



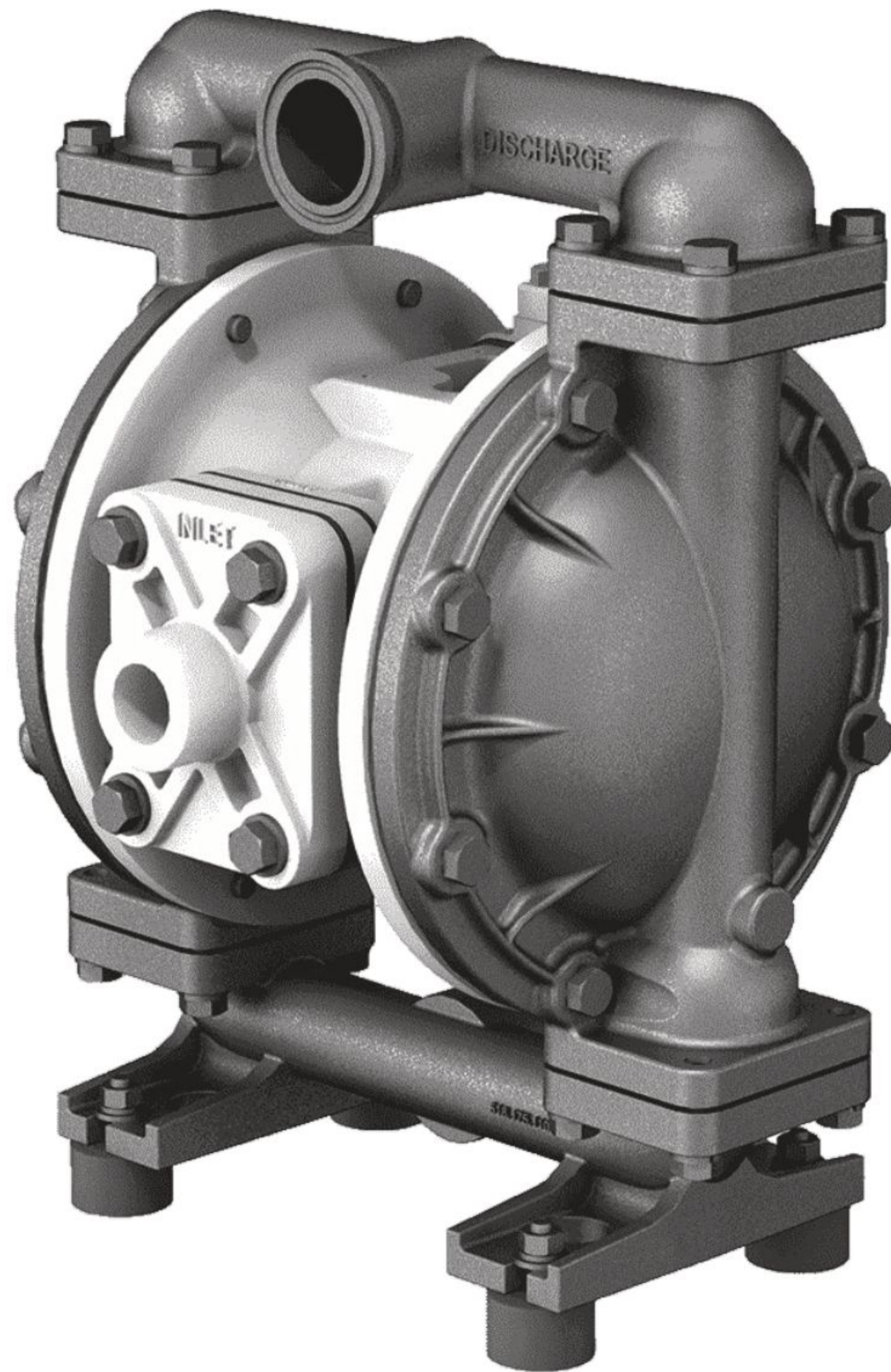
# SERVICE & OPERATING MANUAL

Original Instructions

Certified Quality



## Model F1F FDA Food Processing Metallic Design Level 1



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A Unit of PRG Corporation  
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1: PUMP SPECS

2: INSTAL & OP

3: EXP VIEW

4: AIR END

5: WET END

6: OPTIONAL

# Safety Information

## IMPORTANT



Read the safety warnings and instructions in this manual before pump installation and start-up. Failure to comply with the recommendations stated in this manual could damage the pump and void factory warranty.



When the pump is used for materials that tend to settle out or solidify, the pump should be flushed after each use to prevent damage. In freezing temperatures the pump should be completely drained between uses.

## CAUTION



Before pump operation, inspect all fasteners for loosening caused by gasket creep. Retighten loose fasteners to prevent leakage. Follow recommended torques stated in this manual.



Nonmetallic pumps and plastic components are not UV stabilized. Ultraviolet radiation can damage these parts and negatively affect material properties. Do not expose to UV light for extended periods of time.



**WARNING**  
Pump not designed, tested or certified to be powered by compressed natural gas. Powering the pump with natural gas will void the warranty.

## WARNING



When used for toxic or aggressive fluids, the pump should always be flushed clean prior to disassembly.



Before maintenance or repair, shut off the compressed air line, bleed the pressure, and disconnect the air line from the pump. Be certain that approved eye protection and protective clothing are worn at all times. Failure to follow these recommendations may result in serious injury or death.



Airborne particles and loud noise hazards. Wear eye and ear protection.



In the event of diaphragm rupture, pumped material may enter the air end of the pump, and be discharged into the atmosphere. If pumping a product that is hazardous or toxic, the air exhaust must be piped to an appropriate area for safe containment.



Take action to prevent static sparking. Fire or explosion can result, especially when handling flammable liquids. The pump, piping, valves, containers and other miscellaneous equipment must be properly grounded.



This pump is pressurized internally with air pressure during operation. Make certain that all fasteners and piping connections are in good condition and are reinstalled properly during reassembly.



Use safe practices when lifting

## ATEX Pumps - Conditions For Safe Use

1. Ambient temperature range is as specified in tables 1 to 3 on the next page (per Annex I of DEKRA 18ATEX0094X)
2. ATEX compliant pumps are suitable for use in explosive atmospheres when the equipment is properly grounded in accordance with local electrical codes
3. **Non-Metallic ATEX Pumps only — See Explanation of Pump Nomenclature / ATEX Details Page**  
Conductive Polypropylene, conductive Acetal or conductive PVDF pumps are not to be installed in applications where the pumps may be subjected to oil, greases and hydraulic liquids.
4. The optionally provided solenoids shall be protected by a fuse corresponding to its rated current (max  $3 \cdot I_{rat}$  according to EN 60127) or by a motor protecting switch with short circuit and thermal instantaneous tripping (set to the rated current) as short circuit protection. For solenoids with a very low rated current, a fuse with the lowest current value according to the indicated standard will be sufficient. The fuse may be accommodated in the associated supply unit or shall be separately arranged. The rated voltage of the fuse shall be equal or greater than the stated rated voltage of the solenoid. The breaking capacity of the fuse shall be as high as or higher than the maximum expected short circuit current at the location of the installation (usually 1500 A). The maximum permissible ripple is 20% for all dc solenoids.  
**\*Not applicable for all pump models — See Explanation of Pump Nomenclature / ATEX Details Page**
5. When operating pumps equipped with non-conductive diaphragms that exceed the maximum permissible projected area, as defined in EN ISO 80079-36 : 2016 section 6.7.5 table 8, the following protection methods must be applied
  - Equipment is always used to transfer electrically conductive fluids or
  - Explosive environment is prevented from entering the internal portions of the pump, i.e. dry running.
6. Pumps provided with the pulse output kit and used in the potentially explosive atmosphere caused by the presence of the combustible dust shall be installed in such a way that the pulse output kit is protected against impact  
**\*Not applicable for all pump models — See Explanation of Pump Nomenclature / ATEX Details Page**

# Temperature Tables

**Table 1. Category 1 & Category 2 ATEX Rated Pumps**

Ambient Temperature Range [°C]	Process Temperature Range [°C] <sup>1</sup>	Temperature Class	Maximum Surface Temperature [°C]
-20°C to +60°C	-20°C to +80°C	T5	T100°C
	-20°C to +108°C	T4	T135°C
	-20°C to + 160°C	T3	T200°C
	-20°C to +177°C	(225°C) T2	

<sup>1</sup>Per CSA standards ANSI LC6-2018 US & Canadian Technical Letter R14, G-Series Natural Gas Models are restricted to (-20°C to + 80°C) process temperature

**Table 2. Category 2 ATEX Rated Pumps Equipped with Pulse Output Kit or Integral Solenoid:**

Ambient Temperature Range [°C]	Process Temperature Range [°C]	Temperature Class	Maximum Surface Temperature [°C]	Options	
				Pulse Output Kit	Integral Solenoid
-20°C to +60°C	-20°C to +100°C	T5	T100	X	
-20°C to +50°C	-20°C to +100°C	T5	T100		X

<sup>2</sup>ATEX Pulse output or Intergral Solenoid Not Available For All Pump Models See Explanation of Pump Nomenclature / ATEX Details Page

**Table 3. Category M1 ATEX Rated Pumps for Mining**

Ambient Temperature Range [°C]	Process Temperature Range [°C]
-20°C to +60°C	-20°C to +150°C

Note: The ambient temperature range and the process temperature range should not exceed the operating temperature range of the applied non-metallic parts as listed in the manuals of the pumps.

