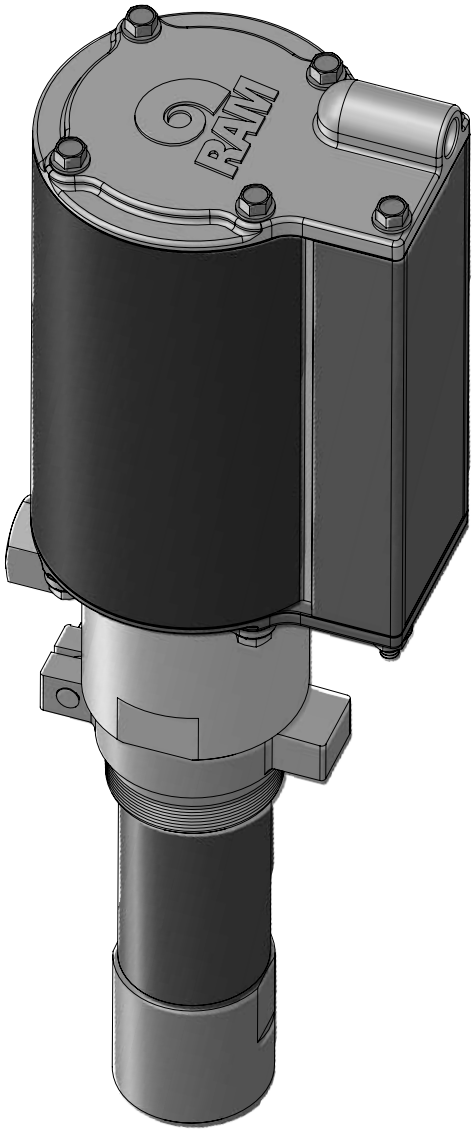
Service guide

Low-pressure stub pump

Models 9968, 9968-A, 9968-M



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ALEMITE	Declaration of Conformity *	DOCUMENT NUMBER SER670789

Manufacturer name/address:
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CE

This Declaration of Conformity is issued under sole responsibility of the manufacturer Alemite, L.L.C. hereby declares that the machinery stated below:

Product: RAM pump
Model number(s):
9968, 9968-A, 9968-M
Designation: Low-pressure stub pump

consisting of the following incomplete machines:

Name: Air motor
Model number(s): 339413

Name: Pump tube
Model number(s):
338067-A1, 338607-B1
Year of CE: 2023

in its intended use, is in conformity with the relevant union harmonization legislation:

Machinery Directive 2006/42/EC

and conforms to the following harmonized standards:

EN ISO 4413: 2010
Hydraulic fluid power - general rules and safety requirements for systems and their components

EN ISO 12100: 2010
Safety of machinery. General principles for design. Risk assessment and risk reduction.

EN ISO 809: 1998+A1:2009
Pumps and pump units for liquids - common safety requirements

EN 12162:2001 +A1: 2009
Liquid pumps - safety requirements - procedure for hydrostatic testing

The manufacturer maintains a technical file summary sheet containing test reports and product documentation:

Technical file summary sheet number:
RA670789

I, the undersigned of Alemite, L.L.C., do hereby declare that the equipment specified above, in its intended use, conforms to the requirements of the above directives and harmonized standards at the time of placing the above product on the market.

Robert Collins
Technical Compliance Manager
St. Louis, MO, U.S.A.
2023/02/20

* Indicates change

ALEMITE	U.K. Declaration of Conformity *	DOCUMENT NUMBER SER670789

Manufacturer name/address:
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UKCA

This U.K. Declaration of Conformity is issued under sole responsibility of the manufacturer Alemite, L.L.C. hereby declares that the machinery stated below:

Product RAM pump
Model number(s):
9968, 9968-A, 9968-M
Designation: Low-pressure stub pump

consiting of the following incomplete machines:

Name: Air motor
Model number(s): 339413

Name: Pump tube
Model number(s):
338067-A1, 338607-B1
Year of CE: 2023

in its intended use, is in conformity with the relevant union harmonization legislation:

Supply of Machinery (Safety) Regulations 2008 (S.I. 2008:159)

and conforms to the following harmonized standards:

EN ISO 4413: 2010
Hydraulic fluid power - general rules and safety requirements for systems and their components

EN ISO 12100: 2010
Safety of machinery. General principles for design. Risk assessment and risk reduction.

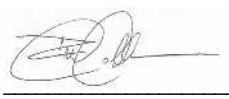
EN ISO 809: 1998+A1:2009
Pumps and pump units for liquids - common safety requirements

EN 12162: 2009
Liquid pumps - safety requirements - procedure for hydrostatic testing

The manufacturer maintains a technical file summary sheet containing test reports and product documentation:

Technical file summary sheet number:
RA670789

I, the undersigned of Alemite, L.L.C., hereby declare that the equipment specified above, in its intended use, conforms with all requirements of the U.K. legislation Supply of Machinery (Safety) Regulations 2008 No. 1597 by the time of placing it on the market.



Robert Collins
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St. Louis, MO, U.S.A.
2023/02/20

* Indicates change

Safety *

The assembly must be installed, maintained and repaired exclusively by persons familiar with the instructions.

Always disconnect power source (electricity, air or hydraulic) from the equipment when it is not being used.

