

# Quincy QR-25<sup>®</sup> Series Models 106 & 108

Parts Manual · Record of Change 100

This manual contains important safety information and should be made available to all personnel who operate and/or maintain this product. Carefully read this manual before attempting to operate or perform maintenance on this compressor.

*Fill Out & Return*  
Warranty Registration Card Located Inside



## Quincy Compressor<sup>®</sup>

True Blue Reliability<sup>™</sup>

Manual No. 50235-100

March 1988 Edition

ALPHABETICAL INDEX

**CONNECTING ROD AND PISTON GROUPS**  
 MODEL 106..... 15-16  
 MODEL 108..... 17-18

**CONTROL GROUPS**  
 LOADLESS..... 31-32  
 PILOT CONTROLLED..... 33-34  
 PILOT CONTROLLED WITH SAFE-Q-LUBE PROTECTION... 35-36  
 DUAL CONTROL WITH SHUTOFF VALVE..... 37-38

**CRANKCASE GROUPS**  
 PLAIN..... 3-4  
 LOADLESS..... 5-6

**CRANKSHAFT GROUPS**  
 MODEL 106  
     plain..... 7-8  
     loadless..... 11-12  
 MODEL 108  
     plain..... 9-10  
     loadless..... 13-14

**CYLINDER AND HEAD GROUPS (WITH TORQUE SEQUENCES)**  
 MODEL 106  
     plain..... 19-20  
     loadless..... 23-24  
 MODEL 108  
     plain..... 21-22  
     loadless..... 25-26

**GASKET SETS & "O"RING KITS..... 42**

**HEAD ASSEMBLIES**  
 MODEL 106 OR 108  
     plain..... 27-28  
     loadless..... 29-30

**PILOT ASSEMBLIES..... 39-40**  
**PILOT ASSEMBLIES INSTRUCTIONS..... 41**  
**RECOMMENDED SPARE PARTS..... 43**  
**SERIAL NUMBER IDENTIFICATION..... 2**

GENERAL SPECIFICATIONS

FOR

MODELS 106 & 108 RECIPROCATING COMPRESSORS

MODEL 106	MODEL 108
AIRCOOLED	AIRCOOLED
SINGLE STAGE	SINGLE STAGE
SPLASH LUBRICATED	SPLASH LUBRICATED
2-1/2" BORE X 2-1/2" STROKE	2-1/2" BORE X 3" STROKE
400-900 R.P.M. SPEED RANGE	400-900 R.P.M. SPEED RANGE
WITH PRESSURE CAPABILITY	WITH PRESSURE CAPABILITY
UP TO 150 P.S.I. WITH	UP TO 150 P.S.I. WITH
PROPER CONTROLS &	PROPER CONTROLS &
MODIFICATIONS	MODIFICATIONS

## SERIAL NUMBER IDENTIFICATION

The serial number identification tag is located on the handhole plate on the side of the crankcase.

MODEL		Record of Change No.
SERIAL NO.		
SIZE		
Colt Industries	Quincy	
110831	Compressor Division	

## ORDERING REPLACEMENT PARTS

Prompt service can be rendered on repair parts orders if the following information is given:

1. The model number, record of change number, & serial number must be given when ordering replacement parts.
2. State the exact part number needed. Do not order by index numbers, as index numbers are repeated throughout this manual, and if used for ordering replacement parts, will necessitate time consuming correspondence.
3. State the exact quantity needed.
4. State the preferred type of transportation.

**ALL REPLACEMENT PARTS ARE TO BE ORDERED THROUGH AN AUTHORIZED DISTRIBUTOR.  
INSIST ON GENUINE QUINCY PARTS ONLY! FAILURE TO DO SO MAY VOID WARRANTY**

### **CAUTION !**

*Follow all safety precautions outlined  
in the QR 25 instruction manual.*

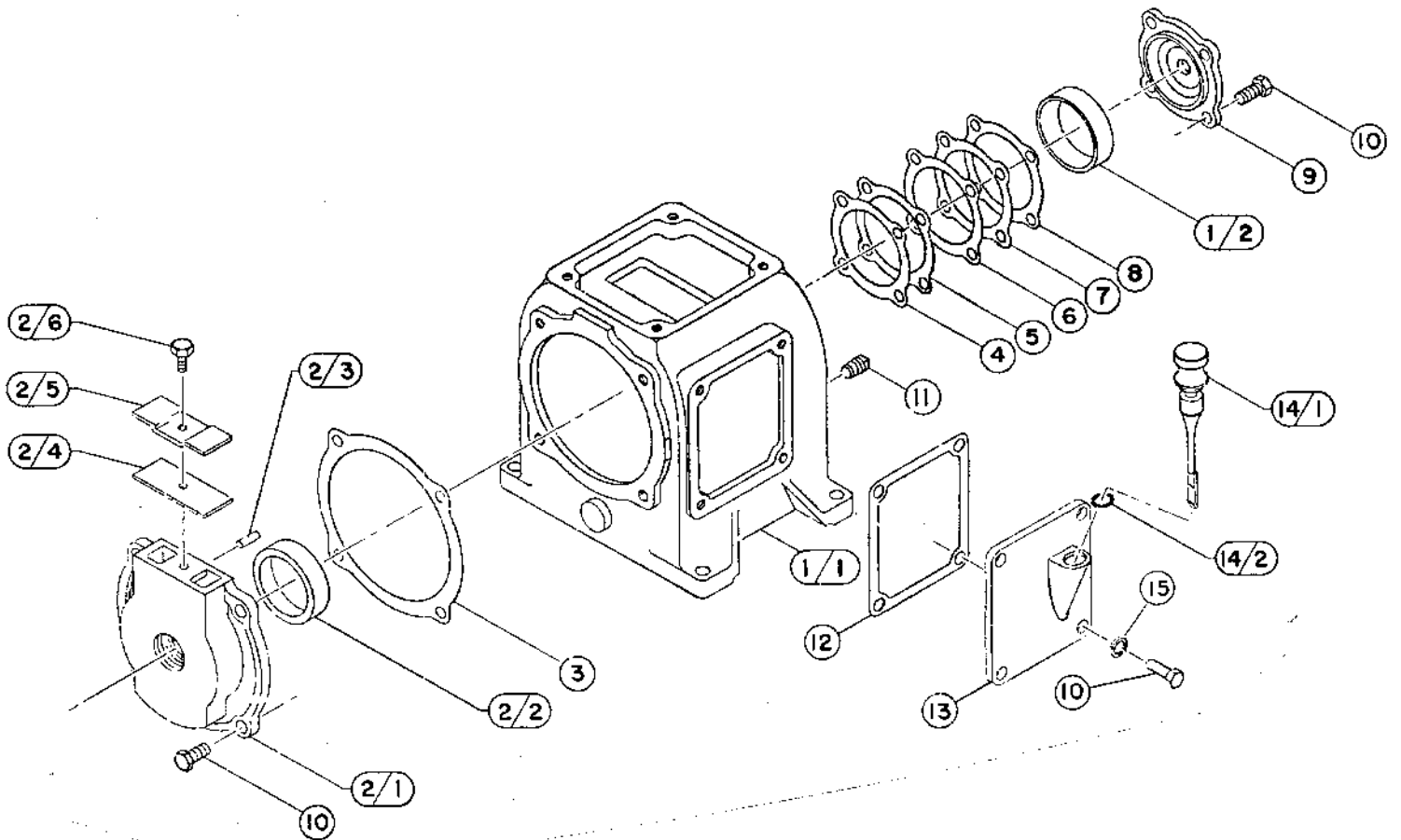
### **WARNING !**

*Do not operate this compressor without a totally enclosed  
belt guard or any other required safety equipment.*



*Air from this compressor will cause severe injury or death if used for  
breathing or food processing. Air for these processes must meet  
OSHA 29 CFR 1910 or FDA 21 CFR 178.3570 regulations.*

**CRANKCASE GROUP 110271  
(FOR 106/108 PLAIN VALVE COMPRESSORS)**



**CRANKCASE GROUP 110271  
(FOR 106/108 PLAIN VALVE COMPRESSORS)**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	1522X	CRANKCASE ASSEMBLY
1/1	1	1522	CRANKCASE-BARE
1/2	1	4018	CUP-BEARING
2	1	40403	BEARING CARRIER ASSEMBLY
2/1	1	1521	CARRIER-BEARING
2/2	1	4018	CUP-BEARING
2/3	1	110705-F10	PIN-ROLL, 3/16 X .75
2/4	1	1679	VALVE-BREATHER
2/5	1	1680	BUMPER-BREATHER VALVE
2/6	1	123478-J07	SCREW-HEX., 1/4-20 UNC X .50, GRADE 5
3	1	1592	GASKET-BEARING CARRIER
4	*	1644B	SHIM-.020" THICK STEEL BEARING ADJUSTMENT
5	*	1644C	SHIM-.005" THICK PAPER BEARING ADJUSTMENT
6	*	1644	SHIM-.005" THICK STEEL BEARING ADJUSTMENT
7	*	1644A	SHIM-.007" THICK STEEL BEARING ADJUSTMENT
8	*	1644D	SHIM-.002" THICK PLASTIC BEARING ADJUSTMENT
9	1	1520	PLATE-PLAIN VACUUM PUMP BEARING ADJUSTMENT
10	12	123478-L10	SCREW-HEX., 3/8-16 UNC X .75, GRADE 5 (⊕ 30FT.-LBS.)
11	1	1301	PLUG-PIPE, 3/8 NPT
12	1	1599	GASKET-INSPECTION PLATE
13	1	2320	PLATE-INSPECTION
14	1	40404	OIL GAGE ASSEMBLY
14/1	1	110070-1	GAGE-OIL
14/2	1	123157-112	"O"RING-3/32 WIDE X .69 O.D. (BAYONET OIL GAUGE)
15	4	110428M038	FLATWASHER-3/8

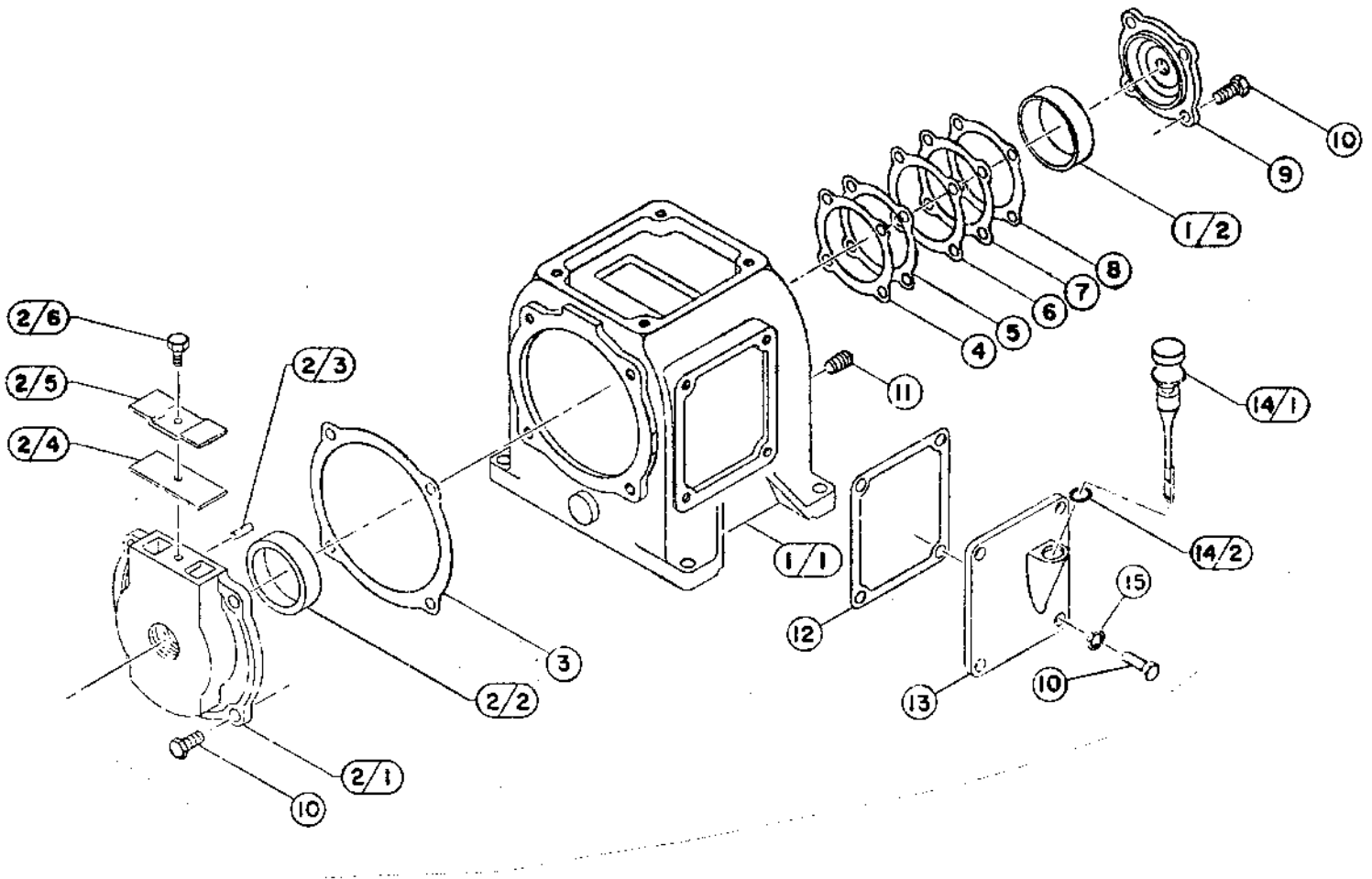
\* QUANTITY AS REQUIRED

⊕ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**PARTS FOR SPECIAL APPLICATIONS  
(FOR USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC LUBRICANTS)**

2/2	1	22749-112	"O"RING-3/32 WIDE X .69 O.D. (BAYONET OIL GAUGE)
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CRANKCASE GROUP 110271-001  
(FOR 106/108 LOADLESS VALVE COMPRESSORS)



**CRANKCASE GROUP 110271-001  
(FOR 106/108 LOADLESS VALVE COMPRESSORS)**

INDEX NUMBER	Q T Y	PART NUMBER	DESCRIPTION
1	1	1522X	CRANKCASE ASSEMBLY
1/1	1	1522	CRANKCASE-BARE
1/2	1	4018	CUP-BEARING
2	1	40403	BEARING CARRIER ASSEMBLY
2/1	1	1521	CARRIER-BEARING
2/2	1	4018	CUP-BEARING
2/3	1	110705-F10	PIN-ROLL, 3/16 X .75
2/4	1	1679	VALVE-BREATHER
2/5	1	1680	BUMPER-BREATHER VALVE
2/6	1	123478-J07	SCREW-HEX., 1/4-20 UNC X .50, GRADE 5
3	1	1592	GASKET-BEARING CARRIER
4	*	1644B	SHIM-.020" THICK STEEL BEARING ADJUSTMENT
5	*	1644C	SHIM-.005" THICK PAPER BEARING ADJUSTMENT
6	*	1644	SHIM-.005" THICK STEEL BEARING ADJUSTMENT
7	*	1644A	SHIM-.007" THICK STEEL BEARING ADJUSTMENT
8	*	1644D	SHIM-.002" THICK PLASTIC BEARING ADJUSTMENT
9	1	1520U	PLATE-BEARING ADJUSTMENT
10	12	123478-L10	SCREW-HEX., 3/8-16 UNC X .75, GRADE 5 (2 30FT.-LBS.)
11	1	1301	PLUG-PIPE, 3/8 NPT
12	1	1599	GASKET-INSPECTION PLATE
13	1	2320	PLATE-INSPECTION
14	1	40404	OIL GAGE ASSEMBLY
14/1	1	110070-1	GAGE-OIL
14/2	1	123157-112	"O"RING-3/32 WIDE X .69 O.D. (BAYONET OIL GAUGE)
15	4	110428N038	FLATWASHER-3/8

