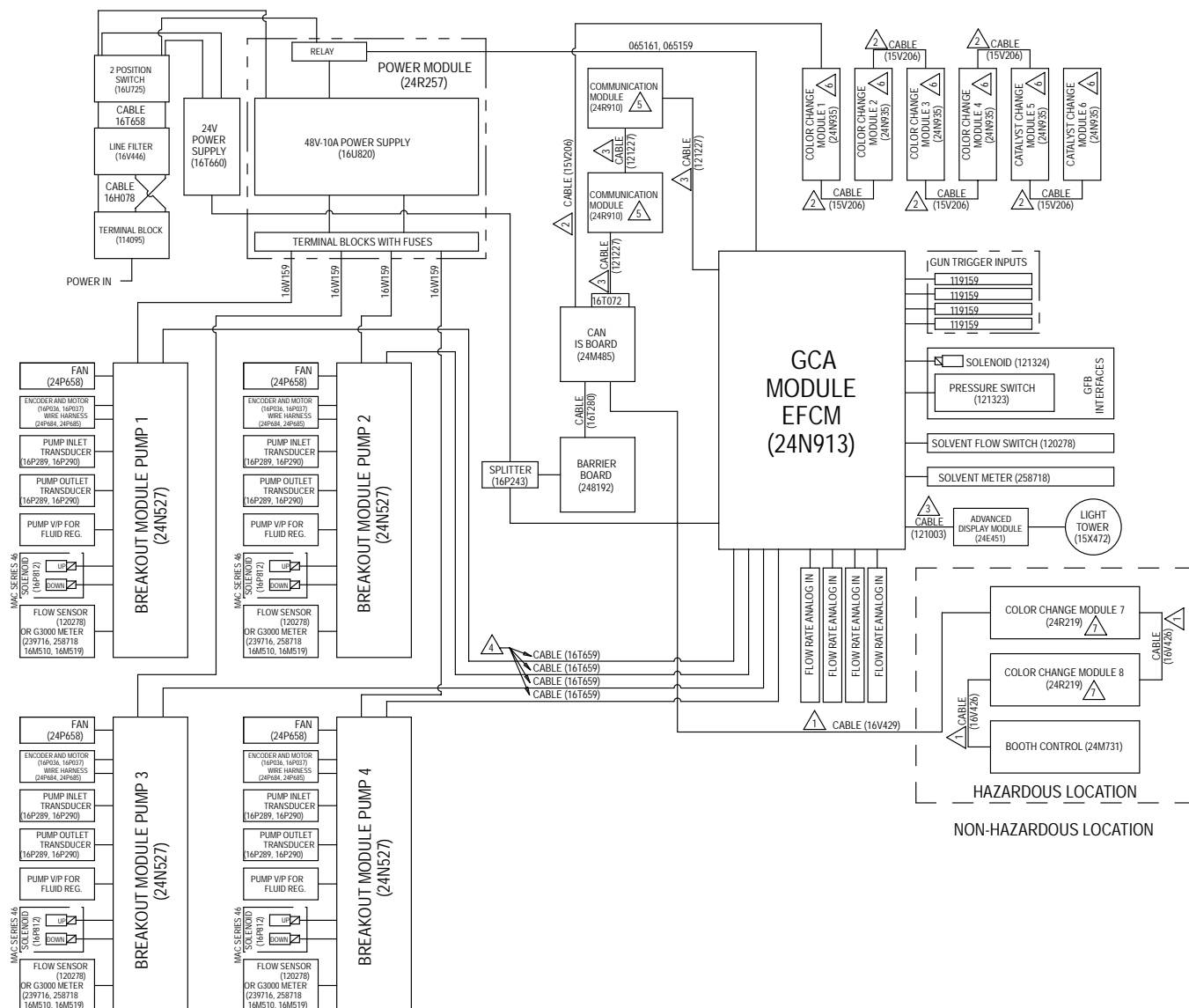


Figure 22 Electrical Schematic, Sheet 1

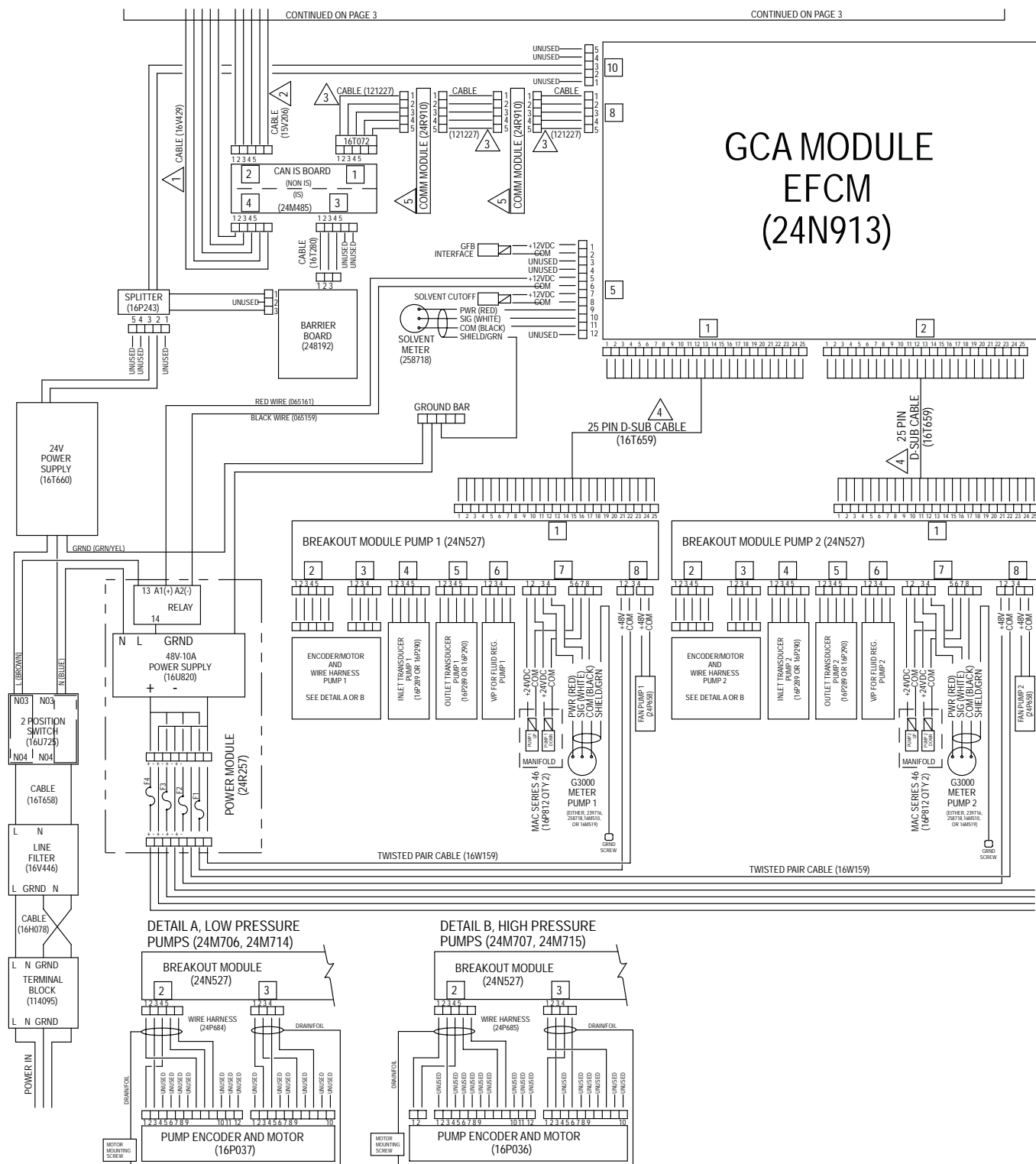