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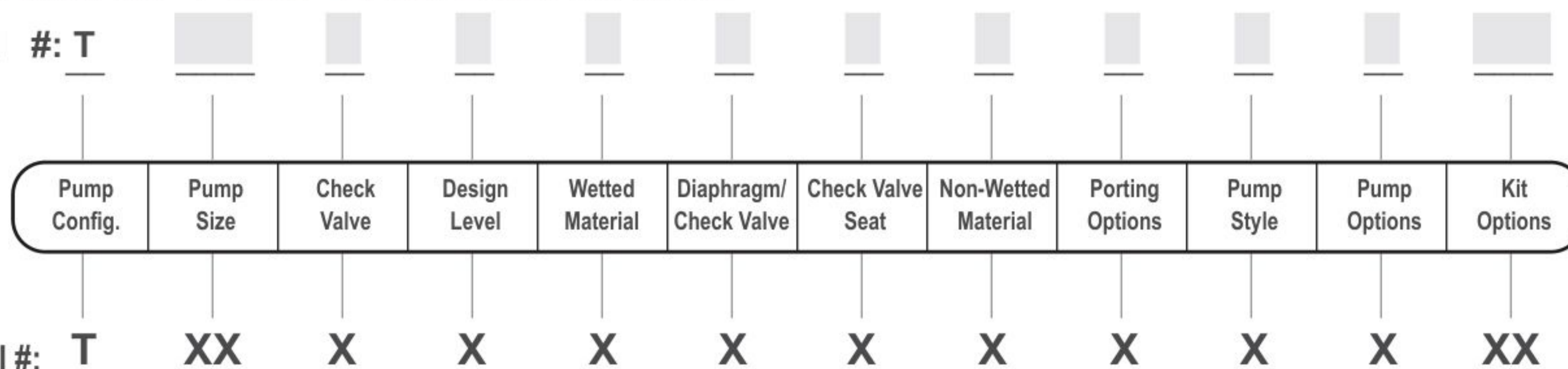
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# EXPLANATION OF PUMP NOMENCLATURE

Your Model #: T

(fill in from pump nameplate)



## Pump Brand

F FTA® T Food Processing

T PTFE

## Pump Size

1F 1"

## Non-Wetted Material Options

W White Epoxy Coated Aluminum w/Stainless Steel Hardware

## Check Valve Type

B Ball

## Porting Options

T 1 1/2" Sanitary Clamp Fitting

## Design Level

1 Design Level

## Pump Style

S Standard

## Wetted Material

S Stainless Steel

## Muffler Options

0 None  
6 Metal Muffler

## Diaphragm/Check Valve Materials

- \*A PTFE - FDA Nitrile/PTFE
- \*L FDA Santoprene/PTFE
- \*9 FDA Nitrile/PTFE
- \*D FDA Santoprene/FDA Santoprene
- S\* PTFE - FDA Santoprene/PTFE
- Z PTFE One-Piece Bonded Synthesis Diaphragm / PTFE

## Pump Options

0 None

## Check Valve Seat

S Stainless Steel

\*Model equipped with these options are compliant with the traceability requirements of EC Regulation 1935/2004/EC. 

Your Serial #: (fill in from pump nameplate) \_\_\_\_\_

# Performance

## T1F METALLIC

### SUCTION/DISCHARGE PORT SIZE

- 1 1/2" Sanitary Clamp Ports

### CAPACITY

- 0 to 45 gallons per minute  
(0 to 170 liters per minute)

### AIR DISTRIBUTION VALVE

- No-lube, no-stall design

### SOLIDS-HANDLING

- Up to .25 in. (6mm)

### HEADS UP TO

- 125 psi or 289 ft. of water  
(8.6 Kg/cm<sup>2</sup> or 86 meters)

### DISPLACEMENT/STROKE

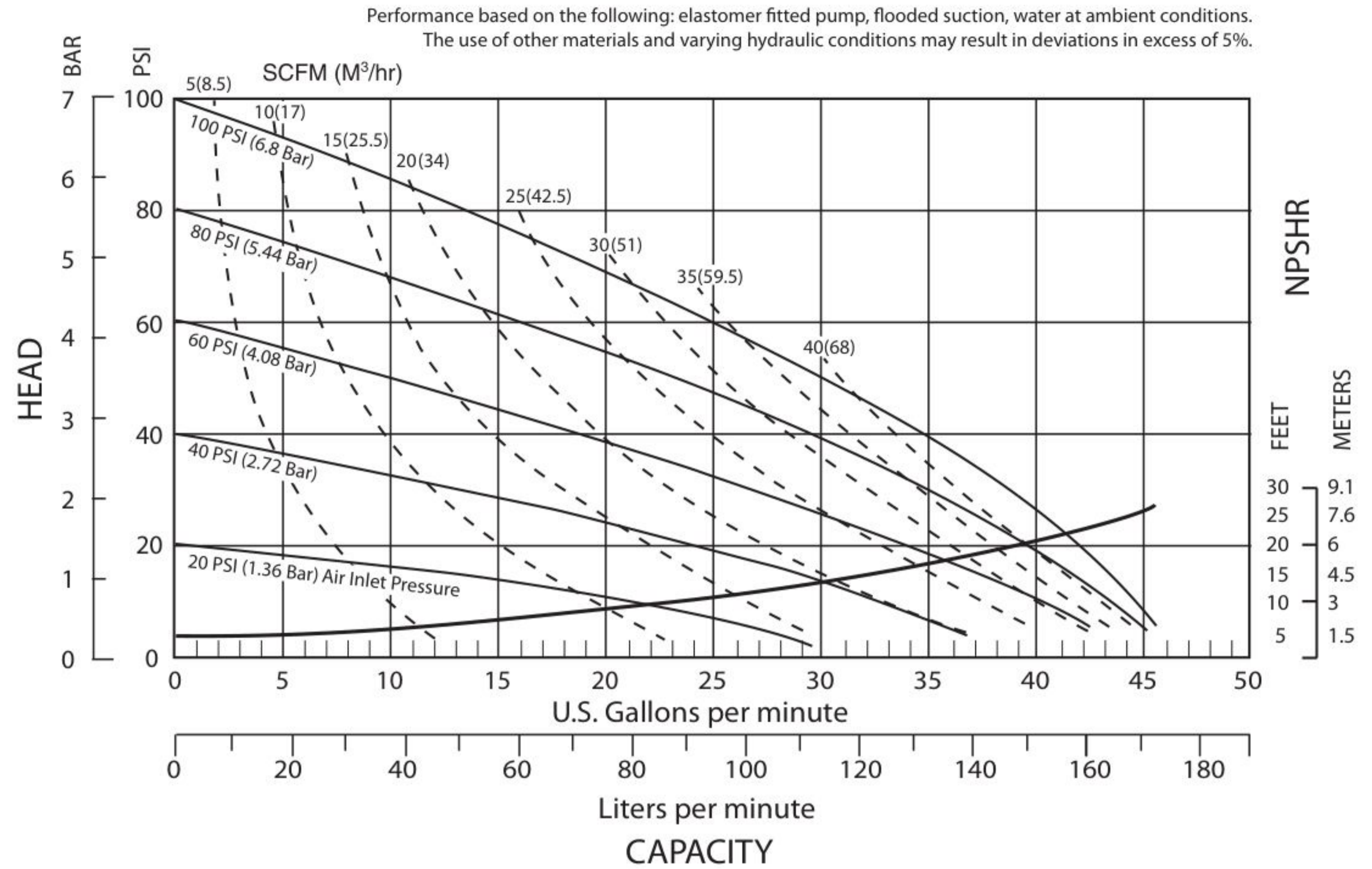
- .11 Gallon / .42 liter

### MAXIMUM OPERATING PRESSURE

- 125 psi (8.6 bar)

### SHIPPING WEIGHT

- Stainless Steel 43 lbs. (20kg)



## Materials

### Material Profile:

**CAUTION!** Operating temperature limitations are as follows:

**Nitrile:** General purpose, oil-resistant. Shows good solvent, oil, water and hydraulic fluid resistance. Should not be used with highly polar solvents like acetone and MEK, ozone, chlorinated hydrocarbons and nitro hydrocarbons.

**Santoprene®:** Injection molded thermoplastic elastomer with no fabric layer. Long mechanical flex life. Excellent abrasion resistance.

**Virgin PTFE:** (PFA/TFE) Chemically inert, virtually impervious. Very few chemicals are known to chemically react with PTFE; molten alkali metals, turbulent liquid or gaseous fluorine and a few fluoro-chemicals such as chlorine trifluoride or oxygen difluoride which readily liberate free fluorine at elevated temperatures.

Maximum and Minimum Temperatures are the limits for which these materials can be operated. Temperatures coupled with pressure affect the longevity of diaphragm pump components. Maximum life should not be expected at the extreme limits of the temperature ranges.

### Metals:

**Stainless Steel:** Equal to or exceeding ASTM specification A743 CF-8M for corrosion resistant iron chromium, iron chromium nickel and nickel based alloy castings for general applications. Commonly referred to as 316 Stainless Steel in the pump industry.

For specific applications, always consult the Chemical Resistance Chart.

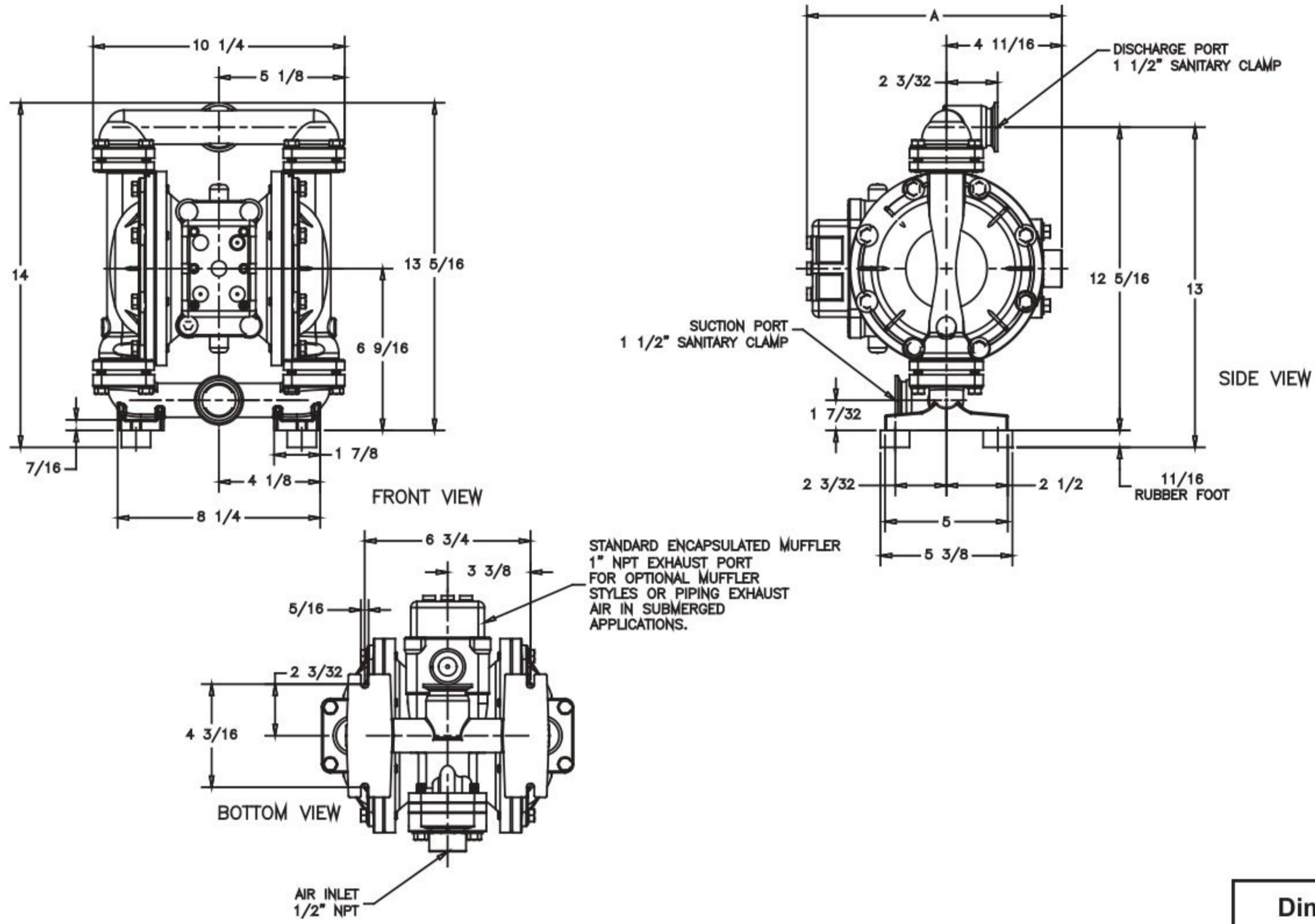
# Dimensional Drawings

## T1F Metallic

The dimensions on this drawing are for reference only. A certified drawing can be requested if physical dimensions are needed.