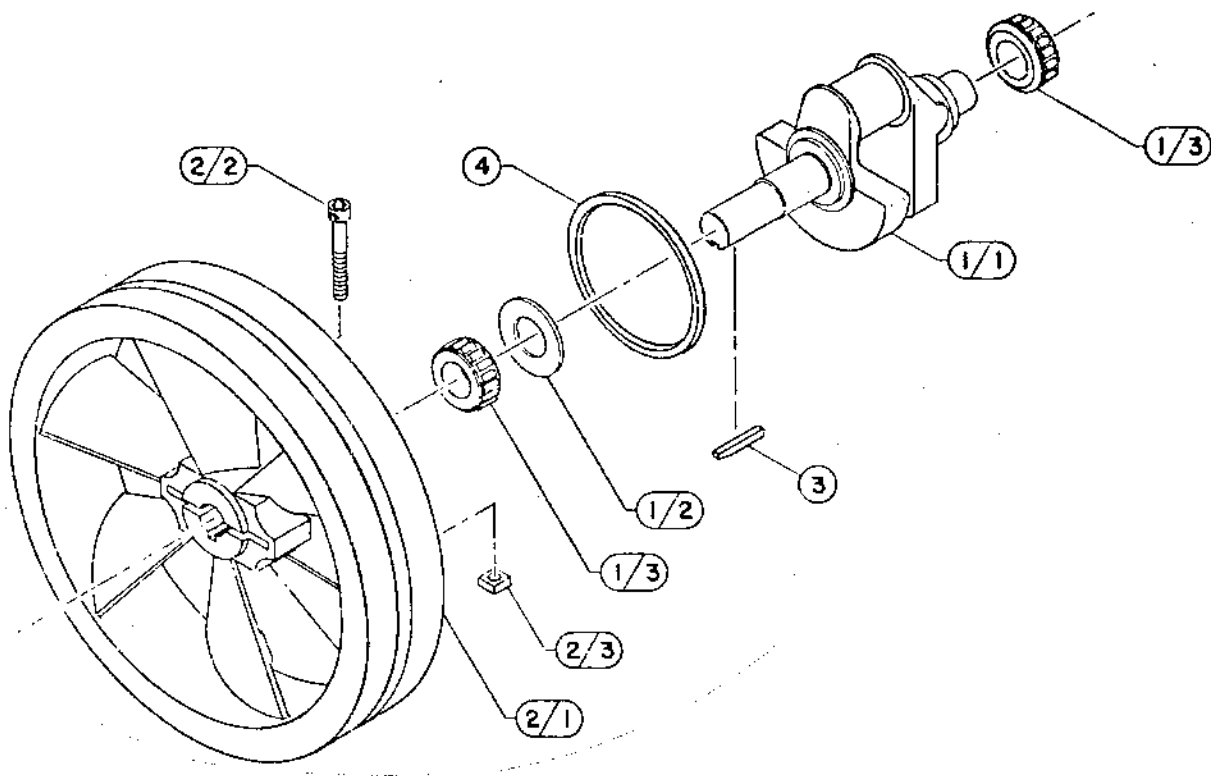
\* QUANTITY AS REQUIRED

2 INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**PARTS FOR SPECIAL APPLICATIONS**  
(FOR USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC LUBRICANTS)

2/2	1	22749-112	"O"RING-3/32 WIDE X .69 O.D. (BAYONET OIL GAUGE)
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**CRANKSHAFT GROUP 110540  
(FOR 106 PLAIN VALVE COMPRESSOR)**



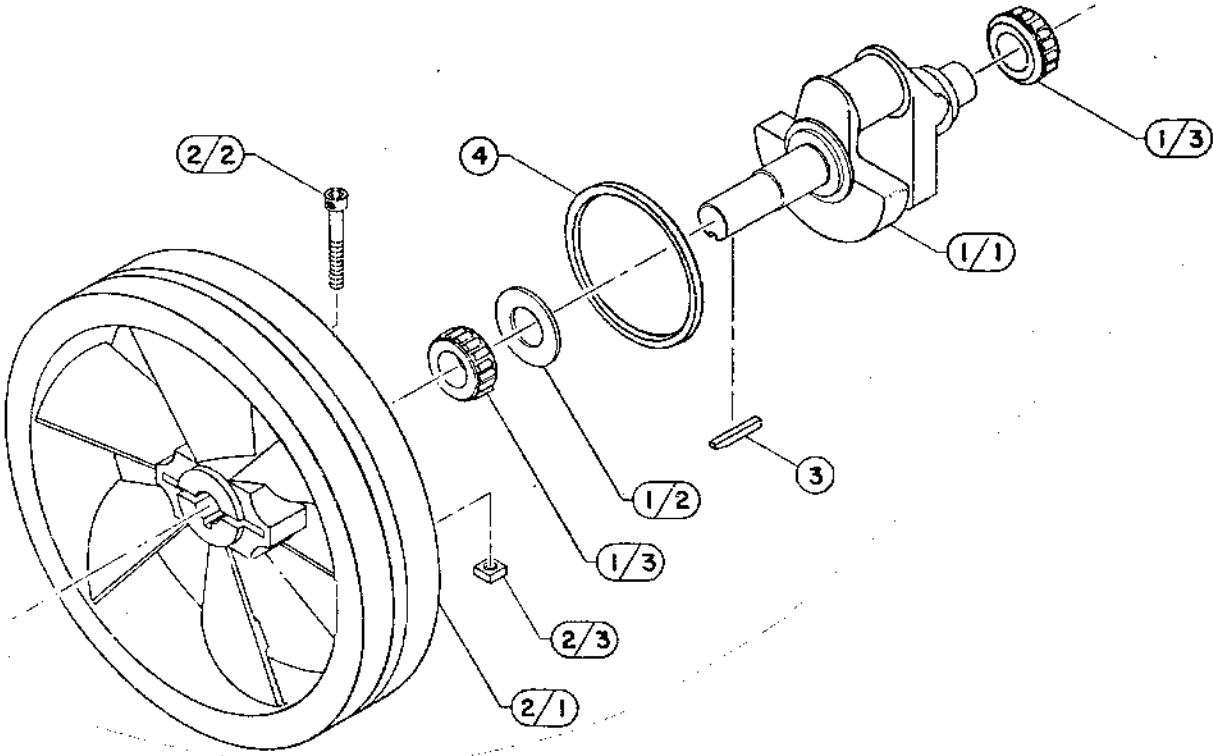


**CRANKSHAFT GROUP 110540  
(FOR 106 PLAIN VALVE COMPRESSOR)**

INDEX NUMBER	Q T Y	PART NUMBER	DESCRIPTION
1	1	1523X	CRANKSHAFT ASSEMBLY
1/1	1	1523	CRANKSHAFT (NOT SOLD SEPARATELY;ORDER 1523X)
1/2	1	1692	WASHER-OIL CIRCULATING RING RETAINER
1/3	2	4019	CONE-BEARING
2	1	2909X	SHEAVE ASSEMBLY
2/1	1	2909	SHEAVE-COMPRESSOR,14.00 O.D.,1 GROOVE,8 SECTION,CCW (NOT SOLD SEPARATELY;ORDER 2909X)
2/2	1	123478-N18	SCREW-HEX.,1/2-13 UNC X 2.25,GRADE 5 (@ 75FT.-LBS.)
2/3	1	124372-N02	NUT-SQUARE,1/2-13 UNC
3	1	1761	KEY-CRANKSHAFT
4	1	1589	RING-OIL CIRCULATING

@ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**CRANKSHAFT GROUP 110272  
(FOR 108 PLAIN VALVE COMPRESSOR)**

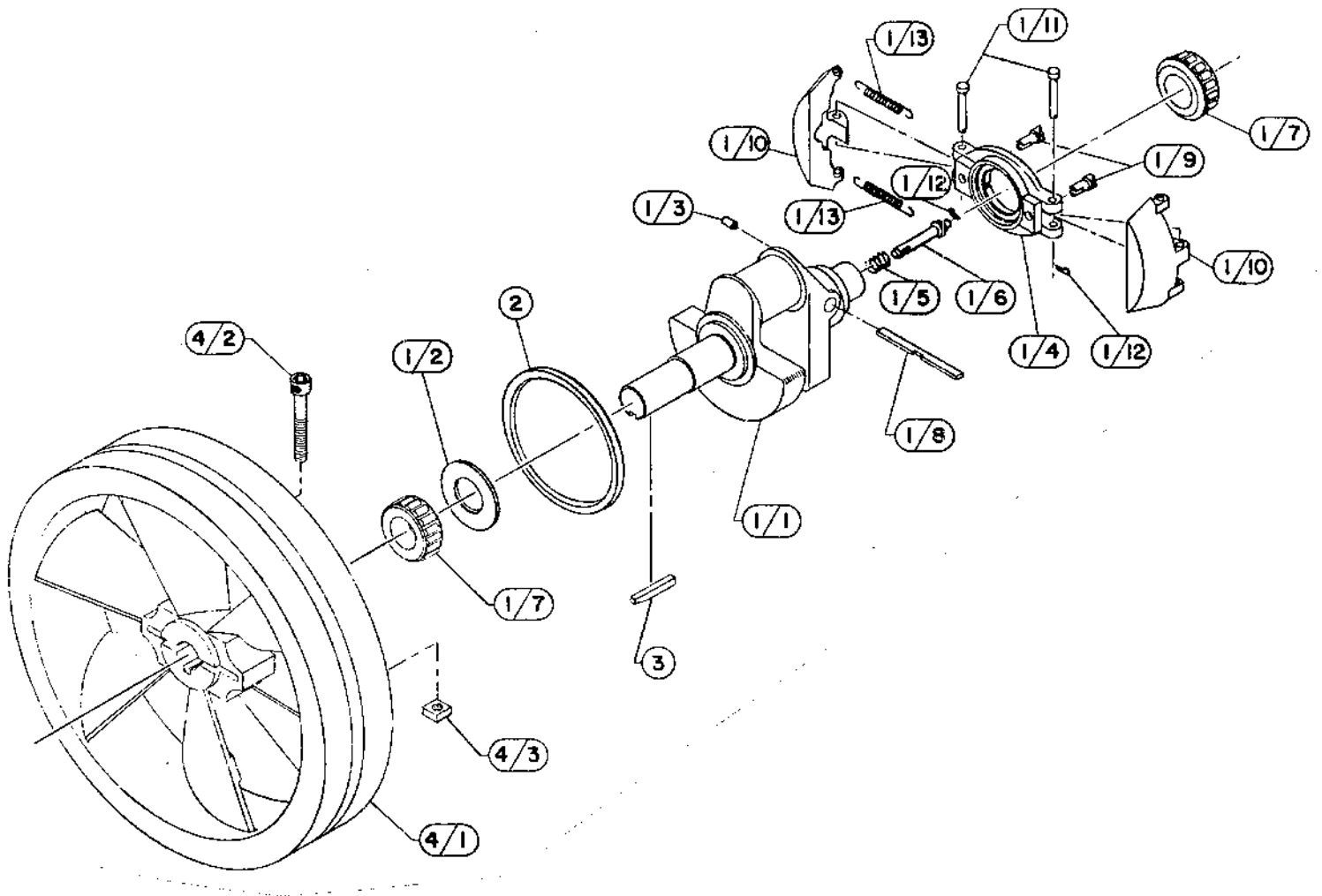


CRANKSHAFT GROUP 110272  
(FOR 108 PLAIN VALVE COMPRESSOR)

INDEX NUMBER	Q T Y	PART NUMBER	DESCRIPTION
1	1	1523X	CRANKSHAFT ASSEMBLY
1/1	1	1523	CRANKSHAFT (NOT SOLD SEPARATELY;ORDER 1523X)
1/2	1	1692	WASHER-OIL CIRCULATING RING RETAINER
1/3	2	4019	CONE-BEARING
2	1	2909X	SHEAVE ASSEMBLY
2/1	1	2909	SHEAVE-COMPRESSOR,14.00 O.D.,1 GROOVE,B SECTION,CCW (NOT SOLD SEPARATELY;ORDER 110422X)
2/2	1	123478-N18	SCREW-SOCKET HEAD,3/8-16 UNC X 2.75,GRADE 5 (@ 30FT.-LBS.)
2/3	1	124372-N02	NUT-SQUARE,1/2-13 UNC
3	1	1761	KEY-CRANKSHAFT
4	1	1589	RING-OIL CIRCULATING

@ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**CRANKSHAFT GROUP 110540-001  
(FOR 106 LOADLESS VALVE COMPRESSOR)**

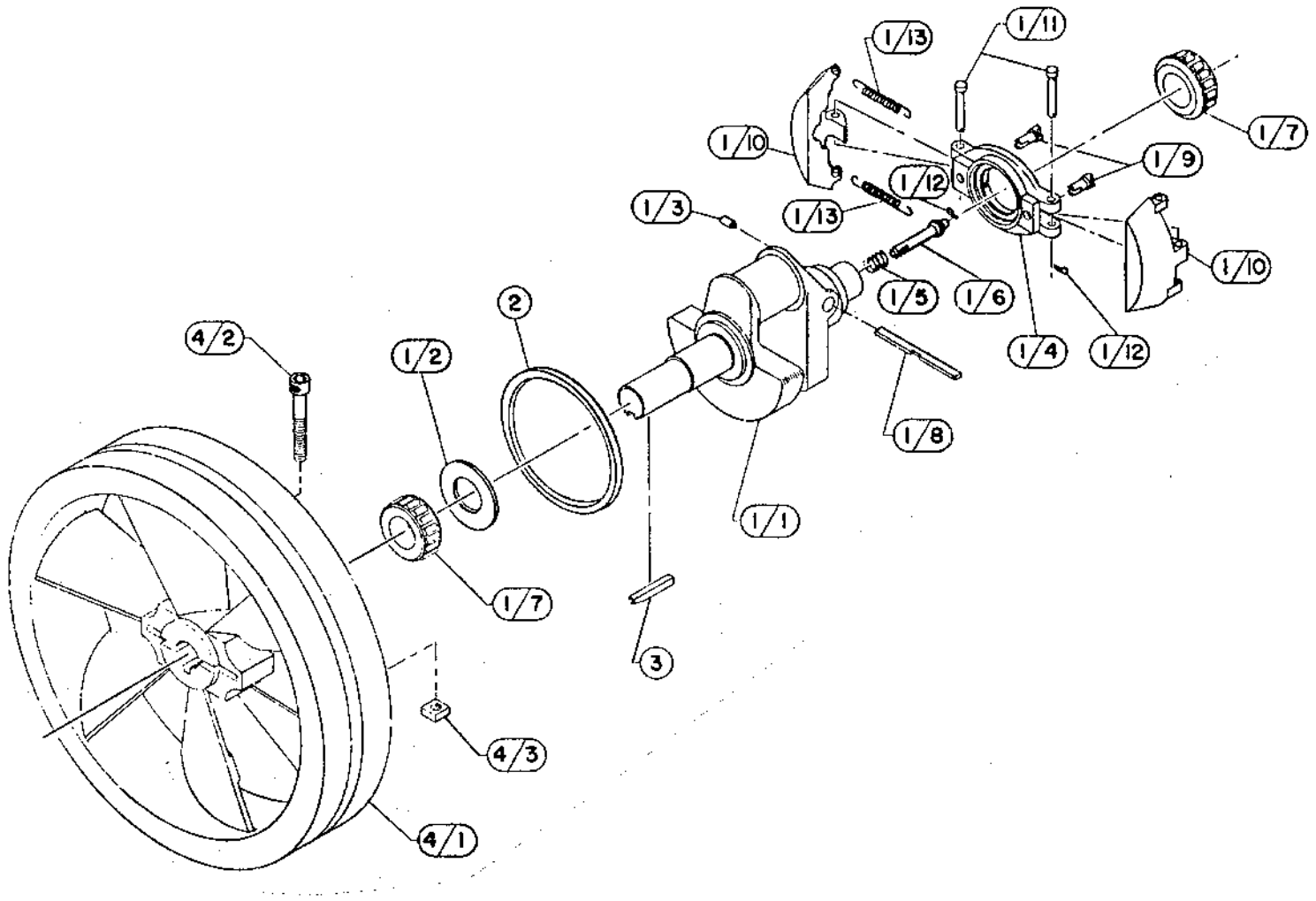


**CRANKSHAFT GROUP 110540-001  
(FOR 106 LOADLESS VALVE COMPRESSOR)**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	1523LSX	CRANKSHAFT ASSEMBLY
1/1	1	1523LS	CRANKSHAFT (NOT SOLD SEPARATELY;ORDER 1523LSX)
1/2	1	1692	WASHER-OIL CIRCULATING RING RETAINER
1/3	1	3770	PIN-CENTRIFUGAL GOVERNOR HEAD RETAINING
1/4	1	1575	HEAD-CENTRIFUGAL GOVERNOR
1/5	1	1866	SPRING-CENTRIFUGAL GOVERNOR PLUNGER
1/6	1	1578	PLUNGER-CENTRIFUGAL GOVERNOR
1/7	2	4019	CONE-BEARING
1/8	1	1864	BAR-CENTRIFUGAL GOVERNOR
1/9	2	1863	PIN-CENTRIFUGAL GOVERNOR HEEL
1/10	2	1861	FLYWEIGHT-CENTRIFUGAL GOVERNOR
1/11	2	1579	PIN-FLYWEIGHT PIVOT PIN
1/12	2	2741	KEY-CENTRIFUGAL GOVERNOR FLYWEIGHT
1/13	2	1580	SPRING-CENTRIFUGAL GOVERNOR FLYWEIGHT CUSHION
2	1	1589	RING-OIL CIRCULATING
3	1	1761	KEY-CRANKSHAFT
4	1	2909X	SHEAVE ASSEMBLY
4/1	1	2909	SHEAVE-COMPRESSOR,14.00 O.D.,1 GROOVE,B SECTION,CCW (NOT SOLD SEPARATELY;ORDER 2909X)
4/2	1	123478-N18	SCREW-HEX.,1/2-13 UNC X 2.25,GRADE 5 (Ø 75FT.-LBS.)
4/3	1	124372-N02	NUT-SQUARE,1/2-13 UNC