Figure 23 Electrical Schematic, Sheet 2, Part 1

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Electrical Schematics

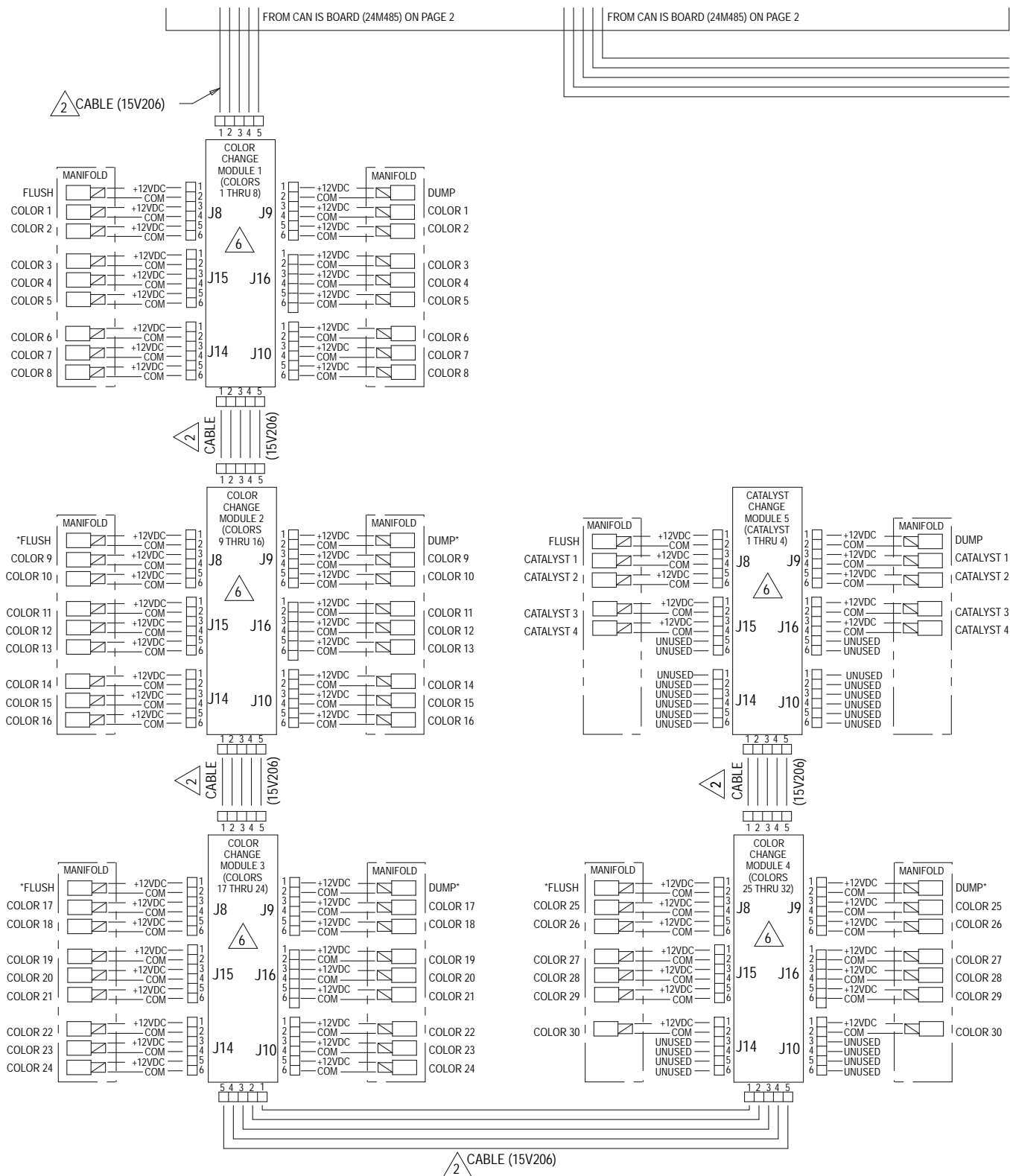


Figure 25 Electrical Schematic, Sheet 3

* May be unused in some configurations.

