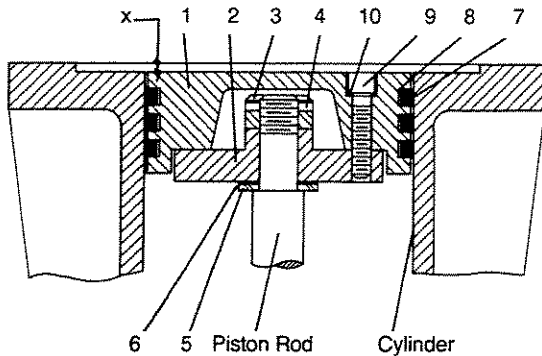
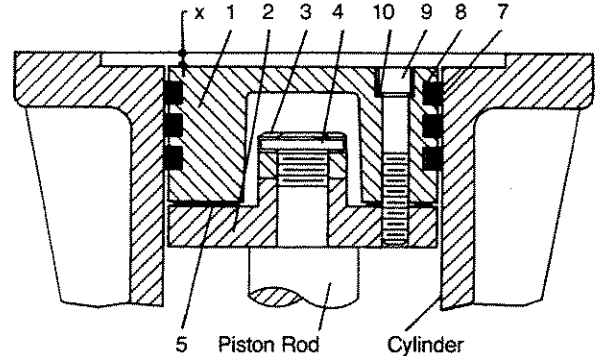


MODELS 91, 191, 291, 391, 491, 491-3



MODELS 590, 691, 691-4



TWO-STAGE	ALL MODELS 190/191				ALL MODELS 390/391				ALL MODELS 590/591			
	1983-X		2001-X		1987-X		1981-X		1754-X		1755-X	
Piston Assembly No.	3" (7.62 cm)		1 3/4" (4.45 cm)		4 1/2" (11.43 cm)		2 1/2" (6.35 cm)		6" (15.24 cm)		3 1/4" (8.26 cm)	
Piston Diameter												
Ref. No. Part Name	Part No.	Qty./Piston	Part No.	Qty./Piston	Part No.	Qty./Piston	Part No.	Qty./Piston	Part No.	Qty./Piston	Part No.	Qty./Piston
1. Head, Iron	1983	1	2001	1	1987	1	1981	1	1754	1	1755	1
2. Piston Platform	1984	1	2002	1	1986	1	1982	1	1986	1	1986-1	1
3. Locknut	1482	1	1448	1	1482	1	1482	1	1482	1	1482	1
4. Lock Pin	1483	1	1483	1	1483	1	1483	1	1483	1	1483	1
5. Thrust Washer	1527	1	None	-	1527	1	1527	1	None	-	None	-
6. Shim Washer, Thick	1528	As	1378	As	1528	As	1528	As	1735	As	1735	As
Shim Washer, Thin	1528-1	Req.		Req.	1528-1	Req.	1528-1	Req.	1735-1	Req.	1735-1	Req.
7. Piston Ring	1772	3	1770	3	1739	3	1771	3	1752	3	1756	3
8. Ring Expander	1775	3	2015	3	1740	3	1774	3	1753	3	1757	3
9. Screw, Soc. Hd.	7002-010		7002-008		7002-025		7002-008		7002-025		7002-025	
	OC100A	4	NC125A	4	OC125A	8	NC125A	6	OC175A	8	OC175A	4
10. Lock Washer	7207-010A	4	7207-008A	4	7207-025A	8	7207-008A	6	7207-025A	8	7207-025A	4

SINGLE STAGE	ALL MODELS 90/91, 290/291		ALL MODELS 490/491		ALL MODELS 491-3		ALL MODELS 690/691		ALL MODELS 690-4/691-4	
	1983-X		1985-X		1983-X1		1987-X1		1985-X1	
Piston Assembly No.	3" (7.62 cm)		4" (10.16 cm)		3" (7.62 cm)		4.5" (11.43 cm)		4" (10.16 cm)	
Piston Diameter										
Ref. No. Part Name	Part No.	Qty./Piston	Part No.	Qty./Piston	Part No.	Qty./Piston	Part No.	Qty./Piston	Part No.	Qty./Piston
1. Head, Iron	1983	1	1985	1	1983	1	1987	1	1985	1
2. Piston Platform	1984	1	1986	1	1984-1	1	1986	1	1986	1
3. Locknut	1482	1	1482	1	1482	1	1482	1	1482	1
4. Lock Pin	1483	1	1483	1	1483	1	1483	1	1483	1
5. Thrust Washer	1527	1	1527	1	1527	1	None	-	None	-
6. Shim Washer, Thick	1528	As	1528	As	1528	As	1735	As	1735	As
Shim Washer, Thin	1528-1	Req.	1528-1	Req.	1528-1	Req.	1735-1	Req.	1735-1	Req.
7. Piston Ring	1772	3	1773	3	1772	3	1739	3	1773	3
8. Ring Expander	1775	3	1776	3	1775	3	1740	3	1776	3
9. Screw, Soc. Hd.	7002-010		7002-025		7002-010		7002-025		7002-025	
	OC100A	4	OC125A	8	OC100A	4	OC125A	8	OC125A	8
10. Lock Washer	7207-010A	4	7207-025A	8	7207-010A	4	7207-025A	8	7207-025A	8

PISTON CLEARANCE (COLD)

MODEL	*X* INCHES (MILLIMETER)	
	MINIMUM	MAXIMUM
91, 191, 291, 491 (b)	.020 (.51)	.044 (1.12)
A91, D91, A191, D191, A291, D291, WA391, WD391, D491, 491-3 (b)	.025 (.64)	.049 (1.24)
T91, T191, T291, FT191, FT291	.030 (.76)	.054 (1.35)
T690-4, WT690-4, WT690, WT590	.100 (2.54)	.112 (2.84)
T691	.115 (2.92)	.127 (3.22)
190, 390, 490, 491 (a)	.000 (.00)	.024 (.61)
A190, D190, A390, D390, A490, D490, D491, D490-3, D491-3	.005 (.13)	.029 (.74)
T491, T490-3	.010 (.25)	.034 (.86)
WT391, T491, T491-3 (b)	.030 (.76)	.054 (1.36)
590, 690, W690	.000 (.00)	.012 (.30)
691	.015 (.38)	.027 (.68)
A590, WA590, A690, WA690	.045 (1.14)	.057 (1.45)
D590, WD590, D690, D690-4, WD690, WD690-4	.050 (1.27)	.062 (1.57)
D691	.065 (1.65)	.077 (1.95)