Dimensions in Inches

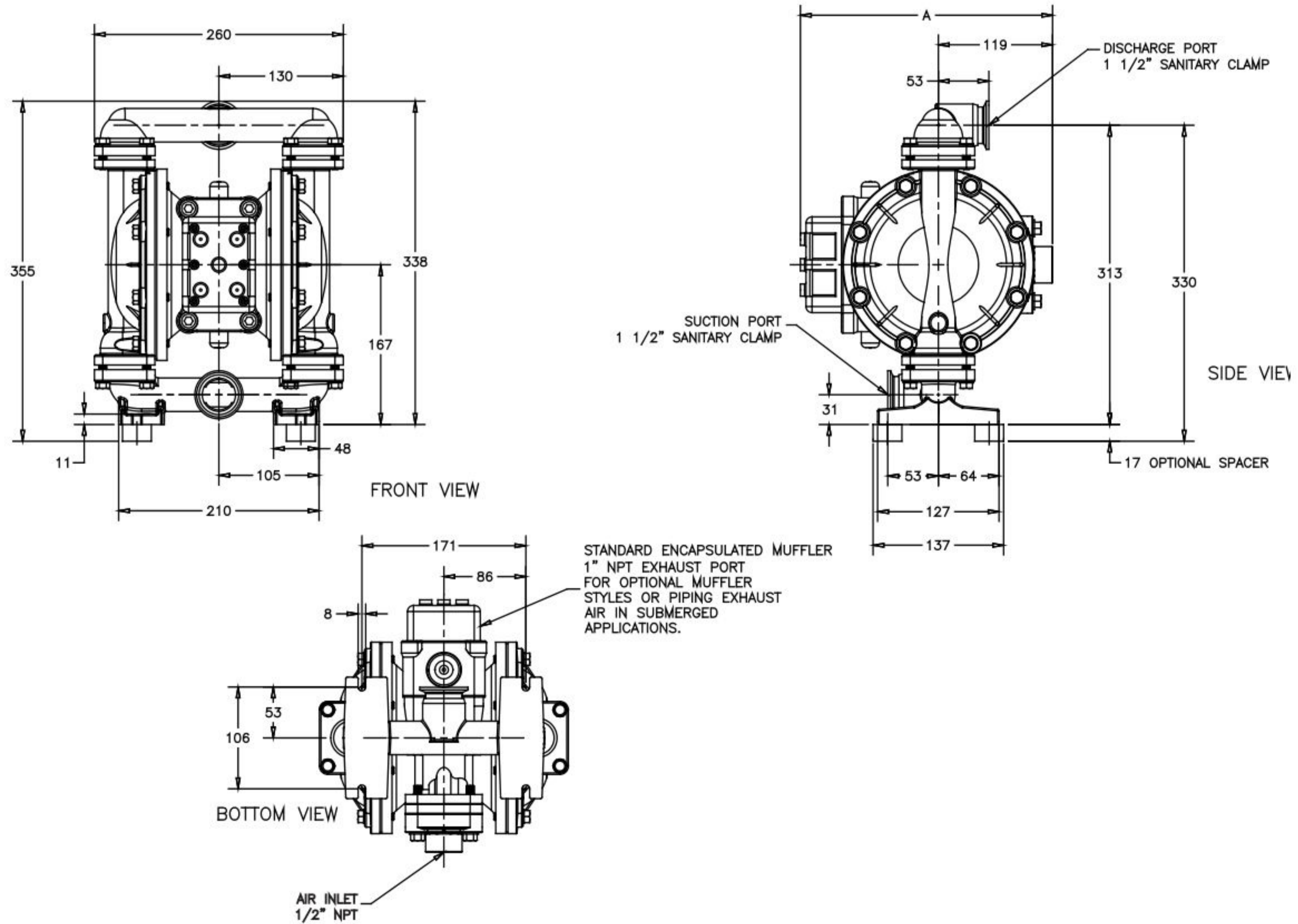
Dimensional Tolerance:  $\pm 1/8"$



Dimension	A
Metal Muffler	12 1/2
	319

Dimensions in Millimeters

Dimensional Tolerance:  $\pm 3\text{mm}$

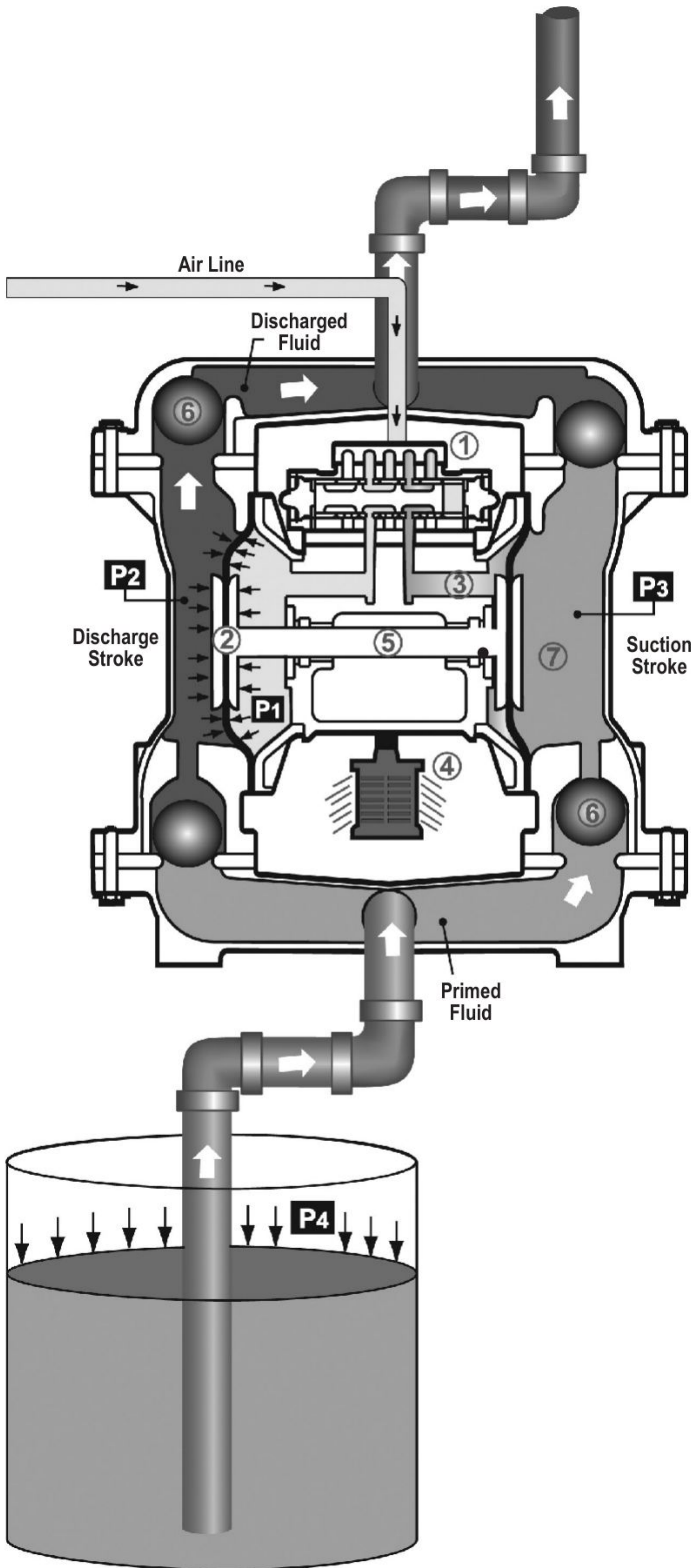


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# Principle of Pump Operation



Air-Operated Double Diaphragm (AODD) pumps are powered by compressed air or nitrogen.

