



No. SP-A1

Service Procedure Rev. 0

Service Department

For: Replacing Southworth Air Motor to Gast

Issue Date: September 18, 1998

Reissue Date:

Replacing Southworth Air Motor with Gast

DISASSEMBLY OF EXISTING POWER UNIT

- 1) Disconnect the air hose from the motor located at the elbow on the back of the motor.
- 2) Remove the steel tubing from the pump fittings and the down valve.
- 3) Remove the suction hose from the tank and the pump. The fittings on the suction hose are reusable.
- 4) Disconnect the hydraulic cylinder hose from the pump.
- 5) Unbolt the motor from the tank and remove motor and pump.

REASSEMBLY

- 1) Mount new motor to pump.
- 2) Grind off existing mounting studs.
- 3) Attach new mounting plate to the motor with nuts and lockwashers.
- 4) Position and tack weld new mounting plate to tank.
- 5) Install the new hose assembly in place of the tubing that runs from the pump to the down valve.
- 6) Install new suction hose using the existing reusable fittings.

Service Department

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Caution: Before performing any service on a machine read and understand all safety instructions in the service manual. Manuals are available free of charge, if you do not have one please call the Customer Service Department at the toll free number above.