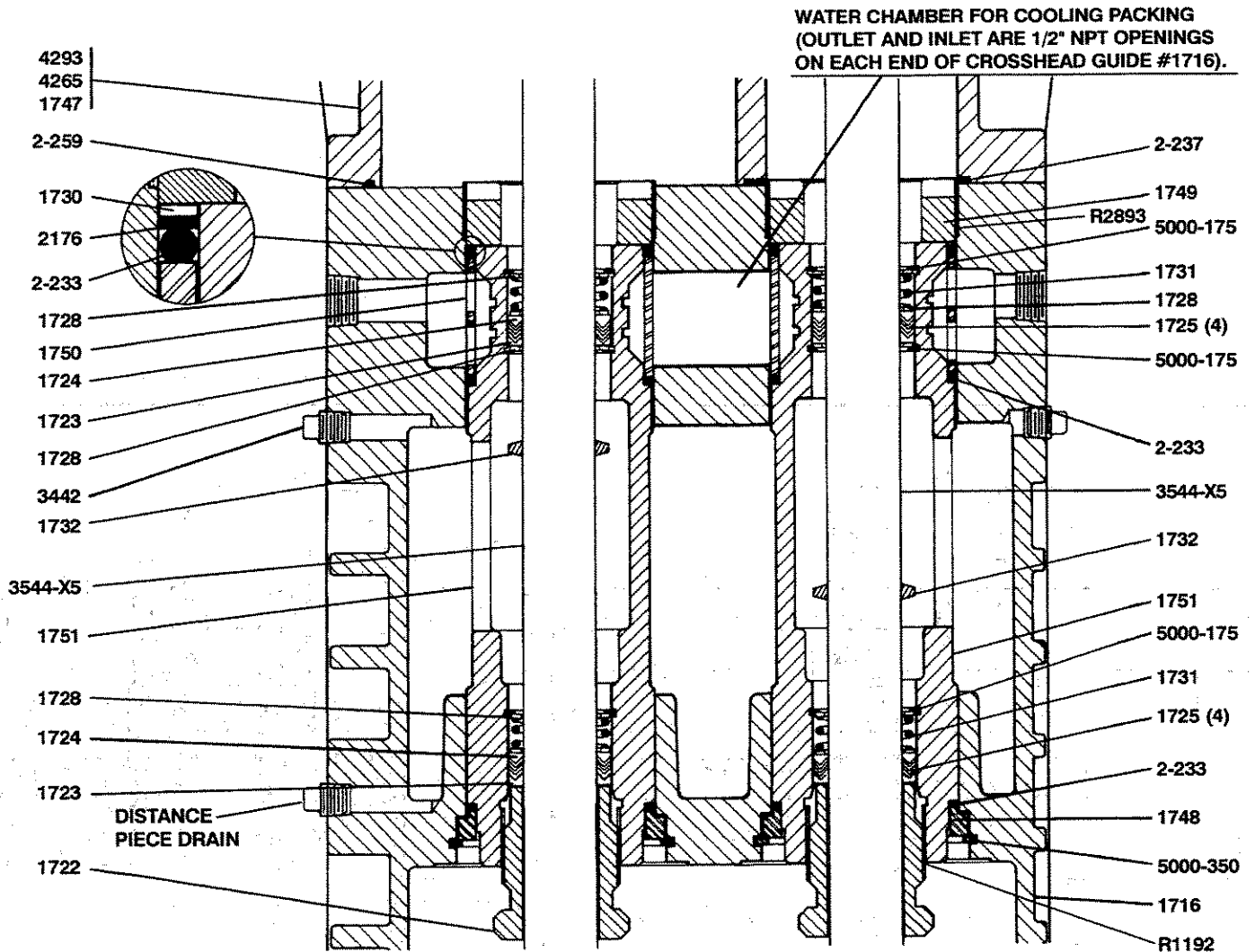
NOTES:

- (a) For 491 Compressor with flat gasket.
- (b) For 491 Compressor with head o-rings.

CAUTION: ALWAYS RELIEVE PRESSURE IN THE UNITS BEFORE ATTEMPTING ANY REPAIRS.

DISTANCE PIECE DETAILS
 MODELS D590A, WD590A, FD591, WFD591 COMPRESSORS
 M-STYLE CRANKCASE - ALL SPECIFICATIONS

SERVICE	MANUAL
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SUPERSEDES	E282D



PART NO.	PART NAME
1716	CROSSHEAD GUIDE
1722	ADJUSTING SCREW
1723	FEMALE PACKING RING
1724	MALE PACKING RING
1725	PACKING RING
1728	PACKING WASHER
1730	CAGE WASHER
1731	PACKING SPRING
1732	OIL DEFLECTOR RING
1747	CYLINDER (D/WD590 ONLY)
1748	CARTRIDGE PLATE
1749	CARTRIDGE HOLDDOWN SCREW
1750	PACKING BOX CAGE
1751	PACKING BOX CARTRIDGE
2176	BACK-UP RING (TFE)
3442	PIPE PLUG, 1/4" NPT
5000-175	RETAINER RING
5000-350	RETAINER RING
2-233	O-RING
2-237	O-RING
2-259	O-RING
4293	CYL FD591
4265	CYL WFD591