This equipment generates high pressure. Extreme caution should be used when operating this equipment as material leaks from loose or ruptured components can inject fluid through the skin and into the body. If any fluid appears to penetrate the skin, seek attention from a doctor immediately. Do not treat injury as a simple cut. Tell attending doctor exactly what type of fluid was injected.

Any other use not in accordance with instructions will result in loss of claim for warranty or liability.

- Do not misuse, over-pressurize, modify parts, use incompatible chemicals, fluids, or use worn and/or damaged parts.
- Do not exceed the stated maximum working pressure of the equipment or of the lowest rated component in your system.
- Always read and follow the manufacturer's recommendations regarding fluid compatibility, and the use of protective clothing and equipment.
- Failure to comply may result in personal injury and/or damage to equipment.

Explanation of signal words for safety

NOTE
Emphasizes useful hints and recommendations as well as information to prevent property damage and ensure efficient trouble-free operation.

⚠ CAUTION
Indicates a dangerous situation that can lead to light personal injury if precautionary measures are ignored.

⚠ WARNING
Indicates a dangerous situation that could lead to death or serious injury if precautionary measures are ignored.

⚠ DANGER
Indicates a dangerous situation that will lead to death or serious injury if precautionary measures are ignored.

⚠ WARNING

Do not operate equipment without reading and fully understanding safety warnings and instructions.

Failure to follow warnings and instructions may result in serious injury.

⚠ CAUTION
Do not operate equipment without wearing personal protective gear.

Wear eye protection. Protective equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.

Failure to comply may result in light personal injury.

⚠ WARNING

Do not allow any body part to be trapped by equipment.

Body parts can be crushed by subassemblies during operation.

Failure to comply may result in death or serious physical injury.

⚠ WARNING

Do not allow fluid to leak onto floor when operating equipment. If spill occurs, clean any fluid on floor before continuing operation.

Failure to comply may result in death or serious personal injury.

⚠ WARNING
Do not use this equipment to supply, transport, or store hazardous substances and mixtures in accordance with annex I part 2-5 of the CLP regulation (EG 1272/2008) or HCS 29 CFR 1910.1200 marked with GHS01, GHS06 and GHS08 hazard pictograms shown:

* Indicates change

Description

The major components of the stub pumps in the model 9968 series consists of an air-operated motor and a pump tube. The air motor connects directly to a double-acting reciprocating pump tube. These low-pressure stub pumps (5:1 ratio) are designed to deliver all grades of oil.

Pump extensions

Extensions that screw directly into the pump's fluid inlet allow the pump to accommodate different size drums and tanks. Extensions are accessory items and are not included with the pump.
See **Accessories table, page 7**.

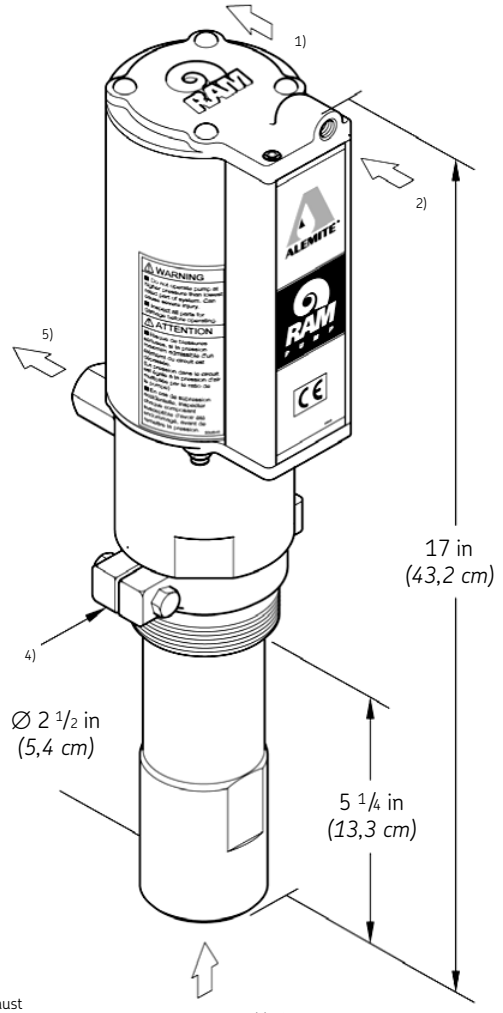
Models 9968 series comparison

Model 9968 and 9968-M [1] include a 2 in NPTF (e) bung adapter that allows installation directly onto original containers or bulk tanks. The bung adapter is not included with model 9968-A.

NOTE
Model 9968-M contains components manufactured with BSPT(P) thread connections that include air motor model 339413-A1 and fluid outlet adapter in the pump tube body

Fig. 1

Stub pump model 9968 series
Model 9968-M shown



1) Air exhaust
2) Air inlet
3) Fluid inlet
4) Bung adapter
5) Fluid outlet

Pump model	Bung adapter
9968	Included
9968-A	Not included
9968-M [1]	Included

1) With BSPT(P) thread connection components (see **Specifications** tables).

Air motor specifications

Model	Piston diameter x stroke	Air inlet	Maximum air pressure
339413	3 x 3 5/16 in (*7.6 x 8.4 cm*)	1/4 in NPTF (i)	150 psi (*10,3 bar*)
339413-A1	3 x 3 5/16 in (*7.6 x 8.4 cm*)	1/4 in BSPT (i)	150 psi (*10,3 bar*)

1) For details on the air motors, refer to manual **670782**.

