

Displacement Pump

309577F

FOR USE WITH REACTOR™ ELECTRIC PROPORTIONERS

3500 psi (24.5 MPa, 245 bar) Maximum Working Pressure

Component A (ISO) Pumps with wet-cup flush feature

Part No. 246830, Series A

0.396 in.² (2.55 cm²)

Part No. 246831, Series B

0.552 in.² (3.56 cm²)

Part No. 246832, Series A

0.743 in.² (4.79 cm²)

Component B (Resin) Pumps

Part No. 245970, Series A

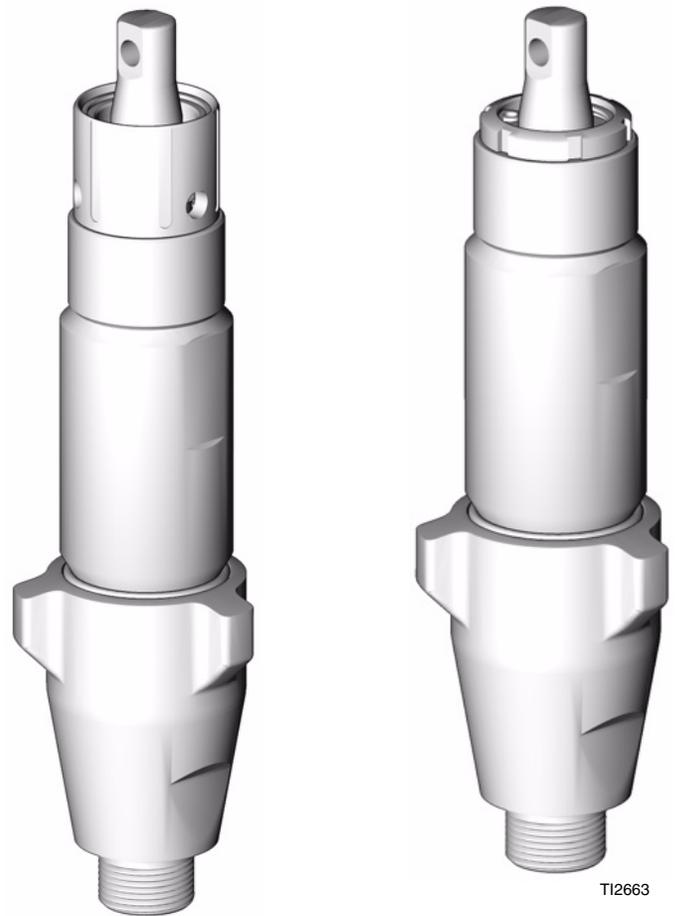
0.396 in.² (2.55 cm²)

Part No. 245971, Series B

0.552 in.² (3.56 cm²)

Part No. 245972, Series A

0.743 in.² (4.79 cm²)



T13733

T12663



Important Safety Instructions

Read all warnings and instructions in this manual.
Save these instructions.

PROVEN QUALITY. LEADING TECHNOLOGY.

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Manual Conventions

Warning

 **WARNING**




A warning alerts you to possible serious injury or death if you do not follow instructions.

Symbols, such as fluid injection (shown), alert you to a specific hazard and direct you to read the indicated hazard warnings on pages 3-4.

Caution

 **CAUTION**

A caution alerts you to possible equipment damage or destruction if you do not follow instructions.

Note

 A note indicates additional helpful information.

Related Manuals

The following manuals are available for the Reactor™. Refer to these manuals for detailed equipment information.

| Reactor Electric Proportioner | |
|-------------------------------|--|
| Part No. | Description |
| 309551 | Reactor Electric Proportioner, Operation Manual (English) |
| 309574 | Reactor Electric Proportioner, Repair-Parts Manual (English) |
| 309911 | Reactor Pump Wet-Cup Flush Kits |


WARNING
**SKIN INJECTION HAZARD**

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.**

- Do not point the gun at anyone or at any part of the body.
- Do not put your hand or fingers over the gun fluid nozzle.
- Do not stop or deflect leaks with your hand, body, glove, or rag.
- Do not “blow back” fluid; this is not an air spray system.
- Follow **Pressure Relief Procedure**, page 5, when you stop spraying and before cleaning, checking, or servicing equipment.
- Use lowest possible pressure when flushing, priming, or troubleshooting.
- Engage spray gun piston safety lock when not spraying.
- Tighten all fluid connections before operating the equipment.
- Check hoses, tubes, and couplings daily. Replace worn or damaged parts immediately. High pressure hose cannot be recoupled; replace the entire hose.

**FIRE AND EXPLOSION HAZARD**

Solvent and fumes in work area can ignite or explode. To help prevent fire and explosion:

- Use equipment only in well ventilated area.
- Eliminate all ignition sources, such as pilot lights, cigarettes and plastic drop cloths (potential static arc).
- Do not plug or unplug power cords or turn lights on or off when flammable fumes are present.
- Keep the work area free of debris, including solvent, rags, and gasoline.
- Ground equipment and conductive objects. See **Grounding** in your Reactor manual.
- Hold gun firmly to side of grounded pail when triggering into pail.
- Use only grounded hoses.
- If there is static sparking or you feel a shock, **stop operation immediately**. Do not use equipment until you identify and correct the problem.

**EQUIPMENT MISUSE HAZARD**

Misuse can cause serious injury or death.

- For professional use only.
- Use equipment only for its intended purpose. Call your Graco distributor for information.
- Read manuals, warnings, tags, and labels before operating equipment. Follow instructions.
- Check equipment daily. Repair or replace worn or damaged parts immediately.
- Do not alter or modify equipment. Use only Graco parts and accessories.
- 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.
- Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces.
- Do not use hoses to pull equipment.
- Comply with all applicable safety regulations.

|  WARNING | |
|--|--|
|  | <p>BURN HAZARD</p> <p>This equipment is used with heated fluid, which can cause equipment surfaces to become very hot. To avoid severe burns:</p> <ul style="list-style-type: none"> • Do not touch hot fluid or equipment. • Allow equipment to cool completely before touching it. • Wear gloves if fluid temperature exceeds 110°F (43°C). |
|  | <p>TOXIC FLUID OR FUMES HAZARD</p> <p>Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled, or swallowed.</p> <ul style="list-style-type: none"> • Read Material Safety Data Sheet (MSDS) 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. |
|  | <p>PERSONAL PROTECTIVE EQUIPMENT</p> <p>You must wear proper protective equipment when operating, servicing, or when in the operating area of the equipment to help protect you from serious injury, including eye injury; inhalation of toxic fumes; and hearing loss. This equipment includes but is not limited to:</p> <ul style="list-style-type: none"> • Protective eyewear • Gloves, clothing, and respirator as recommended by the fluid and solvent manufacturer • Hearing protection. |

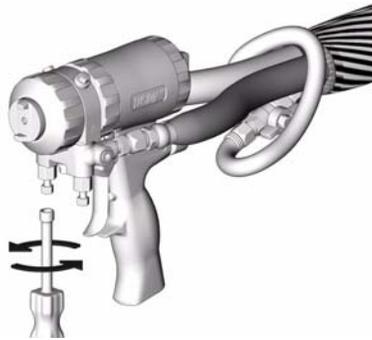
Pressure Relief Procedure

WARNING

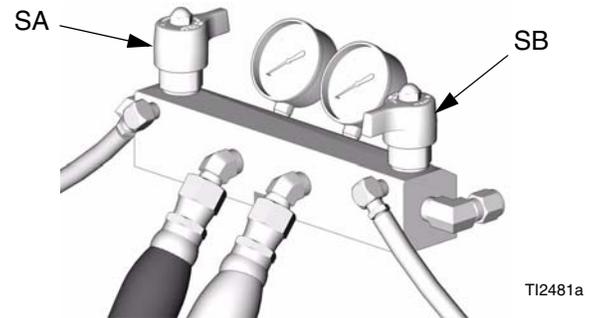


Read warnings, page 3.

1. Relieve pressure in gun and perform gun shut-down procedure. See gun manual.
2. Close gun fluid manifold valves A and B.



3. Shut off feed pumps and agitator, if used.
4. Turn PRESSURE RELIEF/SPRAY valves (SA, SB) to PRESSURE RELIEF. Route fluid to waste containers or supply tanks. Ensure that gauges drop to 0.



Tools Needed

- Vise with flat jaws
- 12 in. adjustable, open end wrench (2)
- Non-sparking hammer, 20 oz maximum
- Small screwdriver
- Throat Seal Liquid (TSL), Graco Part No. 206995
- ISO Pump Oil, Graco Part No. 217374
- Pick or long small screwdriver
- Snap-ring pliers
- 1/2 in. (13 mm) diameter plastic rod
- 7/8 in. deep-well socket (246830 and 245970 only)
- 1/2 in. (13 mm) x 2.5 in. (64 mm) bolt with washers and nut
- Channel locks
- Dropcloth and rags

Repair Kits

A repair kit is available for your pump. Kit parts are marked with an asterisk, for example (3*). See page 23. Kit must be purchased separately. For best results, use all parts in the kit.

Clean and Inspect Parts

- 1.** Clean and inspect all parts. Intake and piston ball seats, sleeve, and displacement rod must not be worn, scratched, or damaged.
- 2.** Remove and clean sleeve when repacking pump.