ASSEMBLY NO.	ASSEMBLY NAME
1716-X	CROSSHEAD GUIDE ASSEMBLY WITH 1716, 1748 (2), 5000-350 (2)
3544-X5	CROSSHEAD-PISTON ROD ASSEMBLY - STD.
*3544-X6	CROSSHEAD-PISTON ROD ASSEMBLY - CHROME OXIDE
1725-2X	PACKING SET WITH 1723, 1724, 1725, (4), 1728, 1731
*1725-2X2	PACKING SET - ALLOY/K-RING

*OPTIONAL

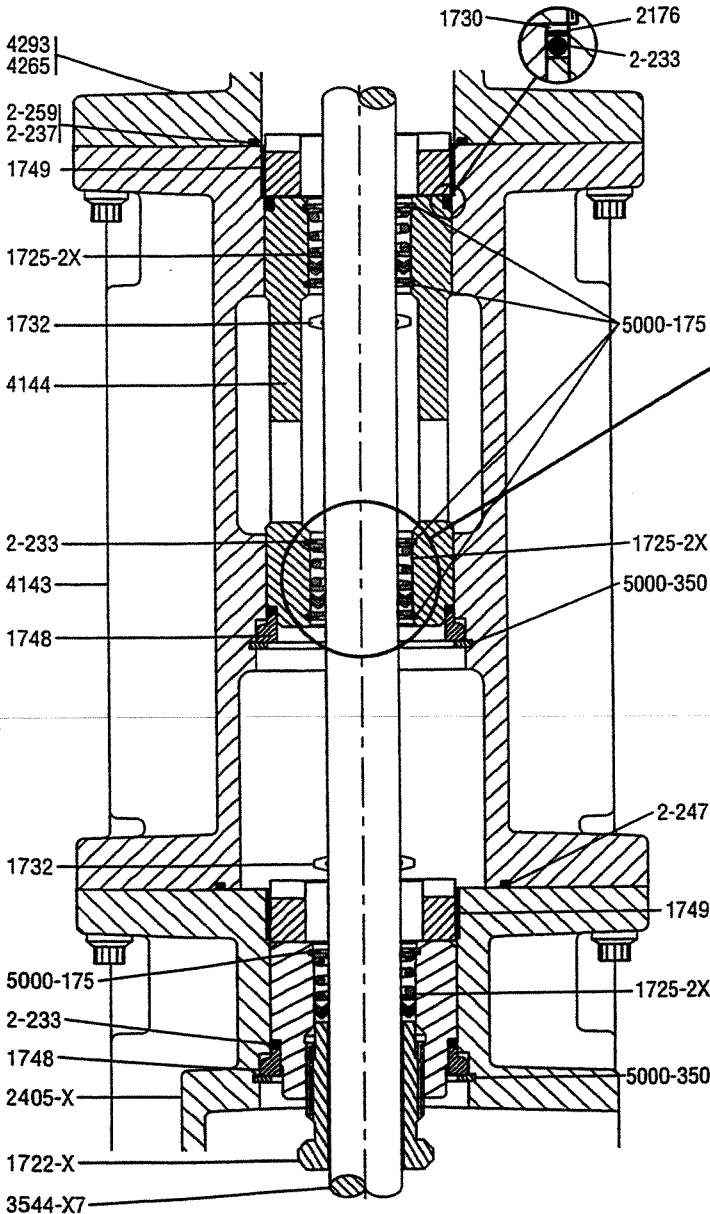
USE 3905 CONE FOR PACKING INSTALLATION.
 FOR O-RING MATERIAL CODING SEE PAGE A500.
 SEE PAGE E270 FOR DESCRIPTION AND APPLICATION OF
 DISTANCE PIECE ARRANGEMENTS.

**CAUTION: ALWAYS RELIEVE PRESSURE IN THE UNIT
 BEFORE ATTEMPTING ANY REPAIRS.**

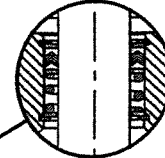
**DISTANCE PIECE DETAILS
ALL MODELS T591 COMPRESSORS
ALL SPECIFICATIONS**

PACKING SPEC. G

PACKING SPEC. H



Invert middle packing set only for packing specification 'H' as shown below.



PART NO.	PART NAME
1722	ADJUSTING SCREW WITH LOCKING DEVICE
1723	FEMALE PACKING RING
1724	MALE PACKING RING
1725	PACKING RING
1728	PACKING WASHER
1730	CAGE WASHER
1731	PACKING SPRING
1732	OIL DEFLECTOR RING
1748	CARTRIDGE PLATE
1749	CARTRIDGE HOLDDOWN SCREW
1750	PACKING BOX CAGE
1751	PACKING BOX CARTRIDGE
2176	BACKUP RING (TFE)
2405-X	CROSSHEAD GUIDE
2893	LOCKING DEVICE
4143	DISTANCE PIECE
4144	PACKING CARTRIDGE
4265	CYLINDER - WFD591 (WATER COOLED)
4293	CYLINDER - FD151
5000-175	RETAINER RING
5000-350	RETAINER RING
2-233	O-RING
2-237	O-RING - STAGE 2
2-259	O-RING - STAGE 1

ASSEMBLY NUMBER	ASSEMBLY NAME
1725-2X	PACKING SET WITH 1723, 1724, 1725 (4), 1728, 1731
1725-2X2	PACKING SET WITH K-RING SPACERS (OPTIONAL)
2405-X	CROSSHEAD-GUIDE ASSEMBLY WITH 2405, 1748 (2), 5000-350 (2)
3544-X7	CROSSHEAD PISTON ROD ASSEMBLY
3544-X8	CROSSHEAD PISTON ROD ASSEMBLY - CHROME OXIDE (OPTIONAL)

PACKING SPEC. IDENTIFICATION:
 Example: Model No. T691 **G** M4
 WFT691 **H** M9
 Packing Spec. _____

For o-ring material coding see page A500.

Note: Models built with coating option MC1002 use some coated parts. Coated parts must be specified with a "C" at the end of the part number (Example 3713C).

Assembly Note: Use packing installation cone *3905 when installing packing cartridge on piston rod.