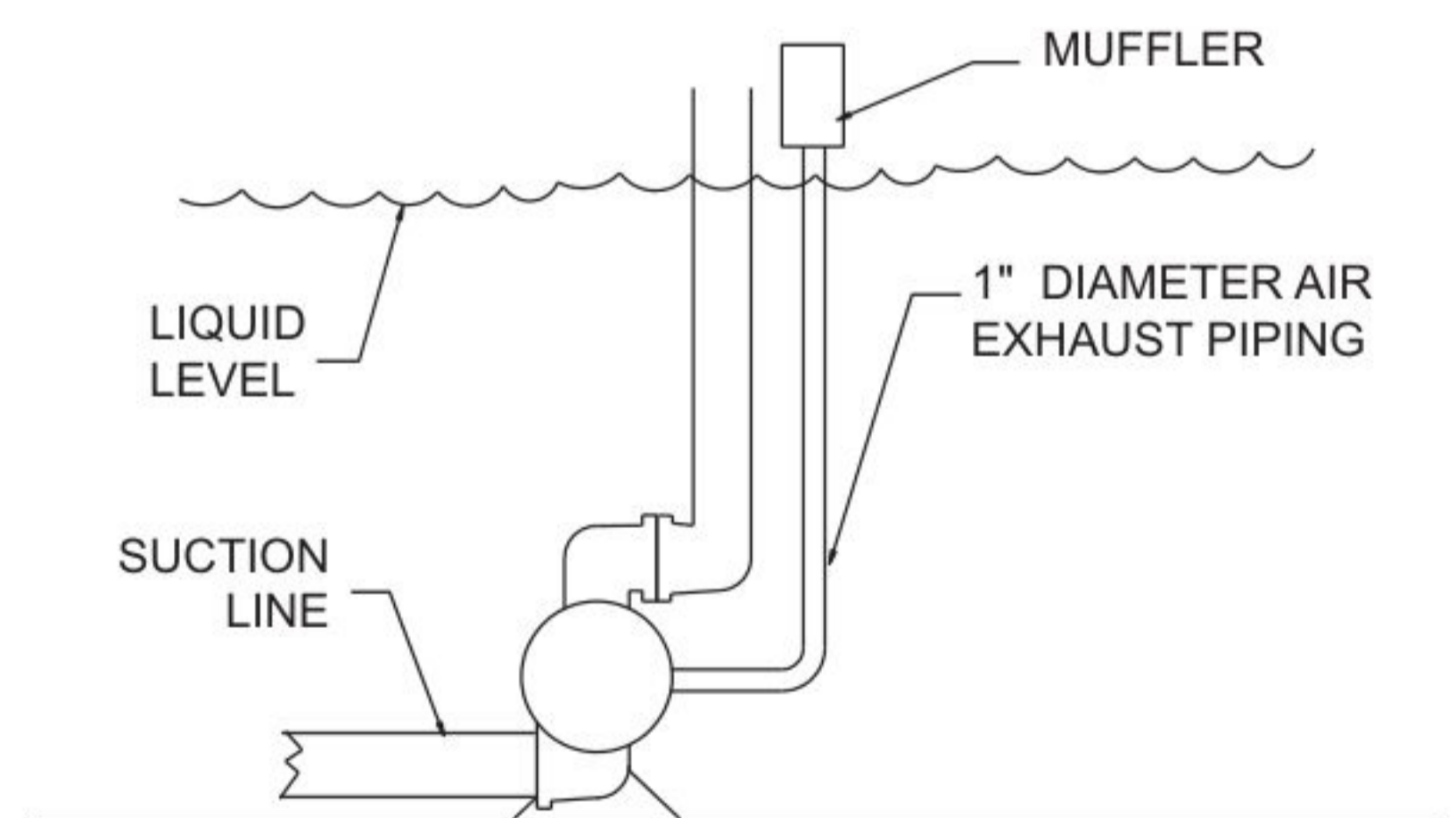
The main directional (air) control valve ① distributes compressed air to an air chamber, exerting uniform pressure over the inner surface of the diaphragm ②. At the same time, the exhausting air ③ from behind the opposite diaphragm is directed through the air valve assembly(s) to an exhaust port ④.

As inner chamber pressure (P1) exceeds liquid chamber pressure (P2), the rod ⑤ connected diaphragms shift together creating discharge on one side and suction on the opposite side. The discharged and primed liquid's directions are controlled by the check valves (ball or flap)⑥ orientation.

The pump primes as a result of the suction stroke. The suction stroke lowers the chamber pressure (P3) increasing the chamber volume. This results in a pressure differential necessary for atmospheric pressure (P4) to push the fluid through the suction piping and across the suction side check valve and into the outer fluid chamber ⑦.

Suction (side) stroking also initiates the reciprocating (shifting, stroking or cycling) action of the pump. The suction diaphragm's movement is mechanically pulled through its stroke. The diaphragm's inner plate makes contact with an actuator plunger aligned to shift the pilot signaling valve. Once actuated, the pilot valve sends a pressure signal to the opposite end of the main directional air valve, redirecting the compressed air to the opposite inner chamber.

## SUBMERGED ILLUSTRATION



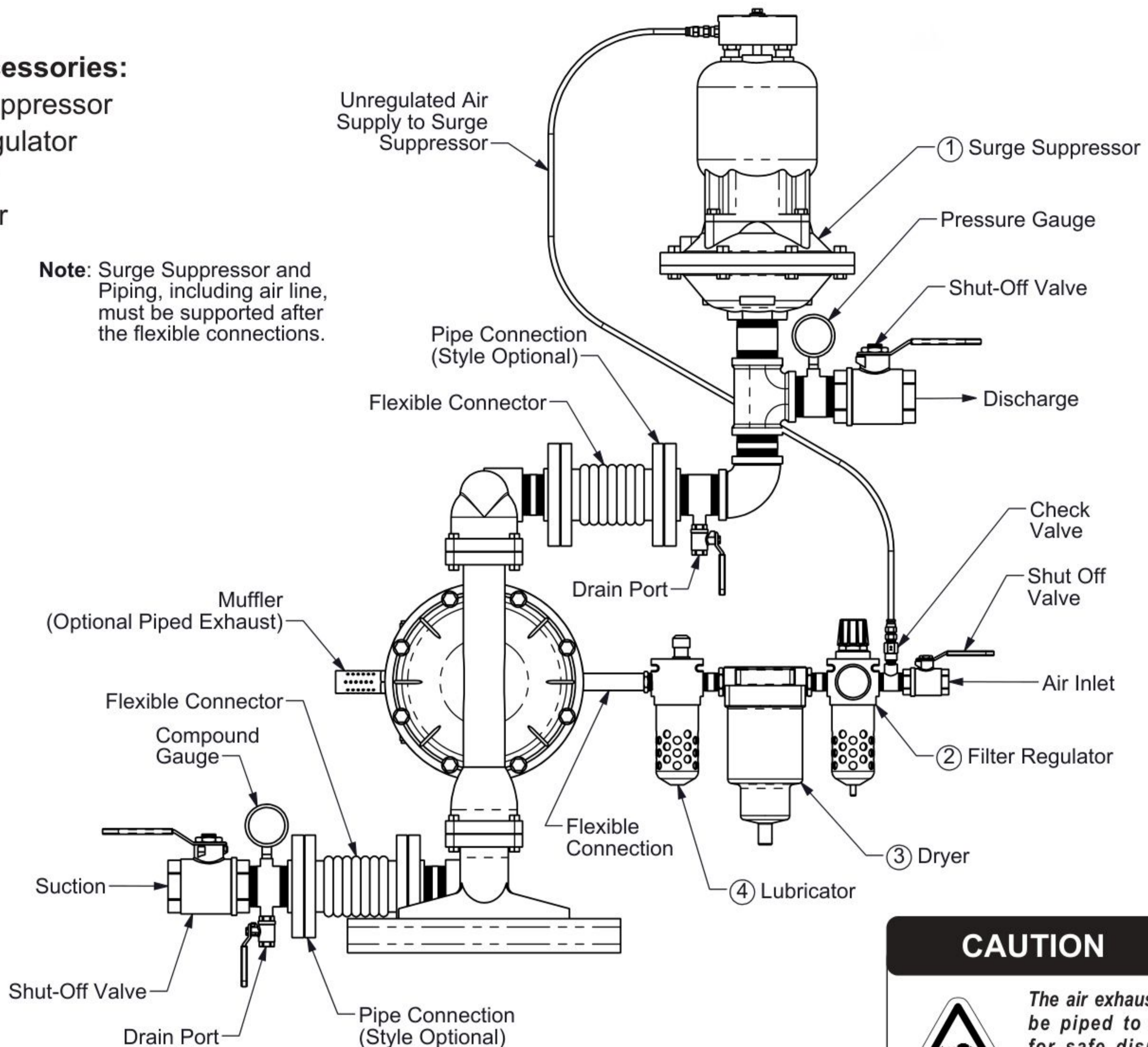
Pump can be submerged if the pump materials of construction are compatible with the liquid being pumped. The air exhaust must be piped above the liquid level. When the pumped product source is at a higher level than the pump (flooded suction condition), pipe the exhaust higher than the product source to prevent siphoning spills.

# Recommended Installation Guide

## Available Accessories:

1. Surge Suppressor
2. Filter/Regulator
3. Air Dryer
4. Lubricator

**Note:** Surge Suppressor and Piping, including air line, must be supported after the flexible connections.



**CAUTION**

The air exhaust should be piped to an area for safe disposition of the product being pumped, in the event of a diaphragm failure.

### Installation And Start-Up

Locate the pump as close to the product being pumped as possible. Keep the suction line length and number of fittings to a minimum. Do not reduce the suction line diameter.

### Air Supply

Connect the pump air inlet to an air supply with sufficient capacity and pressure to achieve desired performance. A pressure regulating valve should be installed to insure air supply pressure does not exceed recommended limits.

### Air Valve Lubrication

The air distribution system is designed to operate WITHOUT lubrication. This is the standard mode of operation. If lubrication is desired, install an air line lubricator set to deliver one drop of SAE 10 non-detergent oil for every 20 SCFM (9.4 liters/sec.) of air the pump consumes. Consult the Performance Curve to determine air consumption.

### Air Line Moisture

Water in the compressed air supply may cause icing or freezing of the exhaust air, causing the pump to cycle erratically or stop operating. Water in the air supply can be reduced by using a point-of-use air dryer.