Pump tube specifications

Pump model	Fluid outlet in body	Maximum fluid pressure	Delivery/min. (approximately) [1]	Displacement/ cycle
9968, 9968-A	1/2 in NPTF (i)	750 psi (*52 bar*)	7 gals (*26,5 l*)	7.2 in^3 (*118 cm^3*)
9968-M	1/2 in NPTF (i) [2]	750 psi (*52 bar*)	7 gals (*26,5 l*)	7.2 in^3 (*118 cm^3*)

1) For detailed information (→ **Diagram 1, page 7**).
2) Includes a 1/2 in BSPP (i) x 1/2 in NPTF (e) fluid outlet adapter

Low-pressure stub pump model 9968 series accessories

Extension description	Drum 16 gallon	55 gallon	200/205 liter	Tank 250 gallon bench top	275 gallon obround
V-cut	338147-1	338147-2	338147-2	338147-3	338147-7
Threaded at both ends [1]	338246-1	338246-2	338246-2	338246-3	338246-6

[1] For use with low level cut-off valve part number 321206

Low-pressure stub pump model 9968 series accessories (continued)

Cover assembly description	Drum 5 gallon	16 gallon	55 gallon
Bolt-on	-	338145 [1]	-
With 2 in *(50,8 cm)* bung adapter fitting	327817-4	338977 [1]	338246-6

[1] With sealing gasket

Performance curves

A pump's ability to deliver fluid is based on the pressure (psi *(bar)*) and quantity (cfm *(lpm)*) of air supplied to the motor and the amount of fluid discharge (back) pressure to be overcome within the system.

This chart contains curves based on three different air pressures. The curves relate delivery in gallons *(liters)* per minute (X axis) to air consumption in cubic feet *(liters)* per minute (right Y axis) and to fluid discharge pressure in psi/bar (left Y axis).

Diagram 1

Delivery versus discharge pressure and air consumption

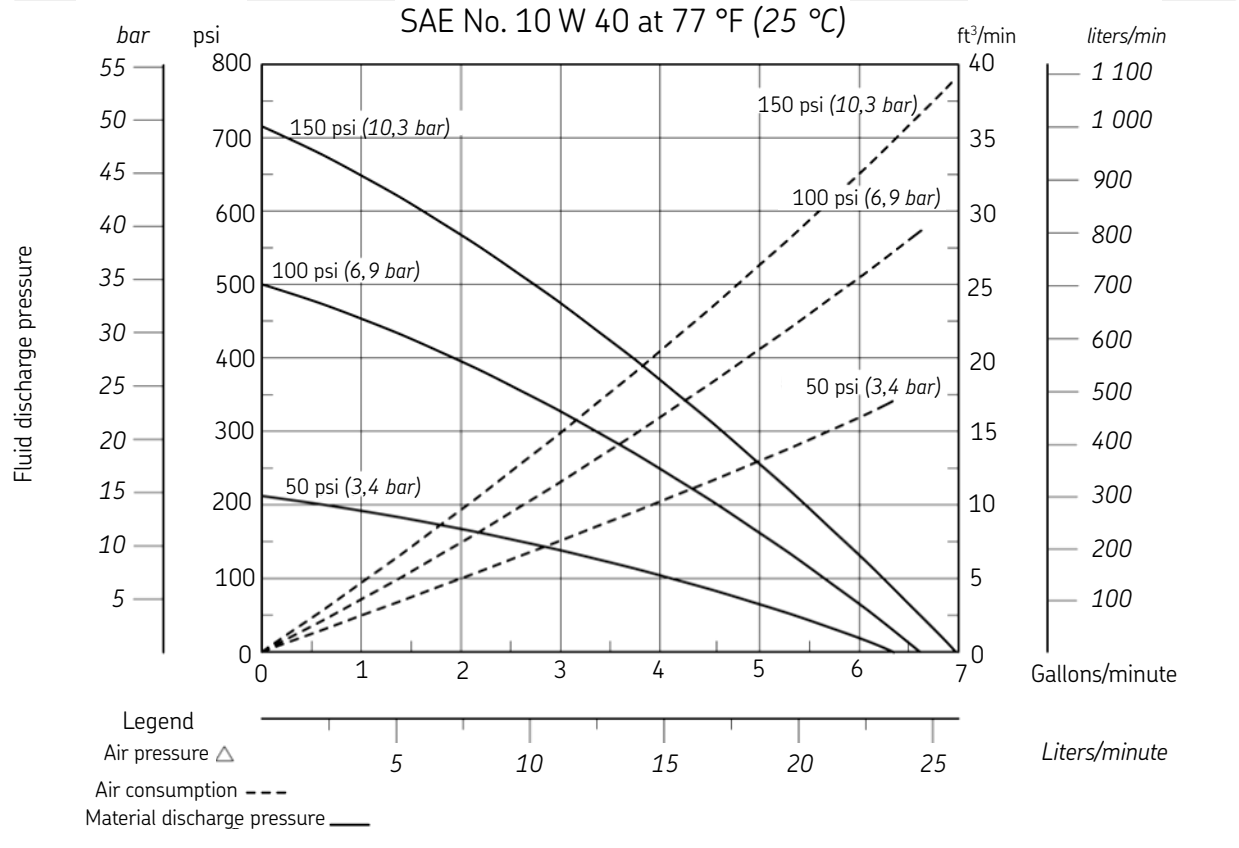
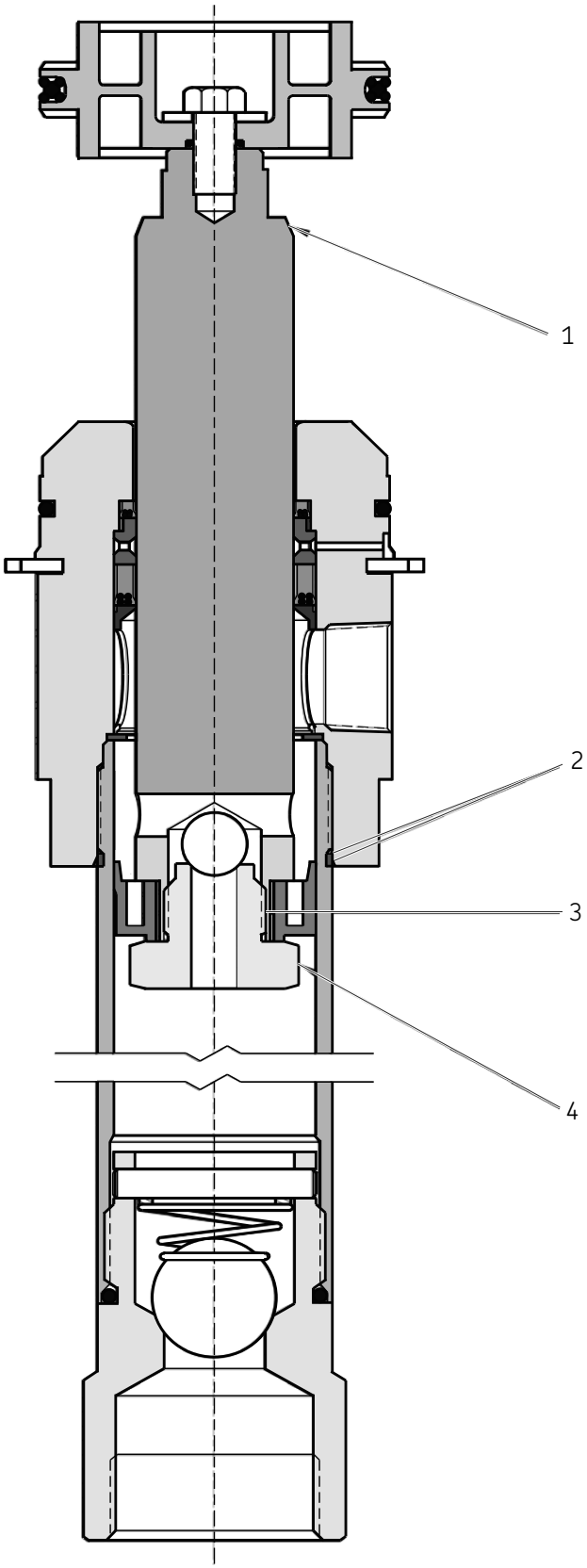


