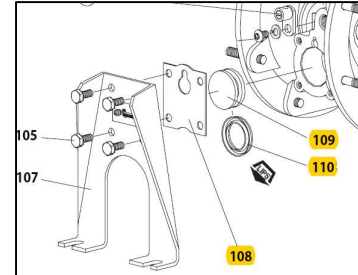Pro-Series Air Motor Rebuild Instructions:

These instructions are for rebuilding the air motor of a 1" metallic ARO Pro-Series diaphragm pump.

Information is taken from the 66610X-X-C Operator's Manual. But these instructions will apply to any model pump from the Pro-Series.
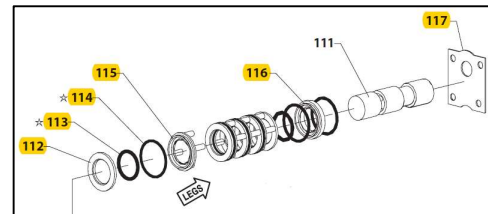
1.) On the air inlet side of the pump, first install the #110 (**Y186-51**) U-Cup onto the #109 (**92011**) Piston.
With the U-Cup lips facing UP, slide the #109 (**92011**) Piston into the #101 (**94743**) Center Body until it is flush.

2.) Lay the #108 (**92878**) Gasket with notch over the Piston. Make sure that the notch faces UP. Secure with the #107 (**92003**) Leg.

3.) Start rebuilding the Major Valve by first turning the pump so that the opening for the valve faces UP.
Lubricate the #113 (**Y325-214**) small O-Rings and #114 (**Y325-126**) large O-Rings with the grease packet that came in the **637118-C** kit.
Go ahead and pre-install the #113 (**Y325-214**) small O-Rings into the center of the #115 (**92876**) Legged Spacers and the #116 (**92006**) Spacer.

4.) Insert a #112 (**92877**) Washer into the housing with the lip facing UP. Place a long screwdriver through the Washer so that it doesn't turn when being installed.

5.) Install a #114 (**Y325-126**) large O-Ring into the housing. Make sure it seats on the #112 (**92877**) Washer.
Now insert a #115 (**92876**) Legged Spacers into the housing with the legs facing UP. Place a long screwdriver through the Legged Spacer so that it doesn't turn on you when being installed.
Repeat this process until all components are in place. Finish by placing the #116 (**92006**) Spacer on the stack. There is no need to press down, or compress, the stack at this time.

6.) Lubricate the #111 (**92005**) Spool. With the open end of the Spool facing UP, use the palm of your hand to gently insert the Spool into the valve stack. You will feel resistance as it glides over the O-Rings. If there is too much resistance, pull out the Spool and make sure the O-Rings are in place and lubricated.

7.) Finish by attaching the #117 (**92004**) Gasket and the second #107 (**92003**) Leg.