



an EnPro Industries company

QR-25[®] Series Model 325

Parts Manual
Record of Change 106

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

Manual No. 50215-106

October 2006 Edition

INTRODUCTION

This manual provides information for the following QR-25 Series, Model 325 (Record of Change 106) compressor versions:

- L Control Version L**
head assembly with 1 unloader tower & a hydraulic unloader
- LS Control Version LS**
head assembly with 2 unloader towers, a hydraulic unloader, & a pilot valve with a check valve assembly
- LVD Control Version LVD**
head assembly with 2 unloader towers, a hydraulic unloader, & a pilot valve with a lockout & check valve

These compressors are aircooled, two stage, two cylinder, pressure lubricated compressors, with up to 200 PSI continuous pressure capability (*201 to 500 PSI intermittent pressure capability with proper configuration; consult factory*). The Model 325 has a 4.5" low pressure piston bore and a 2.5" high pressure piston bore and a 3" stroke and can be run at 400-900 RPM.

- Available options included in this manual:
- high pressure rated cylinder and head
 - spin-on oil filter
 - hooded air filter
 - hooded air filter / silencer

CHANGES

since previous printing dated March 2005:

Control groups were redesigned.

TABLE OF CONTENTS

Serial Number Identification 2

Ordering Replacement Parts 2

Quin-Cip Lubricant 2

Crankcase Lubricant Capacity 2

Crankshaft Group 3-4

Crankcase Group 5-6

Bearing Carrier Groups

 with oil filter 7-8

 less oil filter 9-10

Connecting Rod & Piston Groups

 High Pressure 11-12

 Low Pressure 13-14

Cylinder & Head Groups

 Control Version L 15-16

 Control Versions LS, LVD 17-18

Head Assemblies

 Control Version L 19-20

 Control Versions LS, LVD 21-22

Control Groups

 Version L 23

 Version LS 24-25

 Version LVD 26-27

Pilot Valves 28

Pilot Valve Repair Kit 28

Differential Setting Charts 28

Suction Valve Unloader Assemblies 29

Gasket Set 30

Kits 30

Recommended Spare Parts 31

Decals 31

Typical Unit Repair Parts List 32-34

MODEL & SERIAL NUMBER IDENTIFICATION

Record
of
Change No.

MODEL		
SERIAL NO.		

110831 

**Model & Serial Number
Identification Tag**

The model & serial number tag is located on the handhole plate side of the crankcase. Fill in the numbers from your compressor's tag in the corresponding spaces provided here and reference this page when ordering replacement parts.

All replacement parts are to be ordered through an authorized Quincy distributor. Insist on genuine Quincy parts only! Failure to do so may void warranty.

ORDERING REPLACEMENT PARTS

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

- Item 1)** the model number, record of change number, & serial number.
- Item 2)** the exact part number needed. (Do not order by item numbers.)
- Item 3)** the exact quantity needed.
- Item 4)** the preferred type of transportation

QUIN-CIP® LUBRICANT

Refer to the chart below to order Quin-Cip compressor lubricant from your local authorized Quincy distributor.

Package	Part No.	Description
Barrel	112541D032	55 gal., SAE 10W
Pail	112541P032	5 gal., SAE 10W
Gallon	112541G032	1 gal., SAE 10W
Gallon Case	112541X032	(4)-1 gal., SAE 10W
Quart	112541Q032	1 qt., SAE 10W
Quart Case	112541C032	(12)-1 qt., SAE 10W
Barrel	112542D068	55 gal., SAE 20
Pail	112542P068	5 gal., SAE 20
Gallon	112542G068	1 gal., SAE 20
Gallon Case	112542X068	(4)-1 gal., SAE 20
Quart	112542Q068	1 qt., SAE 20
Quart Case	112542C068	(12)-1 qt., SAE 20
Barrel	112543D100	55 gal., SAE 30
Pail	112543P100	5 gal., SAE 30
Gallon	112543G100	1 gal., SAE 30
Gallon Case	112543X100	(4)-1 gal., SAE 30
Quart	112543Q100	1 qt., SAE 30
Quart Case	112543C100	(12)-1 qt., SAE 30

CRANKCASE LUBRICANT CAPACITY

Model	Less Filter	With Filter
325	1½ Qts.(1.42 lit.)	Add 10oz.(296 ml)

CAUTION !

Refer to the Quincy QR-25 Series instruction manual for vital lubrication information.

CAUTION !