Fig. 2

Service hints
Refer to the **Overhaul procedure, page 9** for details



Item	Description
1	Inspect the chamber of the rod for roughness. Damage to seals may occur
2	Ensure rings are not exposed after tube installation. Product leakage can occur.
3	Apply threadlocker to the threads of the valve seat. Valve seat may loosen.
4	Do not overtighen the valve seat into the rod. Distortion of the nylon piston can occur.

Overhaul

NOTE
Refer to **fig. 3, page 12** and **IPB 1, page 14** for component identification on all overhaul procedures.

Prior to performing any maintenance procedure, the following safety precautions must be observed. Personal injury may occur.

⚠ WARNING
Do not use halogenated hydrocarbon solvents such as methylene chloride or 1,1,1-trichloroethane in this pump. An explosion can result when aluminum and/or zinc-plated parts in pump come in contact with halogenated hydrocarbon solvents.

Release all pressure within system prior to performing any overhaul procedure.

- Disconnect air supply line from pump motor.
- Into an appropriate container, operate control valve to discharge remaining pressure within system.

Never point a control valve at any portion of your body or another person. Accidental discharge of pressure and/or fluid can result in injury.

Read each step of instructions carefully. Make sure a proper understanding is achieved before proceeding.

Disassembly

Separate air motor from pump tube

1 Clamp pump assembly in a soft-jaw vise at bung adapter (**22**) or body (**8**).
2 Remove cover (**1a**).
2.1 Pry and swing cover sideways away from cylinder (→ **SER 670782** for details).
3 Remove screw (**1b**) from top cap.
4 Remove nuts (**1d**) that secure body to air motor assembly (**1**).
5 Remove carriage bolts (**1c**) from top cap.
5.1 Remove keepers (**9**) from body.
6 Remove the cap from the cylinder.

⚠ CAUTION
Remove cylinder with care. Damage to quad-ring (**6**) and/or o-ring (**7**) can occur.

7 With a side-to-side motion, pull cylinder from body and air piston (**4**).
8 Remove o-ring (**7**) from body.
9 Remove bottom cap from body.

Pump tube assembly

Tube assembly

1 Unscrew tube (**21**) from body.

Step for model 9968 and 9968-m only:
2 Remove bung adapter from tube as required.
3 Remove o-ring (**19**) and back-up ring (**20**) from tube.

Air piston assembly

4 Remove screw (**2**) that secures air piston (**4**) to rod (**15**).
4.1 Remove air piston from rod.
5 Remove washer (**3**) quad-ring (**6**), and o-ring (**5**) from air piston.

