

The enclosed Piston Pump Rebuild Kit is a direct replacement for use on all piston motor pump assemblies in PACE power sources.

NOTE: POTENTIAL SHOCK HAZARD - The following procedures are to be performed by qualified service personnel only. Removal of the power source panels exposes line voltage parts. Service personnel must ensure that the AC Power Cord is disconnected prior to disassembly.

Perform the following procedure to rebuild the pump.

1. Turn the Power Switch on the power source to the OFF ("O") position.
2. Disconnect the power cord and all accessories (hand pieces, Tip & Tool Stands etc.) from the power source.
3. Open the power source case. On PACE SensaTemp power sources, use the applicable PACE Service Manual as a guide. Following are the service manuals for SensaTemp systems.

SYSTEM	MANUAL PART NO.
MBT 101(A), MBT 201(A)	5050-0340
MBT 250(A), MBT 220(A)	5050-0352

4. Locate the Motor Pump Assembly. Note the position of each air hose (2) connection to the motor pump assembly. Remove both air hoses.
5. You may find it necessary to remove the motor pump from its mounted location to install the kit. If this is the case, take note of and remove all mounting hardware and wiring attachments. Remove the motor pump assembly from the power source.
6. Take note of the position of the ports. Refer to the different views in the Illustration Section.
7. Begin the disassembly of the pump by completely removing the 4 mounting screws from the assembly then remove the following:
 - a. Piston Pump Plate
 - b. Lower Piston Pump Seal
 - c. Piston Pump Valve Body
 - d. Valve Sheet
 - e. Piston Pump Cylinder
 - f. Piston Pump Washer
 - g. Piston Pump Seal

NOTE: If these parts are stuck to the assembly housing, you may find it necessary to gently tap the side of the Pump Plate.

NOTE: There is an Orientation Indicator (notch) along one edge of the Pump Plate and Pump Seal. It is not necessary that these notches be in alignment with each other. Be sure to notice the two different size alignment pins on the Piston Pump Cylinder. The Piston Pump Valve Body and the Valve Sheet have two different size holes, which must be aligned with the correct pins on the Piston Pump Cylinder. If these parts are not in alignment, the pump will not work.

8. Once the above items are removed, you can now remove the Piston Pump Seal by carefully removing the Phillips Screw from the connecting rod.
9. Be sure to inspect and clean all of the parts before reassembly.
10. Position the replacement parts (Piston Pump Seal, Valve Sheet, and Lower Piston Pump Seal) together exactly as shown in the pictures.
11. Install the Pump Seal and Washer on the connecting rod with the large black Phillips Screw. (MUST TORQUE TO 18 IN-LBS)
12. Carefully install the Piston Pump Cylinder. This will need to be oriented to the proper position depending on the pump.
13. Install the Valve Sheet. Make sure that the alignment holes match up properly to the Piston Pump Seal. (failure to do this could damage the Valve body).
14. Next install the Piston Pump Valve Body along with the Piston Pump Seal and the Piston Pump Plate.
15. Secure in position using the 4 mounting screws removed in step 7.
16. Torque these 4 mounting screws to 18 in. lbs. Be sure to snug the 4 screws up in a criss-cross pattern before torquing to the required specification.
17. Install the Motor Pump Assembly (if removed in step 5) and assemble the power source.
18. Connect the power cord and all accessories (handpieces, Tip & Tool Stands etc.) removed in step 2 to the power source.
19. Turn the Power Switch to the ON ("1") position and test system operation.

NOTE: Torque values must be observed in order for successful pump operation.

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PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications including MIL STD 2000, ANSI/JSTD 001, IPC7711, and IPC A-610.

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**Piston Pump Rebuild Kit
PACE P/N 6993-0260-P1**

Installation Instructions

Manual Number 5050-0539

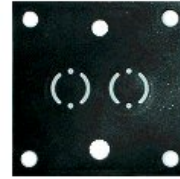
For any questions regarding the following the following instructions, contact your local authorized PACE dealer or contact PACE directly at:

Telephone (301) 490-9860, Fax (301) 498-0193

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Illustration Guide for the Piston Pumps

