

Repair Kit



Air Motor Seal Kit 255057

311865 rev.A

Air motor seals and bearing used on Reactor A-20 proportioner.



Important Safety Instructions

Read all warnings and instructions in manual 311512. Save those instructions.

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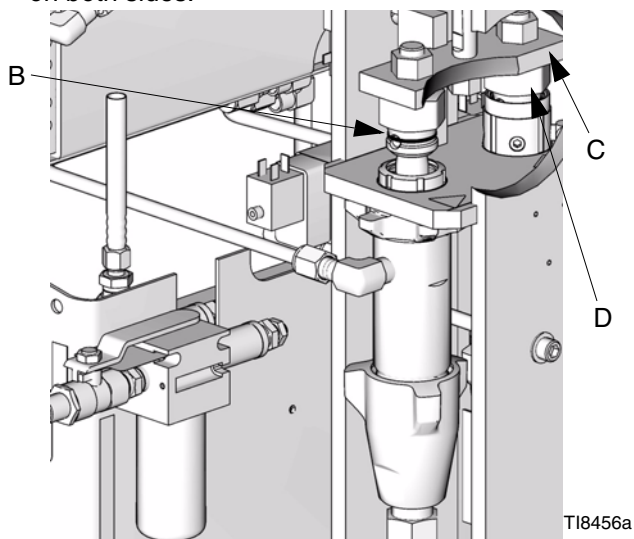




Before beginning, follow the Pressure Relief Procedure in manual 311512.

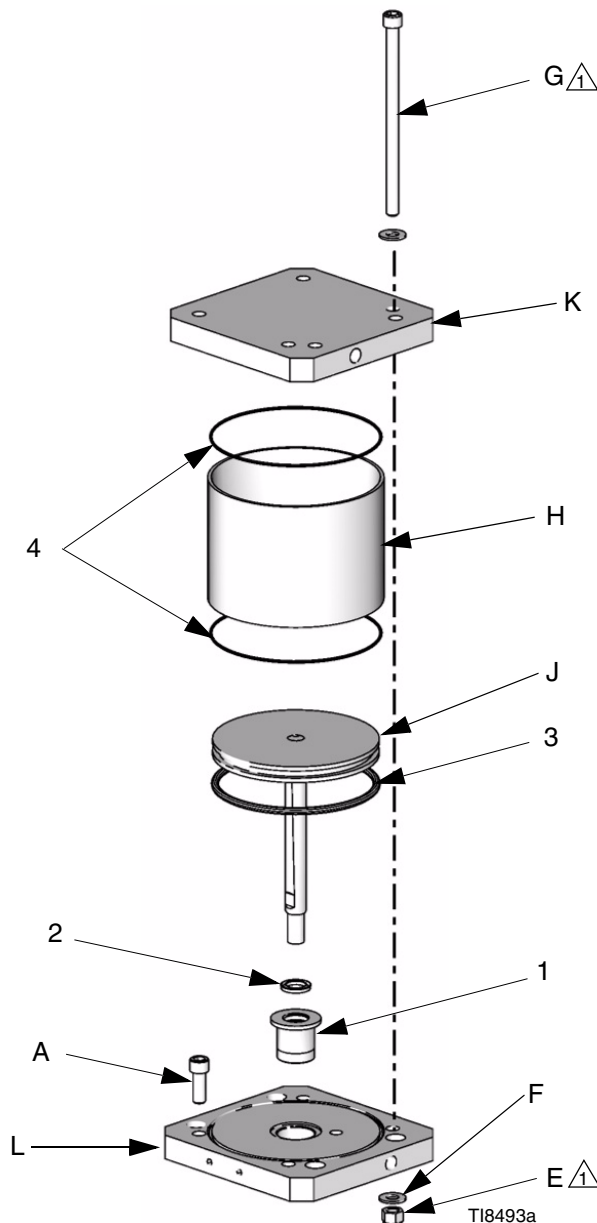
Air Motor Removal/Repair

1. Remove four bolts from air motor shrouds. Leave fan connected.
2. Raise retaining spring (B) and knock retaining pin out of hole. Leave yoke (C) and link in place. Repeat on both sides.



3. Disconnect air lines.
4. Remove four bolts (A) to remove entire air motor assembly.
5. Remove lock nut (D) from piston rod and remove yoke (C).
6. Remove four lock nuts (E), washers (F), and tie-rod bolts (G).
7. Lift top plate (K) and remove from cylinder (H).
8. Push piston rod assembly (J) out of the cylinder. Replace piston o-ring (3) and lubricate.
9. Press fit replacement bearing (1) into bottom plate (L), flange to inside of plate.
10. Insert u-cup seal (2) into bearing. Orient open vee of u-cup to flange end of bearing (1) and lubricate.

11. Replace top and bottom o-rings (4) in the end plates. Use lubricant to hold in place.
12. Assemble in reverse order.



⚠ Torque tie rods to 17-22 ft-lbs (1.9-2.5 N•m). Torque evenly in diagonal pattern in increasing incremental values.

Ref.	Part	Description	Qty.
1	15J149	BUSHING, rod, air motor, A-20	1
2	120554	SEAL, u-cup, bevel lip	1
3	296113	O-RING, #350, buna-n	1
4	296112	O-RING, #049, buna-n	2

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*All written and visual data contained in this document reflects the latest product information available at the time of publication.
Graco reserves the right to make changes at any time without notice.*

MM 311865

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