Rod assembly

6 Pull rod assembly from bottom of body.
7 Unscrew valve seat (**18**) from rod.
7.1 Remove ball (**17**) and nylon piston (**16**).

Body assembly

8 Remove o-ring (**7**) from body.
9 Remove washer (**14**), spacer (**13**) and seal (**12**) from body.
10 Remove bearing (**11**) and seal (**10**) from body.

Step for model 9968-M only:
11 Unscrew adapter (**29**) from body only when necessary.
11.1 Adapter is secured with threadlocker.

Foot valve assembly

12 Unscrew foot valve (**27**) from tube (**21**).
13 Remove o-ring (**26**) from foot valve.
14 Remove pin (**28**) from foot valve.
15 Remove washer (**23**), spring (**24**), and ball (**25**) from foot valve.

Clean and inspect

NOTE
Use appropriate repair kit for replacement parts. Make sure all components are included in kit before discarding used parts.

1 Clean all metal parts in cleaning solvent. Solvent should be environmentally safe.
2 Inspect all parts for wear and/or damage.
2.1 Replace as necessary.
3 Inspect air piston (**4**) for fatigue cracks.
3.1 Replace as necessary.
4 Inspect nylon piston (**16**) and rod (**15**) closely. Use a magnifying glass to detect any score marks on the rod.
4.1 Replace as necessary.
5 Closely inspect mating surfaces of all check valve components for any imperfections. Ensure a smooth and clean contact is obtained when assembled.
Example: place ball (**25**) into foot valve (**27**). Fill foot valve with solvent. Make sure no leakage occurs.

Assembly

NOTE
Prior to assembly, certain components require lubrication. Refer to **Lubricated components** table for details.

NOTE
Refer to **fig. 3, page 12** for a section view of pump tube assembly.

Foot valve

1 Install o-ring (**26**) onto foot valve (**27**).
2 Install ball (**25**), spring (**24**) (small diameter first), and washer (**23**) into foot valve.
3 Install pin (**28**) into foot valve.
3.1 Make sure pin retains washer properly and is flush the foot valve.

Body

4 Install o-ring (**7**) onto upper groove of body (**8**).
5 Install and seat seal (**10**) (heel end first) into bottom of the body.
6 Install and seat bearing (**11**) (small diameter first) into body.
7 Install and seat seal (**12**) (heel end first) into body.
8 Install spacer (**13**) (small diameter first) and washer (**14**) into body.

Step for model 9968-M only
9 Screw adapter (**29**) (with threadlocker) into body as required.

Tube and rod

10 Install and seat nylon piston (**16**) (openings upward) onto bottom of rod (**15**).
11 Install ball (**17**) into rod.

NOTE
Do not tighten the valve seat more than 1/4 turn once it contacts nylon piston. Distortion of nylon piston can occur which causes excessive drag on the tube.

12 Screw valve seat (**18**) (with threadlocker) into rod (→ **fig. IPB 1, page 14**).
12.1 Follow thread sealant manufacturer's recommendations.

⚠ CAUTION
Install rod into body with a twisting motion. Use care not to damage seals.

13 Install rod assembly into bottom of body.
13.1 Position the nylon piston flush with the bottom of the body.
14 Install back-up ring (**20**) (concave upward) onto tube (**21**).
15 Install o-ring (**19**) on top of back-up ring.
16 Screw and seat tube assembly into body.
16.1 Make sure both rings are not visible.

Step for model 9968 and 9968-M only
17 Slide bung adapter (**22**) onto tube.

18 Screw foot valve assembly into tube.
18.1 Tighten foot valve assembly securely to tube and tube to body.

Air piston

19 Install quad-ring (**6**) onto air piston (**4**).
20 Install and seat o-ring (**5**) into bottom of air piston.
21 Place air piston (observe this side up) on top of rod.
22 Install screw (**2**) and washer (**3**) that secures air piston to rod.
22.1 Tighten screw to 15 ft.lbf. *(20.7 Nm)*.

Attach air motor to pump tube

23 Clamp pump assembly in a soft-jaw vise at bung adapter (**22**) or body (**8**).
24 Install bottom cap onto body.
25 Install o-ring (**7**) onto upper groove of body.

⚠ CAUTION
Install cylinder with care. Damage to quad-ring (**6**) and/or o-ring (**7**) can occur.

Hint: Angle cylinder onto quad-ring.

26 Install cylinder over body's o-ring and seat it properly onto bottom cap.
27 Install top cap onto cylinder.
27.1 Use care passing o-ring.
28 Install keeper (**9**) into groove of body.
28.1 Make sure hole aligns with carriage bolt (**1c**).
29 Install one carriage bolt through air motor and through keeper.
30 Install flange nut (**1d**).
30.1 Do not tighten flange nut at this time.
31 Repeat procedural steps 27 - 29 for additional keepers and carriage bolts.