Ø INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

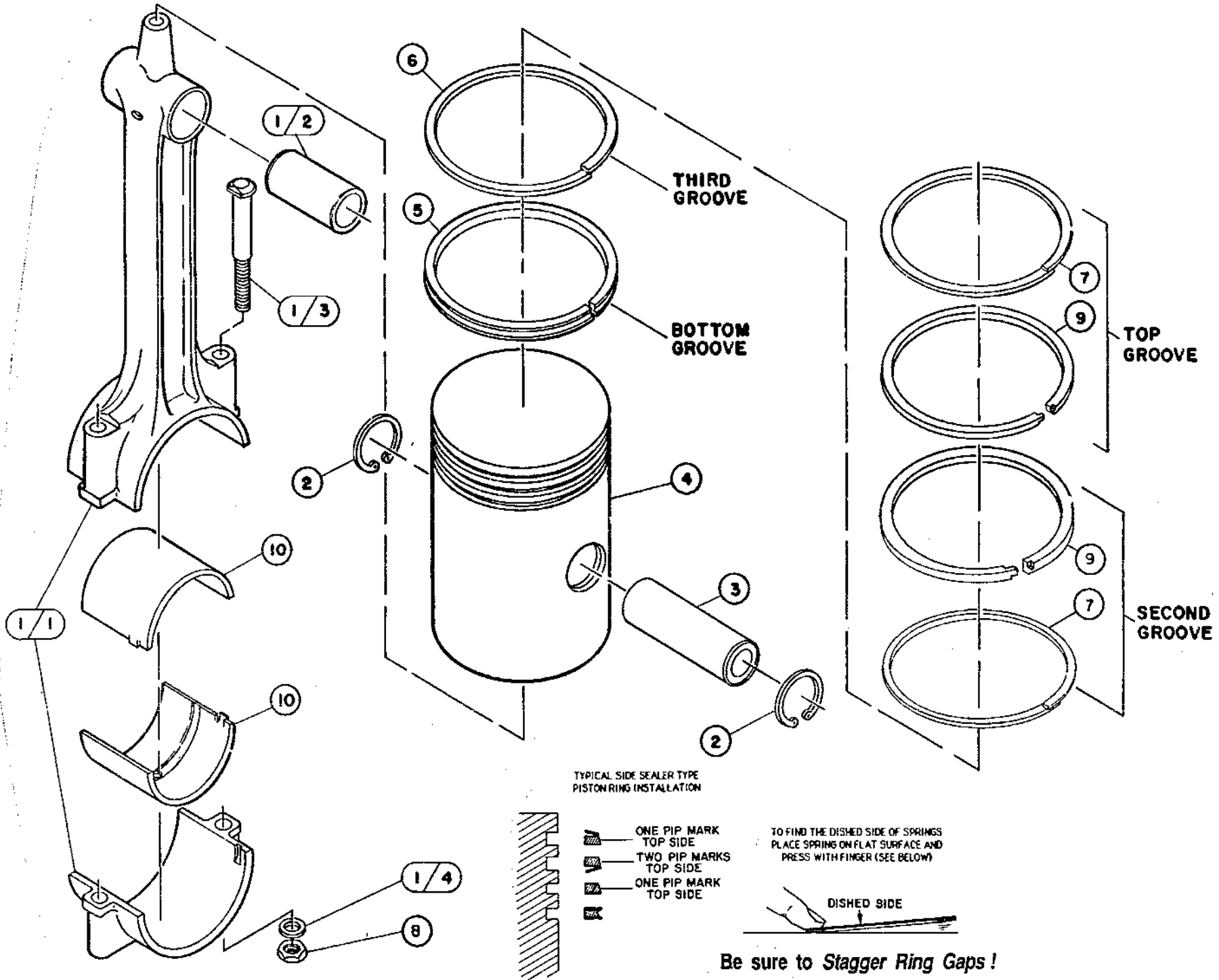
**CRANKSHAFT GROUP 110272-001  
(FOR 108 LOADLESS VALVE COMPRESSOR)**



**CRANKSHAFT GROUP 110272-001  
(FOR 108 LOADLESS VALVE COMPRESSOR)**

<b>INDEX NUMBER</b>	<b>Q T Y</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	1523LSX	CRANKSHAFT ASSEMBLY
1/1	1	1523LS	CRANKSHAFT (NOT SOLD SEPARATELY;ORDER 1523LSX)
1/2	1	1692	WASHER-OIL CIRCULATING RING RETAINER
1/3	1	3770	PIN-CENTRIFUGAL GOVERNOR HEAD RETAINING
1/4	1	1575	HEAD-CENTRIFUGAL GOVERNOR
1/5	1	1866	SPRING-CENTRIFUGAL GOVERNOR PLUNGER
1/6	1	1578	PLUNGER-CENTRIFUGAL GOVERNOR
1/7	2	4019	CONE-BEARING
1/8	1	1864	BAR-CENTRIFUGAL GOVERNOR
1/9	2	1863	PIN-CENTRIFUGAL GOVERNOR HEEL
1/10	2	1861	FLYWEIGHT-CENTRIFUGAL GOVERNOR
1/11	2	1579	PIN-FLYWEIGHT PIVOT PIN
1/12	2	2741	KEY-CENTRIFUGAL GOVERNOR FLYWEIGHT
1/13	2	1580	SPRING-CENTRIFUGAL GOVERNOR FLYWEIGHT CUSHION
2	1	1589	RING-OIL CIRCULATING
3	1	1761	KEY-CRANKSHAFT
4	1	2909X	SHEAVE ASSEMBLY
4/1	1	2909	SHEAVE-COMPRESSOR,14.00 O.D.,1 GROOVE,8 SECTION,CCM (NOT SOLD SEPARATELY;ORDER 110422X)
4/2	1	123478-N18	SCREW-SOCKET HEAD,3/8-16 UNC X 2.75,GRADE 5 ( @ 30FT.-LBS. )
4/3	1	124372-N02	NUT-SQUARE,1/2-13 UNC

@ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)





**PISTON & CONNECTING ROD GROUP 110411  
(FOR 106 MODEL)**

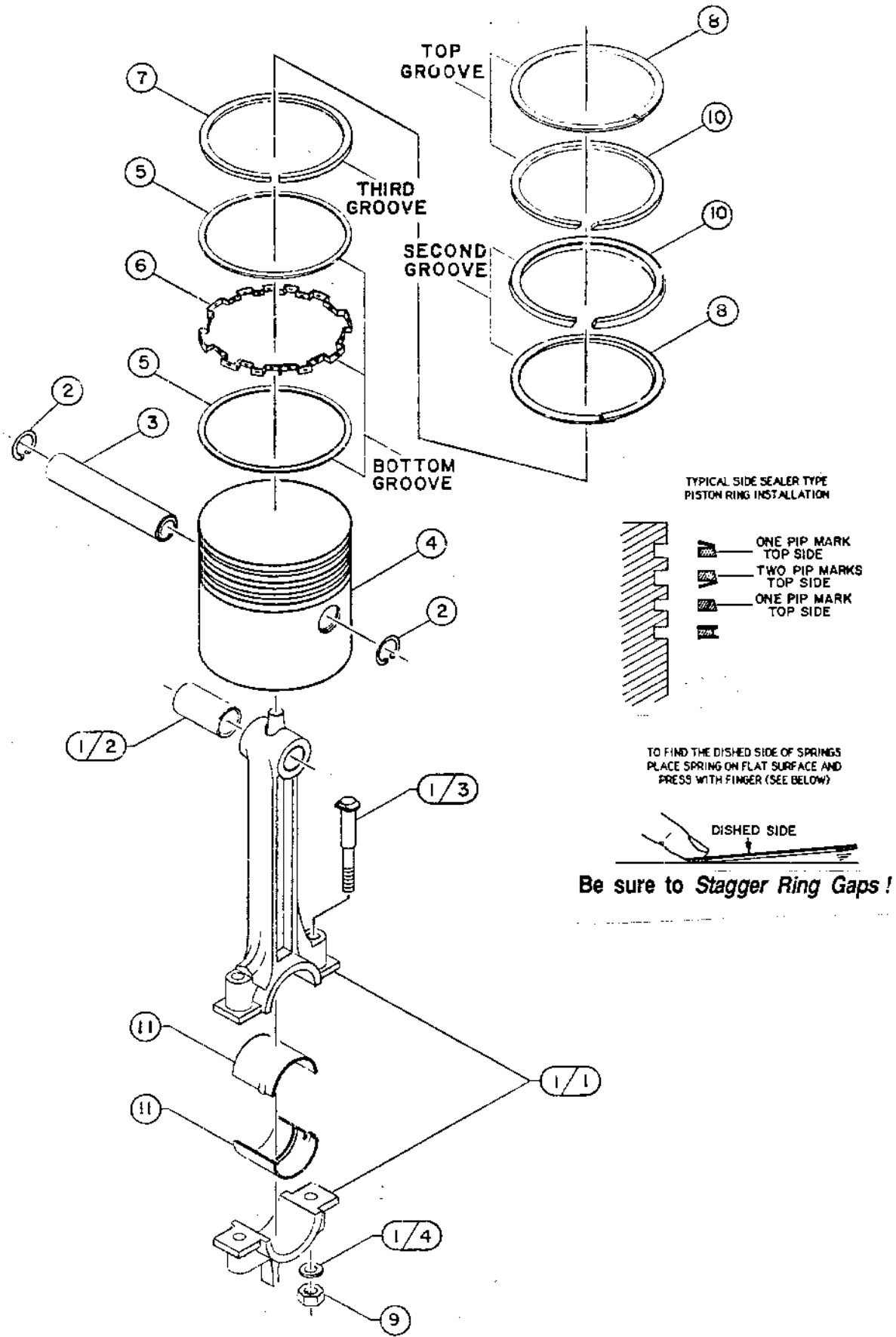
<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	110703X002	CONNECTING ROD ASSEMBLY (NOT SOLD SEPARATELY;ORDER 110703X102)
1/1	1	110703-002	ROD-CONNECTING (NOT SOLD SEPARATELY;ORDER 110703X102)
1/2	1	6440	BUSHING-CONNECTING ROD (CAN NOT BE PURCHASED;ORDER 6440SR)
1/3	2	3532	BOLT-CONNECTING ROD,5/16-24 UNF
1/4	2	111260-002	WASHER-CONNECTING ROD
2	2	8648	RING-RETAINING
3	1	110190-002	PIN-PISTON
4	1	1530-001	PISTON-COMPRESSOR
5	1	111280	EXPANDER-OIL RING
6	1	1652	RING-PISTON
7	2	6538	SPRING-SIDE SEALER
8	2	124471-K08	LOCKNUT-5/16-24 UNF (⊗ 28FT.-LBS.)
9	2	6536	RING-PISTON
10	2	2824	INSERT-CON ROD BEARING (NOT SOLD SEPARATELY;ORDER 2824PR)
11	2	111281	RAIL-OIL RING

⊗ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**MAINTENANCE PARTS**

1	2824PR	INSERTS(PAIR)-CON ROD BEARING,(STANDARD)
1	2824-010PR	INSERTS(PAIR)-CON ROD BEARING,(.010 OVERSIZE)
1	1530-011	PISTON-COMPRESSOR,(.010 OVERSIZE)
1	1530-021	PISTON-COMPRESSOR,(.020 OVERSIZE)
1	8161	RING SET-SIDE SEALER,(STANDARD;NO COLOR CODE)
1	4422-010	RING SET-PISTON,(.010 OVERSIZE) (LIGHT BLUE)
1	4422-020	RING SET-PISTON,(.020 OVERSIZE) (YELLOW)
1	<b>1530X001</b>	<b>PISTON ASSEMBLY (STANDARD)</b>
		INCLUDES:
1	110190-002	PIN-PISTON
1	1530-001	PISTON-COMPRESSOR
1	8161	RING SET-SIDE SEALER,(STANDARD;NO COLOR CODE)
2	8648	RING-RETAINING
1	<b>1530X011</b>	<b>PISTON ASSEMBLY,(.010 OVERSIZE)</b>
		INCLUDES:
1	110190-002	PIN-PISTON
1	1530-011	PISTON-COMPRESSOR,(.010 OVERSIZE)
1	4422-010	RING SET-PISTON,(.010 OVERSIZE) (LIGHT BLUE)
2	8648	RING-RETAINING
1	<b>1530X021</b>	<b>PISTON ASSEMBLY,(.020 OVERSIZE)</b>
		INCLUDES:
1	110190-002	PIN-PISTON
1	1530-021	PISTON-COMPRESSOR,(.020 OVERSIZE)
1	4422-020	RING SET-PISTON,(.020 OVERSIZE) (YELLOW)
2	8648	RING-RETAINING
1	<b>110703X102</b>	<b>CONNECTING ROD ASSEMBLY (STANDARD)</b>
		INCLUDES:
1	110703X002	CONNECTING ROD ASSEMBLY
2	124471-K08	LOCKNUT-5/16-24 UNF
1	2824PR	INSERTS(PAIR)-CON ROD BEARING,(STANDARD)
1	<b>110703X01S</b>	<b>CONNECTING ROD ASSEMBLY (.010 UNDERSIZE)</b>
		INCLUDES:
1	110703X002	CONNECTING ROD ASSEMBLY
2	124471-K08	LOCKNUT-5/16-24 UNF
1	2824-010PR	INSERTS(PAIR)-CON ROD BEARING,(.010 OVERSIZE)