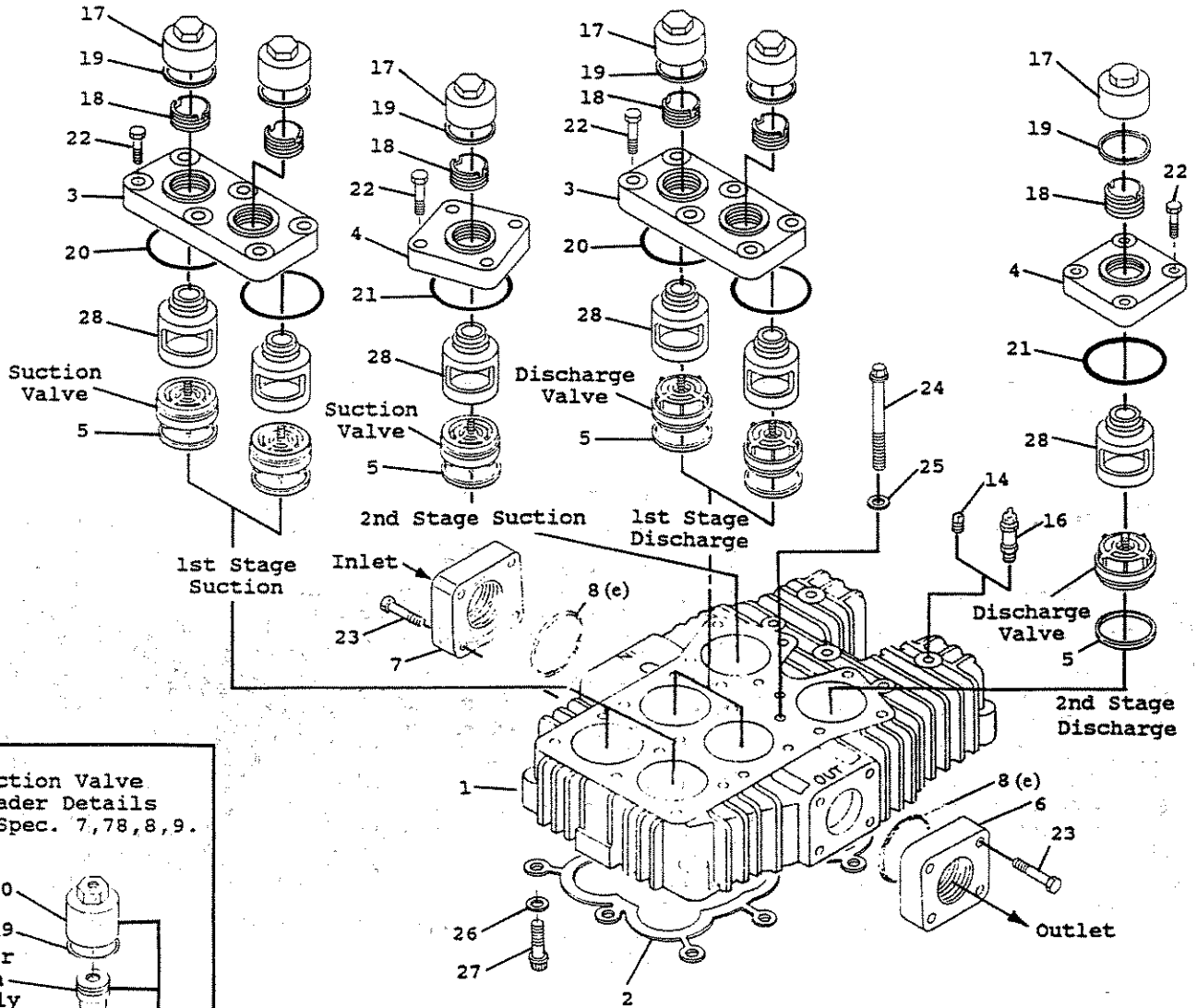
HEAD ASSEMBLY DETAILS

MODEL 590, W590, WA590, D590, WD590
 S/N MR50653 AND LATER
 ALL SPECIFICATIONS

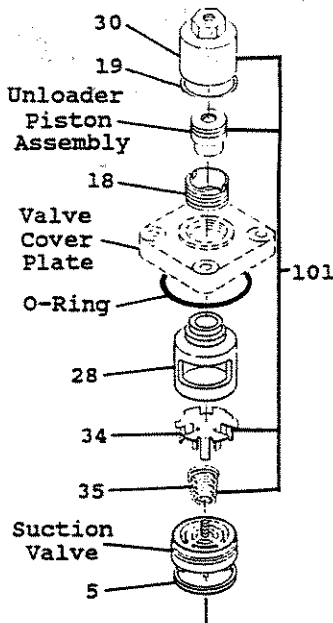
SERVICE MANUAL
 PAGE E326E

November 1991
 Supersedes E326D

Head Assembly, Valve Spec. 4 Shown:

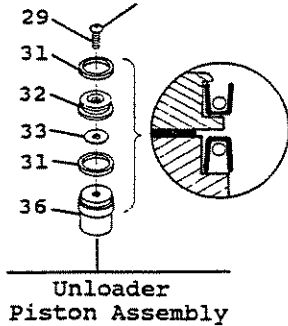


Suction Valve Unloader Details
 Valve Spec. 7,78,8,9.

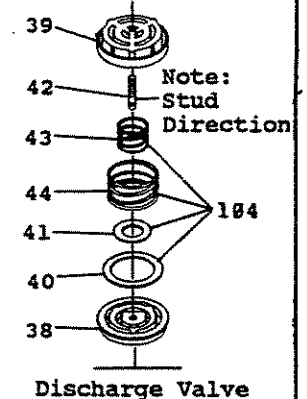
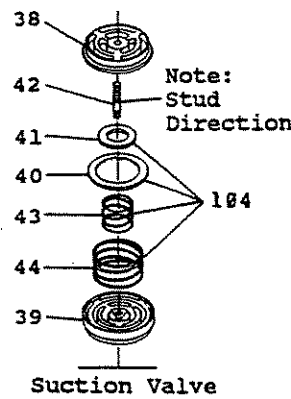


Unloader Piston Details

Apply Loctite #290 when assembling



Valve Details



NOTE: When ordering parts use
"Part No." not "Ref. No."