Lubricated components

Item no.	Description
5	O-ring, 3/8 in ID x 1/2 in OD *(9,5 mm ID x 12,7 mm OD)*
6	Quad-ring, 2 5/8 in ID x 3 in OD *(66,68 mm ID x 76,2 mm OD)*
7	O-ring, 2 3/4 in ID x 3 in OD *(69,85 mm ID x 76,5 mm OD)*
10	Seal, 1 5/16 in ID x 1 9/16 in OD *(33,34 mm ID x 39,69 OD)*
12	Seal, 1 5/16 in ID x 1 11/16 in OD *(33,34 mm ID x 42,86 mm OD)*
19	O-ring, 1 7/8 in ID x 2 in OD *(47,63 mm ID x 50,8 mm OD)*
26	O-ring, 1 11/16 in ID x 1 7/8 in OD *(42,86 mm ID x 47,63 mm OD)*

Specialty grease [1]*
Coat the bore of the air motor assembly

[1] Includes a sachet of 393590 grease

⚠ CAUTION

Do not overtighten flange nuts (**1d**). Component damage can occur.

32 Torque each flange nut in an alternate pattern from 60 to 70 in.lbf. *(6.8 to 7.9 Nm)*.
33 Install screw (1b) into top cap.
33.1 Tighten screw to 50 in.lbf *(5.6 Nm)*.
34 Snap cover (**1a**) onto cylinder.

Bench test and operation

1 Slowly supply air pressure (recommended minimum of 25 psi *(1.7 bar)*) to the pump's motor.
1.1 Pump assembly should cycle.

If pump assembly does not cycle, refer to **Troubleshooting chart, page 13** or details.

With air pressure at zero:
2 Connect a product hose to pump's fluid outlet.
2.1 Direct hose into an appropriate collection container.
3 Place pump in oil.
4 Slowly supply air pressure to pump's motor.
5 Allow pump to cycle slowly until is free of air.

If pump assembly does not prime, refer to **Troubleshooting chart, page 13** for details.
With air pressure at zero:

⚠ WARNING

Do not operate air motor if leakage is present. Disconnect motor should leakage occur anywhere within system. Failure to comply may result in personal injury or damage to equipment.

6 Attach a control valve to outlet hose of pump.
6.1 Make sure nozzle on control valve is open.
7 Slowly supply air pressure to pump's motor.
8 Allow pump to cycle slowly until oil is once again free of air.
9 Set air pressure to normal operating pressure.
10 Operate control valve into a container.
11 Shut off control valve.
11.1 Visually inspect pump for external leaks.
11.2 The pump should not cycle more than once or twice in one hour.

If pump does not stall, refer to **Troubleshooting chart, page 13** for details.

12 Check motor for air leakage.

If motor leaks, refer to **Air motor service** guide for details.

Installation

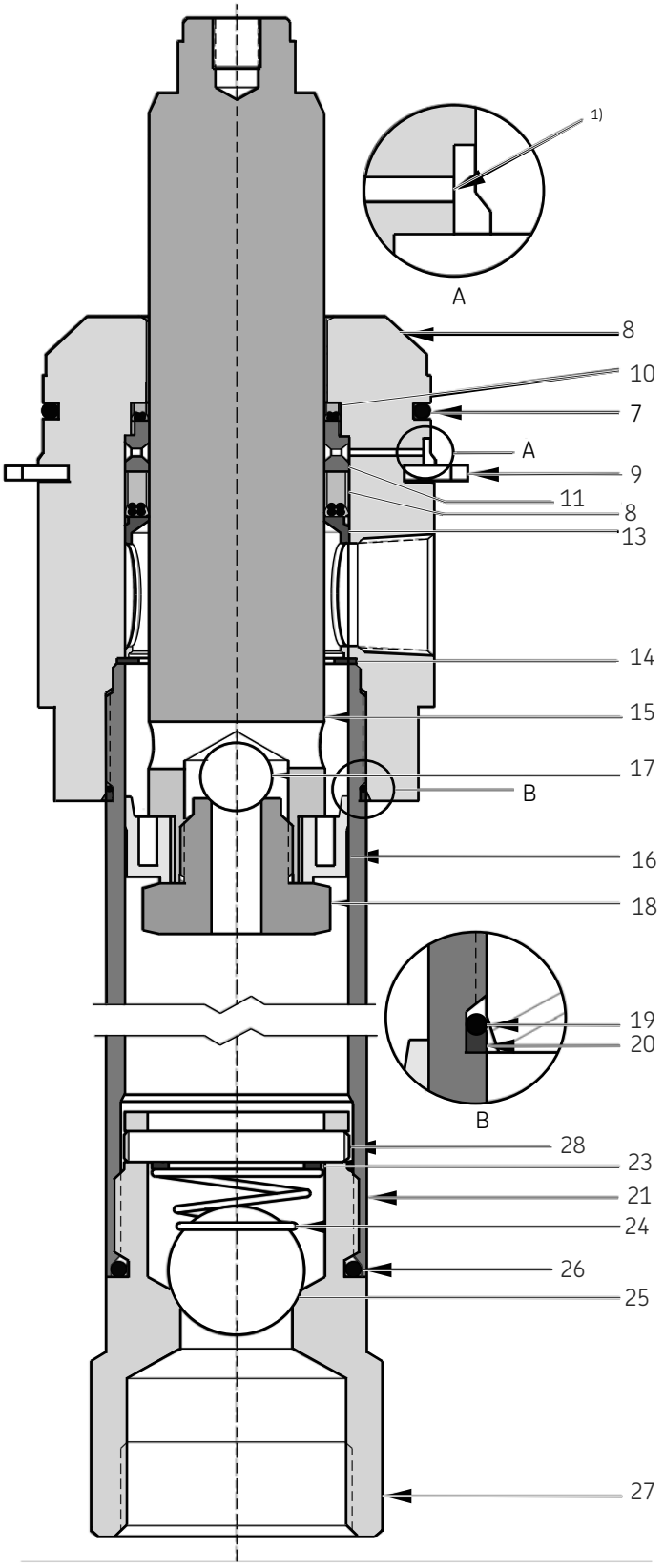
Additional items that should be incorporated into the air piping systems are listed in Air line components table below.