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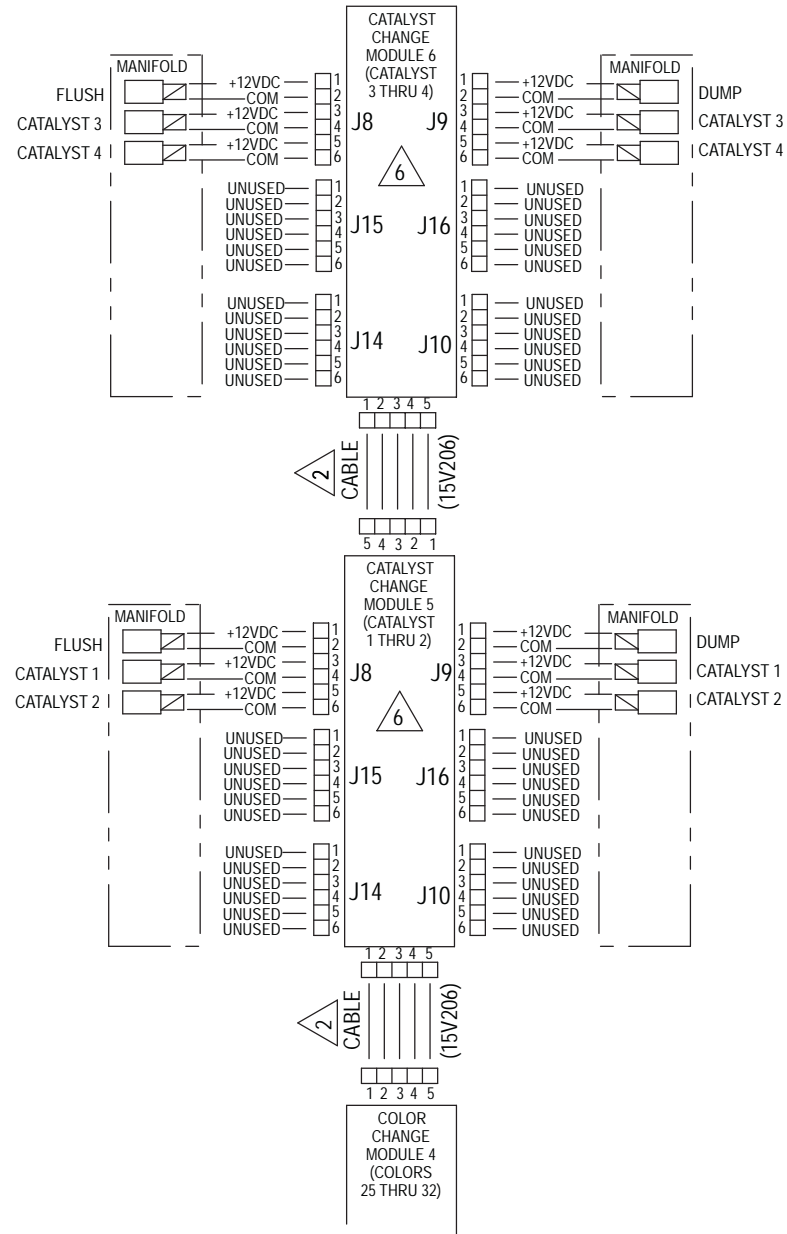


Figure 26 Electrical Schematic, Sheet 3, Alternate Configuration for Catalyst Change Control