REF. PART NO. NO.	PART NAME
1. 4003	Head (590,A590,D590 Only)
2566	Head (W590,WA590,WD590 Only) (Not Shown)
(a) 2. 1746	Head Gasket
(a,c) 1746-1	Head Gasket (Grafoil)
3. 1763	Valve Cover Plate
4. 1764	Valve Cover Plate
5. 2114	Valve Gasket, Aluminum
(a) 2114-1	Valve Gasket, Copper
(a) 2114-2	Valve Gasket, Iron
6. 2144-1.5	Discharge Flange, 1-1/2"NPT
(a) 2144-1.5S	Discharge Flange, 1-1/2" Weld
7. 2144-2	Suction Flange, 2" NPT
(a) 2144-2S	Suction Flange, 2" Weld
(e) 8. 2-231	O-Ring
9. 2201	Unloader Piston, Steel
10. —	Omitted
11. —	Omitted
12. —	Omitted
13. —	Omitted
14. 3442	Plug, 1/4" NPT
15. —	Omitted
16. 2415	Interstage Relief Valve (A590, WA590 Only)
17. 2714-1	Valve Cap(Grooved for O-Ring)
18. 2715	Holddown Screw
(b) 19. 2-031	O-Ring, Valve Cap
(b) 20. 2-151	O-Ring, Cover Plate
(b) 21. 2-235	O-Ring, Cover Plate
22. 7001-043	
NC125A	Bolt,Hex Hd 7/16-14 x 1-1/4
23. 7001-043	
NC150A	Bolt,Hex Hd 7/16-14 x 1-1/2
(c) 24. 2136	Center Head Bolt
(c) 25. 1625	Center Head Bolt Gasket, Steel
(a,c) 1625-1	Center Head Bolt Gasket, Copper
26. 7005-050	
NC150A	Bolt, 1/2-13 x 1-1/2" Ferry Hd
27. 7206-050A	Regular Lockwasher - 1/2
28. 2797	Valve Cage
29. 1910	Bolt, 1/4-20 x 1/2" Soc Button Hd
30. 2598-1	Unloader Cap
31. 2619-X	Piston Seal Assembly
32. 2857	Piston Cap
33. 2858	Unloader Piston Cap Gasket
34. 4032	Unloader Actuator
35. 4033	Unloader Spring
36. 2710	Unloader Piston
37. —	Omitted
38. 3856	Valve Seat
39. 3857	Valve Bumper
40. 3871	Outer Valve Plate
41. 3872	Inner Valve Plate
42. 3920	Valve Stud
43. 3929	Inner Valve Spring - Heavy
44. 3928	Outer Valve Spring - Heavy

REF. ASSY. NO. NO.	ASSEMBLY NAME
101. 4032-X	Suction Valve Unloader Assembly w/ 29,30,31,32,33,34,35,36.
102. 3856-X	Suction Valve Assembly w/ 5,38,39,40,41,42,43,44.
(a) 3856-X1	Same as above but with Copper Gaskets.
(a) 3856-X2	Same as above but with Iron-Lead Gaskets.
103. 3857-X	Discharge Valve Assembly w/ 5,38,39,40,41,42,43,44.
(a) 3857-X1	Same as above but with Copper Gaskets.
(a) 3857-X2	Same as above but with Iron-Lead Gaskets.
104. 3146-X1	Valve Repair Kit (Suction or Discharge)

IDENTIFICATION OF VALVE UNLOADER SPEC.

Example: Model No. 590M 4 FBA
590K 78 FBAB
590L 9 FBA

Valve Unloader Spec.

Spec.	Head Assy No.	Model No.
4	4003-X	590, D590
4	2566-X	W590,WD590.
4	4003-X3	MODEL A590.
4	2566-X3	MODEL WA590.
7,78,8,9	4003-X1	590,D590.
7,78,8,9	2566-X	W590,WD590.
7,78,8,9	4003-X2	MODEL A590.
7,78,8,9	2566-X2	MODEL WA590.

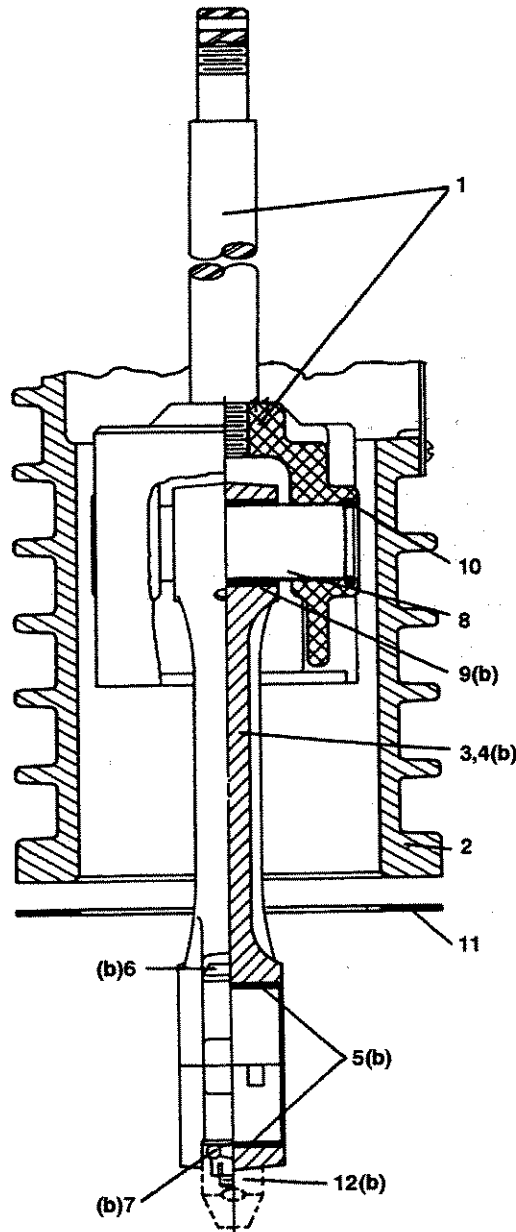
NOTES:

- (a) Optional.
- (b) For O-Ring Material Coding see Page A500.
- (c) Not Included in Head Assembly.
- (d) Effective S/N JX47791 This Head (4003) is interchangeable with the old head (1725), but a new intercooler must be used (4011-1 Steel or 4011-2 Copper.
- (e) S/N NQ51455 and later. Earlier models use Gasket #2177.