Air line components

Part number	Description
5604-2	Moisture separator
7604-B	Regulator and gauge

Fig. 3

Pump tube assembly 338067-B1 - section view



Refer to **Fig. IPB 1, page 14** and **Parts list, page 15** for parts identification
1) Lower seal weep hole

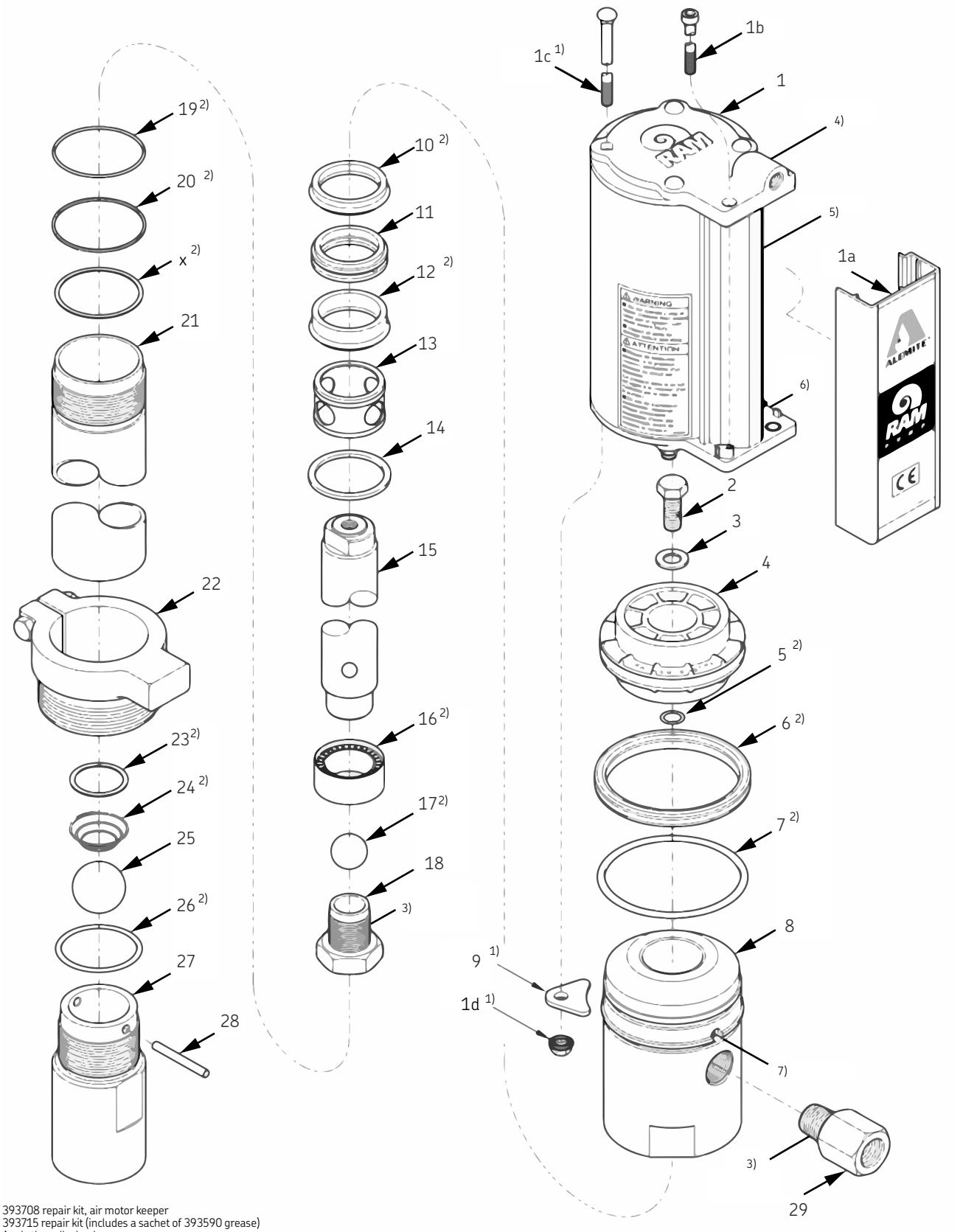
Troubleshooting chart

Pump indications	Possible problems	Solutions
Pump does not cycle.	1. Air motor not operating properly. 2. Pump tube jammed and/or contains loose components. 3. Insufficient air pressure.	1. Inspect air motor and rebuild or replace as necessary. 2. Rebuild pump tube. 3. Increase air pressure.
Pump will not prime.	1. Excessive cycling speed. 2. Pump leaking internally. 3. Extension not sufficiently tight and/or thread sealant missing or inadequate.	1. Reduce air pressure. 2. See internal leaks. 3. Apply thread sealant [1] to external pipe threads and tighten extension.
Pump cycles rapidly.	1. Product source empty. 2. Extension not sufficiently tight and/or thread sealant missing or inadequate.	1. Replenish product. 2. Apply thread sealant [1] to external pipe. Threads and tighten extension.
Pump will not stall (cycles more than once or twice/hour).	1. Pump requires break-in period. 2. Pump leaking internally. 3. Pump leaking externally. 4. Distribution system leaking. 5. Extension not sufficiently tight and/or thread sealant missing or inadequate.	1. Operate pump against moderate fluid pressure for up to one hour. 2. See internal leaks. 3. See external leaks. 4. Correct leak. 5. Apply thread sealant [1] to external pipe threads and tighten extension.
External leaks		
Product leakage visible at weep hole in body (**8**).	1. Damaged seal (**12**). 2. Damaged rod (**15**).	1. Replace seal (**12**). 2. Inspect rod (**15**) and replace as necessary.
Product leakage visible at bottom of body (**8**).	1. Tube (**21**) not sufficiently tight. 2. Damaged o-ring (**19**).	1. Tighten tube (**21**) into body (**8**). 2. Separate tube (**21**) from body (**8**) and replace o-ring (**19**).
Air leakage at weep hole in body (**8**).	Damaged seal (**10**).	Replace seal (**10**).
Product leakage visible between tube (**21**) and foot valve (**27**).	1. Foot valve (**27**) not sufficiently tight. 2. Damaged o-ring (**26**).	1. Tighten foot valve (**27**) into tube (**21**). 2. Separate foot valve (**27**) from tube (**21**) and replace o-ring (**26**).
Internal leaks		
Continuous slow air leak.	Worn or damaged o-ring (**7**).	Replace o-ring (**7**).
