

# Bellows Chamber Kits

406854C

Merkur™ Bellows Pumps

ENG



## Important Safety Instructions

Read all warnings and instructions in manuals 312793 and 312795. Save all instructions.

See reverse for parts illustration and assembly notes.

**TIP:** Some o-rings are close in size. Stack on bench to differentiate.

**Kit 24E758, LB050x (50cc) pumps**

**Kit 24E759, LB100x (100 cc) pumps**

**Kit 24E760, LB150x (150cc) pumps**

Ref	Description	Size in. (mm)			Qty
		24E878	24E759	24E760	
101	O-RING, packing nut top	1.9 (48)	1.9 (48)	1.9 (48)	1
102	O-RING, bellows chamber	2.5 (64)	2.5 (64)	2.5 (64)	1
103	WASHER				3
104	SCREW, M6 x 25				1
105	CHAMBER, bellows				3
106	O-RING, foot cap	1.8 (46)	2.4 (61)	2.7 (69)	1
107	FITTING, inlet	3/4 in. npt	3/4 in. npt	1 in. npt	1
108	O-RING, inlet fitting	1.0 (25)	1.0 (25)	1.0 (25)	1
109*	O-RING, packing nut bottom	1.6 (41)	2.0 (51)	2.3 (58)	1
110**	O-RING, piston	0.6 (15)	0.8 (20)	0.8 (20)	1

\* May not be used. Remove packing nut only if necessary. If removed, replace o-rings before reassembly.

\*\* May not be used. Piston and rod may separate during disassembly. If separated, always replace the o-ring before reassembly.

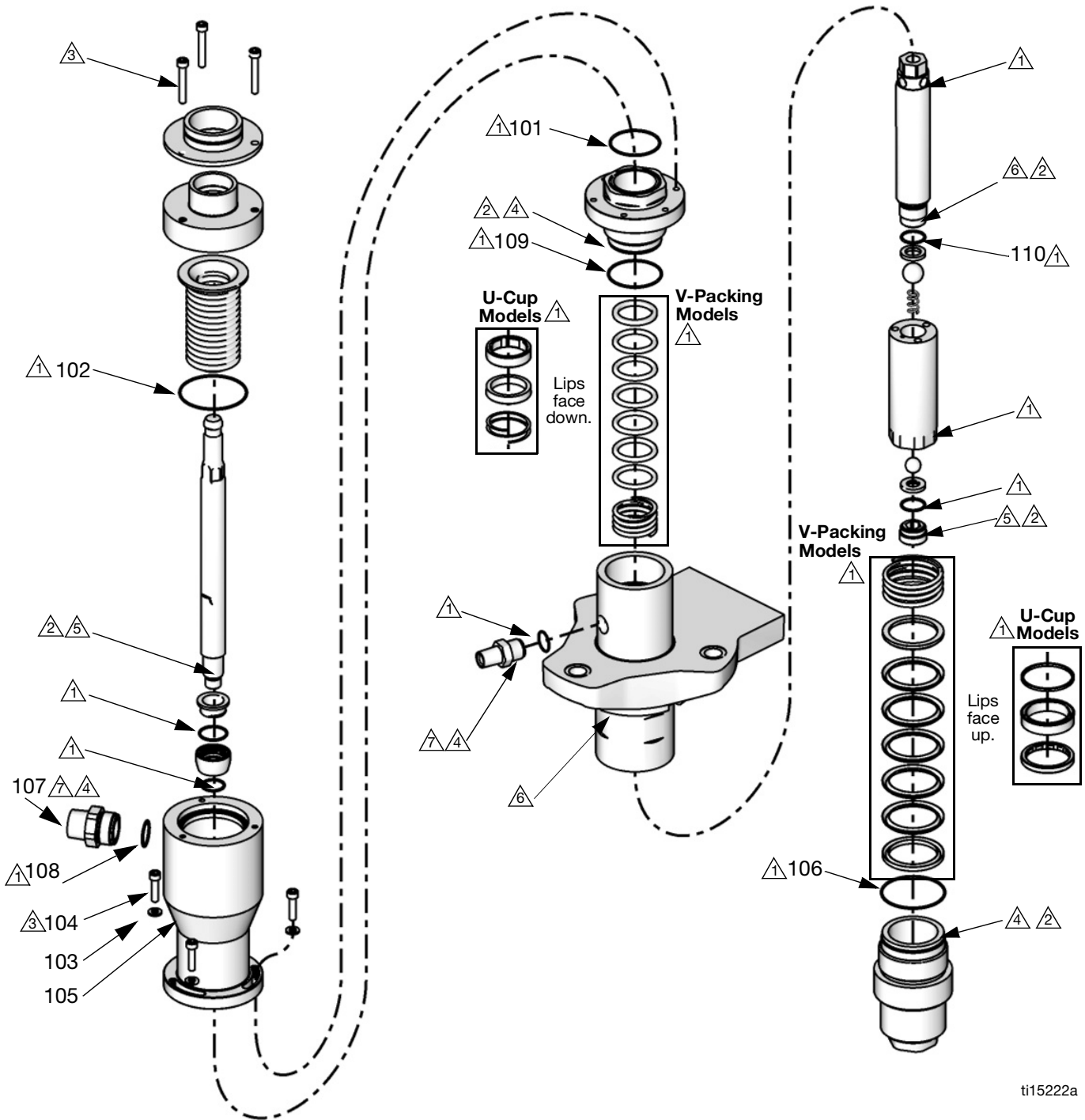
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Original instructions. MM 406854

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**NOTE:** Full disassembly shown. Disassemble only as far as needed for the parts being replaced.



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- 1 Apply grease.
- 2 Apply thread lubricant.
- 3 Torque to 100-120 in-lb (11-14)
- 4 Torque to 54-66 ft-lb (73-89)
- 5 Torque to 74-86 ft-lb (100-117)
- 6 Torque to 91-109 ft-lb (123-148)
- Apply high-strength thread locker.