

Assembly/Disassembly QF20k Pump Chamber/Elastomers/Shaft-Bearing-Cap-Unit incl. Tool List

1) Assembly/disassembly pump chamber [QF20CU]				
No.	Work Step	Component	Pos.-No.	Tool
1 / 5	Unscrew/tighten up the hexagon socket head cap screw	PQ20A	1.18	Hex tip screw driver (4mm)
2 / 4	Take out/assemble the bearing box cover	PQ20A	1.5	
3 / 3	Unscrew/tighten up the hexagon socket head cap screw	QF20CU	2.14	Hex tip screw driver (6mm)
4 / 2	Unscrew/tighten up the hexagon socket head cap screw	QF20CU	2.12	Hex tip screw driver (8mm)
5 / 1	Assemble/take out the whole component QF20CU			

2) Replacing elastomers				
No.	Work Step	Component	Pos.-No.	Tool
1 / 14	Disassemble/assemble pump chamber, as described at 1)			
2 / 13	Turn the pump-chamber that the clamp-ring is upwards	QF20CU		
3 / 12	Unscrew/tighten up the hexagon socket head cap screw	QF20CU	2.10	Hex tip screw driver (8mm)
4 / 11	Unscrew/tighten up the hexagon socket head cap screw	QF20CU	2.11	Hex tip screw driver (6mm)
5 / 10	Take out/assemble clamp-ring, diaphragm-housing-cover, diaphragms	QF20CU	2.6, 2.3, 2.9.2	
6 / 9	Change diaphragms and unscrew/tighten up the diaphragm-supports. (The diaphragm-supports are made of a core-part and an outside-part. The core-part gets tightened up on the diaphragm and the outside-part gets pressed on the core-part by the help of the clamp-ring (2.6))	QF20CU	2.9.2, 2.5	
7 / 8	Take out/assemble the valve-plate	QF20CU	2.2	
8 / 7	Unscrew/tighten up the hexagon socket head cap screw	QF20CU	2.13	Hex tip screw driver (6mm)
9 / 6	Take out/assemble the inlet-valve-plate	QF20CU	2.4	
10 / 5	Change the inlet-/outlet-valves and the o-rings of the valve-plate by unscrewing/tightening up the valve-screws.	QF20CU	2.9.1, 2.9.3.1, 2.8	slot screwdriver
11 / 4	Change the o-rings of the valve-plate	QF20CU	2.9.3.5	
12 / 3	Change the o-rings of the pump-housing	QF20CU	2.9.3.2, 2.9.3.3	
13 / 2	Unscrew/tighten up the hexagon socket head cap screw	QF20CU	3.2	Hex tip screw driver (6mm)
14 / 1	change the o-rings of the connectors	QF20CU	2.9.3.4	

3) Replacing shaft-bearing-cap-unit				
No.	Work Step	Component	Pos.-No.	Tool
1 / 10	Disassemble/assemble pump chamber, as described at 1.)			
2 / 9	Unscrew/tighten the raised countersunk screw	PQ20A	5.2	Phillips-tip screwdriver
3 / 8	Disassemble/assemble housing	PQ20N	6.1.2	
4 / 7	Unscrew/tighten up the hexagon socket head cap screw (the coupling should not get disassembled!)	PQ20H	(5.2)	Hex tip screw driver (10mm)
5 / 6	Unscrew/tighten hex bolt	PQ20E	4.4, 4.5	open-end spanner (A/F 19)
6 / 5	Removal complete component PQ20A	PQ20A		
7 / 4	Unscrew/tighten up the hexagon socket head cap screw	PQ20A	1.14	Hex tip screw driver (10mm)
8 / 3	Removal/assemble shaft-bearing-cap unit, fixing ring and bushing	PQ20A, PSKITWLC20K	1.12, 1.1.4	
9 / 2	Unscrew/tighten up the hexagon socket head cap screw	PQ20A	1.15	Hex tip screw driver (8mm)
10 / 1	Replacement of the shaft-bearing-cap unit	PQ20A	1.1.1-1.1.9	

