

## Assembly/Disassembly QF4400 Pump Chamber/Elastomers/Shaft-Bearing-Cap-Unit incl. Tool List

1) Assembly/disassembly pump chamber [QF44CU]				
No.	Work Step	Component	Pos.-No.	Tool
1 / 4	Unscrew/tighten up the locking screw	PQ44A	1.6	Hex tip screw driver (10 mm)
2 / 3	Unscrew/tighten up the hexagon socket head cap screw	QF44CU	2.11	Hex tip screw driver (6 mm)
3 / 2	Unscrew/tighten up the hexagon socket head cap screws	QF44CU	2.12	Hex tip screw driver (8 mm)
4 / 1	Assemble/take out the whole component QF44CU			

2) Replacing elastomers				
No.	Work Step	Component	Pos.-No.	Tool
1 / 12	Disassemble/assemble pump chamber, as described at 1)			
2 / 11	Turn the pump-chamber that the clamp-ring is upwards	QF44CU		
3 / 10	Unscrew/tighten up the hexagon socket head cap screw	QF44CU	2.10	Hex tip screw driver (5mm)
4 / 9	Removing the diaphragm-housing-cover, clamp-ring and diaphragms	QF44CU	2.6, 2.4, 2.1.1	
5 / 8	Unscrew/tighten up sheet-metal screw with cross recess	QF44CU	2.8	Phillips-tip screwdriver
6 / 7	Changing the diaphragms by unscrewing the diaphragm-supports	QF44CU	2.1.1, 2.5	
7 / 6	Take out/assemble the valve-plate and the o-rings inside of/into the pump-housing	QF44CU	2.3 (2.1.2, 2.1.3), 2.1.4.1, 2.1.4.4	
8 / 5	Change the outlet-valve by unscrewing/tighten up the hexagon socket head cap screw	QF44CU	2.1.3, 2.9	Hex tip screw driver (5mm)
9 / 4	Change the inlet-valve and the o-rings inside the valve-plate by unscrewing/tightening up the valve-nuts	QF44CU	2.1.2, 2.1.4.3, 2.3, 2.7	open-end-spanner (A/F 10)
10 / 3	Change o-rings inside the pump-housing	QF44CU	2.1.4.1, 2.1.4.4, 2.2	
11 / 2	Unscrew/tighten up the hexagon socket head cap screw	QF44CU	3.2	Hex tip screw driver (4mm)
12 / 1	Change o-rings of the connectors	QF44CU	2.1.4.2, 3.1	

3) Replacing shaft-bearing-cap-unit				
No.	Work Step	Component	Pos.-No.	Tool
1 / 6	Disassemble/assemble pump chamber, as described at 1)			
2 / 5	Unscrew/tighten up the hexagon socket head cap screw	PQ44A	4.5	Hex tip screw driver (6mm)
3 / 4	Take out/assemble the whole component PQ44A	PQ44A		
4 / 3	Unscrew/tighten up the hexagon socket head cap screw, while assembling please note the lash for the coupling (sketch below)	PQ44A, PSKITWLC44	5.2.3	Hex tip screw driver (2,5mm)
5 / 2	Unscrew/tighten up the hexagon socket head cap screw, while assembling of fixingring (Pos. 1.1.1) use the mounting aid which is shown in the sketch below	PQ44A	1.10	Hex tip screw driver (6mm) (mounting aid)
6 / 1	Take out/assemble the shaft-bearing-cap-unit		1.1.1 – 1.1.10	