**PISTON & CONNECTING ROD GROUP 110391  
(FOR 108 MODEL)**



**PISTON & CONNECTING ROD GROUP 110391  
(FOR 108 MODEL)**

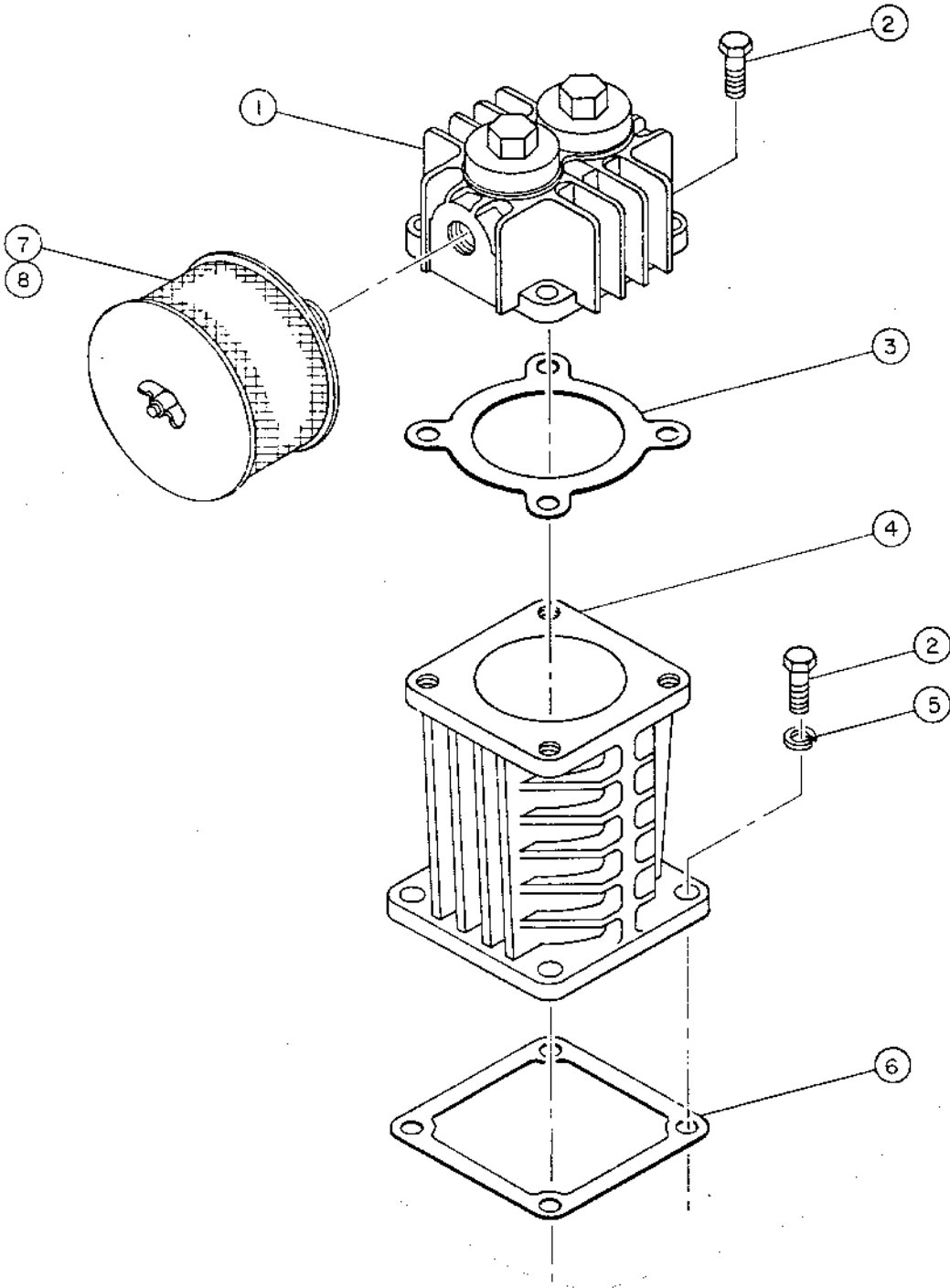
<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	110703X002	CONNECTING ROD ASSEMBLY (NOT SOLD SEPARATELY;ORDER 110703X102)
1/1	1	110703-002	ROD-CONNECTING (NOT SOLD SEPARATELY;ORDER 110703X102)
1/2	1	6440	BUSHING-CONNECTING ROD
1/3	2	3532	BOLT-CONNECTING ROD,5/16-24 UNF
1/4	2	111260-002	WASHER-CONNECTING ROD
2	2	8648	RING-RETAINING
3	1	110190-008	PIN-PISTON
4	1	1531-001	PISTON-COMPRESSOR
5	2	6451	RAIL-PISTON
6	1	6450	EXPANDER-PISTON
7	1	1648	RING-COMPRESSION
8	2	6448	SPRING-PISTON
9	2	124471-K08	LOCKNUT-5/16-24 UNF ( @ 28FT.-LBS. )
10	2	6446	RING-COMPRESSION
11	2	2824	INSERT-CON ROD BEARING (NOT SOLD SEPARATELY;SEE MAINTENANCE PARTS)

@ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**MAINTENANCE PARTS**

1	2824PR	INSERTS(PAIR)-CON ROD BEARING,(STANDARD)
1	2824-010PR	INSERTS(PAIR)-CON ROD BEARING,(.010 OVERSIZE)
1	1531-011	PISTON-COMPRESSOR
1	1531-021	PISTON-COMPRESSOR
1	6452	RING-SET,SIDE SEALER (STANDARD) (NO COLOR CODE)
1	4425-010	RING SET-PISTON (.010 OVERSIZE) (LIGHT BLUE)
1	4425-020	RING SET-PISTON (.020 OVERSIZE) (YELLOW)
1	<b>1531X001</b>	<b>PISTON ASSEMBLY</b>
		INCLUDES:
1	110190-008	PIN-PISTON
1	1531-001	PISTON-COMPRESSOR
1	6452	RING-SET,SIDE SEALER (STANDARD) (NO COLOR CODE)
2	8648	RING-RETAINING
1	<b>1531X011</b>	<b>PISTON ASSEMBLY</b>
		INCLUDES:
1	110190-008	PIN-PISTON
1	1531-011	PISTON-COMPRESSOR
1	4425-010	RING SET-PISTON (.010 OVERSIZE) (LIGHT BLUE)
2	8648	RING-RETAINING
1	<b>1531X021</b>	<b>PISTON ASSEMBLY</b>
		INCLUDES:
1	110190-008	PIN-PISTON
1	1531-021	PISTON-COMPRESSOR
1	4425-020	RING SET-PISTON (.020 OVERSIZE) (YELLOW)
2	8648	RING-RETAINING
1	<b>110703X102</b>	<b>CONNECTING ROD ASSEMBLY (STANDARD)</b>
		INCLUDES:
1	110703X002	CONNECTING ROD ASSEMBLY
2	124471-K08	LOCKNUT-5/16-24 UNF
1	2824PR	INSERTS(PAIR)-CON ROD BEARING,(STANDARD)
1	<b>110703X105</b>	<b>CONNECTING ROD ASSEMBLY (.010 UNDERSIZE)</b>
		INCLUDES:
1	110703X002	CONNECTING ROD ASSEMBLY
2	124471-K08	LOCKNUT-5/16-24 UNF
1	2824-010PR	INSERTS(PAIR)-CON ROD BEARING,(.010 OVERSIZE)

**CYLINDER & HEAD GROUP 110538  
(FOR 106 PLAIN VALVE COMPRESSOR)**



**CYLINDER & HEAD GROUP 110538  
(FOR 106 PLAIN VALVE COMPRESSOR)**

INDEX NUMBER	QTY	PART NUMBER	DESCRIPTION
1	1	1914P	HEAD ASSEMBLY (SEE PAGE 28)
2	8	123478-L12	SCREW-HEX., 3/8-16 UNC X 1.00, GRADE 5 (@ 30FT.-LBS.)
3	1	1945	GASKET-CYLINDER HEAD
4	1	1915-001	CYLINDER
5	4	123115-06C	LOCKWASHER-3/8
6	1	1593	GASKET-CYLINDER TO CRANKCASE
7	1	110377F075	FILTER-AIR

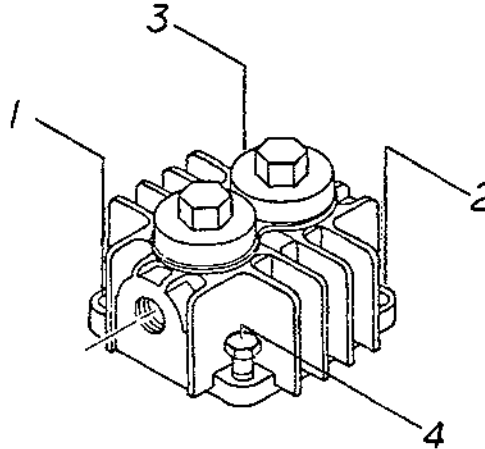
⊘ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**MAINTENANCE PARTS**

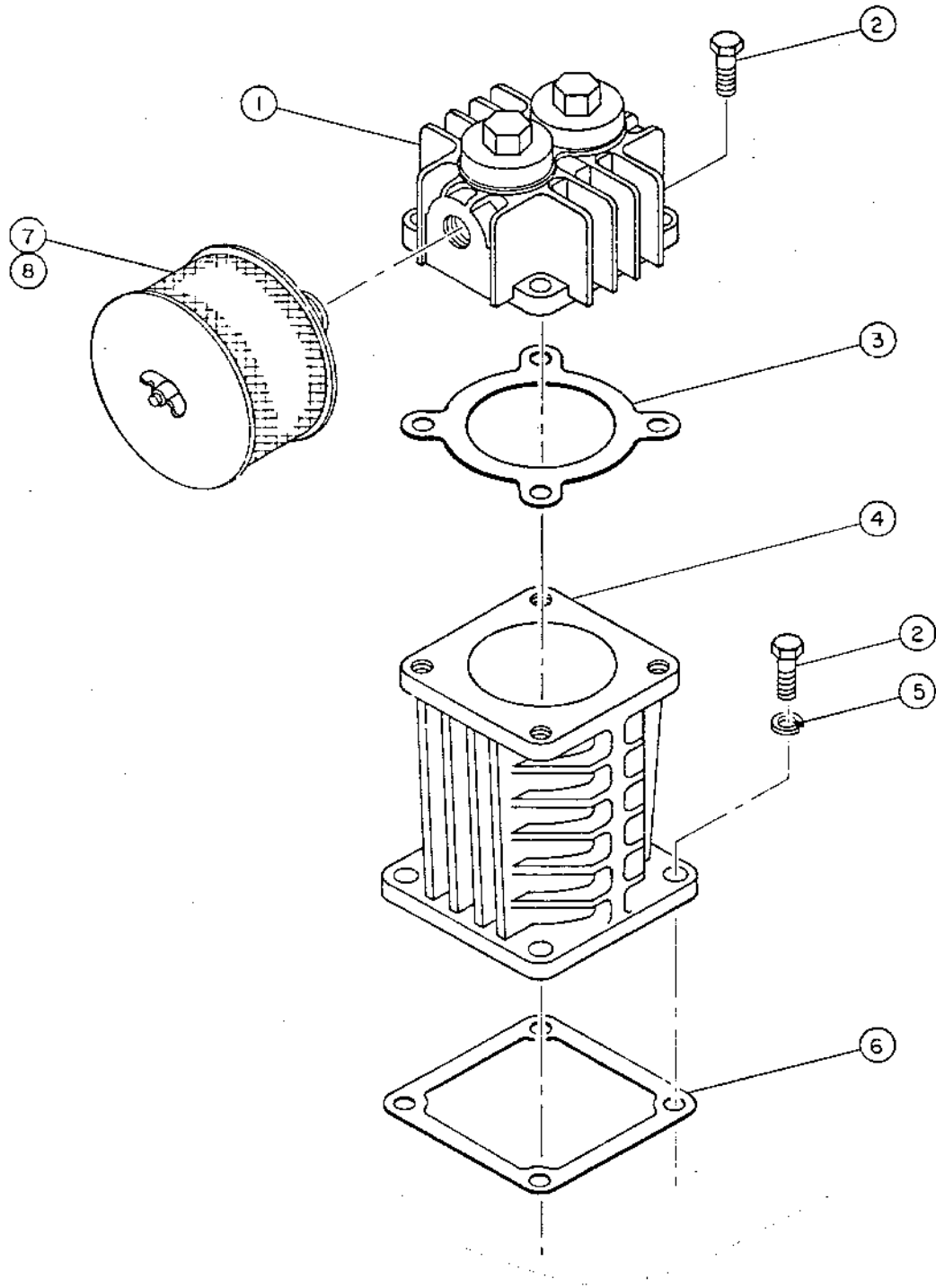
8	1	110377E075	ELEMENT-AIR FILTER
	1	1914X16P	HEAD ASSEMBLY INCLUDES:
	1	1914P	HEAD ASSEMBLY
	1	1945	GASKET-CYLINDER HEAD

**NOTE: TIGHTEN ALL BOLTS & CAPSCREWS IN ANY BOLT PATTERN EVENLY BRINGING EACH BOLT TO TORQUE IN EVEN INCREMENTS WHILE MOVING ABOUT THE BOLT PATTERN. THIS IS PARTICULARLY TRUE OF CONNECTING ROD & HEAD BOLTS.**

**PROPER HEAD BOLT  
TORQUE SEQUENCE**



**CYLINDER & HEAD GROUP 110273  
(FOR 108 PLAIN VALVE COMPRESSOR)**



**CYLINDER & HEAD GROUP 110273  
(FOR 108 PLAIN VALVE COMPRESSOR)**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	1914P	HEAD ASSEMBLY (SEE PAGE 28)
2	8	123478-L12	SCREW-HEX., 3/8-16 UNC X 1.00, GRADE 5 (⊕ 30FT.-LBS.)
3	1	1946	GASKET-CYLINDER HEAD
4	1	1916-001	CYLINDER
5	4	123115-06C	LOCKWASHER-3/8
6	1	1593	GASKET-CYLINDER TO CRANKCASE
7	1	110377F075	FILTER-AIR

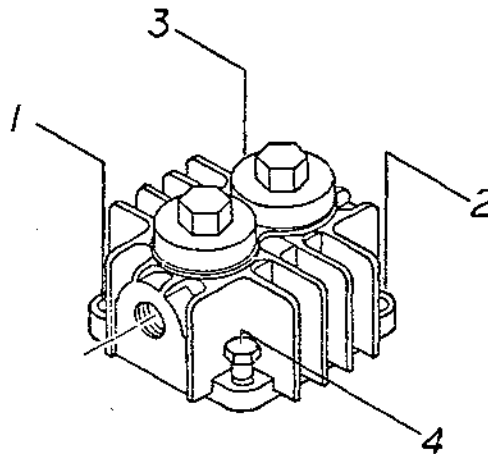
⊕ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**MAINTENANCE PARTS**