Supply Wet-cups with Throat Seal Liquid

2.

Component B (Resin) Pump: Check felt washers (21) in packing nut/wet-cup (19) daily. Keep saturated with Graco Throat Seal Liquid (TSL), Part No. 206995, to prevent material from hardening on displacement rod. Replace felt washers when worn or contaminated with hardened material.

WARNING



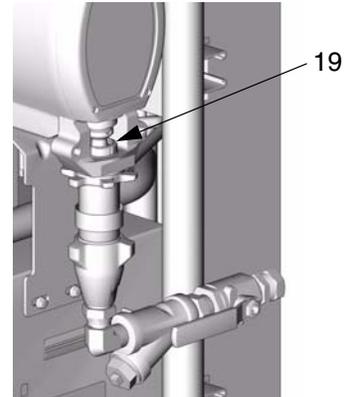
Pump rod and connecting rod move during operation. Moving parts can cause serious injury such as pinching or amputation. Keep hands and fingers away from wet-cup during operation. Turn main power OFF



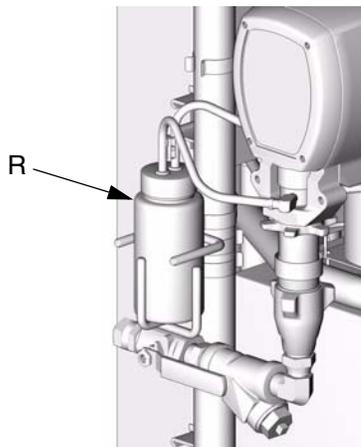
before filling wet cup.

1. Component A (ISO) Pump: Keep reservoir (R) 3/4 filled with Graco Throat Seal Liquid (TSL), Part No. 206995. Wet-cup piston (28) circulates TSL through packing nut/wet-cup (19), to carry away isocyanate film on displacement rod.

After some time TSL will thicken and darken, and must be replaced. Thick, dirty TSL will not pump through lines and will harden in wet-cup. Check condition of TSL every week, minimum, and change when needed.



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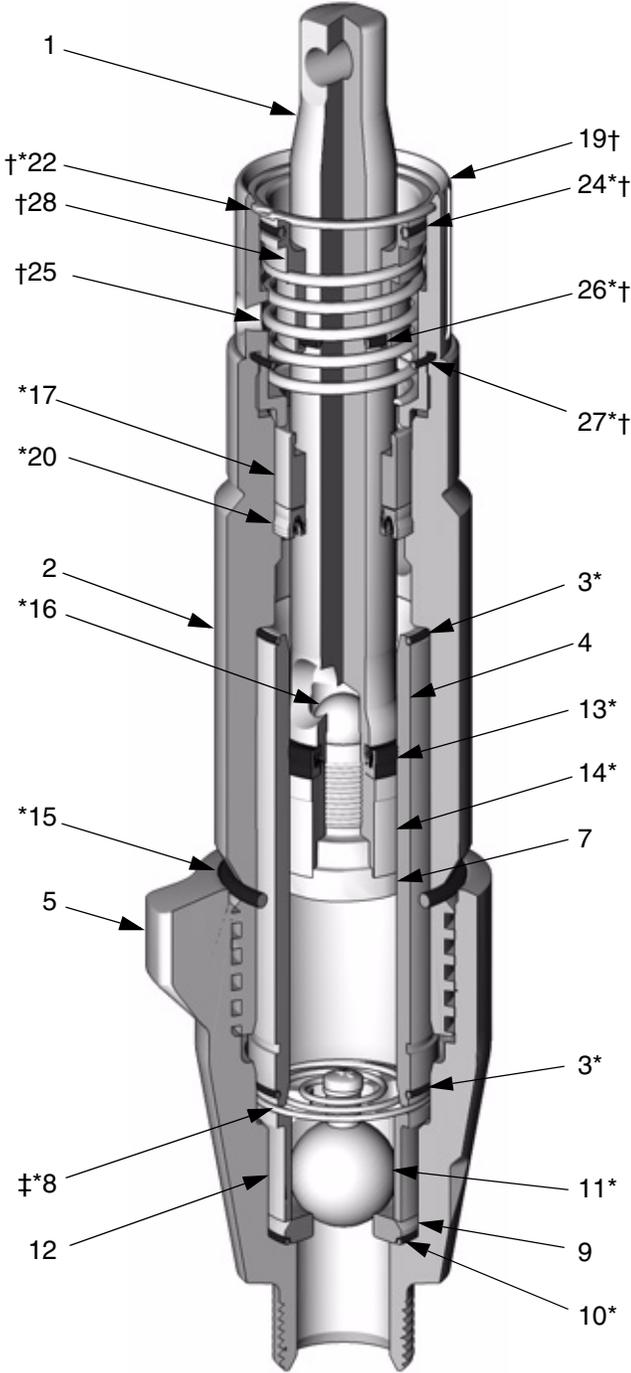