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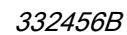
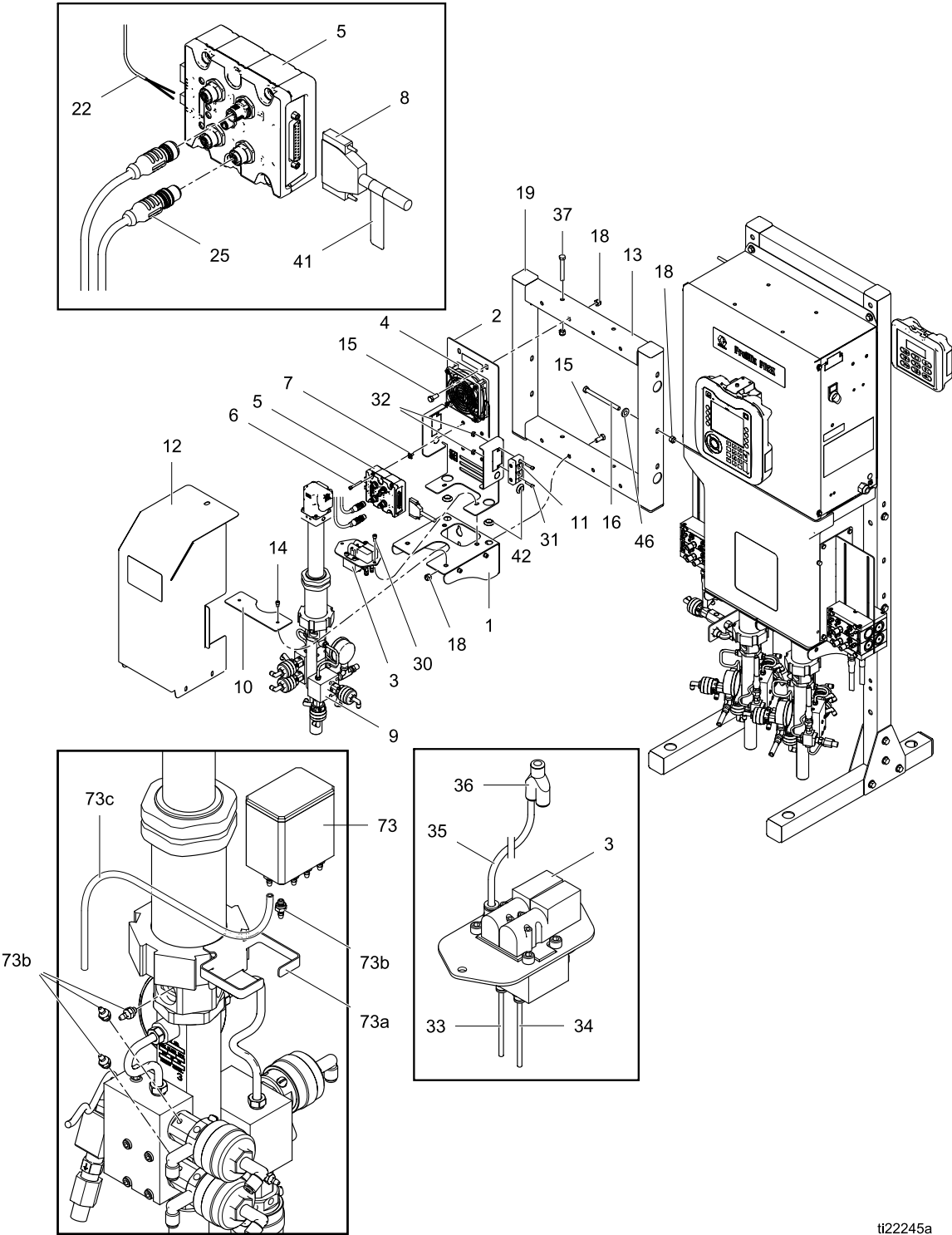