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

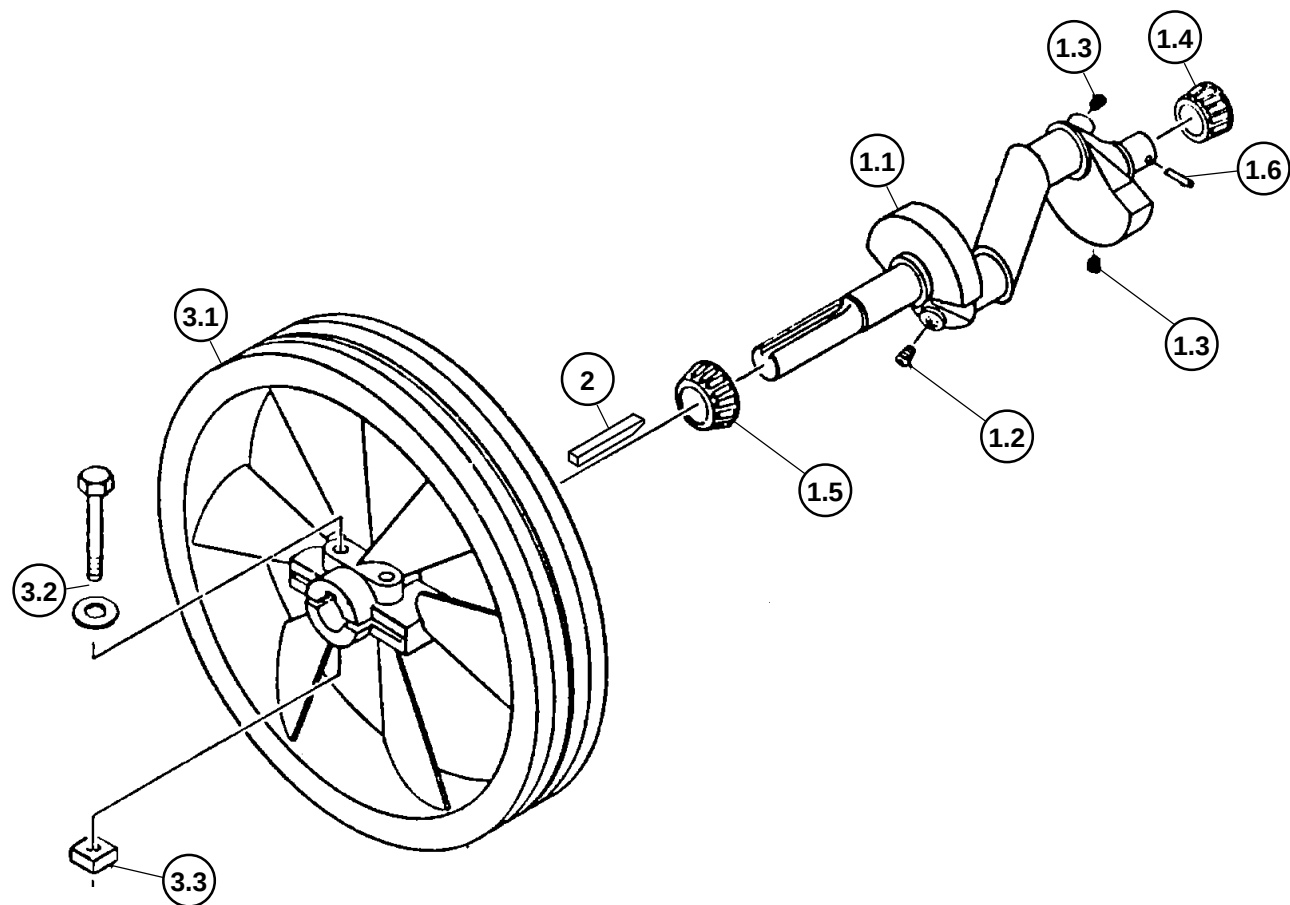
WARNING !

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

DANGER !

Air used for breathing or food processing must meet OSHA 1910.134 or FDA 21 CFR 178.3570 regulations. Failure to do so may cause severe injury or death.