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Cutaway Views

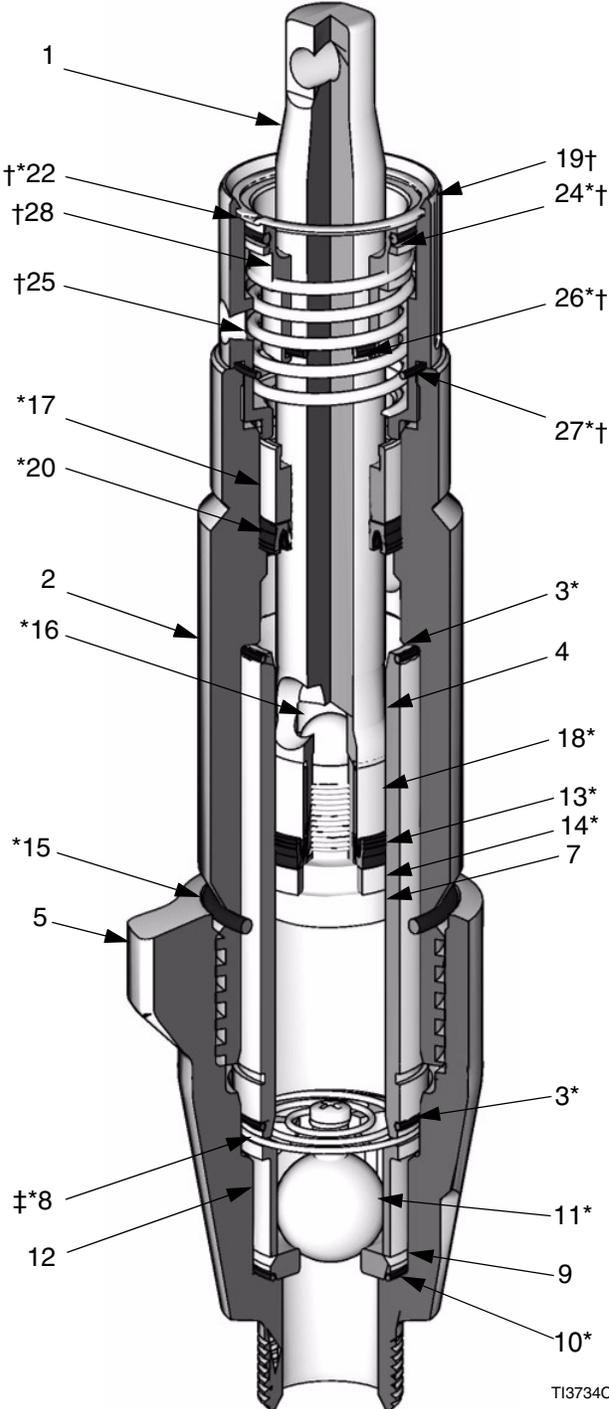
Component A (ISO) Pump

246830
246832



TI3734b

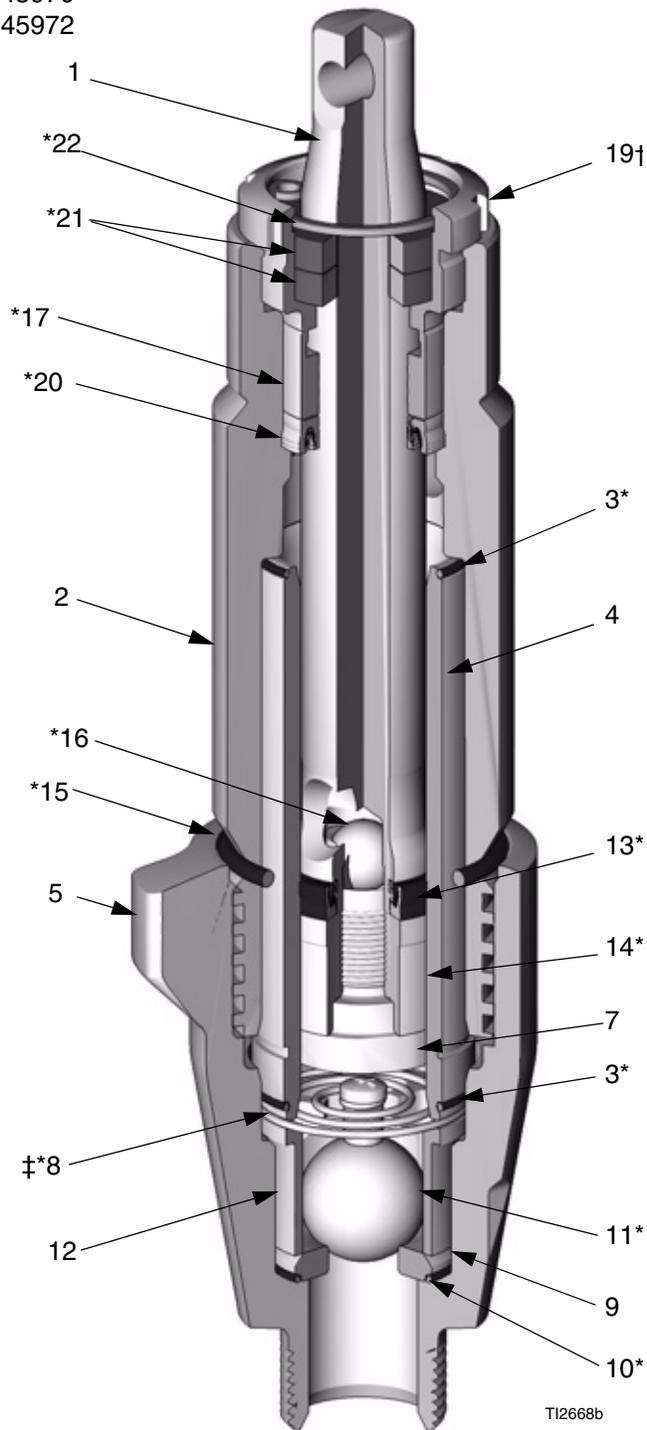
246831



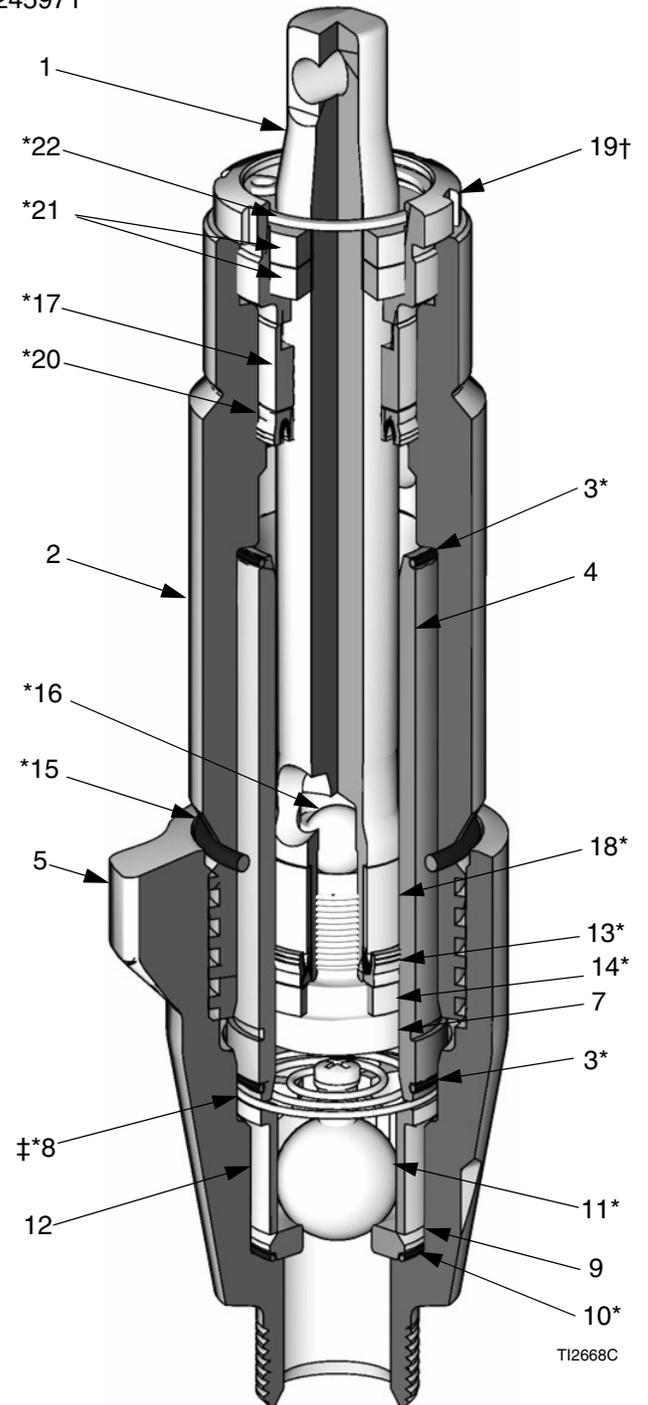
TI3734C

Component B (Resin) Pump

245970
245972



245971



Disassembly

 **WARNING**



Pump rod and connecting rod move during operation. Moving parts can cause serious injury such as pinching or amputation. Keep hands and fingers away from connecting rod during operation.

1. Shut off , , and  heat zones.

2. Flush pumps. See Reactor manual.

3. Relieve pressure, page 5.

4. Press . Motor will run until pumps are at bottom of strokes, then shut off.

5. Turn main power OFF . Disconnect power supply.

 Steps 6-8 apply to pump A. See FIG. 1. To disconnect pump B, go to steps 9 and 10. Use dropcloth or rags to protect Reactor and surrounding area from spills.

6. Disconnect fluid inlet (C) and outlet (D). Also disconnect steel outlet tube from heater inlet.

7. Disconnect tubes (T). Remove tube fittings (U) from wet-cup.

8. Loosen star-shaped locknut (G) by hitting firmly with a non-sparking hammer. Unscrew pump far enough to expose retaining pin under plastic finger guard. Push retaining spring up. Push pin out. Continue unscrewing pump.



Steps 9 and 10 apply to pump B. See FIG. 2. Use dropcloth or rags to protect Reactor and surrounding area from spills.

9. Disconnect fluid inlet (C) and outlet (D). Also disconnect steel outlet tube from heater inlet.

10. Push retaining spring (E) up. Push pin (F) out. Loosen star-shaped locknut (G) by hitting firmly with a non-sparking hammer. Unscrew pump.

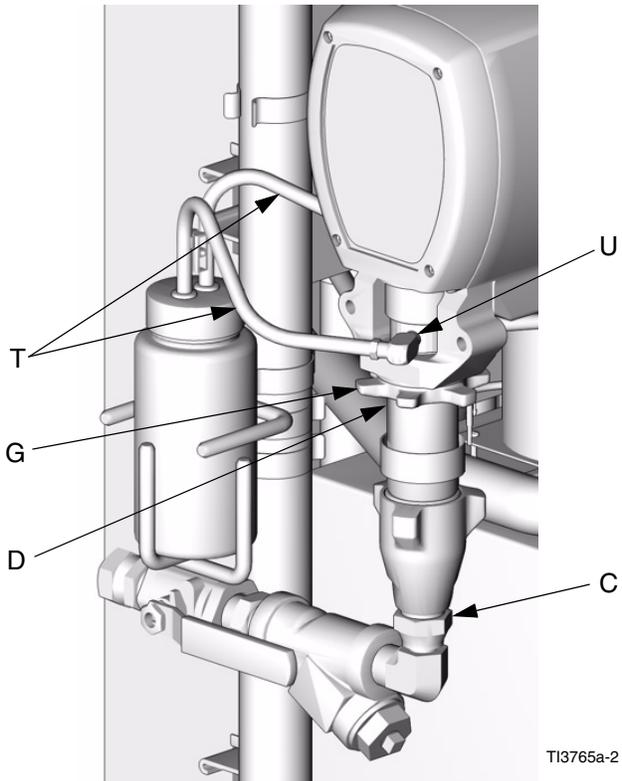


FIG. 1. Disconnect Pump A

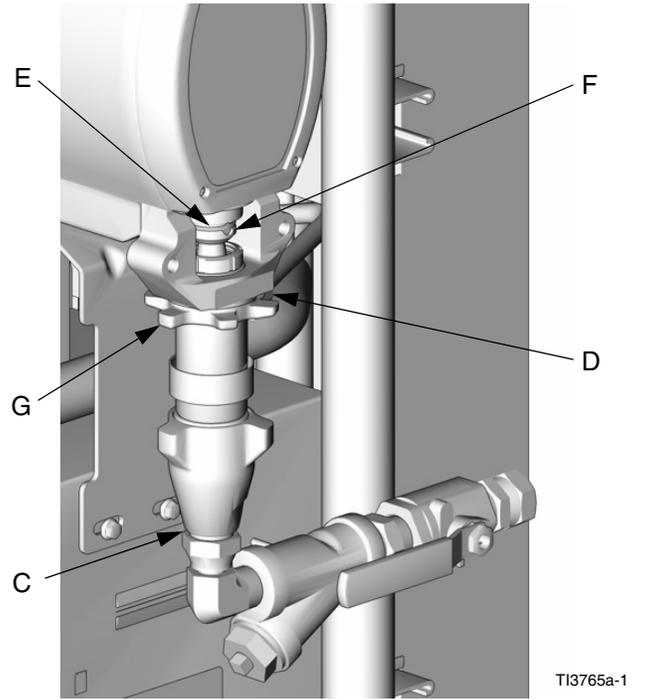
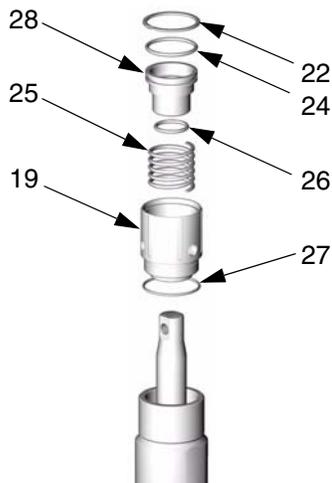