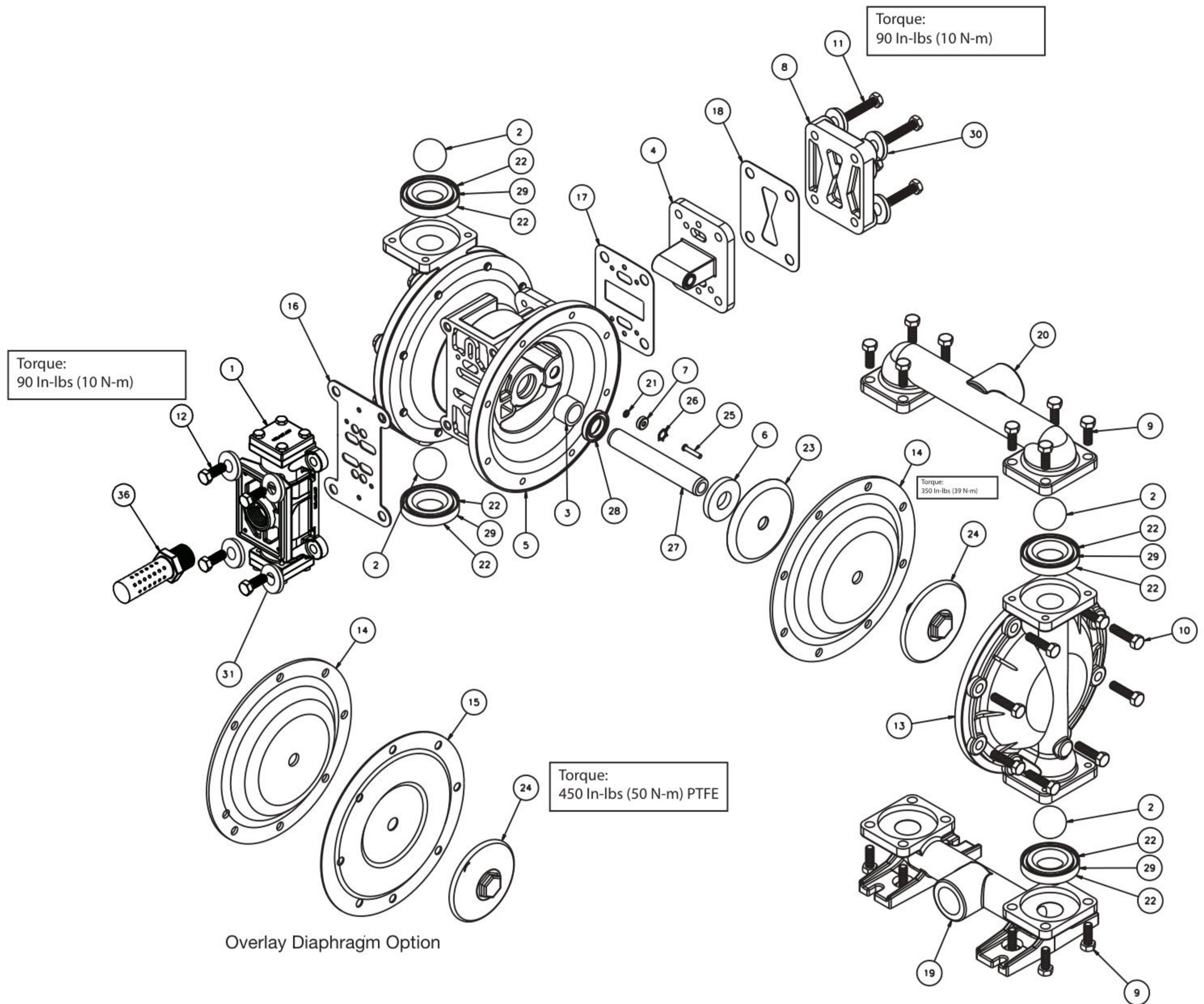
### Air Inlet And Priming

To start the pump, slightly open the air shut-off valve. After the pump primes, the air valve can be opened to increase air flow as desired. If opening the valve increases cycling rate, but does not increase the rate of flow, cavitation has occurred. The valve should be closed slightly to obtain the most efficient air flow to pump flow ratio.

# Troubleshooting Guide

Symptom:	Potential Cause(s):	Recommendation(s):
<b>Pump Cycles Once</b>	Deadhead (system pressure meets or exceeds air supply pressure).	Increase the inlet air pressure to the pump. Pump is designed for 1:1 pressure ratio at zero flow. (Does not apply to high pressure 2:1 units).
	Air valve or intermediate gaskets installed incorrectly.	Install gaskets with holes properly aligned.
	Bent or missing actuator plunger.	Remove pilot valve and inspect actuator plungers.
<b>Pump Will Not Operate / Cycle</b>	Pump is over lubricated.	Set lubricator on lowest possible setting or remove. Units are designed for lube free operation.
	Lack of air (line size, PSI, CFM).	Check the air line size and length, compressor capacity (HP vs. CFM required).
	Check air distribution system.	Disassemble and inspect main air distribution valve, pilot valve and pilot valve actuators.
	Discharge line is blocked or clogged manifolds.	Check for inadvertently closed discharge line valves. Clean discharge manifolds/piping.
	Deadhead (system pressure meets or exceeds air supply pressure).	Increase the inlet air pressure to the pump. Pump is designed for 1:1 pressure ratio at zero flow. (Does not apply to high pressure 2:1 units).
	Blocked air exhaust muffler.	Remove muffler screen, clean or de-ice, and re-install.
	Pumped fluid in air exhaust muffler.	Disassemble pump chambers. Inspect for diaphragm rupture or loose diaphragm plate assembly.
	Pump chamber is blocked.	Disassemble and inspect wetted chambers. Remove or flush any obstructions.
<b>Pump Cycles and Will Not Prime or No Flow</b>	Cavitation on suction side.	Check suction condition (move pump closer to product).
	Check valve obstructed. Valve ball(s) not seating properly or sticking.	Disassemble the wet end of the pump and manually dislodge obstruction in the check valve pocket. Clean out around valve ball cage and valve seat area. Replace valve ball or valve seat if damaged. Use heavier valve ball material.
	Valve ball(s) missing (pushed into chamber or manifold).	Worn valve ball or valve seat. Worn fingers in valve ball cage (replace part). Check Chemical Resistance Guide for compatibility.
	Valve ball(s) / seat(s) damaged or attacked by product.	Check Chemical Resistance Guide for compatibility.
	Check valve and/or seat is worn or needs adjusting.	Inspect check valves and seats for wear and proper setting. Replace if necessary.
	Suction line is blocked.	Remove or flush obstruction. Check and clear all suction screens or strainers.
	Excessive suction lift.	For lifts exceeding 20' of liquid, filling the chambers with liquid will prime the pump in most cases.
	Suction side air leakage or air in product.	Visually inspect all suction-side gaskets and pipe connections.
	Pumped fluid in air exhaust muffler.	Disassemble pump chambers. Inspect for diaphragm rupture or loose diaphragm plate assembly.
	<b>Pump Cycles Running Sluggish / Stalling, Flow Unsatisfactory</b>	Over lubrication.
Icing.		Remove muffler screen, de-ice, and re-install. Install a point of use air drier.
Clogged manifolds.		Clean manifolds to allow proper air flow.
Deadhead (system pressure meets or exceeds air supply pressure).		Increase the inlet air pressure to the pump. Pump is designed for 1:1 pressure ratio at zero flow. (Does not apply to high pressure 2:1 units).
Cavitation on suction side.		Check suction (move pump closer to product).
Lack of air (line size, PSI, CFM).		Check the air line size, length, compressor capacity.
Excessive suction lift.		For lifts exceeding 20' of liquid, filling the chambers with liquid will prime the pump in most cases.
Air supply pressure or volume exceeds system hd.		Decrease inlet air (press. and vol.) to the pump. Pump is cavitating the fluid by fast cycling.
Undersized suction line.		Meet or exceed pump connections.
Restrictive or undersized air line.		Install a larger air line and connection.
Suction side air leakage or air in product.		Visually inspect all suction-side gaskets and pipe connections.
Suction line is blocked.		Remove or flush obstruction. Check and clear all suction screens or strainers.
Pumped fluid in air exhaust muffler.		Disassemble pump chambers. Inspect for diaphragm rupture or loose diaphragm plate assembly.
Check valve obstructed.		Disassemble the wet end of the pump and manually dislodge obstruction in the check valve pocket.
Check valve and/or seat is worn or needs adjusting.		Inspect check valves and seats for wear and proper setting. Replace if necessary.
Entrained air or vapor lock in chamber(s).		Purge chambers through tapped chamber vent plugs. Purging the chambers of air can be dangerous.
<b>Product Leaking Through Exhaust</b>	Diaphragm failure, or diaphragm plates loose.	Replace diaphragms, check for damage and ensure diaphragm plates are tight.
	Diaphragm stretched around center hole or bolt holes.	Check for excessive inlet pressure or air pressure. Consult Chemical Resistance Chart for compatibility with products, cleaners, temperature limitations and lubrication.
<b>Premature Diaphragm Failure</b>	Cavitation.	Enlarge pipe diameter on suction side of pump.
	Excessive flooded suction pressure.	Move pump closer to product. Raise pump/place pump on top of tank to reduce inlet pressure. Install Back pressure device (Tech bulletin 41r). Add accumulation tank or pulsation dampener.
	Misapplication (chemical/physical incompatibility).	Consult Chemical Resistance Chart for compatibility with products, cleaners, temperature limitations and lubrication.
	Incorrect diaphragm plates or plates on backwards, installed incorrectly or worn.	Check Operating Manual to check for correct part and installation. Ensure outer plates have not been worn to a sharp edge.
<b>Unbalanced Cycling</b>	Excessive suction lift.	For lifts exceeding 20' of liquid, filling the chambers with liquid will prime the pump in most cases.
	Undersized suction line.	Meet or exceed pump connections.
	Pumped fluid in air exhaust muffler.	Disassemble pump chambers. Inspect for diaphragm rupture or loose diaphragm plate assembly.
	Suction side air leakage or air in product.	Visually inspect all suction-side gaskets and pipe connections.
	Check valve obstructed.	Disassemble the wet end of the pump and manually dislodge obstruction in the check valve pocket.
	Check valve and/or seat is worn or needs adjusting.	Inspect check valves and seats for wear and proper setting. Replace if necessary.
	Entrained air or vapor lock in chamber(s).	Purge chambers through tapped chamber vent plugs.

# Composite Repair Parts Drawing



## Service & Repair Kits

- 476-228-000**     **Air End Kit (Aluminum Center)**  
Seals, O-Ring, Gaskets, Retaining Rings, Air Valve Sleeve and Spool Set, and Pilot Valve Assembly.
- 476-194-351**     **Wet End Kit**  
FDA Santoprene Diaphragms, FDA Santoprene Balls, and PTFE Encapsulate Seals
- 476-194-666**     **Wet End Kit**  
FDA Nitrile Diaphragms, PTFE Overlay, PTFE Balls, & PTFE Encapsulated Seals
- 476-194-681**     **Wet End Kit**  
FDA Santoprene Diaphragms, PTFE Overlay, PTFE Balls, & PTFE Encapsulated Seals
- 476-194-659**     **Wet End Kit**  
One-Piece Bonded PTFE/Nitrile Diaphragm, PTFE Balls, PTFE Seats.