CAUTION: Always Relieve Pressure In The Unit Before Attempting Any Repairs.

CONNECTING ROD AND CROSSHEAD ASSEMBLY DETAILS
ALL MODELS
ALL SPECIFICATIONS

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PAGE	E350J
MAY	1997
SUPERSEDES	E350I



REFER TO PARTS LIST
ON BACK SIDE OF
THIS SHEET.

**CAUTION: ALWAYS RELIEVE PRESSURE IN THE
UNIT BEFORE ATTEMPTING ANY REPAIRS.**

CONNECTING ROD AND CROSSHEAD ASSEMBLY DETAILS
ALL MODELS
ALL SPECIFICATIONS

MODEL NUMBER	91	A91 D91	191	191	A191 D191	T191	291	A291 D291	T291	391 W391 491	A391 WA391 D391 WD391 A491 D491-3 D491	T391 T491-3 T491	A590 WA590 D590 WD590 A691 WA690 D691 D691-4 WD690 WD690-4	SPEC. K,P ONLY	SPEC. M ONLY	SPEC. M ONLY	590 W590 W690 691	A590 WA590 D590 WD590 691	SPEC. K,P ONLY	SPEC. M ONLY	590 W590 W690 691	D791 DR091
NO.	DESCRIPTION																					
1.	1132-X2	1132-X3	1132-X7 1132-X9 (f)	1132-X1 (g) 1132-X2	1132-X3 1132-X4	1132-X8 1132-X7 1132-X9 1132-X10 (f)(g)	1132-X2 (f)	1132-X3 1132-X5	1132-X7 1132-X9 (f)	1384-X 1384-X4 (f)	1384-X1 1384-X4 (f)	1384-X2 1384-X3 (f)	1717-X	1717-X1	3544-X5	3544-X4	3544-X3	1717-X	1717-X1	3544-X5	3544-X4	3544-X3
2.	2240	2240	4940-X	4383	4383	4383-X	4393	4383-X	4383-X	2765(h) (366(i))	2773-X	2773-X	1716-X	2405-X	2405-X	2405-X	2405-1	1716-X	2405-X	1716-X	2405-X	2405-1
3.	1889-1X	1889-1X	1889-1X	1889-X	1889-X	1889-X	1889-X	1889-X	1889-X	1490-X	1490-X	1490-X	1720-X	1720-X	3785-X1	3785-X1	3785-X	1720-X	1720-X	3785-X1	3785-X1	3785-X
4.	1889-1	1889-1	1889-1	1889	1889	1889	1889	1889	1889	1490	1490	1490	1720	1720	3785	3785	3785	1720	1720	3785	3785	3785
5.	1367	1367	1367	1367	1367	1367	1367	1367	1367	1491	1491	1491	1719	1719	3542	3542	3542	1719	1719	3542	3542	3542
6.	1599	1599	1599	1599	1599	1599	1599	1599	1599	1492	1492	1492	1726	1726	1726	1726	1726	1726	1726	1726	1726	1726
7.	1600(c)	1600(c)	1600(c)	1600(c)	1600(c)	1600	1600(c)	1600(c)	1600	1493(g)	1493(g)	1493(d)	1727(e)	1727(e)	1727(e)	1727(e)	1727(e)	1727(e)	1727(e)	1727(e)	1727(e)	1727(e)
8.	2505	2505	2505	2505	2505	2505	2505	2505	2505	1496	1496	1496	1718	1718	3540	3540	3540	1718	1718	3540	3540	3540
9.	1846-X(a)	1846-X(a)	1846-X(a)	1846-X(a)	1846-X(a)	1846-X(a)	1846-X(a)	1846-X(a)	1846-X(a)	1495-X(a)	1495-X(a)	1495-X(a)	1495-X(a)	1495-X(a)	3541-X(k)	3541-X(k)	3541-X(k)	1495-X(a)	1495-X(a)	3541-X(k)	3541-X(k)	3541-X(k)
10.	1498	1498	1498	1498	1498	1498	1498	1498	1498	1498	1498	1498	1498	1498	3590	3590	3590	1498	1498	3590	3590	3590
11.	2526	2526	2526	2702	2702	2702	2702	2702	2702	1489	1489	1489	1761	1761	1761	1761	1761	1761	1761	1761	1761	1761
12.	2011	2011	2011	2011	2011	2011	2011	2011	2011	1761	1761	1761	1761	1761	1761	1761	1761	1761	1761	1761	1761	1761