FIG. 2. Disconnect Pump B

11. Remove packing nut/wet-cup as follows:

a. Component A (ISO) Pumps:

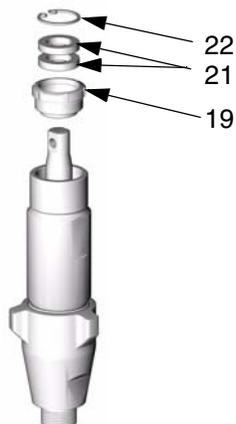
- Remove packing nut/wet-cup assembly.
- Compress piston (28) into wet-cup (19), using a 1/2 in. (13 mm) x 2.5 in. (64 mm) bolt with washers and nut.
- Remove retaining ring (22).
- Remove bolt, washers, and nut.
- Remove piston (28), spring (25), and o-rings (24, 26, 27).



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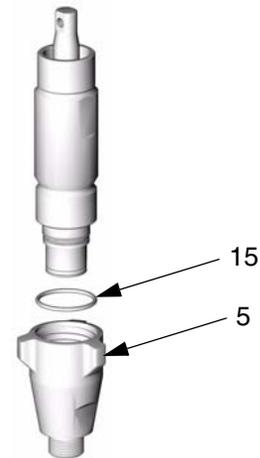
b. Component B (Resin) Pumps:

Unscrew packing nut (19). Remove retaining ring (22) and felt washers (21).



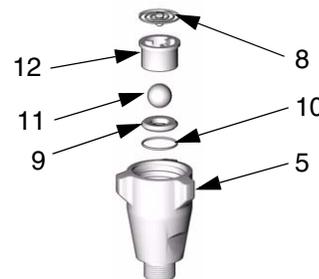
TI2662A

12. Loosen intake valve housing (5) with non-sparking hammer, then unscrew. Remove o-ring (15).



TI2664A

13. Disassemble intake valve. Be sure to remove o-ring (10).

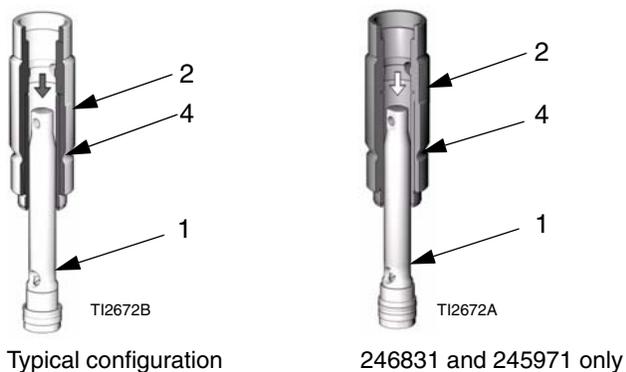


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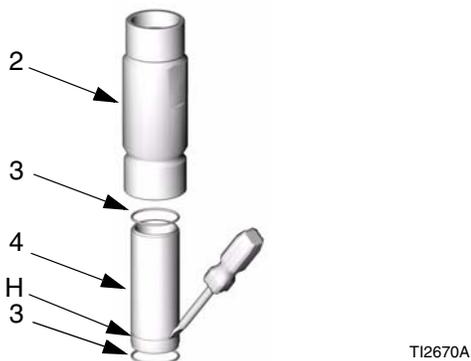
Spring (8) is on Models 246832 and 245972 only.

- 14.** Tap rod (1) with non-sparking hammer to drive it out of cylinder (2).



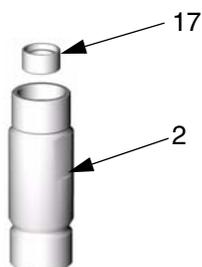
Sleeve (4) may come out with rod.

- 15.** Using screwdriver in groove (H), remove sleeve (4) from cylinder (2), or pull it off rod. Remove o-rings (3).

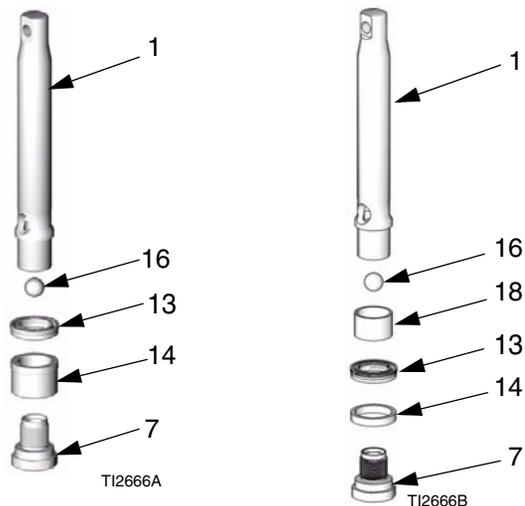


Be sure top o-ring (3) comes out.

- 16.** Remove bushing (17).



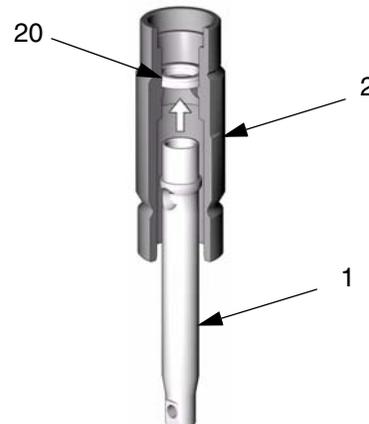
- 17.** Unscrew piston (7) from rod (1). Remove ball (16), u-cup (13), and bushing (14).



Typical configuration

246831 and 245971 only

- 18.** Insert piston end of rod (1) into cylinder (2) and push u-cup (20) out.



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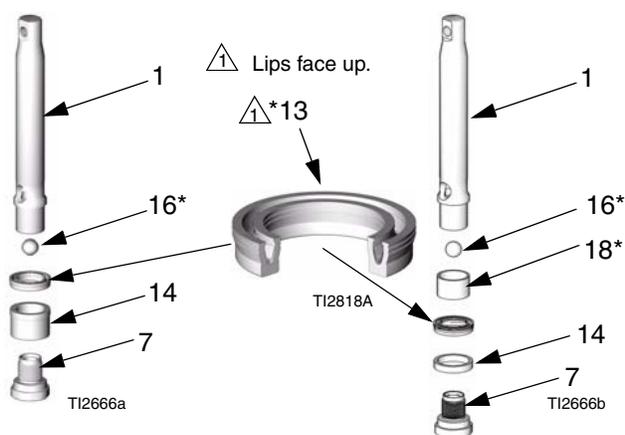


A series of horizontal lines for writing, consisting of 25 evenly spaced lines that span the width of the page.

Reassembly

 Coat all non-Loctited parts with Graco 217374 ISO Pump Oil before reassembly, to ease future disassembly.

1. Install ball (16*) in rod (1). Center u-cup (13*) on rod (1). Lips of u-cup must face up. Use piston (7) to evenly push u-cup onto rod, then remove piston. Slide bushing (14*) onto rod (1). Wide end of bushing must face up, toward u-cup.



Typical configuration

246831 and 245971 only

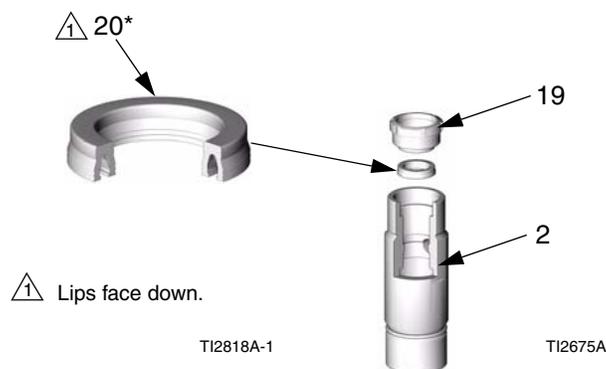
 Sealing patch on piston threads is good for four repackings. Use Loctite® on piston threads after four repackings; be sure none gets on ball.

2. Install piston (7). Be careful not to damage sealing edges of u-cup. Torque as specified below.

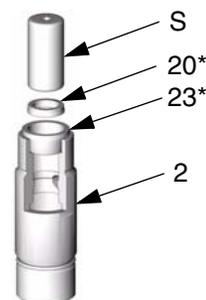
| Model | Torque ft-lb (N•m) |
|-------------------|-----------------------|
| 246830 and 245970 | 24-30 (32-40) |
| 246831 and 245971 | 47-53 (63-71) |
| 246832 and 245972 | 47-53 (63-71) |

3. Install throat u-cup as follows:

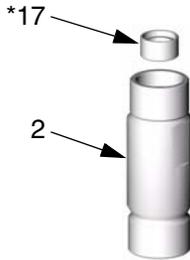
- a. **Models 246831, 246832, 245971, and 245972:** Grease u-cup (20*) and cylinder (2). Place u-cup in cylinder with lips facing down. Be careful not to damage sealing edges of u-cup. Install packing nut (19) to properly insert and align u-cup, then remove packing nut.