# Composite Repair Parts List

ITEM	PART NUMBER	DESCRIPTION	QTY	ITEM	PART NUMBER	DESCRIPTION	QTY
1	031.183.313	Air Valve Assembly	1	20	518.176.110TC	Manifold, Discharge	1
2	050.028.351	Ball, Check	4	21	560.001.360	O.Ring	2
	050.028.600	Ball, Check	4	22	560.091.611	Seal (Check Valve) (See item 29)	
3	070.012.170	Bushing	2	23	612.022.330	Plate, Inner Diaphragm	2
4	095.110.313	Pilot Valve Assembly	1		612.218.330	Plate, Inner Diaphragm	2
5	114.025.313	Intermediate	1			(used with Synthesis diaphragms only)	
6	132.019.357	Bumper	2	24	612.101.110	Plate, Outer Diaphragm Assembly	
7	135.036.506	Bushing	2	25	620.022.115	Plunger, Actuator	2
8	165.120.313	Cap, Air Inlet Assembly	1	26	675.042.115	Ring, Retaining	2
9	170.005.115	Capscrew, Hex Hd 5/16-18 X .88	16	27	685.060.120	Rod, Diaphragm	1
10	170.045.115	Capscrew, Hex Hd 5/16-18 X 1.25	16	28	720.010.360	Seal, U.Cup	2
11	170.069.115	Capscrew, Hex Hd 5/16-18 X 1.75	4	29	722.098.110	Seat, Check Ball (seals required see item 22)	
12	170.006.115	Capscrew, Hex HD 3/8-16 X 100	4	30	901.038.115	Washer, Flat 5/16	4
13	196.173.110	Chamber, Outer	2	31	901.048.115	Washer, Flat 3/8	4
14	286.008.351	Diaphragm	2	36	530.033.000	Metal Muffler	1
	286.008.366	Diaphragm	2				
	286.112.000	Synthesis One-Piece PTFE Diaphragm	2	Parts Not Shown (For Rubber Mounting Feet):			
15	286.015.604	Diaphragm, Overlay	2		171.066.115	Capscrew, Socket Hd	4
16	360.093.360	Gasket, Air Valve	1		350.002.360	Foot, Rubber	4
17	360.114.360	Gasket, Pilot Valve	1		545.003.115	Nut, Hex	4
18	360.104.379	Gasket, Air Inlet Cap	1		900.001.115	Washer, Flat	4
19	518.175.110TC	Manifold, Suction	1		901.035.115	Washer, Lock	4

## LEGEND:

○ = Items contained within Air End Kits

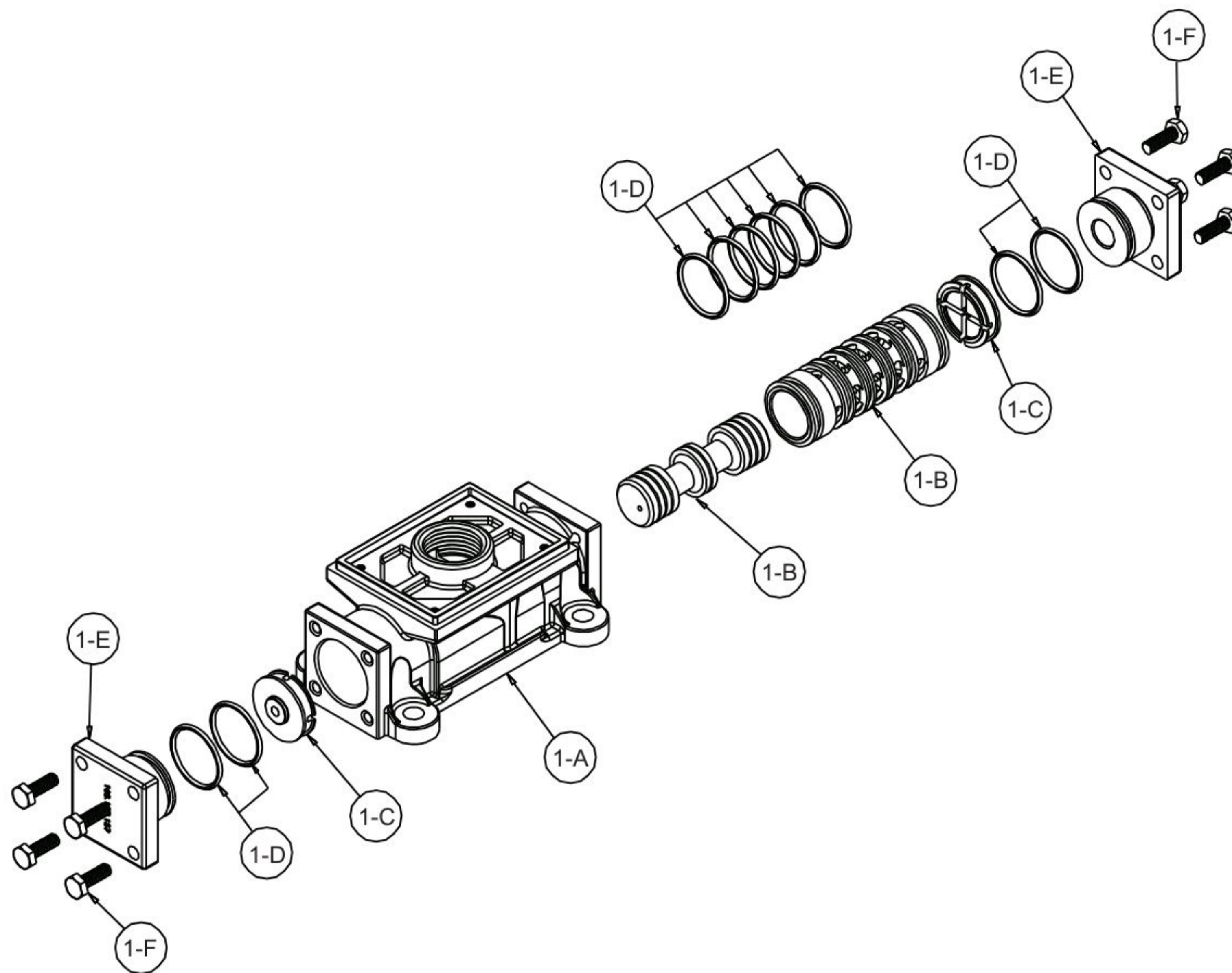
□ = Items contained within Wet End Kits

**Note:** Kits contain components specific to the material codes.

# Material Codes - The Last 3 Digits of Part Number

000.....Assembly, sub-assembly; and some purchased items	364.....EPDM Rubber Color coded: BLUE	• Delrin and Hytrel are registered tradenames of E.I. DuPont.
010.....Cast Iron	365.....Neoprene Rubber Color coded: GREEN	• Nylatron is a registered tradename of Polymer Corp.
015.....Ductile Iron	366.....Food Grade Nitrile	• Gylon is a registered tradename of Garlock, Inc.
020.....Ferritic Malleable Iron	368.....Food Grade EPDM	• Santoprene is a registered tradename of Exxon Mobil Corp.
080.....Carbon Steel, AISI B-1112	371.....Philthane (Tuftane)	• Rulon II is a registered tradename of Dixion Industries Corp.
110.....Alloy Type 316 Stainless Steel	374.....Carboxylated Nitrile	• Ryton is a registered tradename of Phillips Chemical Co.
111.....Alloy Type 316 Stainless Steel (Electro Polished)	375.....Fluorinated Nitrile	• Valox is a registered tradename of General Electric Co.
112.....Alloy C	378.....High Density Polypropylene	
113.....Alloy Type 316 Stainless Steel (Hand Polished)	379.....Conductive Nitrile	
114.....303 Stainless Steel	408.....Cork and Neoprene	
115.....302/304 Stainless Steel	425.....Compressed Fibre	
117.....440-C Stainless Steel (Martensitic)	426.....Blue Gard	
120.....416 Stainless Steel (Wrought Martensitic)	440.....Vegetable Fibre	
148.....Hardcoat Anodized Aluminum	500.....Delrin® 500	
150.....6061-T6 Aluminum	502.....Conductive Acetal, ESD-800	
152.....2024-T4 Aluminum (2023-T351)	503.....Conductive Acetal, Glass-Filled	
155.....356-T6 Aluminum	506.....Delrin® 150	
156.....356-T6 Aluminum	520.....Injection Molded PVDF Natural color	
157.....Die Cast Aluminum Alloy #380	540.....Nylon	
158.....Aluminum Alloy SR-319	542.....Nylon	
162.....Brass, Yellow, Screw Machine Stock	544.....Nylon Injection Molded	
165.....Cast Bronze, 85-5-5-5	550.....Polyethylene	
166.....Bronze, SAE 660	551.....Glass Filled Polypropylene	
170.....Bronze, Bearing Type, Oil Impregnated	552.....Unfilled Polypropylene	
180.....Copper Alloy	555.....Polyvinyl Chloride	
305.....Carbon Steel, Black Epoxy Coated	556.....Black Vinyl	
306.....Carbon Steel, Black PTFE Coated	557.....Unfilled Conductive Polypropylene	
307.....Aluminum, Black Epoxy Coated	558.....Conductive HDPE	
308.....Stainless Steel, Black PTFE Coated	559.....Glass Filled - Conductive Polypropylene	
309.....Aluminum, Black PTFE Coated	558.....Conductive HDPE	
313.....Aluminum, White Epoxy Coated	570.....Rulon II®	
330.....Zinc Plated Steel	580.....Ryton®	
332.....Aluminum, Electroless Nickel Plated	600.....PTFE (virgin material) Tetrafluorocarbon (TFE)	
333.....Carbon Steel, Electroless Nickel Plated	603.....Blue Gylon®	
335.....Galvanized Steel	604.....PTFE	
337.....Silver Plated Steel	606.....PTFE	
351.....Food Grade Santoprene®	607.....Envelon	
353.....Geolast; Color: Black	608.....Conductive PTFE	
354.....Injection Molded #203-40 Santoprene® Duro 40D +/-5; Color: RED	610.....PTFE Encapsulated Silicon	
356.....Hytrel®	611.....PTFE Encapsulated FKM	
357.....Injection Molded Polyurethane	632.....Neoprene/Hytrel®	
358.....Urethane Rubber (Some Applications) (Compression Mold)	633.....FKM/PTFE	
359.....Urethane Rubber	634.....EPDM/PTFE	
360.....Nitrile Rubber Color coded: RED	635.....Neoprene/PTFE	
363.....FKM (Fluorocarbon) Color coded: YELLOW	637.....PTFE, FKM/PTFE	
	638.....PTFE, Hytrel®/PTFE	
	639.....Nitrile/TFE	
	643.....Santoprene®/EPDM	
	644.....Santoprene®/PTFE	
	656.....Santoprene® Diaphragm and Check Balls/EPDM Seats	
	661.....EPDM/Santoprene®	
	666.....FDA Nitrile Diaphragm, PTFE Overlay, Balls, and Seals	
	668.....PTFE, FDA Santoprene®/PTFE	

# Air Distribution Valve Assembly



4: AIR END

## Air Distribution Valve Servicing

See repair parts drawing, remove screws.

**Step 1:** Remove hex cap screws (1-F).

**Step 2:** Remove end cap (1-E) and bumper (1-C).

**Step 3:** Remove spool part of (1-B) (caution: do not scratch).

**Step 4:** Press sleeve (1-B) from body (1-A).

**Step 5:** Inspect O-Rings (1-D) and replace if necessary.

**Step 6:** Lightly lubricate O-Rings (1-D) on sleeve (1-B).

**Step 7:** Press sleeve (1-B) into body (1-A).

**Step 8:** Reassemble in reverse order, starting with step 3.

**Note:** Sleeve and spool (1-B) set is match ground to a specified clearance sleeve and spools (1-B) cannot be interchanged.