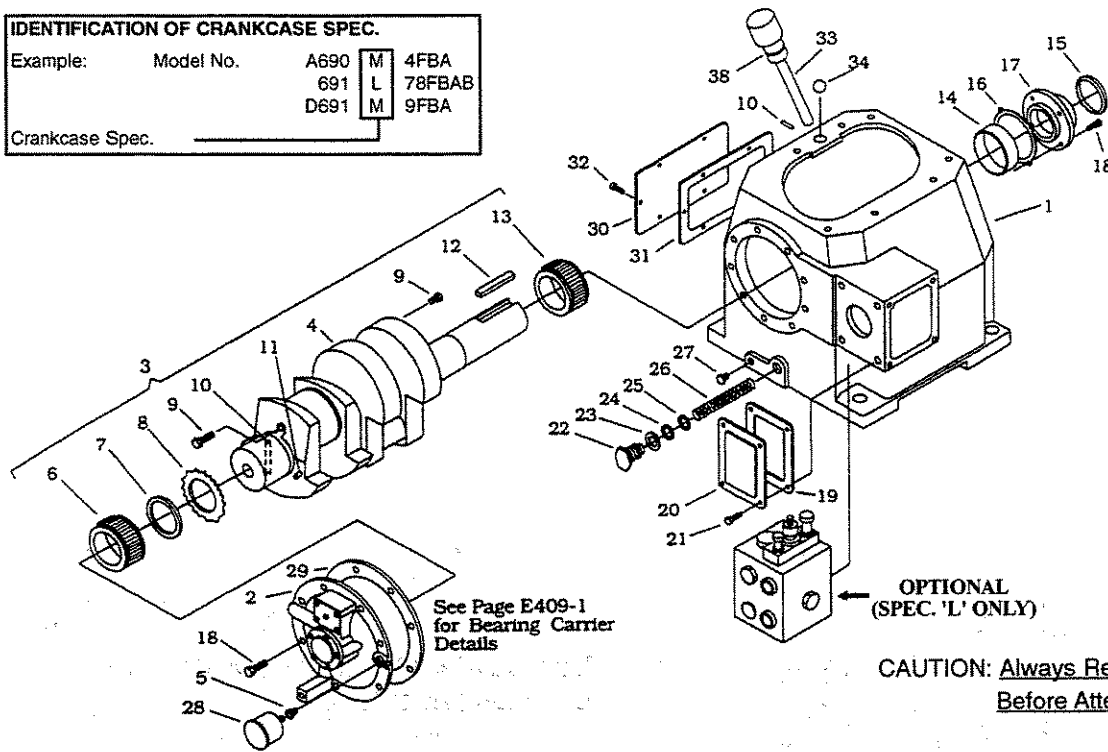
NOTES:

- (a) Must be rebored after replacing (0.8754/0.8751 Dia.)
 - (b) Included with Connecting Rod Assembly
 - (c) Torque Connecting Rod Nut to 28 ft.lbs.
 - (d) Torque Connecting Rod Nut to 30 ft.lbs.
 - (e) Torque Connecting Rod Nut to 40 ft.lbs.
 - (f) Optional Chrome Oxide Piston Rods Only
 - (g) Second Stage (Smaller Piston)
 - (h) S/N XC30633 and Later
 - (i) Prior to S/N XC30633
 - (k) Must be rebored after replacing (1.1256/1.1252 Dia.)
- Never attempt to separate the Piston Rod and Crosshead. When repair becomes necessary the entire Crosshead Assembly must be replaced.

CRANKCASE DETAILS
ALL MODELS 590, 591, 690, 691, D791, D891
CRANKCASE SPECIFICATION: M
CRANKCASE SPECIFICATION: L (S/N KR48400 AND LATER)

SERVICE MANUAL
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 AUGUST 1999
 SUPERSEDES E408-1B

IDENTIFICATION OF CRANKCASE SPEC.			
Example:	Model No.	A690	M 4FBA
		691	L 78FBAB
		D691	M 9FBA
Crankcase Spec. _____			



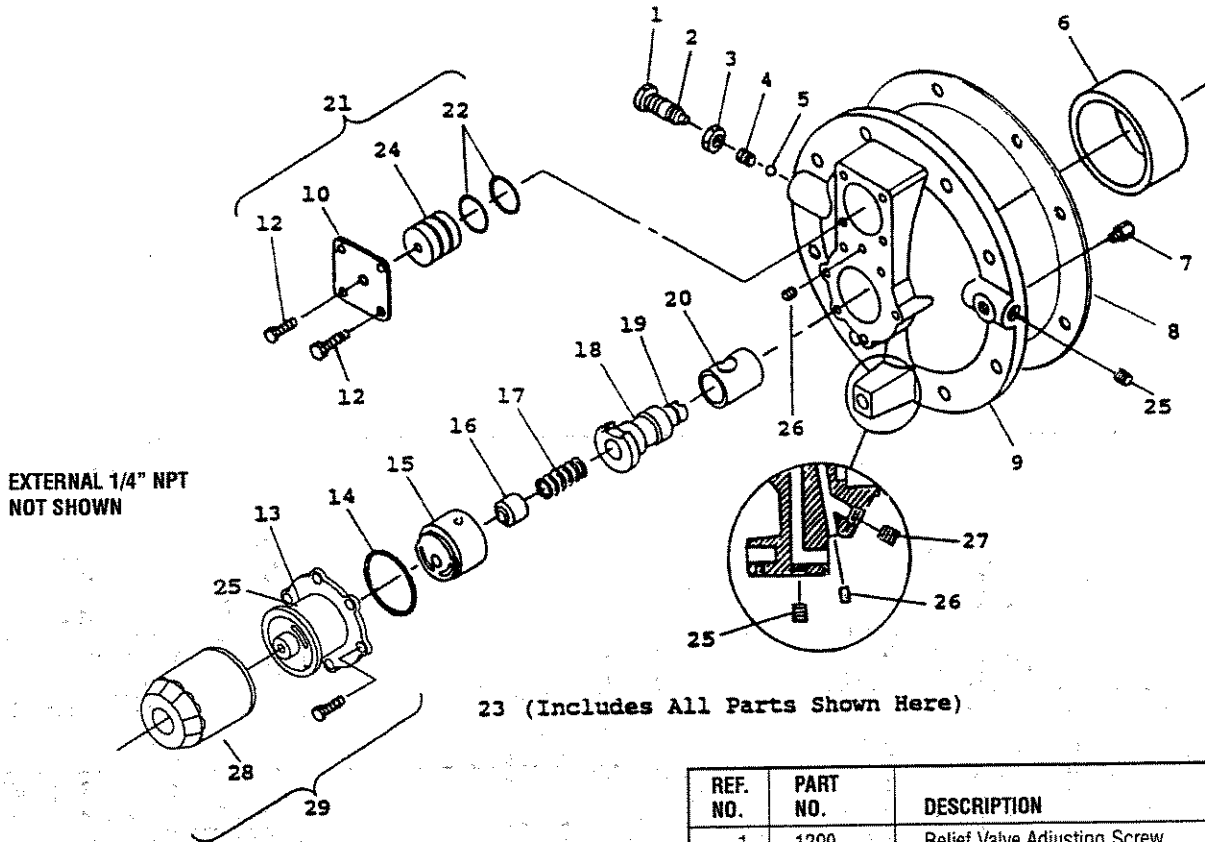
CAUTION: Always Relieve Pressure In The Unit Before Attempting Any Repairs.