Figure 27 Electrical Schematic, Sheet 3, Hazardous Location

Pump Expansion Kit Parts



ti22245a

Pump Expansion Kit Parts

Part No. 24R968, 70 cc Low Pressure Color Pump Kit

Part No. 24R969, 70 cc High Pressure Color Pump Kit

Part No. 24R970, 35 cc Low Pressure Catalyst Pump Kit

Part No. 24R971, 35 cc High Pressure Catalyst Pump Kit

Ref	Part	Description	Qty	Ref	Part	Description	Qty
1	— — —	BRACKET, mounting, pump	1	18	— — —	NUT, lock; 3/8–16	8
2	— — —	PANEL, back	1	19	— — —	PLUG, tube, square	4
3	24T772	MANIFOLD, solenoid	1	22	— — —	CABLE, 2–wire	1
4	24T770	KIT, fan	1	25	24P684	WIRE HARNESS; for Kits 24R968 and 24R970	1
5	24N527	MODULE, control, pump	1		24P685	WIRE HARNESS; for Kits 24R969 and 24R971	1
6	— — —	SCREW, cap, socket head; 10–32 x 1.5 in. (38 mm)	4	27	— — —	TIE WRAP (not shown)	3
7	— — —	SCREW, ground; M5 x 0.8	1	30	101550	SCREW, cap, socket head; 1/4–20 x 1/2 in. (13 mm)	2
8	16V659	CABLE, D-SUB; 25 pin; 6 ft (1.83 m)	1	31	105209	SCREW, cap, socket head; 10–32 x 7/8 in. (22 mm)	4
9	24T790	PUMP, 70 cc, A side, low pressure; for Kit 24R968; see manual 332339	1	32	114231	NUT, lock; 10–32	4
	24T791	PUMP, 70 cc, A side, high pressure; for Kit 24R969; see manual 332339	1	33	— — —	TUBE, nylon, red; for control air to turn valves off; 5/32 in. (4 mm) OD x 18 in. (457 mm)	4
	24T788	PUMP, 35 cc, B side, low pressure; for Kit 24R970; see manual 332339	1	34	— — —	TUBE, nylon, green; for control air to turn valves on; 5/32 in. (4 mm) OD x 18 in. (457 mm)	4
	24T789	PUMP, 35 cc, B side, high pressure; for Kit 24R971; see manual 332339	1	35	— — —	TUBE, polyethylene; 1/4 in. (6 mm) OD x 6 ft (1.83 m)	A/R
10	— — —	BRACKET, mounting, pump	1	36	115287	Y-FITTING; 1/4 in. (6 mm) OD tubing	1
11	— — —	GROMMET, dual cable	2	37	— — —	SCREW, cap, hex head; 3/8–16 x 2.75 in. (70 mm)	1
12	16V858	COVER	1	41	16X048	LABEL, notice	2
13	— — —	FRAME	1	42	— — —	GROMMET	3
14	C19798	SCREW, cap, socket head; 1/4–20 x 3/8 in. (10 mm)	6	46	— — —	WASHER; 3/8	3
15	— — —	SCREW, cap, hex head; 3/8–16 x 7/8 in. (22 mm)	4				
16	— — —	SCREW, cap, hex head; 3/8–16 x 3.75 in. (95 mm)	3				

Pump Expansion Kit Parts

Ref	Part	Description	Qty	Ref	Part	Description	Qty
73	24T302	KIT, cup, TSL; includes items 73a-73e	1	73d	— — —	PLUG, screw; 10–32; to replace unused item 73b at TSL cup; not shown	4
73a	— — —	BRACKET	1	73e	— — —	GASKET; for item 73d; not shown	4
73b	24U617	KIT, barbed fittings; includes o-rings; package of 12	1	Items marked — — — are not available separately.			
73c	— — —	TUBE, polyurethane; 1/4 in. (6 mm) OD; 10 ft (3.05 m); cut to fit	1				

Notes

Technical Data

Pump Expansion Kit	U.S.	Metric
Maximum fluid working pressure:		
Kits 24R968 and 24R970	300 psi	2.1 MPa, 21 bar
Kits 24R969 and 24R971	1500 psi	10.5 MPa, 105 bar
Maximum working air pressure:	100 psi	0.7 MPa, 7.0 bar
Wetted parts:	See Pump manual 332339.	

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Original Instructions. This manual contains English. MM 332456

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