- b. **Models 246830 and 245970:** Grease u-cup (20*) and cylinder (2). Place seal installation tool (23*) in cylinder. Place u-cup in tool with lips facing down. Be careful not to damage sealing edges of u-cup. Press u-cup in place with 7/8 in. deep-well socket (S). Remove socket and tool.

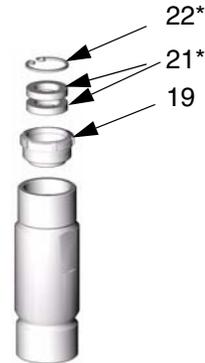


- 4.** Insert bushing (17*). Press bushing in place to seat u-cup.



TI2669B

- b. Component B (Resin) Pump:** Install felt washers (21*) into packing nut (19). Install retaining ring (22*). Install packing nut handtight.

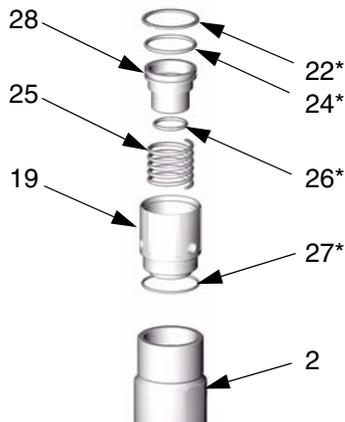


TI2701A

- 5.** Assemble packing nut as follows:

a. Component A (ISO) Pump:

- Install spring (25) in wet-cup (19).
- Install o-rings (24*, 26*) on piston (28) and insert piston in wet-cup.
- Compress piston (28) into wet-cup, using a 1/2 in. (13 mm) x 2.5 in. (64 mm) bolt with washers and nut.
- Install retaining ring (22*) in groove.
- Remove bolt, washers, and nut.
- Install o-ring (27*) on wet-cup.
- Install packing nut/wet-cup assembly handtight. Screw assembly all the way down, so external o-ring (27) seats on top of cylinder (2).

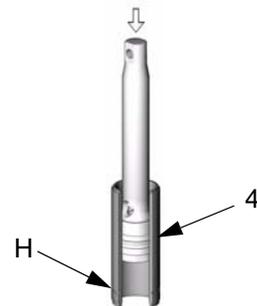


TI3735b



Groove (H) in sleeve outer surface must be toward bottom.

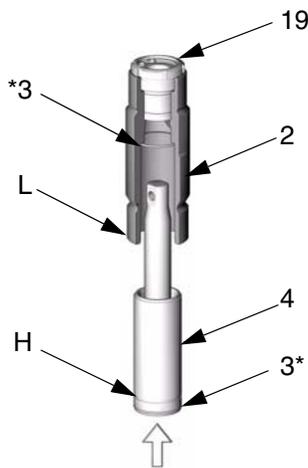
- 6.** Lubricate piston u-cup and sleeve top edge. Push piston assembly into top of sleeve (4). Drive in with non-sparking hammer.



TI2673A

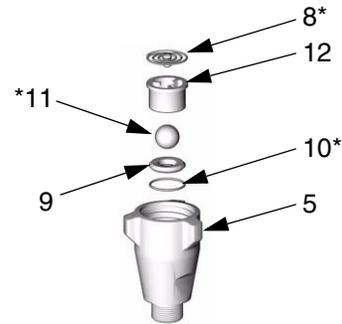
7. Lubricate top 1-2 in. (25-50 mm) of displacement rod (1) and outside of sleeve (4). Grease o-rings (3*) and place one in cylinder and other on bottom of sleeve.

8. Slide sleeve/rod assembly into bottom of cylinder (2). Drive in with hammer until top of groove (H) aligns with bottom of cylinder (L). Use plastic rod to drive displacement rod until 1/4-3/8 in. (6-10 mm) of its greatest diameter is visible above packing nut (19).



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9. Reassemble intake valve with o-ring (10*), seat (9), and ball (11*). Install ball guide (12). *Models 246832 and 245972 only:* Install spring (8*) with screw at top.

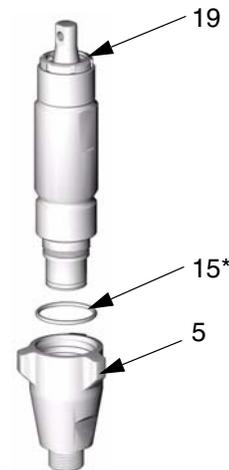


TI2665A



Seat may be flipped over and used on other side. Clean seat thoroughly. No scratches permitted on sealing edge.

10. Replace o-ring (15*). Install intake valve. Torque housing (5) as follows, or be sure intake valve is snug against cylinder.



TI2687A

| Model | Torque ft-lb (N•m) |
|-------------------|-----------------------|
| 246830 and 245970 | 65-75 (88-101) |
| 246831 and 245971 | 75-85 (101-114) |
| 246832 and 245972 | 145-155 (195-209) |

11. Tighten packing nut/wet-cup.

 Do not overtighten packing nut/wet-cup. Throat u-cup (20) is not adjustable.

- a. Pump A: Wrap base of wet-cup (19) with a rag and tighten securely with channel locks.
- b. Pump B: Torque packing nut (19) to 90-110 in-lb (10-12 N•m).

WARNING



Pump rod and connecting rod move during operation. Moving parts can cause serious injury such as pinching or amputation. Keep hands and fingers away from connecting rod during operation.

12. Reconnect power supply. Turn main power ON



13. Press . Motor will run until pumps are at bottom of strokes, then shut off.

14. Turn main power OFF . Disconnect power supply.

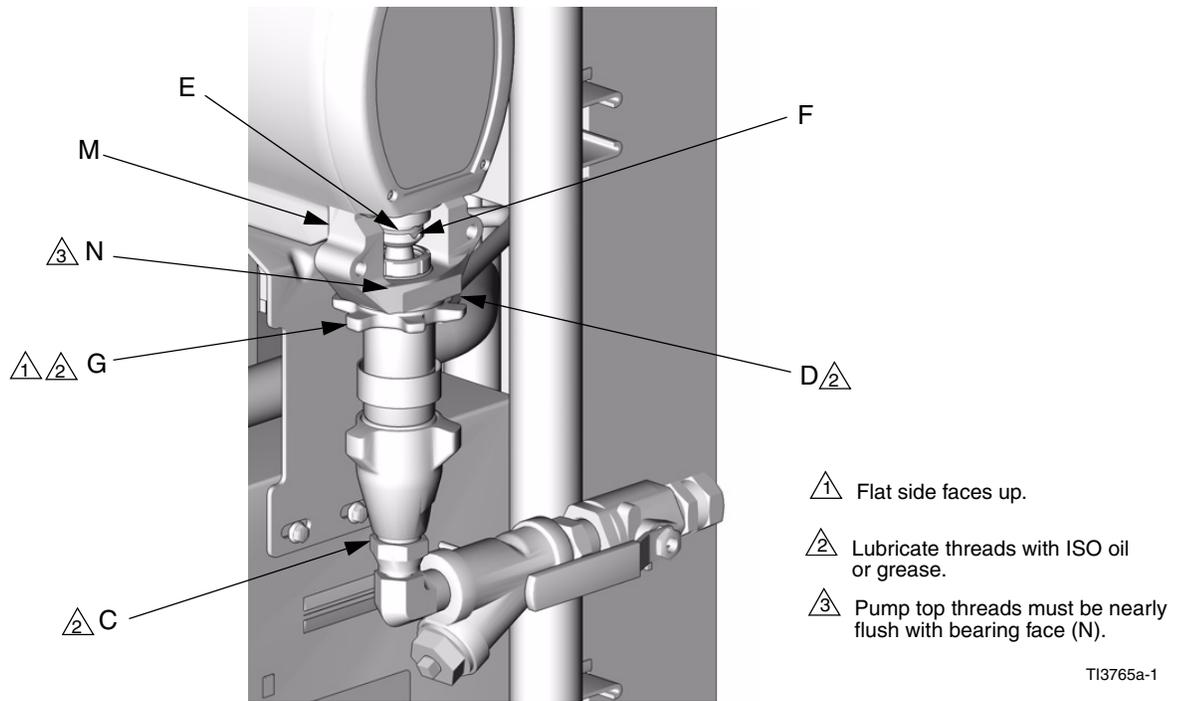
 Steps 15-18 apply to pump B. See FIG. 3. To reconnect pump A, go to step 19.

15. Ensure star-shaped locknut (G) is screwed on pump with flat side up. Screw pump into bearing housing (M) until pin holes align. Push pin (F) in. Pull retaining spring (E) down.

16. Continue screwing pump into housing until fluid outlet (D) is aligned with steel tube and top threads are +/- 1/16 in. (2 mm) of bearing face (N).

17. Tighten star-shaped locknut (G) by hitting firmly with a non-sparking hammer.

18. Reconnect fluid inlet (C) and outlet (D).



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FIG. 3. Reconnect Pump B

 Steps 19-32 apply to pump A only. See FIG. 4.