REF. NO.	PART NO.	DESCRIPTION
1	3221	Crankcase
2	3220-2X	Bearing Carrier Assembly
3	3786-X1	Crankshaft Assembly
4	3786	Crankshaft
5	1044	Bushing, 1/8 x 1/4 NPT
6	1737	Bearing Cone
7	3638	Spacer
8	3635	Drive Sprocket
9	1284	Crankshaft Orifice
10	2135	Drive Pin
11	2933	Link Pin
12	3503	Flywheel Key
13	3580	Bearing Cone
14	3579	Bearing Cup
15	3526	Oil Seal
16	3589	Bearing Adjustment Shim (.005")
	2589-1	Bearing Adjustment Shim (.007")
	2589-2	Bearing Adjustment Shim (.020")
17	3539	Bearing Cover
18	7001-037 NC100A	Bolt, 3/8 - 16 x 1" Hex Head Gr 5
19	3874	Gasket, Access Cover
20	3875	Access Cover
21	7003-025 NC037E	Screw, 1/4 - 20 x 3/8"
22	1280	Filter Screw
23	1281	Gasket, Filter
24	2-116A	O-ring
25	1276	Washer
26	1275	Oil Filter Screen

REF. NO.	PART NO.	DESCRIPTION
27	3443	Pipe Plug, 1/2" NPT Steel
28	1302	Oil Pressure Gauge
29	2131	Gasket, Bearing Carrier
30	2122	Inspection Cover
31	2123	Gasket, Inspection Cover
32	7001-031 NC075A	Bolt, 5/16 - 18 x 3/4" Hex Head
33	3225-X1	Oil Bayonet Assembly (w/ O-ring)
34	2126	Breather Ball (Not Used on A590, WA590, A690, WA690)
35	—	—
36	1885-1	Blank Flange
37	2010	Flange Gasket
38	2-210A	O-ring
(a) —	3852-X	Flywheel Assembly (D791, D891 Only)
(a) —	1762-X	Flywheel Assembly (590/690 Models Only)
(a) —	3852	Flywheel 21.2", 5V, 5 Groove
(a) —	3918	Flywheel Hub Type J2 - 1/8" Bore (D791, D891 Only)
(a) —	1762	Flywheel 19 - 1/2" AB, 4 Groove
(a) —	3918	Flywheel Hub Type E 2 - 1/8" Bore (590 / 690 Models Only)
(a) —	3221-X1	Crankcase Assembly (M3, 4, 8, 9) w/o Lub.
(a) —	3221-X2	Crankcase Assembly (M7, 78) w/o Lub.
(a) —	3221-X3	Crankcase Assembly (L3, 4, 8, 9) w/o Lub.
(a) —	3221-X4	Crankcase Assembly (L7, 78) w/o Lub.

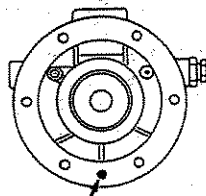
NOTES:
 (a) Not Shown

BEARING CARRIER DETAILS
ALL MODELS 590, 591, 690, 691, D791, D891
CRANKCASE SPECIFICATION: M
CRANKCASE SPECIFICATION: L (S/N KR48400 AND LATER)



23 (Includes All Parts Shown Here)

Inside of
Bearing Carrier



Oil Passage Hole

IMPORTANT

Line up hole in gasket with oil passage hole.

PUMP COVER OIL/FILTER ADAPTER



Pumpsides of adapter shown for proper orientation of cover and location of pump cover pin.

REF. NO.	PART NO.	DESCRIPTION
1	1290	Relief Valve Adjusting Screw
2	2-011A	O-ring
3	1291	Adjusting Screw Locknut
4	1292	Relief Valve Spring
5	1293	Relief Valve Ball
6	1736	Bearing Cup
7	2961-X	Air Release Valve Assembly
8	2131	Bearing Carrier Gasket
9	3220-2	Bearing Carrier
10	1515	Closure Cap
11	2798	Pump Cover Pin (Included w/ 4222-X)
12	7001-025 NC050A	Bolt, 1/4 - 20 x 1/2" Hex Head
(b) 13	4222-X	Oil Filter Adapter Assembly (w/ pin)
14	2-228A	O-ring
(b) 15	2849-1X	Oil Pump Assembly
16	2851	Spring Guide
17	2852	Oil Pump Spring
18	3219	Pump Shaft Adapter
19	2-112A	O-ring
(a) 20	2805-X	Pump Shaft Bushing
21	1515-X	Closure Cap Assembly
22	2-118A	O-ring
23	3220-2X	Bearing Carrier Assembly
24	1516	Closure Body
25	3289	Pipe Plug, 1/4 NPT Fl. Seal
26	1629	Pipe Plug, 1/16 NPT Fl. Seal
27	2590	Pipe Plug, 1/8 NPT Fl. Seal
28	4225	Filter
29	4222-X	Filter Adapter Assembly

NOTES:

- (a) Must be rebores and honed after replacing. (0.876"/0.875" Diameter)
- (b) Caution: To avoid damage during assembly, refer to Installation Instruction Manual IE400.