

## 1. INTRODUCTION

These instructions describe the procedure for rebuilding Ocean Air Feed Module 2063440-1, -2, and -3 using Rebuild Kit 2217901-1, -2, and -3.

**i** **NOTE**  
The following procedure is performed with the air feed module removed from the applicator. For instructions on proper removal or installation of the air feed module from the applicator or for applicator set-up, please see the appropriate instruction sheet. Refer to Instruction Sheet 408-10389 for Ocean Side Feed applicators. Refer to Instruction Sheet 408-10390 for Ocean End Feed applicators.

**i** **NOTE**  
Refer to assembly drawing 2063440 for specific part numbers.

## 2. REBUILD PROCEDURE

Rebuild as follows:

1. Remove the end cap and cover plate from the air feed. Refer to Figure 1 and Figure 2.



Figure 1



Figure 2

2. Remove two set screws holding the front and rear shaft support bushings. See Figure 3 and Figure 4.

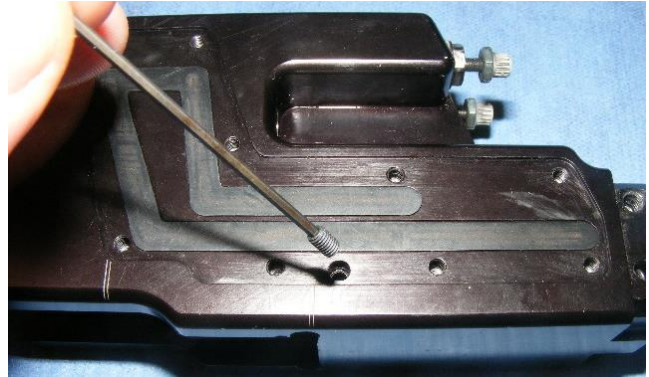


Figure 3

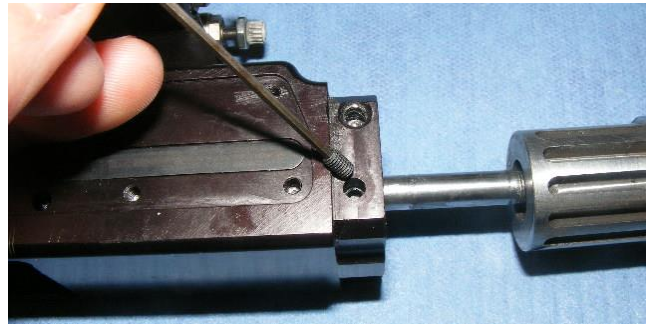


Figure 4

3. Remove the button head screw from the front end of the shaft assembly. See Figure 5.

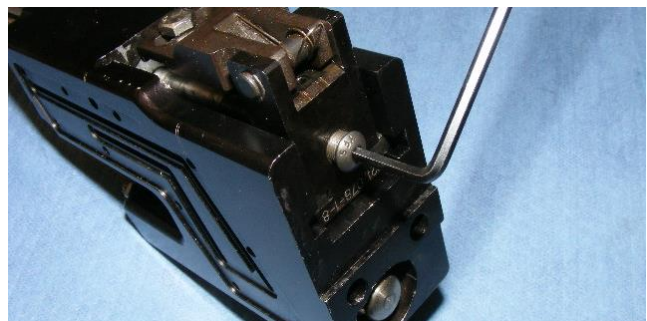


Figure 5

4. Remove the feed arm assembly from the piston shaft by rotating the backstroke adjustment knob until the feed arm assembly comes completely off the shaft. See Figure 6.

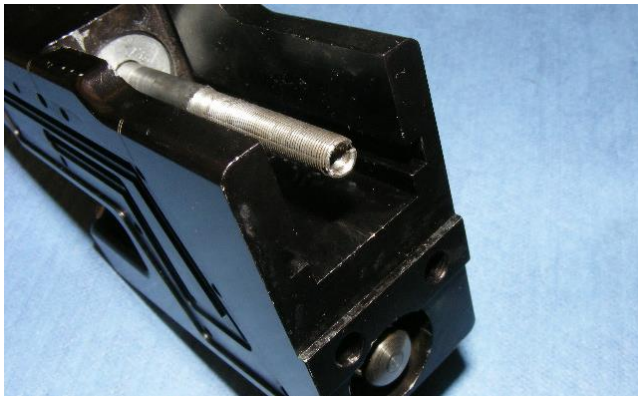


Figure 6

5. Remove the backstroke adjustment knob by removing the mounting screw. See Figure 7



Figure 7

6. Lightly re-install the button head screw (removed in Step 3) into the shaft end.
7. Using a retaining ring tool (recommended tool – Craftsman Pliers 47411) remove the rear ring from its groove. A new retaining ring is provided in the rebuild kit. Refer to Figure 8.