19. Screw pump into bearing housing (M) until top threads are level with bearing face (N). Rotate pump to align pump outlet fitting to outlet tube.

20. Wet-cup has four 1/8 npt ports. Two will be inaccessible when pump is installed. Note or mark these ports. Remove pump. Apply thread sealant and install plugs in the two ports. Torque plugs to 10-15 ft-lb (14-20 N•m). **Do not overtighten.**

21. Ensure star-shaped locknut (G) is screwed on pump with flat side up. Carefully twist and extend the rod (1) 2 in. (51 mm) above the wet-cup assembly.

22. Start threading pump into bearing housing (M). Place finger guard (P) over rod when it is accessible through window of bearing housing. When pin holes align, insert pin. Pull retaining spring down.

 Finger guard is not used on Model E-30.

23. Seat finger guard (P) on wet-cup (19). Continue threading pump into bearing housing (M) until top threads are +/- 1/16 in. (2 mm) of bearing face (N).

24. Apply thread sealant and screw barbed fitting into motor side of wet-cup. Torque to 10-15 ft-lb (14-20 N•m). **Do not overtighten.**

25. Apply thread sealant and screw elbow (U) into remaining wet-cup port. Torque to 10-15 ft-lb (14-20 N•m). **Do not overtighten.**

26. Apply thread sealant and screw barbed fitting into elbow (U). Torque to 10-15 ft-lb (14-20 N•m). **Do not overtighten.**

27. Connect component A outlet tube loosely at pump and at heater. Line up tube, then tighten fittings securely.

28. Tighten star-shaped locknut (G) by hitting firmly with a non-sparking hammer.

29. Apply thread sealant and screw barbed fitting into elbow (U). Torque to 10-15 ft-lb (14-20 N•m). **Do not overtighten.**

30. Apply thin film of TSL to barbed fittings. Using two hands, support tubes (T) while pushing straight onto barbed fittings. **Do not let tubes kink or buckle.** Secure each tube with a wire tie between two barbs.

31. Reconnect fluid inlet (C) and outlet (D).

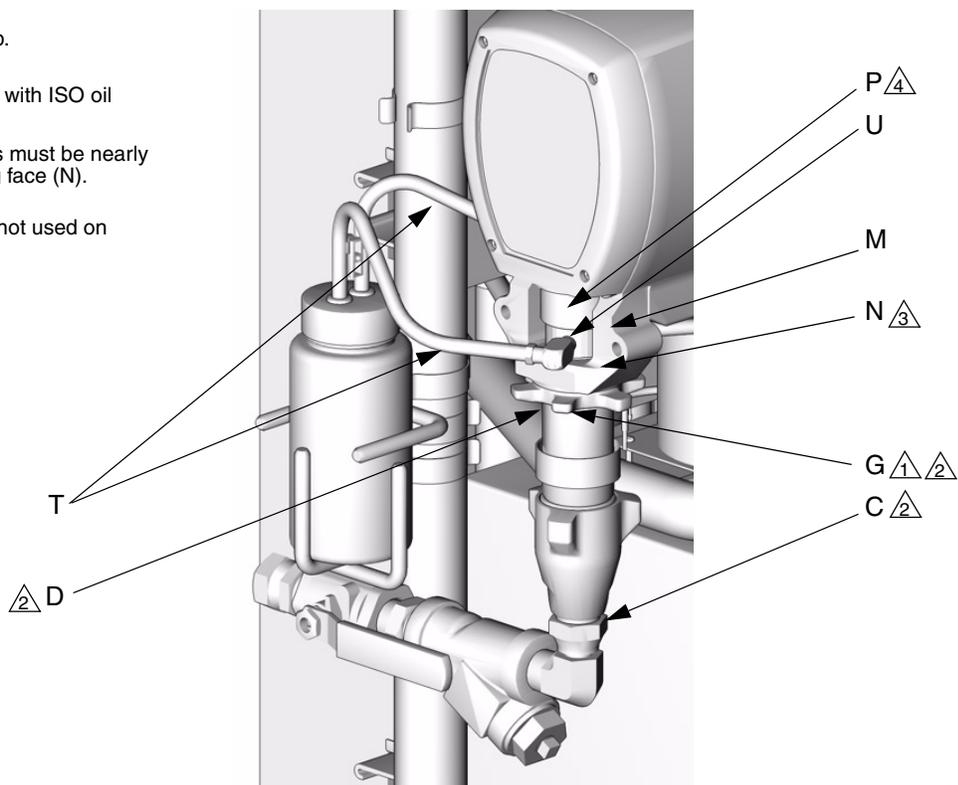
32. Purge air and prime the system. See Reactor operation manual.

① Flat side faces up.

② Lubricate threads with ISO oil or grease.

③ Pump top threads must be nearly flush with bearing face (N).

④ Finger guard (P) not used on Model E-30.



TI3765a-2

FIG. 4. Reconnect Pump A

Parts

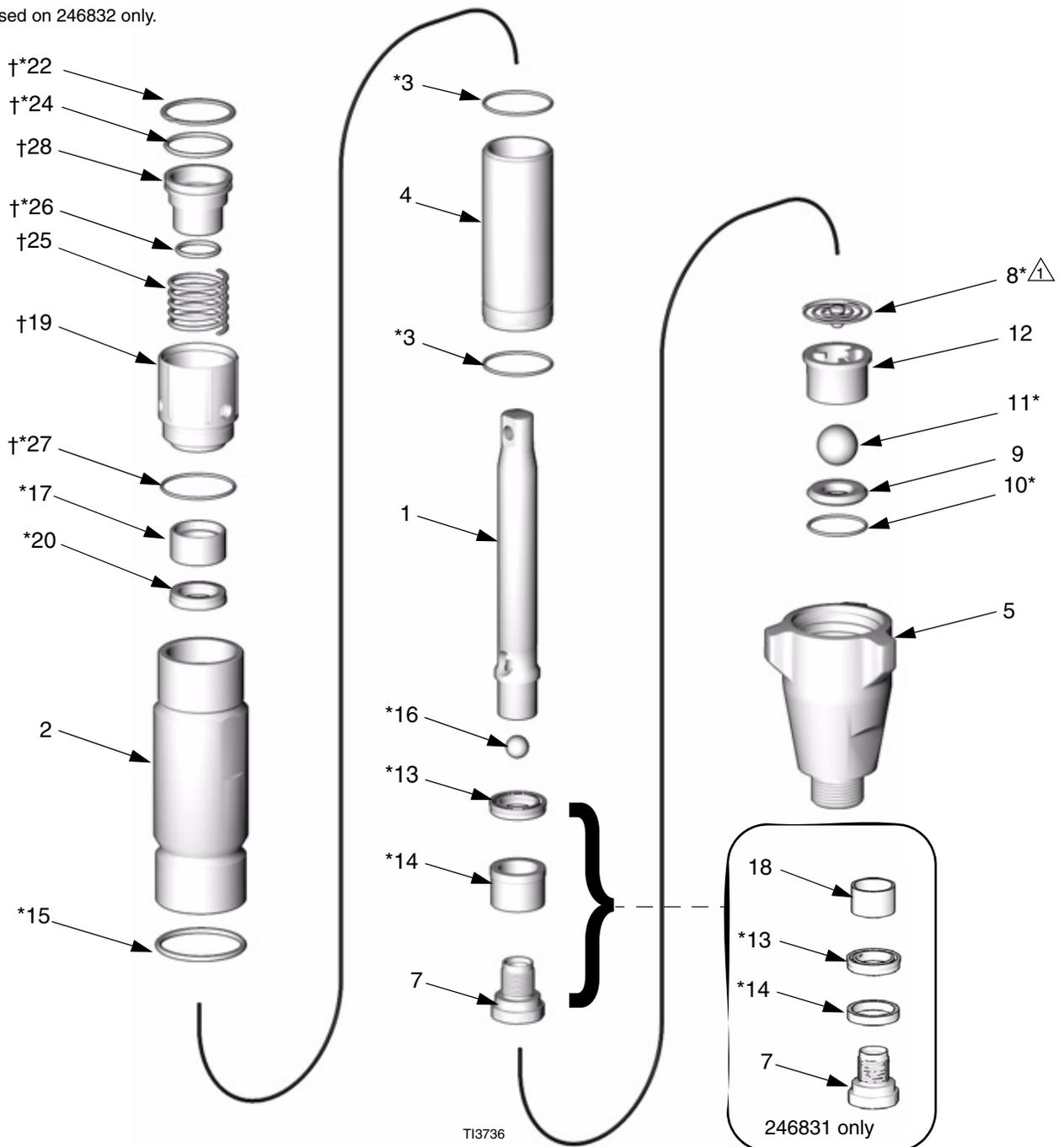
Component A (ISO) Pumps, with wet-cup flush feature

Part No. 246830, E-20 and E-XP1; includes items 1-7, 9-28

Part No. 246831, E-XP2; includes items 1-7, 9-22, 24-28

Part No. 246832, E-30; includes items 1-17, 19-22, 24-28 (shown)

 Used on 246832 only.