Pump does not prime or cycles continuously, or slowly (once or twice/hour).	1. Foreign material between ball (**17**) and valve seat (**18**). 2. Foreign material between ball (**25**) and foot valve (**27**). 3. Worn or damaged ball (**17**). 4. Worn or damaged valve seat (**18**). 5. Worn or damaged ball (**25**). 6. Worn or damaged foot valve (**27**). 7. Worn or damaged nylon piston (**16**).	Locate and eliminate source of foreign material. Disassemble pump tube, clean, inspect, and replace worn or damaged components.

[1] Do not apply thread sealant to first two (2) threads. Contamination can occur.

Fig. IPB 1

Low-pressure stub pump model 9968 series - exploded view



1) 393708 repair kit, air motor keeper
2) 393715 repair kit (includes a sachet of 393590 grease)
3) Apply threadlocker here.
4) Top cap
5) Cylinder
6) Bottom cap
7) Weep hole

Parts list

Item	Description	Part number	Quantity
1	Motor assembly, air	[1]	1
1a	Cover (w/o decals)	340053 [2]	1
1b	Screw, cap, 1/4 in -20 x 6 1/2 in	[2]	1
1c	Bolt, carriage, 1/4 in -20 x 7 1/2 in	[2] [5]	4
1d	Nut, serrated flange, 1/4 in -20	[2] [5]	4
2	Screw, 3/8 in -24 x 3/4 in		1
3	Washer, 3/8 in *(9,5 mm)*		1
4	Piston, air	339429	1
5	O-ring, 3/8 in ID x 1/2 in OD *(9,5 mm ID x 12,7 mm OD)*	X171000-7 [3] [4]	1
6	Quad-ring, 2 5/8 in ID x 3 in OD *(66,68 mm x 76,2 mm)*	X171008-37 [3] [4]	1
7	O-ring, 2 3/4 in ID x 3 in OD *(69,9 mm x 76,2 mm)*	X171003-10 [3] [4]	1
8	Body		1
9	Keeper	339412 [5]	4
10	Seal, 1 5/16 in ID x 1 9/16 in OD *(33,34 x 39,69 mm)*	[4]	1
11	Bearing (brass)	338060	1
12	Seal, 1 5/16 in ID x 1 11/16 in OD *(33,34 mm x 42,87 mm)*	[4]	1
13	Spacer		1
14	Washer, 1.56 in *(39,62 mm)*	339606	1
15	Rod	338106	1
16	Piston (nylon)	338120 [4]	1
17	Ball, 9/16 in *(14,29 mm)* diameter	[4]	1
18	Seat, valve	323707	1
19	O-ring, 1 7/8 in ID x 2 in OD *(47,63 mm ID x 50,8 mm OD)*	[4]	1
20	Ring, back-up	[4]	1
21	Tube	338090	1
22	Adapter, bung, 2 in NPTF (i) (Model 9968, -M)	326750-B1	1
23	Washer, 1 1/8 in OD	[4]	1
24	Spring, tapered	[4]	1
25	Ball, 1 1/16 in *(26,99 mm)* diameter	172270-13	1
26	O-ring, 1 11/16 in ID x 1 7/8 in OD *(42,87 mm ID x 47,63 mm OD)*	[4]	1
27	Valve, foot	323778	1
28	Pin, 1/4 in *(6,35 mm)* diameter x 1 25/32 in *(45,24 mm)* long	323713	1
29	Adapter, 1/2 in BSPP (i) x 1/2 in NPTF (e) (Model 9968-M)		1
Kit components for early model 9668 pump			
x	Gasket (aluminum)	323693 [4]	1

[1] See manual **670782**.
[2] Included with motor assembly
[3] Pack of ten (10).
[4] Part of air motor keeper repair kit 393708.
[5] Part of repair kit 393715.

Repair kits

Part number	Description
393715	Kit, repair (includes a sachet of 393590 grease)
393708	Kit, repair, air motor keeper
393530-22	Kit, seal (includes five (5) of (**10**))
393530-23	Kit, seal (includes five (5) of (**12**))

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