## Air Valve Assembly Parts List

(Use w/Aluminum center sections)

Item	Part Number	Description	Qty
1	031.183.313	Air Valve Assembly	1
1-A	095.109.313	Body, Air Valve	1
1-B	031.139.000	Sleeve and Spool Set	1
1-C	132-029-552	Bumper	2
1-D	560.020.360	O-Ring	10
1-E	165.127.313	Cap, End	2
1-F	170.032.115	Hex Head Capscrew 1/4-20 x .75	8
1-G	901.037.115	Flat Washer	8

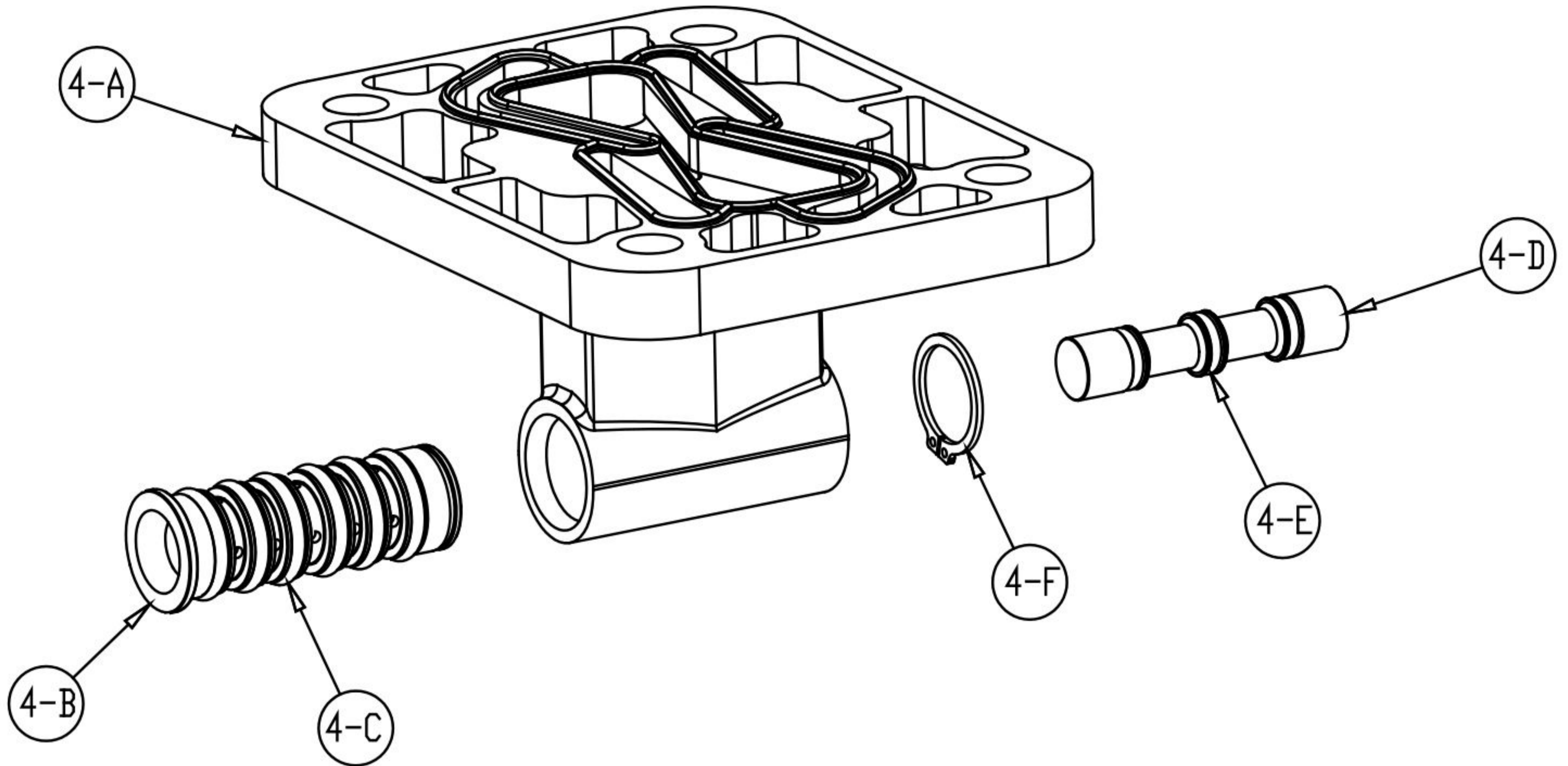
### ⚠ IMPORTANT



Read these instructions completely, before installation and start-up. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.



# Pilot Valve Assembly



4: AIR END

## Pilot Valve Servicing

With Pilot Valve removed from pump.

**Step 1:** Remove snap ring (4-F).

**Step 2:** Remove sleeve (4-B), inspect O-Rings (4-C),  
replace if required.

**Step 3:** Remove spool (4-D) from sleeve (4-B),  
inspect O-Rings (4-E), replace if required.

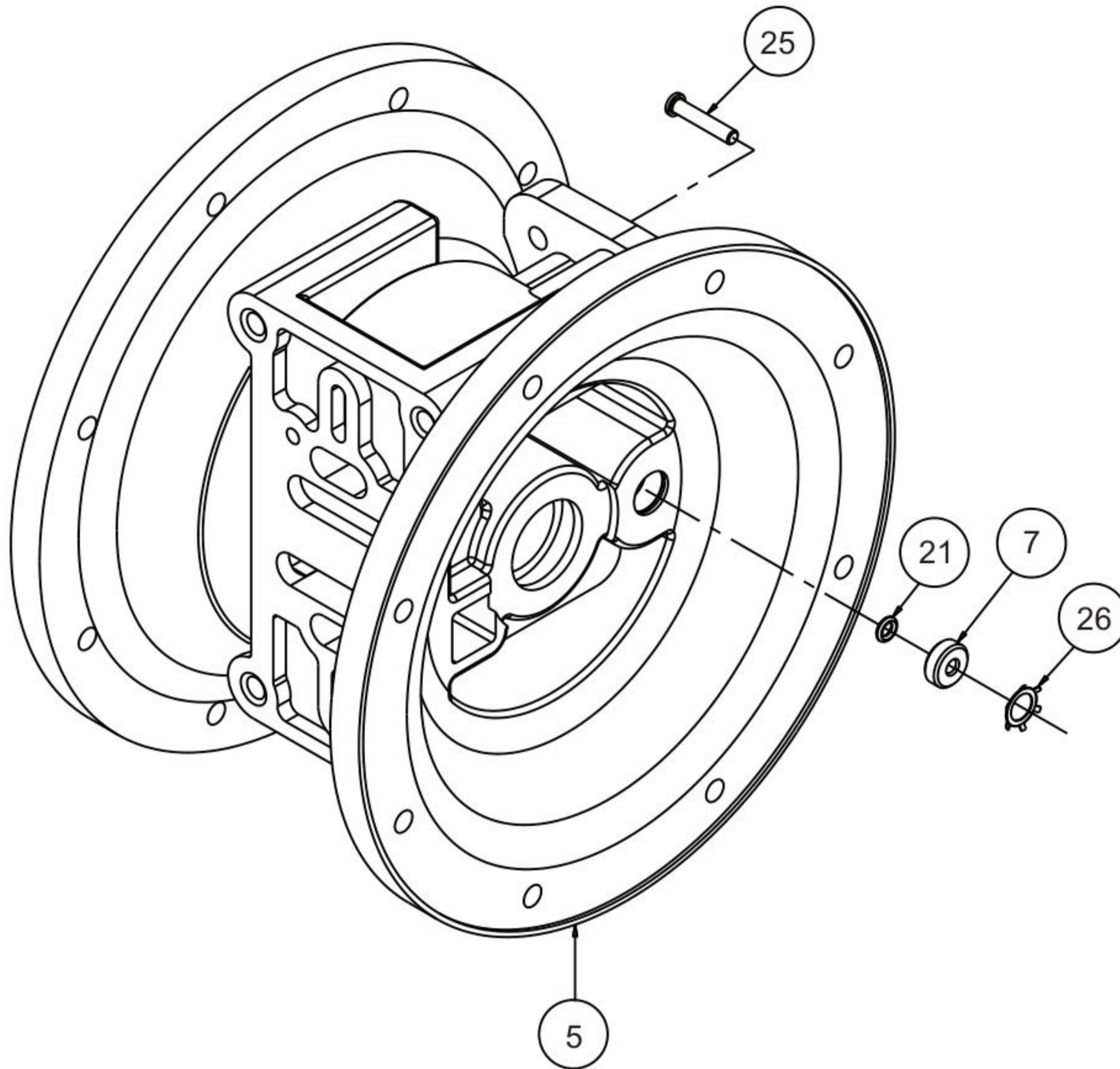
**Step 4:** Lightly lubricate O-Rings (4-C) and (4-E).

Reassemble in reverse order.

## Pilot Valve Assembly Parts List

Item	Part Number	Description	Qty
4	095.110.313	Pilot Valve Assembly	1
4-A	095.095.313	Valve Body	1
4-B	755.052.000	Sleeve (With O-Rings)	1
4-C	560.033.360	O-Ring (Sleeve)	6
4-D	775.055.000	Spool (With O-Rings)	1
4-E	560.023.360	O-Ring (Spool)	3
4-F	675.037.080	Retaining Ring	1

# Intermediate Assembly



## Intermediate Assembly Drawing

- Step 1:** Remove plunger, actuator (25) from center of intermediate pilot valve cavity.
- Step 2:** Remove Ring, Retaining (26), discard.
- Step 3:** Remove bushing, plunger (7), inspect for wear and replace if necessary with genuine parts.
- Step 4:** Remove O-Ring (21), inspect for wear and replace if necessary with genuine parts.
- Step 5:** Lightly lubricate O-Ring (21) and insert into intermediate.
- Step 6:** Utilizing a new Ring, Retaining (26) reassemble in reverse order
- Step 7:** Remove Seal, Diaphragm Rod (28).
- Step 8:** Clean seal area, lightly lubricate and install new Seal, Diaphragm Rod (28).