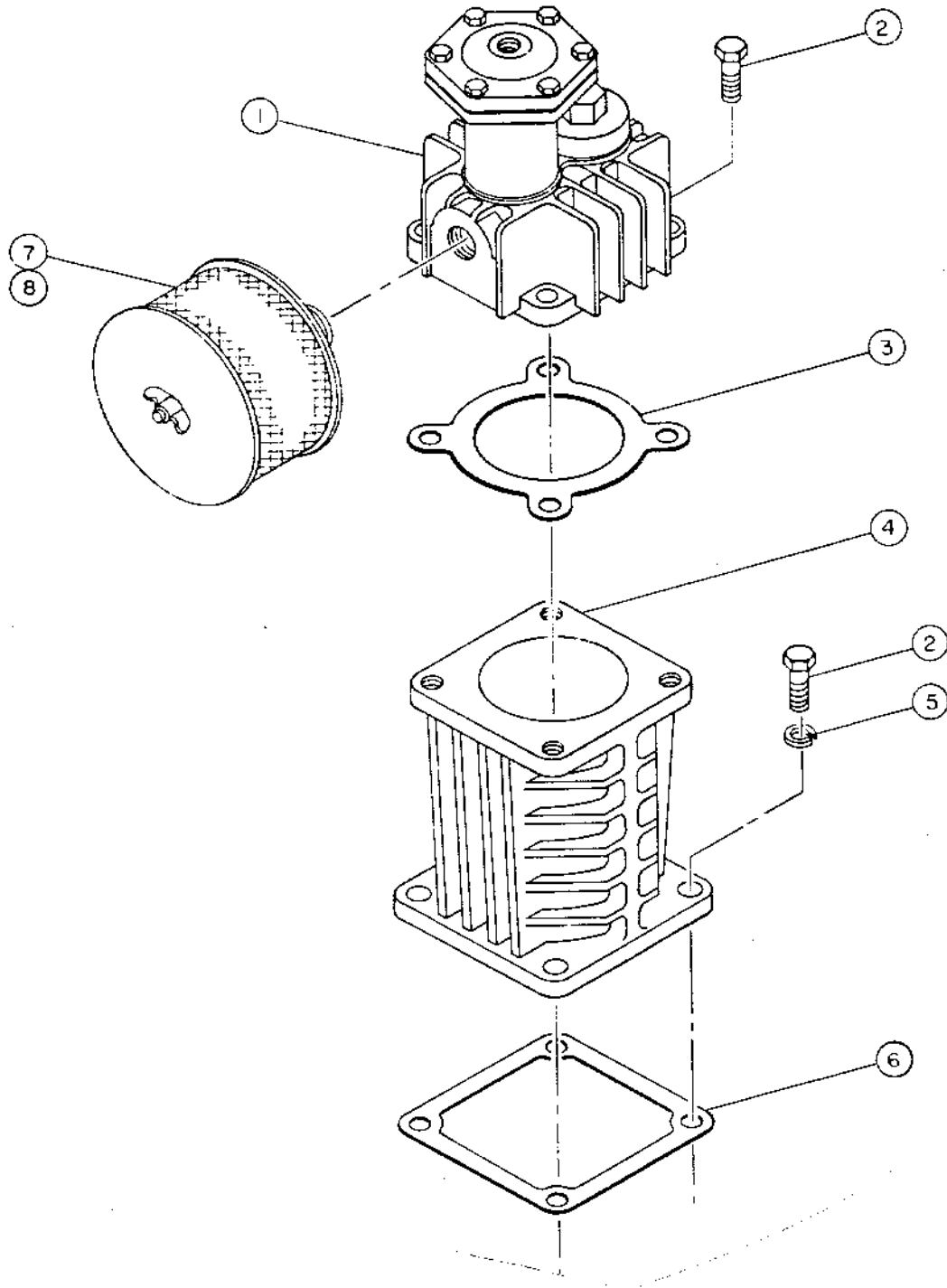
8	1	110377E075	ELEMENT-AIR FILTER
	1	1914X25P	HEAD ASSEMBLY INCLUDES:
	1	1914P	HEAD ASSEMBLY
	1	1946	GASKET-CYLINDER HEAD

**NOTE: TIGHTEN ALL BOLTS & CAPSCREWS IN ANY BOLT PATTERN EVENLY BRINGING EACH BOLT TO TORQUE IN EVEN INCREMENTS WHILE MOVING ABOUT THE BOLT PATTERN. THIS IS PARTICULARLY TRUE OF CONNECTING ROD & HEAD BOLTS.**

**PROPER HEAD BOLT  
TORQUE SEQUENCE**



**CYLINDER & HEAD GROUP 110539  
(FOR 106 LOADLESS VALVE COMPRESSOR)**





**CYLINDER & HEAD GROUP 110539  
(FOR 106 LOADLESS VALVE COMPRESSOR)**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	1914U	HEAD ASSEMBLY (SEE PAGE 30)
2	8	123478-L12	SCREW-HEX., 3/8-16 UNC X 1.00, GRADE 5 (@ 30FT.-LBS.)
3	1	1945	GASKET-CYLINDER HEAD
4	1	1915-001	CYLINDER
5	4	123115-06C	LOCKWASHER-3/8
6	1	1593	GASKET-CYLINDER TO CRANKCASE
7	2	110377F075	FILTER-AIR

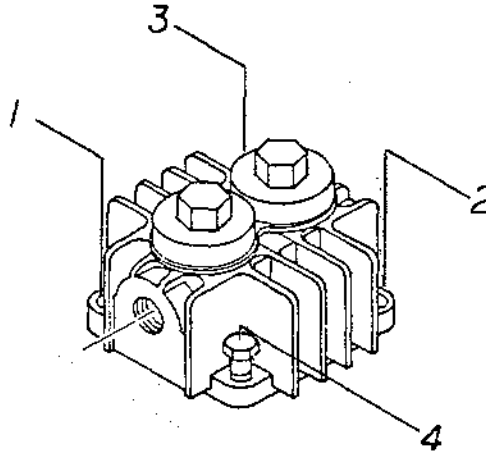
@ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**MAINTENANCE PARTS**

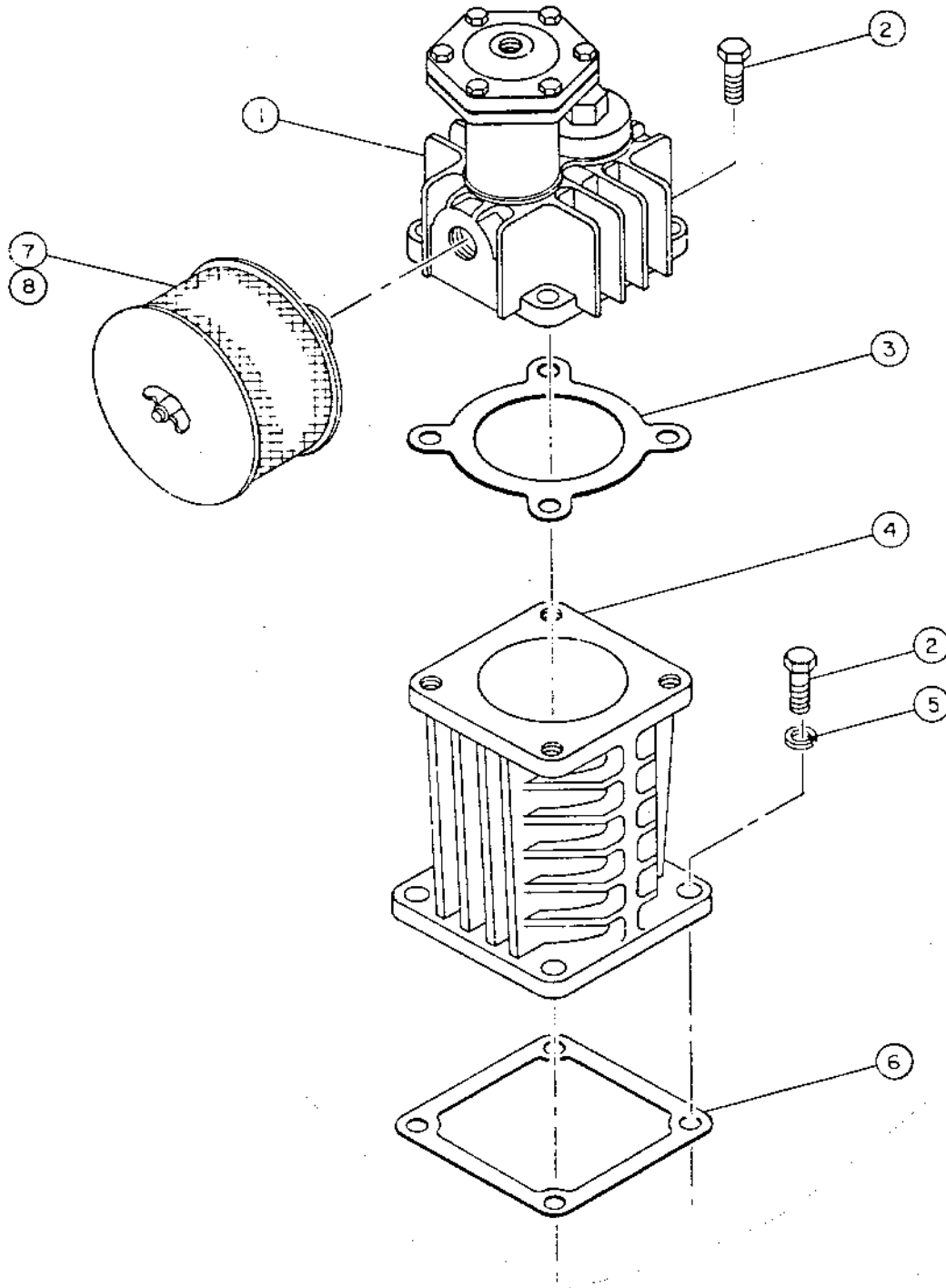
8	1	110377E075	ELEMENT-AIR FILTER
	1	1914X16L	HEAD ASSEMBLY INCLUDES:
	1	1914U	HEAD ASSEMBLY
	1	1945	GASKET-CYLINDER HEAD
	1	1642	FITTING-ELBOW, 1/4 TUBE X 1/8 NPT

NOTE: TIGHTEN ALL BOLTS & CAPSCREWS IN ANY BOLT PATTERN EVENLY BRINGING EACH BOLT TO TORQUE IN EVEN INCREMENTS WHILE MOVING ABOUT THE BOLT PATTERN. THIS IS PARTICULARLY TRUE OF CONNECTING ROD & HEAD BOLTS.

**PROPER HEAD BOLT  
TORQUE SEQUENCE**



**CYLINDER & HEAD GROUP 110275  
(FOR 108 LOADLESS VALVE COMPRESSOR)**



**CYLINDER & HEAD GROUP 110275  
(FOR 108 LOADLESS VALVE COMPRESSOR)**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	1914U	HEAD ASSEMBLY (SEE PAGE 30)
2	8	123478-L12	SCREW-HEX., 3/8-16 UNC X 1.00, GRADE 5 (⊗ 30FT.-LBS.)
3	1	1946	GASKET-CYLINDER HEAD
4	1	1916-001	CYLINDER
5	4	123115-06C	LOCKWASHER-3/8
6	1	1593	GASKET-CYLINDER TO CRANKCASE
7	1	110377F075	FILTER-AIR

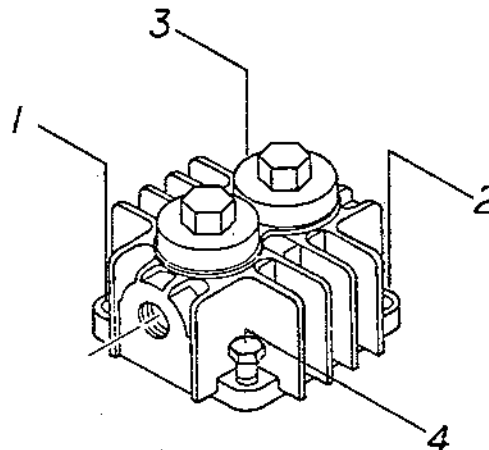
⊗ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**MAINTENANCE PARTS**

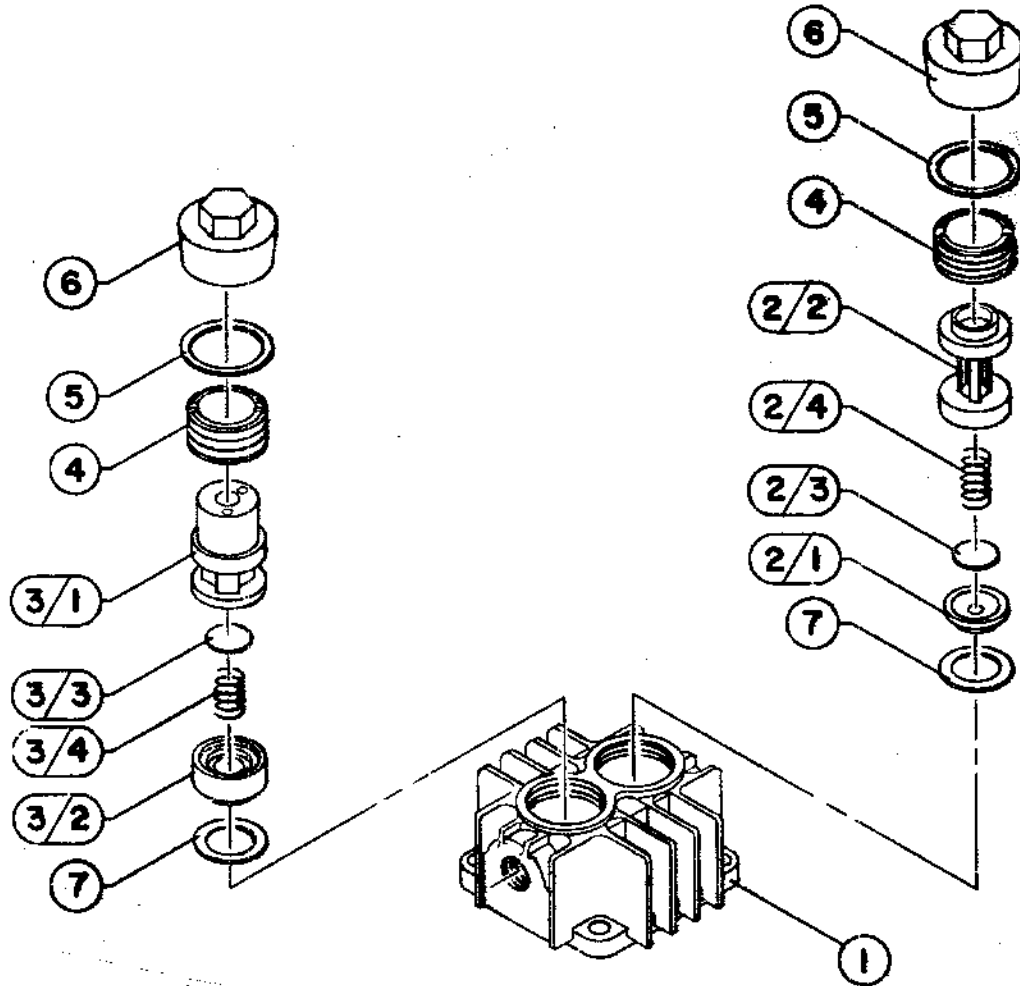
8	1	110377E075	ELEMENT-AIR FILTER
	1	1914X15L	HEAD ASSEMBLY INCLUDES:
	1	1914U	HEAD ASSEMBLY
	1	1946	GASKET-CYLINDER HEAD
	1	1642	FITTING-ELBOW, 1/4 TUBE X 1/8 NPT

**NOTE: TIGHTEN ALL BOLTS & CAPSCREWS IN ANY BOLT PATTERN EVENLY BRINGING EACH BOLT TO TORQUE IN EVEN INCREMENTS WHILE MOVING ABOUT THE BOLT PATTERN. THIS IS PARTICULARLY TRUE OF CONNECTING ROD & HEAD BOLTS.**

**PROPER HEAD BOLT  
TORQUE SEQUENCE**



HEAD ASSEMBLY 1914P  
(FOR PLAIN VALVE COMPRESSOR)



**HEAD ASSEMBLY 1914P  
(FOR PLAIN VALVE COMPRESSOR)**

INDEX NUMBER	Q T Y	PART NUMBER	DESCRIPTION
1	1	1914	HEAD-CYLINDER
2	1	1553X3	VALVE ASSEMBLY-DISCHARGE
2/1	1	1553	SEAT-VALVE
2/2	1	3010	BUMPER-VALVE
2/3	1	1552	DISC-VALVE
2/4	1	1368	SPRING-VALVE
3	1	4610X1	VALVE ASSEMBLY-SUCTION
3/1	1	4610	SEAT-VALVE
3/2	1	1549	BUMPER-VALVE
3/3	1	1552	DISC-VALVE
3/4	1	1202	SPRING-VALVE
4	2	3008	SCREW-HOLDDOWN ( @ 85FT.-LBS. )
5	2	1556	GASKET-VALVE
6	2	1555	CAP-VALVE COVER
7	2	1554	GASKET-VALVE