Part No. 246830, E-20 and E-XP1; includes items 1-7, 9-28
Part No. 246831, E-XP2; includes items 1-7, 9-22, 24-28
Part No. 246832, E-30; includes items 1-22, 24-28 (shown)

| Ref | No. | Part No. | Description | Qty | Ref | No. | Part No. | Description | Qty |
|-----|--------|--|-------------|--|--------|--|----------------------------------|-------------|-----|
| 1 | 240518 | ROD, displacement; sst (246830) | 1 | 16* | 105444 | BALL, piston; sst; 0.3125 in. (8 mm) | (246830) | 1 | |
| | 240517 | ROD, displacement; sst (246831) | 1 | | 101947 | BALL, piston; sst; 0.375 in. (10 mm) | (246831) | 1 | |
| | 246689 | ROD, displacement; sst (246832) | 1 | | 107203 | BALL, piston; sst; 0.5625 in. (14 mm) | (246832) | 1 | |
| 2 | 243346 | CYLINDER, pump (246830) | 1 | 17* | 15B075 | BUSHING, rod (246830) | | 1 | |
| | 240520 | CYLINDER, pump (246831) | 1 | | 15B074 | BUSHING, rod (246831) | | 1 | |
| | 245413 | CYLINDER, pump (246832) | 1 | | 15B076 | BUSHING, rod (246832) | | 1 | |
| 3* | 108526 | O-RING; PTFE (246830) | 2 | 18 | 15J196 | BUSHING, pump (246831 only) | | 1 | |
| | 107098 | O-RING; PTFE (246831) | 2 | 19† | 15C569 | NUT, packing (246830) | | 1 | |
| | 108822 | O-RING; PTFE (246832) | 2 | | 15C571 | NUT, packing (246831) | | 1 | |
| 4 | 240521 | SLEEVE, cylinder; sst (246830) | 1 | | 15C573 | NUT, packing (246832) | | 1 | |
| | 240525 | SLEEVE, cylinder; sst (246831) | 1 | 20* | 117447 | SEAL, u-cup, throat; UHMWPE | (246830) | 1 | |
| | 240921 | SLEEVE, cylinder; sst (246832) | 1 | | 117446 | SEAL, u-cup, throat; UHMWPE | (246831) | 1 | |
| 5 | 195892 | HOUSING, valve, intake (246830) | 1 | | 117448 | SEAL, u-cup, throat; UHMWPE | (246832) | 1 | |
| | 193030 | HOUSING, valve, intake (246831) | 1 | 22*† | 118377 | RING, retaining (246830) | | 1 | |
| | 198219 | HOUSING, valve, intake (246832) | 1 | | 118378 | RING, retaining (246831) | | 1 | |
| 7 | 239932 | VALVE, piston (246830) | 1 | | 118379 | RING, retaining (246832) | | 1 | |
| | 240150 | VALVE, piston (246831) | 1 | 23* | 15B661 | TOOL, installation, seal (246830 only); not shown; part of Repair Kit 246420 | | 1 | |
| | 240580 | VALVE, piston (246832) | 1 | | 24*† | 118381 | O-RING; fluoroelastomer (246830) | 1 | |
| 8*‡ | 245256 | SPRING, intake ball (246832 only) | 1 | | 107563 | O-RING; fluoroelastomer (246831) | | 1 | |
| 9 | 239922 | SEAT, intake; carbide (246830); includes items 10 and 11 | 1 | | 118403 | O-RING; fluoroelastomer (246832) | | 1 | |
| | 244199 | SEAT, intake; carbide (246831); includes items 10 and 11 | 1 | 25† | 118374 | SPRING (246830) | | 1 | |
| | 240918 | SEAT, intake; carbide (246832); includes items 10 and 11 | 1 | | 118375 | SPRING (246831) | | 1 | |
| 10* | 107079 | O-RING; PTFE (246830) | 1 | | 118376 | SPRING (246832) | | 1 | |
| | 108526 | O-RING; PTFE (246831) | 1 | 26*† | 118380 | O-RING; fluoroelastomer (246830) | | 1 | |
| | 107098 | O-RING; PTFE (246832) | 1 | | 110955 | O-RING; fluoroelastomer (246831) | | 1 | |
| 11* | 105445 | BALL, intake; sst; 0.5 in. (13 mm) | 1 | | C20111 | O-RING; fluoroelastomer (246832) | | 1 | |
| | 102972 | BALL, intake; sst; 0.875 in. (22 mm) | 1 | 27*† | 107563 | O-RING; fluoroelastomer (246830) | | 1 | |
| | 107167 | BALL, intake; sst; 1 in. (25 mm) | 1 | | 103414 | O-RING; fluoroelastomer (246831) | | 1 | |
| 12 | 192624 | GUIDE, ball (246830) | 1 | | 111178 | O-RING; fluoroelastomer (246832) | | 1 | |
| | 193027 | GUIDE, ball (246831) | 1 | 28† | 15C570 | PISTON, wet-cup, ISO (246830) | | 1 | |
| | 193391 | GUIDE, ball (246832) | 1 | | 15C572 | PISTON, wet-cup, ISO (246831) | | 1 | |
| 13* | 117450 | SEAL, u-cup, piston; UHMWPE (246830) | 1 | | 15C574 | PISTON, wet-cup, ISO (246832) | | 1 | |
| | 117449 | SEAL, u-cup, piston; UHMWPE (246831) | 1 | * These parts are included in the Pump Repair Kits, which may be purchased separately. Some parts in the kit may not be used in your pump. | | | | | |
| | 117448 | SEAL, u-cup, piston; UHMWPE (246832) | 1 | | | | | | |
| 14* | 15B078 | BUSHING, piston (246830) | 1 | | | | | | |
| | 15J197 | BEARING, lower (246831) | 1 | † These parts are included in the Wet-Cup Kits. Order the correct kit for your pump from the table below. See page 26 for information on 246928 Reservoir Kit. | | | | | |
| | 15B079 | BUSHING, piston (246832) | 1 | | | | | | |
| 15* | 114054 | O-RING; fluoroelastomer (246830) | 1 | | | | | | |
| | 106556 | O-RING; fluoroelastomer (246831) | 1 | | | | | | |
| | 107306 | O-RING; fluoroelastomer (246832) | 1 | | | | | | |

| Pump Part No. | Pump Repair Kit | Wet-Cup Kit |
|---------------|-----------------|-------------|
| 246830 | 246420 | 246962 |
| 246831 | 15C851 | 246963 |
| 246832 | 15C852 | 246964 |

‡ This part is also available in the Intake Spring Kit 249770, which may be purchased separately.

Component B (Resin) Pumps

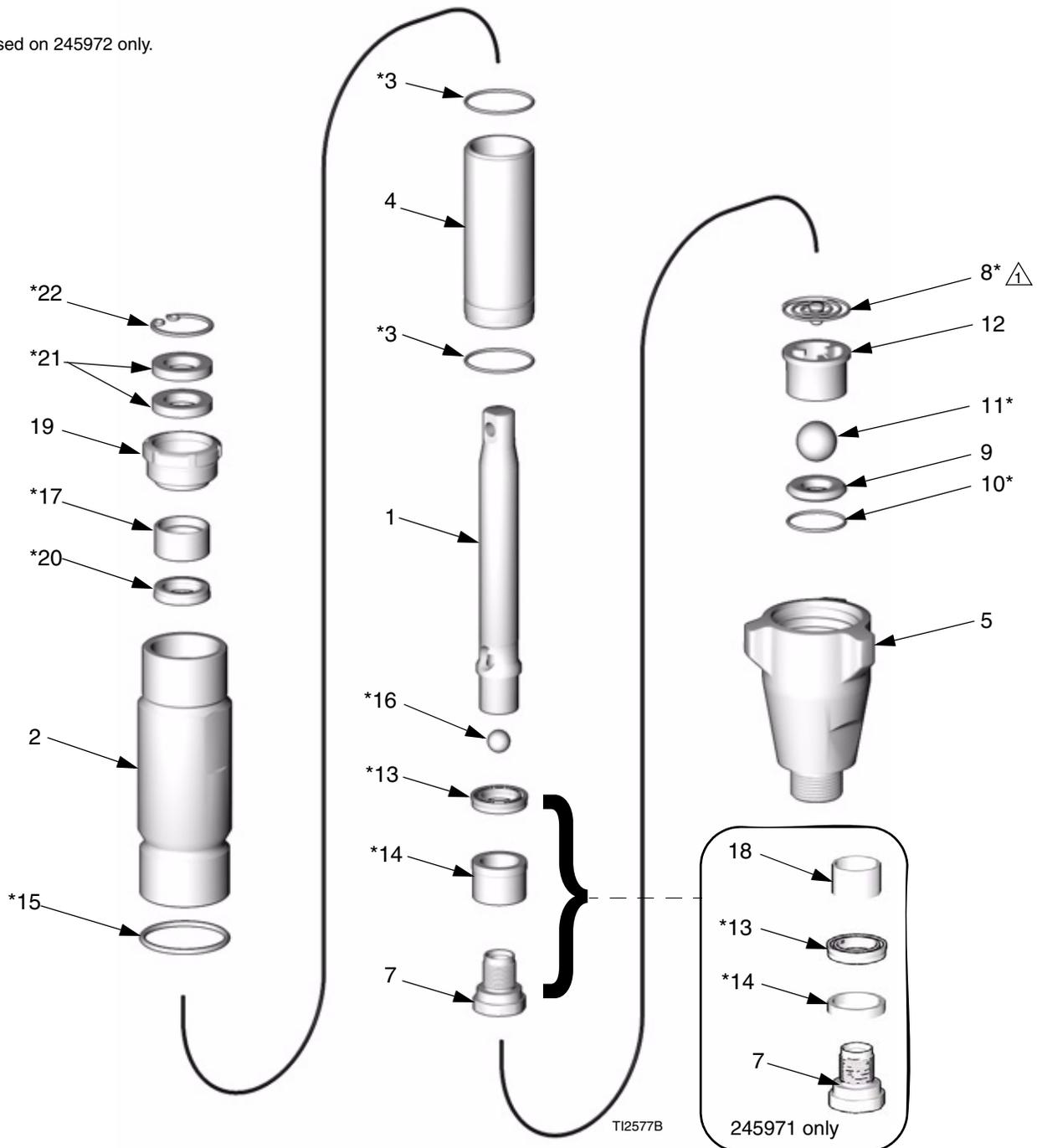
Part No. 245970, E-20 and E-XP1; includes items 1-7, 9-23

Part No. 245971, E-XP2; includes items 1-7, 9-22

Part No. 245972, E-30; includes items 1-22 (shown)

NOTE: These pumps were also used on Component A (ISO) side of Reactors built before May 2003.

