



# TECH BULLETIN

**005**  
08/77

*Published regarding engineering changes and improvements*

## SUBJECT: “B” Manifold and Stepped Valve Seat

Beginning with May 1977, a back-up ring was added to the Valve Seat on all 10 Frame pumps. A thicker “stepped” Valve Seat was necessary to hold the added back-up ring and o-ring. A new manifold marked with a “B” with a deeper valve chamber was also necessary for this change.

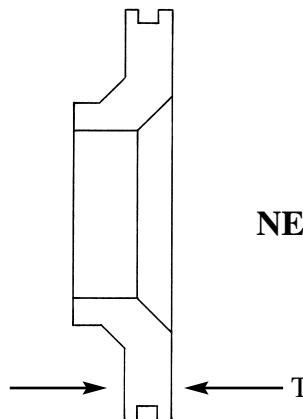
Item Description	524-624		10 Frame	
	Flat Valve O-Ring Only	Stepped Valve O-Ring and Back-up Ring	Flat Valve O-Ring Only	Stepped Valve O-Ring and Back-up Ring
Valve Seat	28680	43061 “B”	27350	43063 “B”
Discharge Manifold	28925	43060 “B”	37352	43046 “B”
Cylinder Bolts	85364	85364	28343	43047
Back-up Ring	—	43059	—	43062
Valve Kit	—	30643	30225	30449

It is important that parts are not interchanged from one design to another. However, with the use of PN 30452 spacer, the old Valve Seat with o-ring only may be used in the new style manifold-B.

The stainless steel discharge manifold (PN 30248) has a deep enough counterbore to permit either valve design.

The stepped Valve Seat back-up ring began with the following serial numbers:

<u>Model</u>	<u>Serial No.</u>
623.....	4770951
820.....	5770221
1010.....	5770421
524.....	8770101
624.....	6770201



### OLD Valve Seat

T = .157" (4.0 mm)  
PN 27350

### NEW Stepped Valve Seat

T = .197" (5.0 mm)  
PN 43046

CAT PUMPS  
Technical Services Department

Rev. 11/99