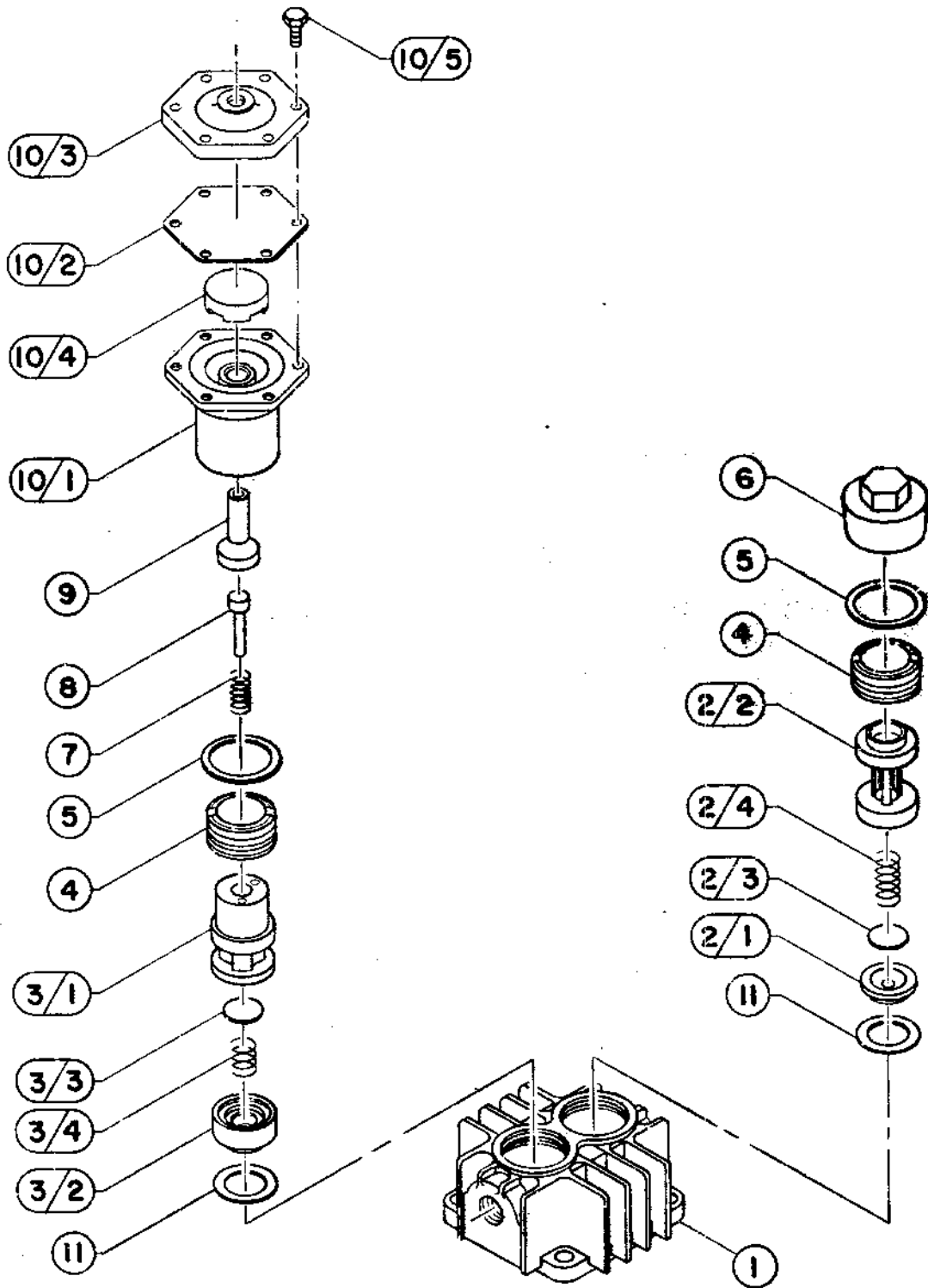
@ INDICATES TORQUE VALUE IN FOOT POUNDS ( DRY THREADS )

**MAINTENANCE PARTS**

1	1919X	REPLACEMENT VALVE ASSEMBLY-DISCHARGE
		INCLUDES:
1	1553X3	VALVE ASSEMBLY-DISCHARGE
1	1554	GASKET-VALVE
1	4610X	REPLACEMENT VALVE ASSEMBLY-SUCTION
		INCLUDES:
1	4610X1	VALVE ASSEMBLY-SUCTION
1	1554	GASKET-VALVE

NOTE: TIGHTEN ALL BOLTS & CAPSCREWS IN ANY BOLT PATTERN EVENLY BRINGING EACH BOLT TO TORQUE IN EVEN INCREMENTS WHILE MOVING ABOUT THE BOLT PATTERN. THIS IS PARTICULARLY TRUE OF CONNECTING ROD & HEAD BOLTS.

HEAD ASSEMBLY 1914U  
 (FOR LOADLESS VALVE COMPRESSOR)



**HEAD ASSEMBLY 1914U  
(FOR LOADLESS VALVE COMPRESSOR)**

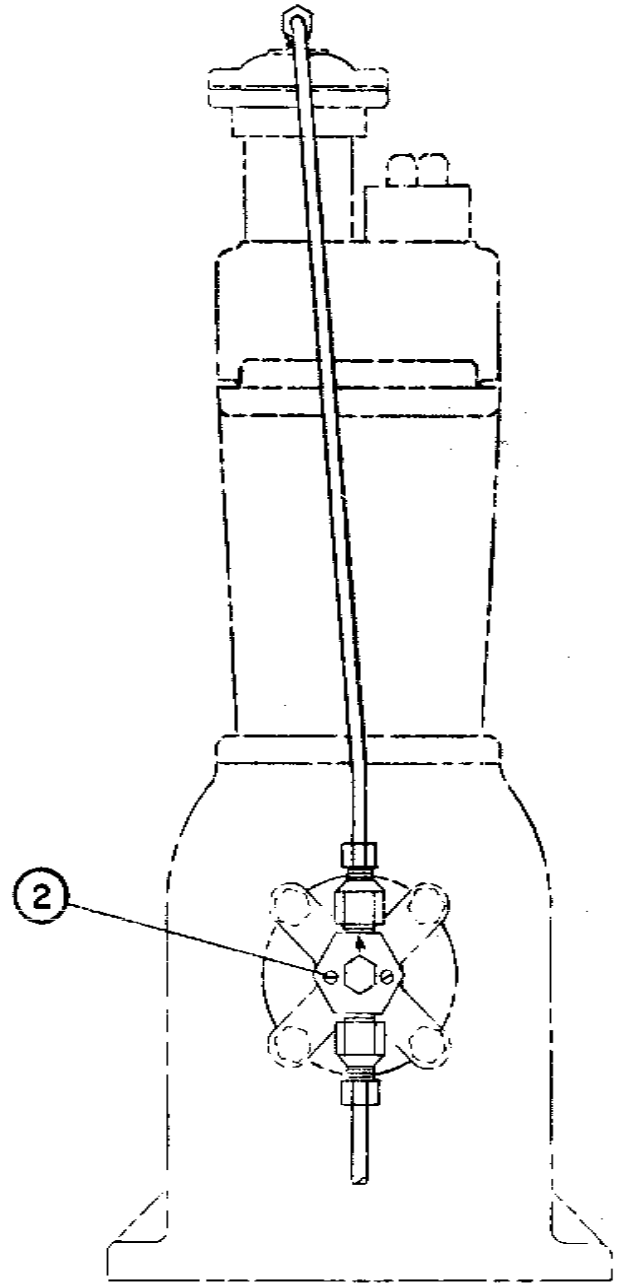
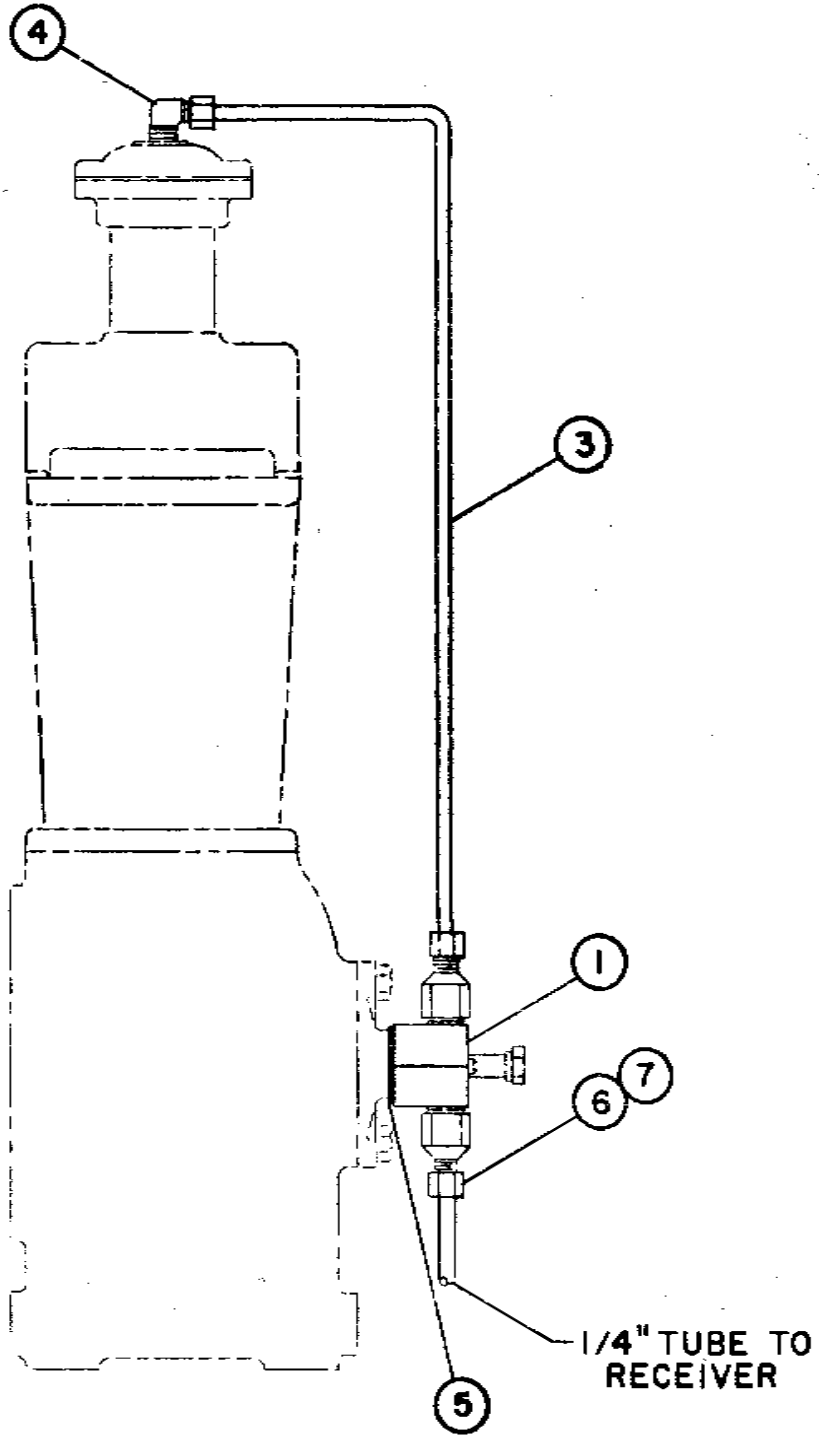
<b>INDEX NUMBER</b>	<b>Q T Y</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	1914	HEAD-CYLINDER
2	1	1553X3	VALVE ASSEMBLY-DISCHARGE
2/1	1	1553	SEAT-VALVE
2/2	1	3010	BUMPER-VALVE
2/3	1	1552	DISC-VALVE
2/4	1	1368	SPRING-VALVE
3	1	4610X1	VALVE ASSEMBLY-SUCTION
3/1	1	4610	SEAT-VALVE
3/2	1	1549	BUMPER-VALVE
3/3	1	1552	DISC-VALVE
3/4	1	1202	SPRING-VALVE
4	2	3008	SCREW-HOLDDOWN ( @ 85FT.-LBS. )
5	2	1556	GASKET-VALVE
6	1	1555	CAP-VALVE COVER
7	1	6945	SPRING-UNLOADER PLUNGER
8	1	6937	PLUNGER-UNLOADER
9	1	7532X	PISTON ASSEMBLY-UNLOADER
10	1	40192	UNLOADER ASSEMBLY ( @ 75FT.-LBS. ) (NOT SOLD SEPARATE;ORDER 8272X)
10/1	1	8272	BODY-UNLOADER
10/2	1	1855	DIAPHRAGM-UNLOADER
10/3	1	1818B	PLATE-DIAPHRAGM COVER
10/4	1	5910	DISC-DIAPHRAGM
10/5	6	7499	SCREW-HEX.,1/4-20 UNC X .75,GRADE 5 ( @ 8FT.-LBS. )
11	2	1554	GASKET-VALVE

@ INDICATES TORQUE VALUE IN FOOT POUNDS (DRY THREADS)

**MAINTENANCE PARTS**

1	1919X	<b>REPLACEMENT VALVE ASSEMBLY-DISCHARGE</b> INCLUDES:
1	1553X3	VALVE ASSEMBLY-DISCHARGE
1	1554	GASKET-VALVE
1	4610X	<b>REPLACEMENT VALVE ASSEMBLY-SUCTION</b> INCLUDES:
1	4610X1	VALVE ASSEMBLY-SUCTION
1	1554	GASKET-VALVE
1	8272X	<b>REPLACEMENT UNLOADER ASSEMBLY</b> INCLUDES:
1	7532X	PISTON ASSEMBLY-UNLOADER
1	1556	GASKET-VALVE
1	40192	UNLOADER ASSEMBLY ( @ 75FT.-LBS. ) (NOT SOLD SEPARATE;ORDER 8272X)

**NOTE: TIGHTEN ALL BOLTS & CAPSCREWS IN ANY BOLT PATTERN EVENLY BRINGING EACH BOLT TO TORQUE IN EVEN INCREMENTS WHILE MOVING ABOUT THE BOLT PATTERN. THIS IS PARTICULARLY TRUE OF CONNECTING ROD & HEAD BOLTS.**



CONTROL GROUP 110276  
(FOR LOADLESS COMPRESSOR)



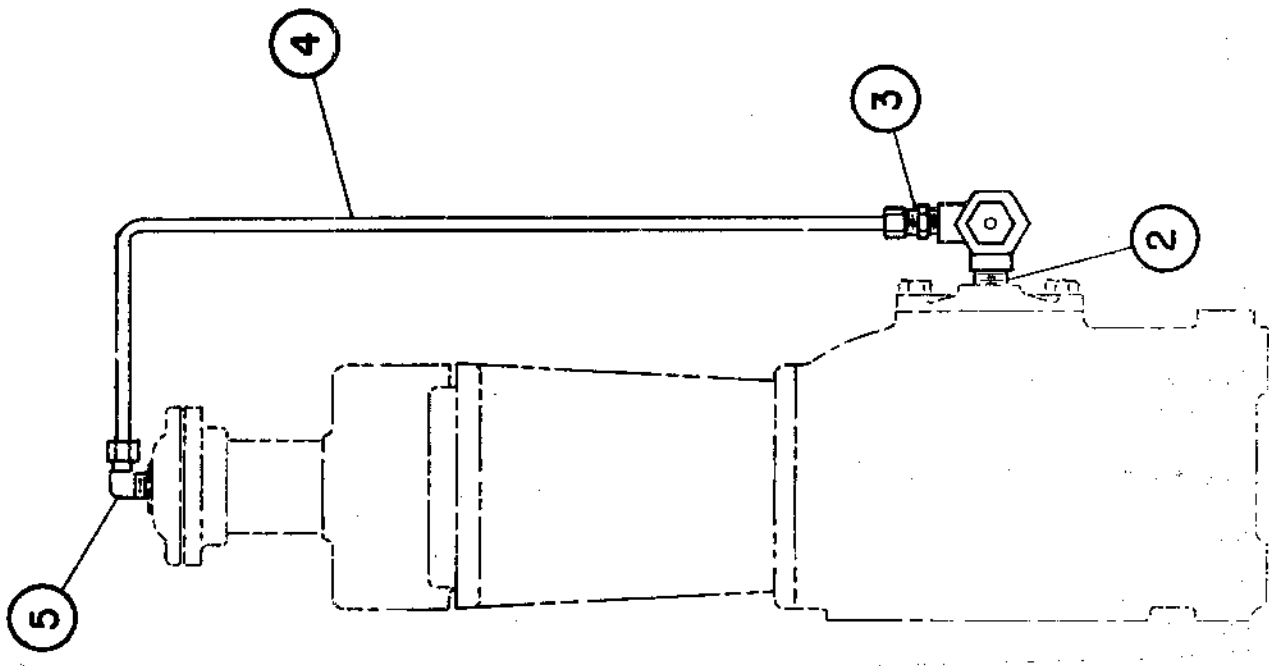
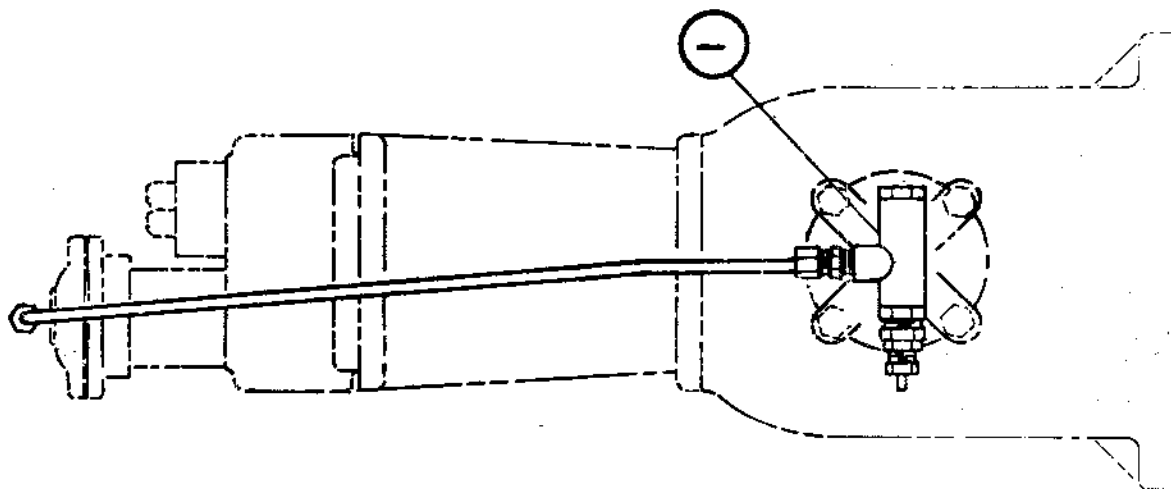
CONTROL GROUP 110276  
(FOR LOADLESS COMPRESSOR)