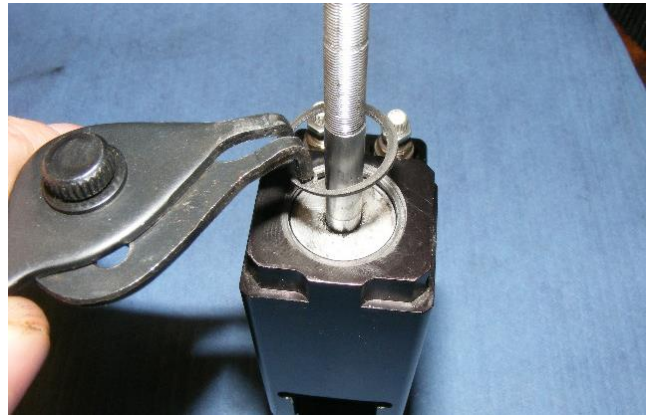


Figure 8

8. Remove the piston shaft assembly from the housing by firmly holding the adjust wheel and pulling straight out. Refer to Figure 9.



Figure 9

9. Remove the shaft support bushings from the shaft.
10. Remove the outer and inner O-rings from the end caps using a pick tool or similar. See Figure 10.

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Figure 10

11. Clean all parts to remove any foreign contaminants as the new seals can easily be cut with dirt or debris.
12. Inspect the shaft and shaft support bushings for gouging or scrapes. Replace if gouges or scrapes are severe as poor sealing surfaces will greatly reduce seal life. Inspect the housing bore. If the bore is scraped or gouged the unit is not re-buildable and should be replaced with a new assembly.



**CAUTION**

*Any sealing surfaces that are scraped or gouged must be replaced or significant reduction in performance and seal life will result.*

13. Install the new O-ring seals in the end caps after generously applying a quality O-ring lubricant (Parker O-ring Lubricant 884-4 is recommended). Refer to Figure 10.



**NOTE**

*Make sure O-ring lube is applied to the inner seal groove before the O-ring is installed as this ensures lubricant will be present in the seal area through many cycles.*

14. Prepare the cleaned piston shaft for O-ring installation by generously applying O-ring lubricant to the O-ring groove.
15. Install the O-ring on the shaft.
16. Generously coat the sealing surfaces of the cleaned piston shaft with O-ring lubricant.
17. Slide the shaft support bushing with new seals onto the shaft. Refer to Figure 11.



Figure 11

18. Prepare the cleaned air feed housing bore by applying O-ring lubricant.
19. Carefully re-install the piston shaft assembly by guiding the shaft and shaft support bushings into the bore. Push the assembly straight down using a firm and steady pressure until the assembly stops against the front retaining ring. See Figure 12.



Figure 12

20. Re-install the set screw to secure the shaft support bushing. While holding the shaft assembly against the retaining ring, lightly

turn the screw until it stops against the bushing. Now tighten an additional 1/4 to 1/2 turn to secure the bushing.

21. Re-install the rear retaining ring in the housing ring groove.
22. Pull the shaft assembly to the rear against the retaining ring. Repeat Step 20.
23. Re-install the backstroke adjustment knob and mounting screw. See Figure 13. Note: The adjustment knob is used to rotate the entire shaft assembly to adjust the feed arm assembly. The mounting bolt must be tight enough to prevent the Adjustment Knob from turning relative to the Piston Shaft. A screwdriver slot is provided in the front of the shaft to hold the shaft stationary while tightening the mounting screw. See Figure 14.



Figure 13



Figure 14

24. Re-install the remaining components in the reverse order of disassembly.
25. Re-attach the air feed to the applicator and follow the applicator instruction sheet to properly set-up the feed positions.

### 3. REVISION SUMMARY

- Added lubricant number in Paragraph 2.13