 Used on 245972 only.



Part No. 245970, E-20 and E-XP1; includes items 1-7, 9-23

Part No. 245971, E-XP2; includes items 1-7, 9-22

Part No. 245972, E-30; includes items 1-22 (shown)

| Ref No. | Part No. | Description | Qty | Ref No. | Part No. | Description | Qty |
|---------|----------|--|-----|---------|----------|--|-----|
| 1 | 240518 | ROD, displacement; sst (245970) | 1 | 15* | 114054 | O-RING; fluoroelastomer (245970) | 1 |
| | 240517 | ROD, displacement; sst (245971) | 1 | | 106556 | O-RING; fluoroelastomer (245971) | 1 |
| | 246689 | ROD, displacement; sst (245972) | 1 | | 107306 | O-RING; fluoroelastomer (245972) | 1 |
| 2 | 243346 | CYLINDER, pump (245970) | 1 | 16* | 105444 | BALL, piston; sst; 0.3125 in. (8 mm) (245970) | 1 |
| | 240520 | CYLINDER, pump (245971) | 1 | | 101947 | BALL, piston; sst; 0.375 in. (10 mm) (245971) | 1 |
| | 245413 | CYLINDER, pump (245972) | 1 | | 107203 | BALL, piston; sst; 0.5625 in. (14 mm) (245972) | 1 |
| 3* | 108526 | O-RING; PTFE (245970) | 2 | 17* | 15B075 | BUSHING, rod (245970) | 1 |
| | 107098 | O-RING; PTFE (245971) | 2 | | 15B074 | BUSHING, rod (245971) | 1 |
| | 108822 | O-RING; PTFE (245972) | 2 | | 15B076 | BUSHING, rod (245972) | 1 |
| 4 | 240521 | SLEEVE, cylinder; sst (245970) | 1 | 18 | 15J196 | BUSHING, pump (245971 only) | 1 |
| | 240525 | SLEEVE, cylinder; sst (245971) | 1 | 19† | 193046 | NUT, packing (245970) | 1 |
| | 240921 | SLEEVE, cylinder; sst (245972) | 1 | | 193032 | NUT, packing (245971) | 1 |
| 5 | 195892 | HOUSING, valve, intake (245970) | 1 | | 189589 | NUT, packing (245972) | 1 |
| | 193030 | HOUSING, valve, intake (245971) | 1 | 20* | 117447 | SEAL, u-cup, throat; UHMWPE (245970) | 1 |
| | 198219 | HOUSING, valve, intake (245972) | 1 | | 117446 | SEAL, u-cup, throat; UHMWPE (245971) | 1 |
| 7 | 239932 | VALVE, piston (245970) | 1 | | 117448 | SEAL, u-cup, throat; UHMWPE (245972) | 1 |
| | 240150 | VALVE, piston (245971) | 1 | 21* | 117597 | WASHER, felt (245970) | 2 |
| | 240580 | VALVE, piston (245972) | 1 | | 117599 | WASHER, felt (245971) | 2 |
| 8*‡ | 245256 | SPRING, intake ball (245972 only) | 1 | | 117600 | WASHER, felt (245972) | 2 |
| 9 | 239922 | SEAT, intake; carbide (245970); includes items 10 and 11 | 1 | 22* | 551528 | RING, retaining (245970) | 1 |
| | 244199 | SEAT, intake; carbide (245971); includes items 10 and 11 | 1 | | 117718 | RING, retaining (245971) | 1 |
| | 240918 | SEAT, intake; carbide (245972); includes items 10 and 11 | 1 | | 117719 | RING, retaining (245972) | 1 |
| 10* | 107079 | O-RING; PTFE (245970) | 1 | 23* | 15B661 | TOOL, installation, seal (245970 only); not shown; part of Repair Kit 246420 | 1 |
| | 108526 | O-RING; PTFE (245971) | 1 | | | | |
| | 107098 | O-RING; PTFE (245972) | 1 | | | | |
| 11* | 105445 | BALL, intake; sst; 0.5 in. (13 mm) (245970) | 1 | | | | |
| | 102972 | BALL, intake; sst; 0.875 in. (22 mm) (245971) | 1 | | | | |
| | 107167 | BALL, intake; sst; 1 in. (25 mm) (245972) | 1 | | | | |
| 12 | 192624 | GUIDE, ball (245970) | 1 | | | | |
| | 193027 | GUIDE, ball (245971) | 1 | | | | |
| | 193391 | GUIDE, ball (245972) | 1 | | | | |
| 13* | 117450 | SEAL, u-cup, piston; UHMWPE (245970) | 1 | | | | |
| | 117449 | SEAL, u-cup, piston; UHMWPE (245971) | 1 | | | | |
| | 117448 | SEAL, u-cup, piston; UHMWPE (245972) | 1 | | | | |
| 14* | 15B078 | BUSHING, piston (245970) | 1 | | | | |
| | 15J197 | BEARING, lower (245971) | 1 | | | | |
| | 15B079 | BUSHING, piston (245972) | 1 | | | | |

* These parts are also included in the Pump Repair Kits, which may be purchased separately. Some parts in the kit may not be used in your pump. Order the correct kit for your pump from the table below.

| Pump Part No. | Repair Kit |
|---------------|------------|
| 245970 | 246420 |
| 245971 | 246421 |
| 245972 | 246422 |

† Wet-Cup Conversion Kits may be purchased separately to convert pumps 245970, 245971, and 245972. See page 26 for further information.

‡ This part is also available in the Intake Spring Kit 249770, which may be purchased separately.

Accessories

Wet-Cup Conversion Kits

These kits convert 245970, 245971, or 245972 pumps to the wet-cup flush design. Refer to the following table to select the correct kit for your pump. Kits include instruction manual 309911.

| Pump Part No. | Wet-Cup Conversion Kit | |
|---------------|---|-------------------------------------|
| 245970 | 248061 , includes: | |
| | 246962 Wet-Cup Kit (see page 23 for parts) | 246928 Reservoir Kit (see below) |
| 245971 | 248062 , includes: | |
| | 246963 Wet-Cup Kit (see page 23 for parts) | 246928 Reservoir Kit (see below) |
| 245972 | 248063 , includes: | |
| | 246964 Wet-Cup Kit (see page 23 for parts) | 246928 Reservoir Kit (see below) |

246928 Reservoir Kit

This kit is included with Wet-Cup Conversion Kits 248061, 248062, and 248063 (see above).

This kit can also be used if replacing an earlier style ISO pump with the wet-cup flush design. Order this kit separately, and order the correct pump for your Reactor from page 22.

Kit includes reservoir, tubing, mounting hardware, and fittings to supply TSL to flush wet-cup. Includes instruction manual 309911.

Throat Seal Liquid

Use in reservoir for piston style wet-cups on component A pumps, or to fill wet-cup of component B pumps.

| Part No. | Quantity |
|----------|---------------------|
| 206995 | 1 qt (1 liter) |
| 206996 | 1 gal. (3.8 liters) |

217374 ISO Pump Oil

Use in wet-cups of non-piston style component A pumps (built before May 2003), and as thread lubricant when rebuilding pumps.

Technical Data

| Category | Data |
|--------------------------------|---|
| Maximum working pressure | 3500 psi (24.5 MPa, 245 bar) |
| Effective area of displacement | 246830 and 245970: 0.396 in. ² (2.55 cm ²) 246831 and 245971: 0.552 in. ² (3.56 cm ²) 246832 and 245972: 0.743 in. ² (4.79 cm ²) |
| Fluid inlet size | 246830, 246831, 245970, and 245971: 3/4 npt(m) 246832 and 245972: 1 npsm(m) |
| Fluid outlet size | 246830 and 245970: 1/4 npt(f) 246831, 246832, 245971, and 245972: 3/8 npt(f) |
| Wetted parts | stainless steel, PTFE, zinc-plated carbon steel, acetal, tungsten carbide, chrome plating, ultra-high molecular weight polyethylene |

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