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INDEX NUMBER	Q T Y	PART NUMBER	DESCRIPTION
1	1	3444	VALVE-THREE WAY
2	2	2668	SCREW-THREE WAY VALVE MOUNTING
3	2FT	110515-025	TUBE-COPPER,1/4 O.D.
4	1	1642	FITTING-ELBOW,1/4 TUBE X 1/8 NPT
5	6	1591	SHIM-THREE WAY VALVE ADJUSTMENT

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CONTROL GROUP 110868  
(FOR PILOT CONTROLLED COMPRESSOR)



CONTROL GROUP 110868  
(FOR PILOT CONTROLLED COMPRESSOR)

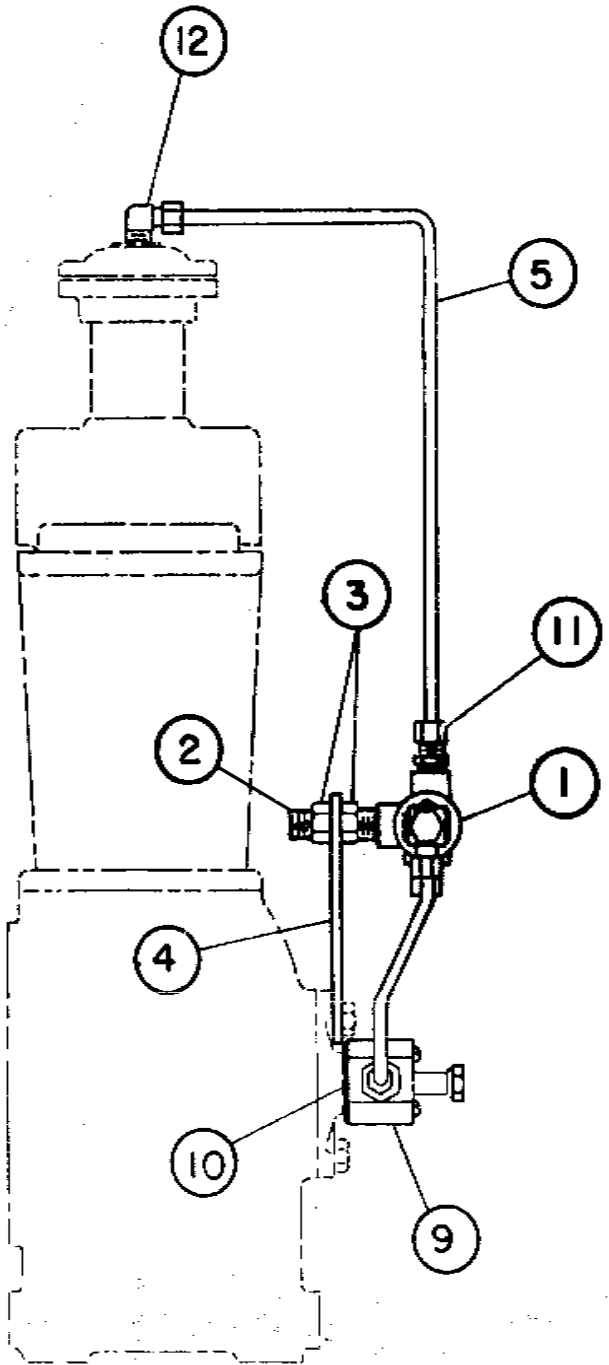
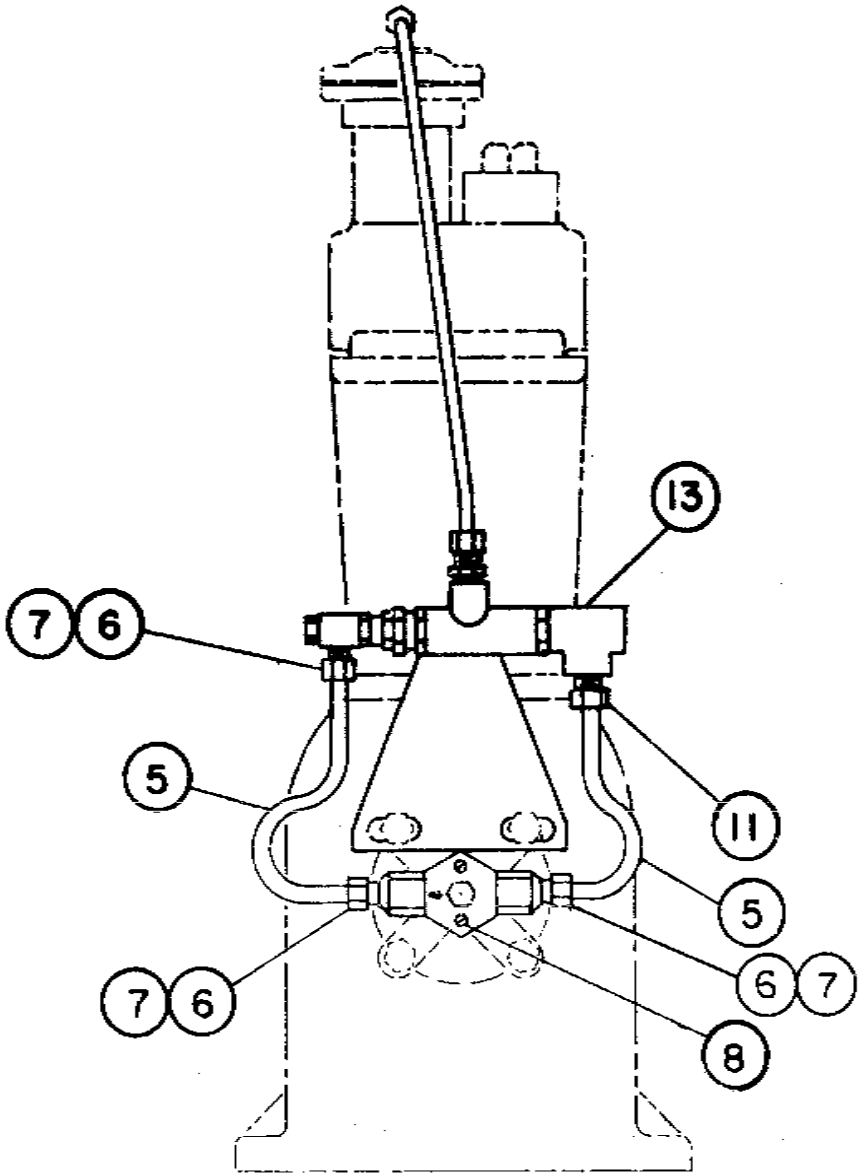
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INDEX NUMBER	Q T Y	PART NUMBER	DESCRIPTION
* 1	1	110832-100	PILOT
2	1	2189	STUD-PILOT MOUNTING
3	1	110594-005	FITTING-STRAIGHT, 1/4 TUBE X 1/4 NPT
4	2FT	110515-025	TUBE-COPPER, 1/4 O.D.
5	1	1642	FITTING-ELBOW, 1/4 TUBE X 1/8 NPT

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\* SEE PAGES 39 & 40 FOR OPTIONAL PILOTS THAT MUST BE USED WITH RESPECTIVE PRESSURE RANGES.

CONTROL GROUP 110869  
(FOR PILOT CONTROLLED COMPRESSOR WITH SAFE-Q-LUBE PROTECTION)



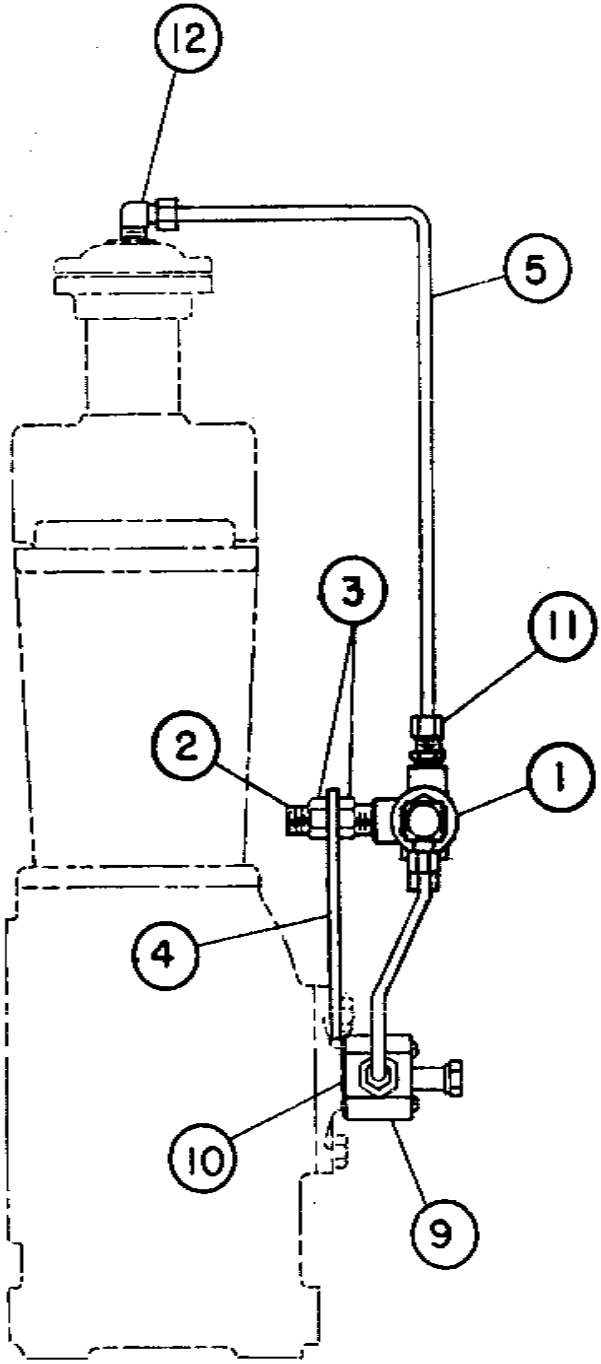
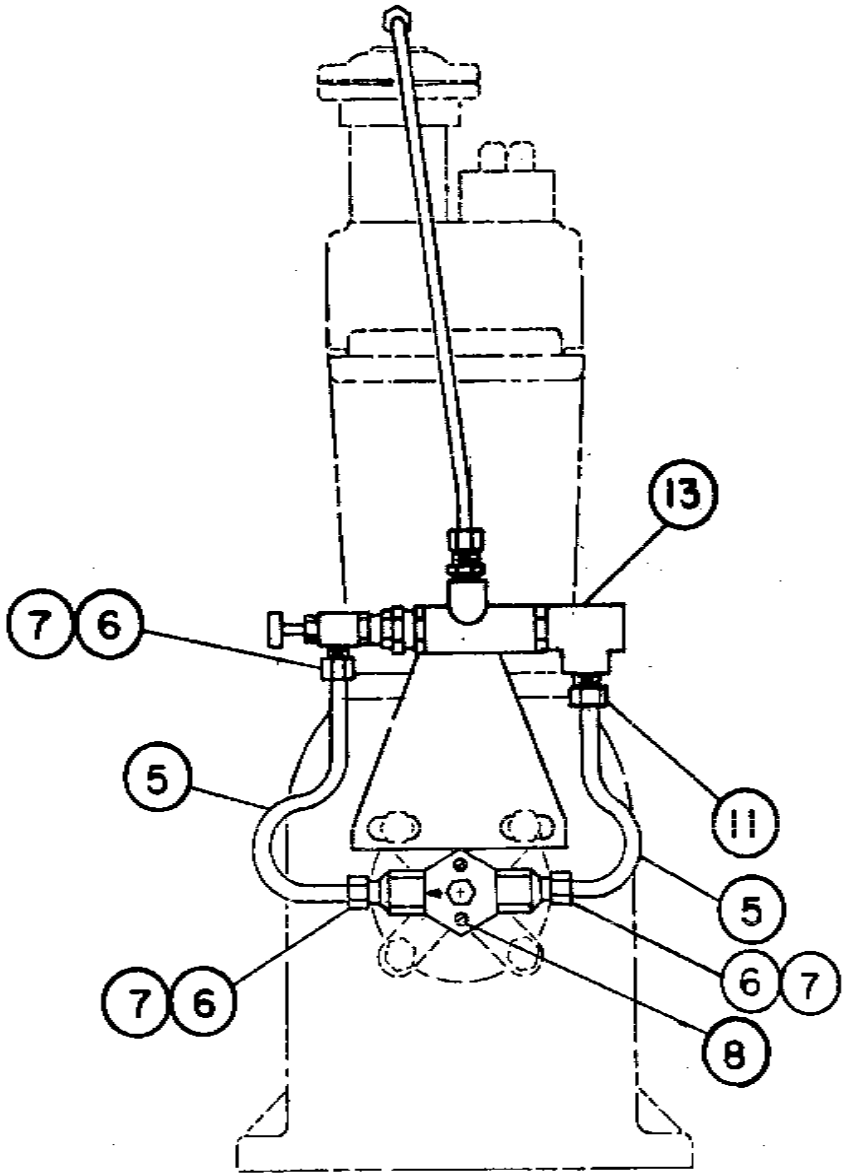
**CONTROL GROUP 110869  
(FOR PILOT CONTROLLED COMPRESSOR WITH SAFE-Q-LUBE PROTECTION)**

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INDEX NUMBER	Q T Y	PART NUMBER	DESCRIPTION
* 1	1	111422-100	PILOT VALVE
2	1	5631	STUD-PILOT MOUNTING
3	2	124364-N02	NUT-HEX., 1/2-13 UNC
4	1	5822	BRACKET-PILOT MOUNTING
5	3FT	110515-025	TUBE-COPPER, 1/4 O.D.
6	1	2708	FITTING-TUBE, 90 MALE ELBOW 1/4 TUBE X 1/4 NPT
7	1	1643	FITTING-STRAIGHT, 1/4 TUBE X 1/8 NPT
8	2	2668	SCREW-THREE WAY VALVE MOUNTING
9	1	3444	VALVE-THREE WAY
10	6	1591	SHIM-THREE WAY VALVE ADJUSTMENT
11	2	110594-005	FITTING-TUBE, MALE CONNECTOR 1/4 TUBE X 1/4 NPT
12	1	1642	FITTING-TUBE, 90 MALE ELBOW 1/4 TUBE X 1/8 NPT
13	1	7361	TEE-PIPE, 1/4 NPT X 1/4 NPT X 1/4 NPT, BRASS

\* SEE PAGES 39 & 40 FOR OPTIONAL PILOTS THAT MUST BE USED WITH RESPECTIVE PRESSURE RANGES.

