

These instructions apply to the following 24 l/s air pumps:-

**S100, S150, S200, S300  
D150, D150R, D150WP, D200  
H100, H150,  
H100HM, H150HM, H200HM**

## Exhaust valve

- Remove the exhaust valve box cover.
- Do NOT attempt to remove the valve stud.



- Pull the old valve off the stud head, and discard.



- Clean the valve seat in outer pump body.
- Smear the head and groove of the stud with soft soap and push on the new valve ensuring it seats correctly.



## Actuator Valve

- Remove the outer pump body.



- Remove the valve by pulling it off the actuator nut.



- With the actuator valve removed, examine the condition of the valve seat. and the security of the actuator screw .
- This should be checked and tightened to 60lbf ft (81 Nm) torque



- To replace the actuator valve smear the bore with soft soap and ease the new valve rubber into position ensuring that it seats correctly.



## Actuator Seal - Removal

- Set the actuator to its maximum distance from the inner pump body by rotating the engine shaft.
- Remove the actuator seal outer by prising it from the inner pump body.



- Remove the actuator screw and withdraw the actuator complete with the seal from the drive rod.



## Actuator Seal - Refit

- Ensure taper on outer diameter is facing the correct way before attempting to fit the seal.
- Insert one side of the new rubber completely; Using a blunt tool that will not cut, insert the other side in 4 places only approx 50mm long, equispaced.
- Slowly work between each position to complete the installation.



## Neck Seal

- Remove the inner pump body and neck seal from the drive rod.
- Fit the new neck seal to the inner pump body and push both components over drive rod using assembly tool (Part No. 0015102000) smeared with soft soap.



## Air Pump Re-assembly

- Check that the bearer washers are in place, fit and fully tighten the screws. The heads of these screws should be fully contained within the recesses in the inner pump body.
- Tighten to 60lb ft (81 Nm)



- Replace the pump actuator/seal assembly. Lightly greasing the actuator bore.
- Tighten the actuator screw to 60lb ft (81 Nm) torque.



- Seat the outside section of the actuator seal in the inner pump body recess by gently tapping with a non-metallic mallet.



- Replace the outer pump body assembly. Evenly tighten screws, washers and nuts.
- Replace the suction box cover, exhaust cover, and air hoses.



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