## Intermediate Assembly Parts List

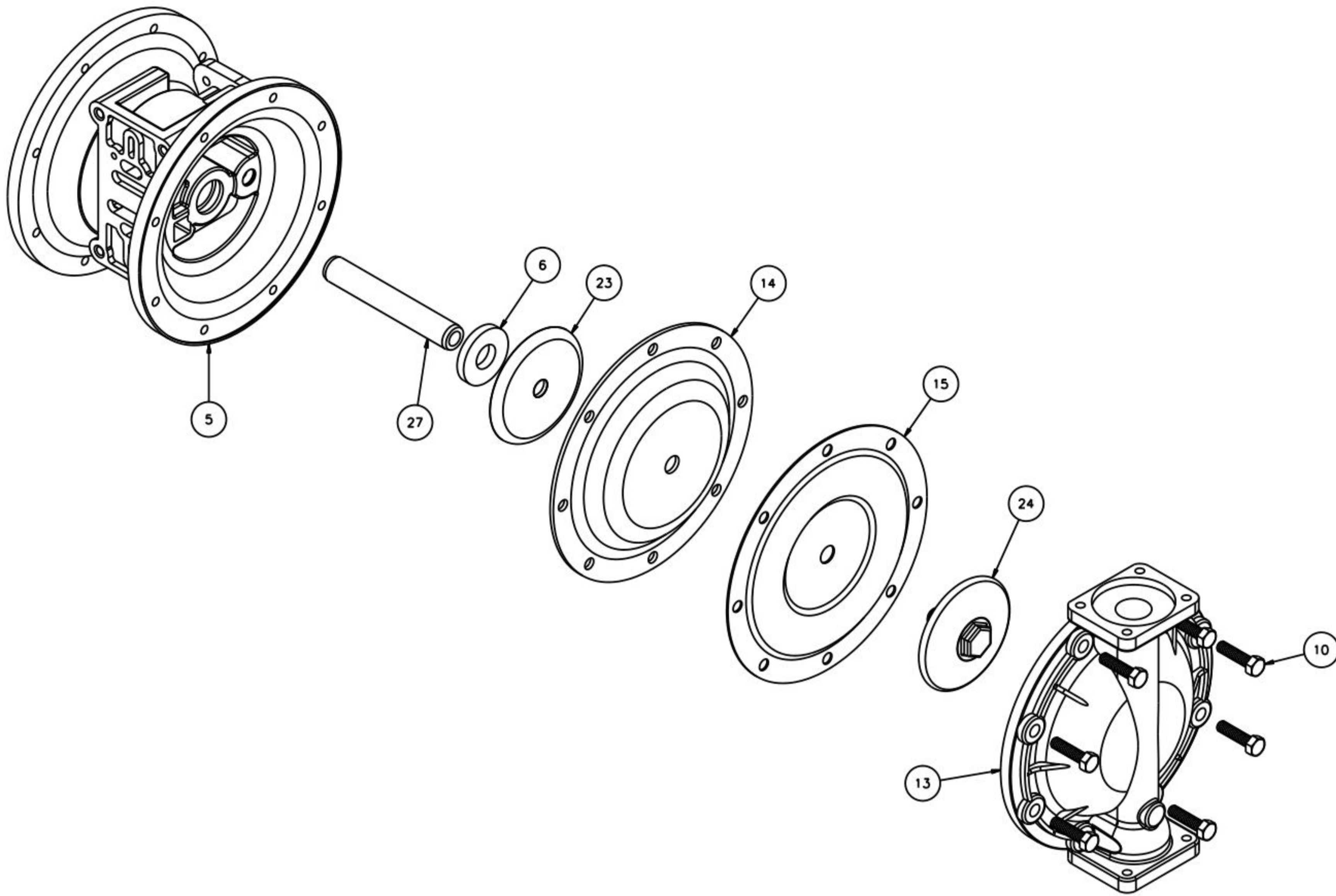
Item	Part Number	Description	Qty
5	114.025.313	Intermediate	1
7	135.036.506	Bushing, Plunger*	2
21	560.001.360	O-Ring	2
25	620.022.115	Plunger, Actuator*	2
26	675.042.115	Ring, Retaining	2
28	720.010.375	Seal, Diaphragm Rod*	2

### ⚠ IMPORTANT



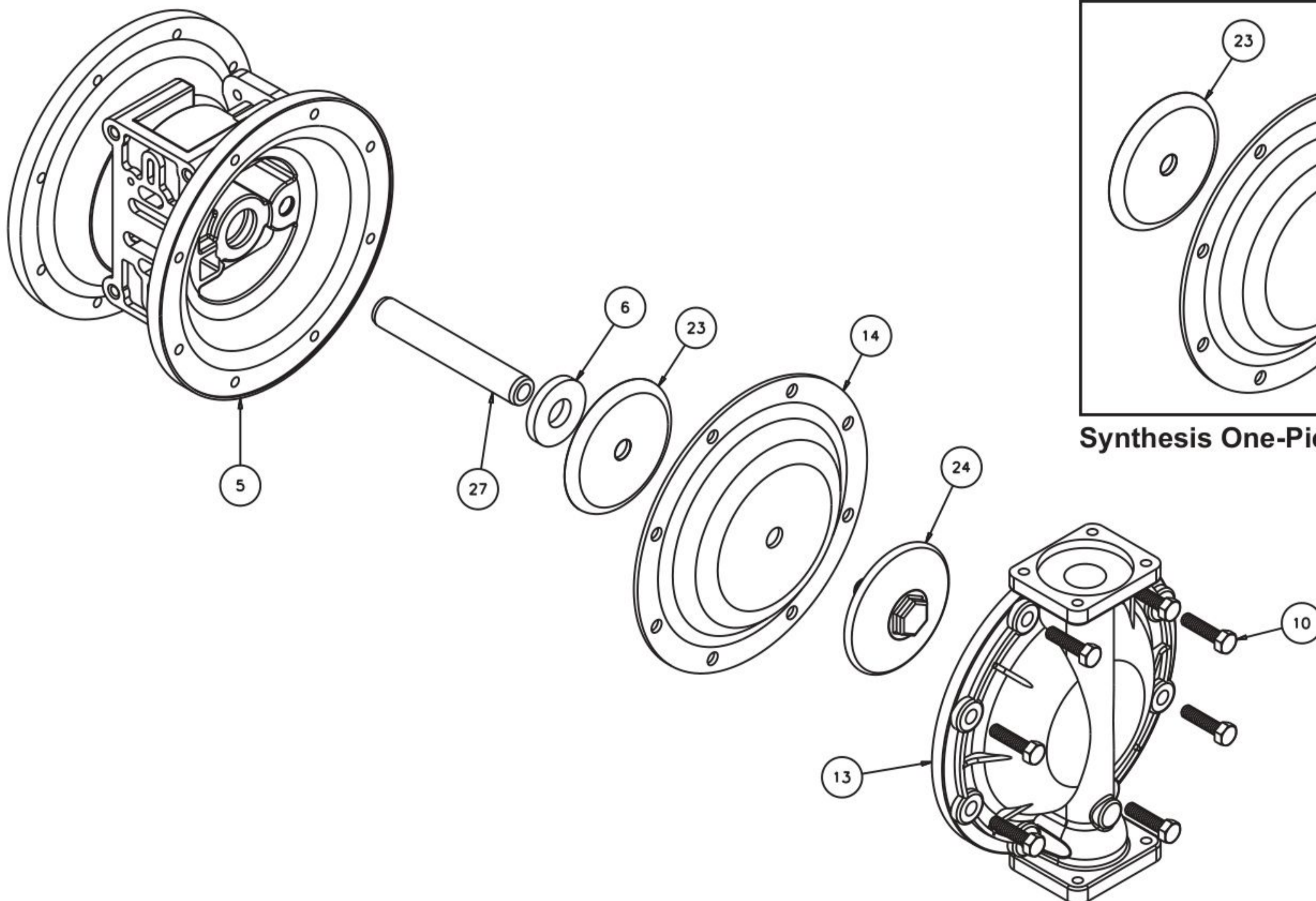
*When the pumped product source is at a higher level than the pump (flooded suction condition), pipe the exhaust higher than the product source to prevent siphoning spills. In the event of a diaphragm failure a complete rebuild of the center section is recommended.*

# Diaphragm Service Drawing, with Overlay



# Diaphragm Service Drawing, Non-Overlay

5: WET END



# Diaphragm Servicing

**Step 1:** With manifolds and outer chambers removed, remove diaphragm assemblies from diaphragm rod. **DO NOT** use a pipe wrench or similar tool to remove assembly from rod. Flaws in the rod surface may damage bearings and seal. Soft jaws in a vise are recommended to prevent diaphragm rod damage.

**Step 1.A: NOTE:** Not all inner diaphragm plates are threaded. Some models utilize a through hole in the inner diaphragm plate. If required to separate diaphragm assembly, place assembly in a vise, gripping on the exterior cast diameter of the inner plate. Turn the outer plate clockwise to separate the assembly.

Always inspect diaphragms for wear cracks or chemical attack. Inspect inner and outer plates for deformities, rust scale and wear. Inspect intermediate bearings for elongation and wear. Inspect diaphragm rod for wear or marks.

Clean or repair if appropriate. Replace as required.

**Step 2:** Reassembly: There are two different types of diaphragm plate assemblies utilized throughout the FTA PUMP product line: Outer plate with a threaded stud, diaphragm, and a threaded inner plate.

Outer plate with a threaded stud, diaphragm, and an inner plate with through hole. Secure threaded inner plate in a vise. Ensure that the plates are being installed with the outer radius against the diaphragm.

**Step 3:** Lightly lubricate, with a compatible material, the inner faces of both outer and inner diaphragm plates when using on non Overlay diaphragms (For EPDM water is recommended). No lubrication is required.

**Step 4:** Push the threaded outer diaphragm plate through the center hole of the diaphragm. **Note:** Most diaphragms are installed with the natural bulge out towards the fluid side. S05, S07, and S10 non-metallic units are installed with the natural bulge in towards the air side.

**Step 5:** Thread or place, outer plate stud into the inner plate. For threaded inner plates, use a torque wrench to tighten the assembly together. Torque values are called out on the exploded view.

Repeat procedure for second side assembly. Allow a minimum of 15 minutes to elapse after torquing, then re-torque the assembly to compensate for stress relaxation in the clamped assembly.

**Step 6:** Thread one assembly onto the diaphragm rod with sealing washer (when used) and bumper.

**Step 7:** Install diaphragm rod assembly into pump and secure by installing the outer chamber in place and tightening the capscrews.

**Step 8:** On opposite side of pump, thread the remaining assembly onto the diaphragm rod. Using a torque wrench, tighten the assembly to the diaphragm rod. Align diaphragm through bolt holes, always going forward past the recommended torque. Torque values are called out on the exploded view. **NEVER** reverse to align holes, if alignment cannot be achieved without damage to diaphragm, loosen complete assemblies, rotate diaphragm and reassemble as described above.

**Step 9:** Complete assembly of entire unit. One Piece Diaphragm Servicing (Bonded PTFE with integral plate) The One Piece diaphragm has a threaded stud installed in the integral plate at the factory. The inner diaphragm plate has a through hole instead of a threaded hole. Place the inner plate over the diaphragm stud and thread the first diaphragm / inner plate onto the diaphragm rod only until the inner plate contacts the rod. Do not tighten. A small amount of grease may be applied between the inner plate and the diaphragm to facilitate assembly. Insert the diaphragm / rod assembly into the pump and install the outer chamber. Turn the pump over and thread the second diaphragm / inner plate onto the diaphragm rod. Turn the diaphragm until the inner plate contacts the rod and hand tighten the assembly. Continue tightening until the bolt holes align with the inner chamber holes. **DO NOT LEAVE THE ASSEMBLY LOOSE.**

## IMPORTANT



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