CONTROL GROUP 110870  
(FOR COMPRESSOR WITH DUAL CONTROL & SHUTOFF VALVE)

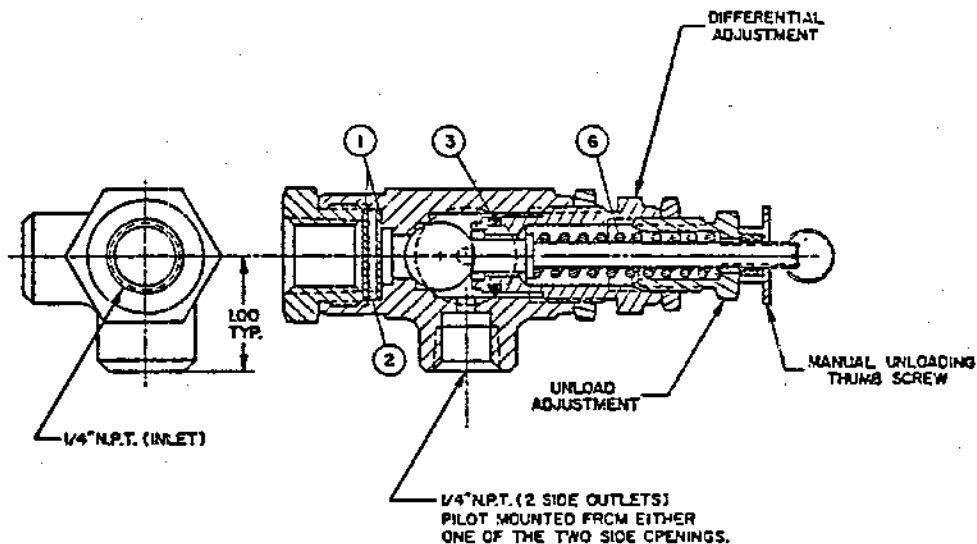


**CONTROL GROUP 110870  
(FOR COMPRESSOR WITH DUAL CONTROL & SHUTOFF VALVE)**

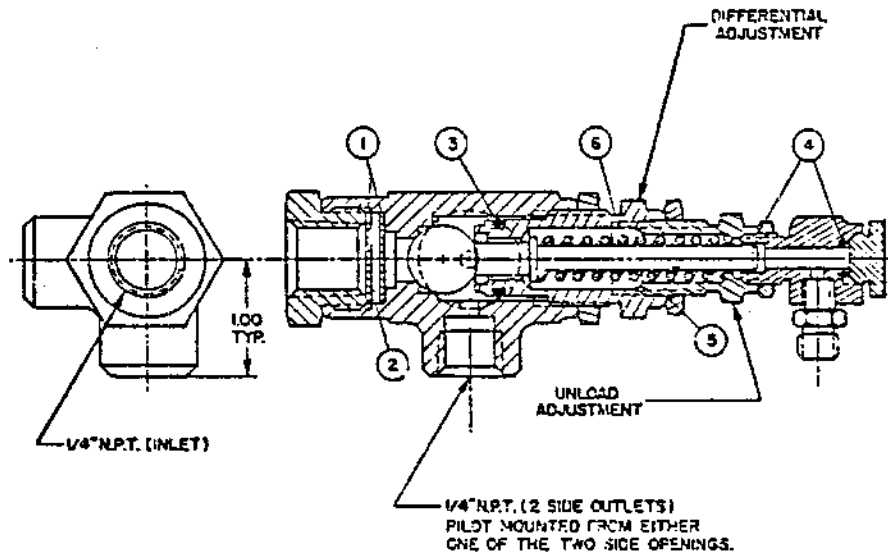
INDEX NUMBER	Q T Y	PART NUMBER	DESCRIPTION
* 1	1	111423-100	PILOT (STANDARD)
2	1	5631	STUD-PILOT MOUNTING
3	2	124364-N02	NUT-HEX.,1/2-13 UNC
4	1	5822	BRACKET-PILOT MOUNTING
5	3FT	110515-025	TUBE-COPPER,1/4 O.D.
6	1	1642	FITTING-TUBE,90 MALE ELBOW 1/4 TUBE X 1/8 NPT
7	1	7361	TEE-PIPE,1/4 NPT X 1/4 NPT X 1/4 NPT,BRASS
8	2	2668	SCREW-THREE WAY VALVE MOUNTING
9	1	3444	VALVE-THREE WAY
10	6	1591	SHIM-THREE WAY VALVE ADJUSTMENT
11	2	110594-005	FITTING-TUBE,MALE CONNECTOR 1/4 TUBE X 1/4 NPT

\* SEE PAGES 35 & 36 FOR OPTIONAL PILOTS THAT MUST BE USED WITH RESPECTIVE PRESSURE RANGES.

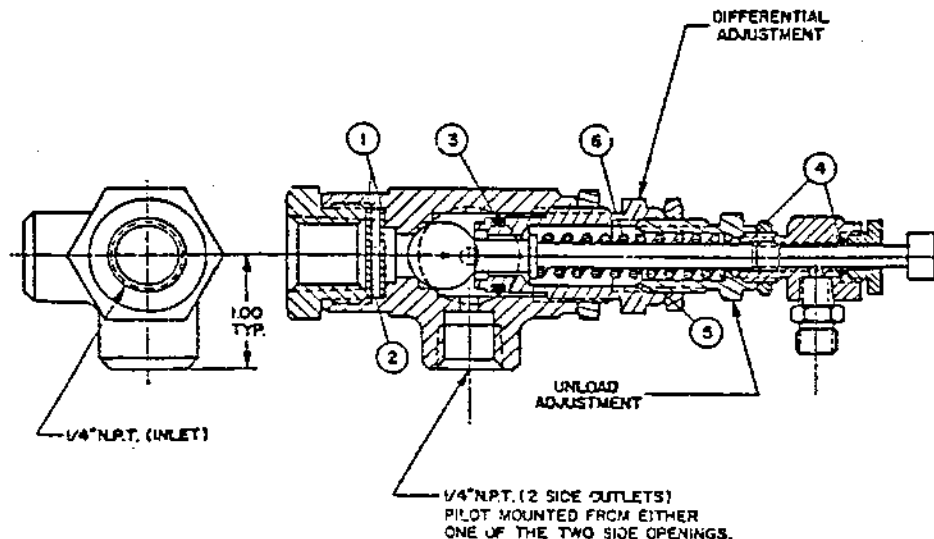
**PILOT ASSEMBLIES  
FOR COMPRESSORS WITH PILOT CONTROL  
PART NUMBER 110832-\_\_\_**



**FOR COMPRESSORS WITH DUAL CONTROL  
PART NUMBER 110833-\_\_\_**



**FOR COMPRESSORS WITH DUAL CONTROL WITH PILOT LOCKOUT  
PART NUMBER 110834-\_\_\_**





**PILOT ASSEMBLIES**

<u>DASH NO.</u>	<u>PRESSURE SETTING</u>
-080	FACTORY PRESET 70 P.S.I. LOAD TO 80 P.S.I. UNLOAD
-100	FACTORY PRESET 90 P.S.I. LOAD TO 100 P.S.I. UNLOAD
-110	FACTORY PRESET 100 P.S.I. LOAD TO 110 P.S.I. UNLOAD
-140	FACTORY PRESET 130 P.S.I. LOAD TO 140 P.S.I. UNLOAD
-150	FACTORY PRESET 135 P.S.I. LOAD TO 150 P.S.I. UNLOAD
-997	** 30 TO 70 P.S.I. ADJUSTABLE UNLOAD PRESSURE
-998	** 71 TO 150 P.S.I. ADJUSTABLE UNLOAD PRESSURE
	** CUSTOMER TO SET- SEE DIFFERENTIAL SETTING CHART BELOW

**WARNING: NOT ALL PILOTS ARE FOR USE WITH ALL COMPRESSOR SYSTEMS. MAKE SURE THAT THE PILOT YOU ORDER IS SET WITHIN THE SAFE OPERATING LIMITS OF YOUR SYSTEM. FAILURE TO HEED THIS WARNING COULD RESULT IN AN EXPLOSION!**

PILOT REPAIR KIT 110832-051

ITEM NO.	QTY	DESCRIPTION
1	2	SCREEN
2	1	FILTER
3	1	"O"RING
4	1	"O"RING
5	1	"O"RING

PILOT REPLACEMENT SPRINGS (ITEM NO. 6 ON DRAWING)

SPRING NO.	UNLOAD P.S.I. RANGE	COLOR CODE
110832-052	30-70	RED
110832-053	71-150	YELLOW

DIFFERENTIAL SETTING CHART

SPRING NO.	UNLOAD P.S.I.	MINIMUM DIFFERENTIAL P.S.I.	MAXIMUM DIFFERENTIAL P.S.I.
110832-052	30	2	4
"	40	5	8
"	50	5	8
"	60	5	8
"	70	5	10
110832-053	80	5	10
"	90	5	12
"	100	5	13
"	110	5	15
"	120	5	15
"	130	5	18
"	140	5	18
"	150	5	20

## PILOT ASSEMBLIES

### INSTRUCTIONS

#### QUINCY BALL TYPE UNLOADER PILOT PART NOS 110832, 110833, & 110834 MAXIMUM OPERATING PRESSURE 150 LBS.

### APPLICATION

Suction valve unloaders are recommended for use on Quincy compressors where the compressor is to run continuously and a constant pressure is to be maintained. The purpose is to automatically unseat the suction valve of the compressor when the air supply is greater than the demand.

The Quincy suction unloader consists of unloading arrangements on the suction valves, having a plunger to contact the suction valve disc and an unloader pilot to automatically regulate the passing of receiver pressure to the unloading arrangement.

### OPERATION

Unloading occurs when receiver pressure is sufficient to overcome pilot spring pressure. The check ball is then unseated allowing receiver pressure to pass to the unloading arrangements. The compressor will then run unloaded until the receiver pressure drops to a predetermined level. At this time the action of the ball is reversed, shutting off receiver pressure to the unloader arrangement and venting the unloader to atmosphere. This allows the compressor to load. The drive, either electric motor or gasoline engine, runs continuously and must be started and stopped manually.

Pilot (#110834) for dual control models has a shut off feature built in. The knurled knob at the top of the pilot is turned clockwise all the way to lock out the pilot. In this mode, a pressure switch is required to stop

the motor. **CAUTION!** Do not use this pilot without a pressure switch. If the pilot is locked out without another device to control the compressor, pressure could rise to an unsafe level causing an explosion. With the knob turned counterclockwise all the way, the pilot functions as shown as above.

### INSTALLATION

The unloader pilot is to be connected to the air receiver using a minimum of 3/8" Q.D. copper tube. Plain machines in field service can be converted to constant speed by installing valve unloaders and an unloader pilot.

### SERVICE

The unloader ball is the only vital moving part in the Quincy ball type unloader pilot and should run for a long period without servicing, providing the inlet filter is kept clean and the pilot is clean inside.

The unloading pressure is adjustable and is regulated by the screw (see cross sectional illustrations of pilot valves) marked "UNLOAD ADJ." (turn clockwise to increase and counterclockwise to decrease). **WARNING: DO NOT SET THE PILOT HIGHER THAN THE SAFE OPERATING LIMITS OF YOUR SYSTEM. FAILURE TO HEED THIS WARNING COULD RESULT IN AN EXPLOSION!**

The differential (difference between unloading and loading pressure) is set by an adjusting screw marked "DIFFERENTIAL ADJ." (see cross section illustration of pilot valve) increase by turning clockwise, decrease by turning counterclockwise. Tighten locknuts after adjustment.

**GASKET SETS & "O"RING KITS**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
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**MODEL 106**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
		<b>3713</b>	<b>GASKET SET</b>
2		1556	GASKET-VALVE
2		1554	GASKET-VALVE
1		1592	GASKET-BEARING CARRIER
1		1593	GASKET-CYLINDER TO CRANKCASE
1		1599	GASKET-INSPECTION PLATE
1		1644	SHIM-.005" THICK STEEL BEARING ADJUSTMENT
2		1644A	SHIM-.007" THICK STEEL BEARING ADJUSTMENT
3		1644B	SHIM-.020" THICK STEEL BEARING ADJUSTMENT
2		1644C	SHIM-.005" THICK PAPER BEARING ADJUSTMENT
2		1644D	SHIM-.002" THICK PLASTIC BEARING ADJUSTMENT
1		1945	GASKET-CYLINDER HEAD

**MODEL 108**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
		<b>3714</b>	<b>GASKET SET</b>
2		1554	GASKET-VALVE
2		1556	GASKET-VALVE
1		1592	GASKET-BEARING CARRIER
1		1593	GASKET-CYLINDER TO CRANKCASE
1		1599	GASKET-INSPECTION PLATE
1		1644	SHIM-.005" THICK STEEL BEARING ADJUSTMENT
2		1644A	SHIM-.007" THICK STEEL BEARING ADJUSTMENT
3		1644B	SHIM-.020" THICK STEEL BEARING ADJUSTMENT
2		1644C	SHIM-.005" THICK PAPER BEARING ADJUSTMENT
2		1644D	SHIM-.002" THICK PLASTIC BEARING ADJUSTMENT
1		1946	GASKET-CYLINDER HEAD

**"O"RING KITS FOR 106 OR 108 MODELS**

**PETROLEUM BASE**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
		<b>110771-001</b>	<b>"O"RING KIT</b>
1		123157-112	"O"RING-3/32 WIDE X .69 O.D. (BAYONET OIL GAUGE)
1		1B55	DIAPHRAGM-UNLOADER

**DIESTER BASE**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
		<b>110287-001</b>	<b>"O"RING KIT</b>
1		22749-112	"O"RING-3/32 WIDE X .69 O.D. (BAYONET OIL GAUGE)
1		1B55	DIAPHRAGM-UNLOADER

**PHOSPHATE ESTER BASE**

<b>INDEX NUMBER</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
		<b>110292-001</b>	<b>"O"RING KIT</b>
1		22749-112	"O"RING-3/32 WIDE X .69 O.D. (BAYONET OIL GAUGE)
2		1B55S	DIAPHRAGM-UNLOADER

**RECOMMENDED SPARE PARTS**

<b>INDEX NUMBER</b>	<b>Q T Y</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
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**MODEL 106**

	2	1855	DIAPHRAGM-UNLOADER
	OR		
*	2	1855S	DIAPHRAGM-UNLOADER
	1	4610X1	VALVE ASSEMBLY-SUCTION
	1	1553X3	VALVE ASSEMBLY-DISCHARGE
	1	110832-051	PILOT REPAIR KIT
	1	3713	GASKET SET-COMPLETE COMPRESSOR OVERHAUL
	1	110377E075	ELEMENT-AIR FILTER

**MODEL 108**

	2	1855	DIAPHRAGM-UNLOADER
	OR		
*	2	1855S	DIAPHRAGM-UNLOADER
	1	4610X1	VALVE ASSEMBLY-SUCTION
	1	1553X3	VALVE ASSEMBLY-DISCHARGE
	1	110832-051	PILOT REPAIR KIT
	1	3714	GASKET SET-COMPLETE COMPRESSOR OVERHAUL
	1	110377E075	ELEMENT-AIR FILTER

\* FOR PHOSPHATE ESTER SYNTHETIC LUBRICATED MODELS

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