Includes



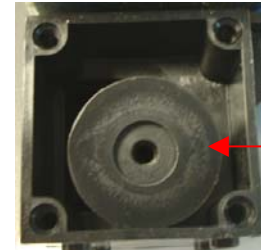
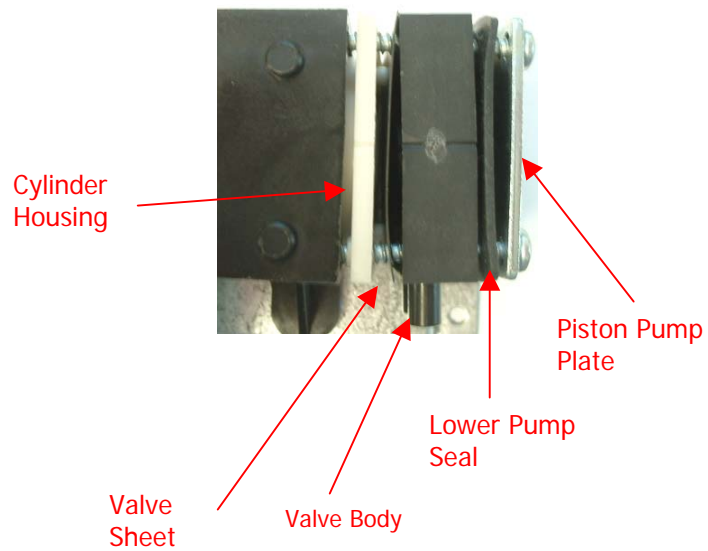
Valve Sheet



Lower Piston Pump Seal

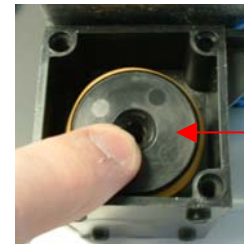


Piston Pump Seal



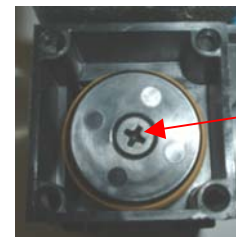
Step 1

Connecting Rod



Step 2

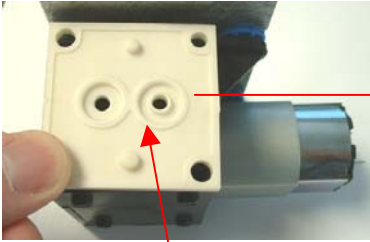
Be sure to fully seat the Piston Pump Washer to the Connecting Rod. Use care in order to avoid pinching the Piston Pump Seal



Step 3

Install the Phillips Screw and torque to 18 in. lbs.

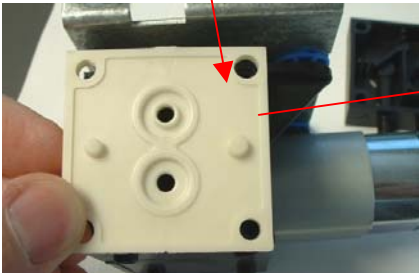
Step 4



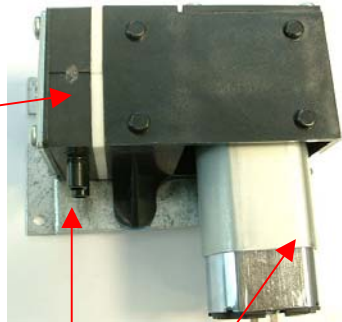
Be sure to orient the Cylinder Housing for the Correct System



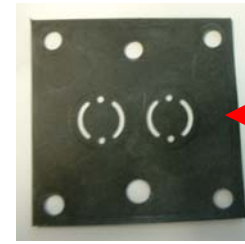
This orientation would be for the following systems: MTS 300/350 and MBT 250



This orientation would be for the following systems: ST 75/ST 115, ST 125/145, ST 105, MBT 201, and MTS 200 SC



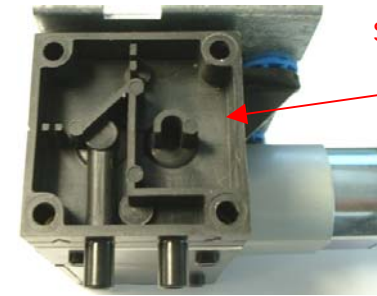
Step 5



Install the Valve Sheet



Step 6



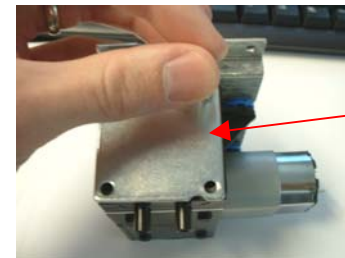
Install the Valve Body

Install the Lower Piston Pump Seal



Step 7

Step 8



Install the Piston Pump Plate. Torque the screws to 18 in. lbs.