CRANKSHAFT GROUP 110238



CRANKSHAFT GROUP 1 10238

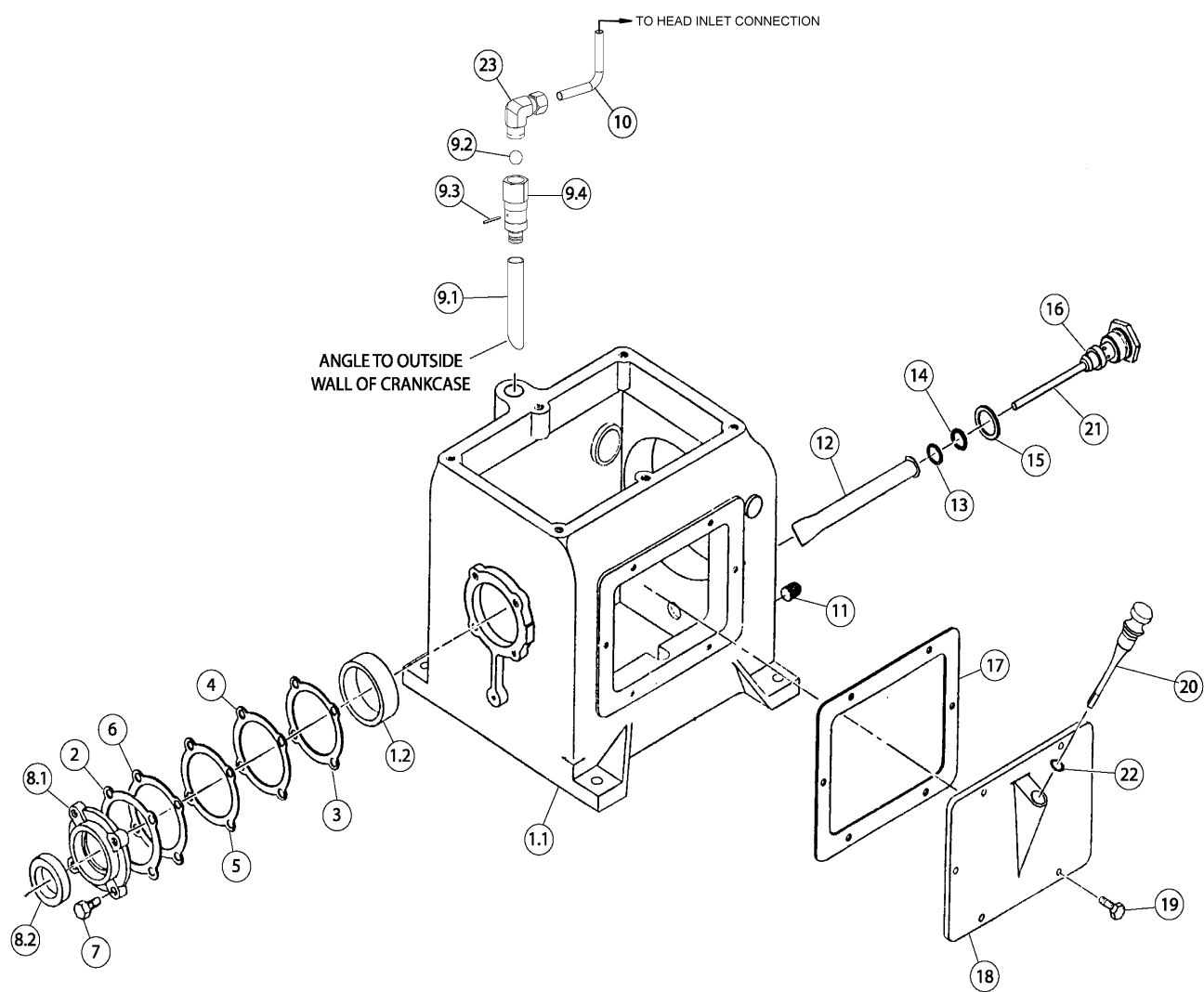
Item Number	Qty.	Part Number	Description
1	1	110217	crankshaft assembly
1.1	1	110216	crankshaft (N.S.S.; order 110217)
1.2	1	110234	orifice, 1/8 npt
1.3	2	2755S	pipe plug, 1/8 npt
1.4	1	2585	bearing cone
1.5	1	2788	bearing cone
1.6	1	110705-F15	pin
2	1	1466	key
3	1	110472X	sheave assembly
3.1	1	4126R	sheave , 16", 2 groove, B sect., ccw (N.S.S.; order 110472X)
3.2	2	123478-N23	hex. screw, 1/2-13 unc x 3.50, grade 5 (@ 75 ft.-lbs.)
3.3	2	124372-N02	square nut, 1/2-13 unc

N.S.S. = Not Sold Separate

@ Indicates torque value in foot pounds (dry threads)

Note: For reversal of compressor rotation refer to QR-25 instruction manual.

CRANKCASE GROUP 110237



CRANKCASE GROUP 1 10237

Item Number	Qty.	Part Number	Description
1	1	5503X003	crankcase assembly
1.1	1	5503-003	crankcase
1.2	1	2720	bearing cup
2	*	6294D	bearing adj. shim, .002 steel
3	*	6294	bearing adj. shim, .005 steel
4	*	6294A	bearing adj. shim, .007 steel
5	*	6294B	bearing adj. shim, .020 steel
6	*	6294C	bearing adj. shim, .005 paper
7	4	123478-L10	hex. screw, 3/8-16 unc x .75, grade 5 (@ 30 ft.-lbs.)
8	1	5506X1	bearing adjustment plate assembly
8.1	1	5506	adjustment plate
8.2	1	6316	oil seal
9	1	112031X001	breather assembly
9.1	1	112032-001	breather tube
9.2	1	5783-002	breather ball
9.3	1	110705-C11	roll pin, 3/32 x .81
9.4	1	112031-001	breather body
10	3 ft.	110515-031	copper tube, 5/16 o.d.
11	1	1301	pipe plug, 3/8 npt
12	1	6272	screen
13	1	6313	gasket, inlet screw
14	1	123157-116	"o"ring, 3/32 wide x .94 o.d.
15	1	6275	gasket, inlet screw
‡ 16	1	6273	inlet screw
17	1	1840	gasket, inspection plate
18	1	2322-1	inspection plate, oil filler type
19	6	123478-K12	hex. screw, 5/16-18 unc x 1.00, grade 5 (@ 12 ft.-lbs.)
20	1	110070-3	oil gauge
‡ 21	1	8270	inlet tube
22	1	123157-112	"o"ring, 3/32 wide x .69 o.d.
23	1	110919-010	tube fitting, 5/16 tube x 3/8 npt, 90°
Maintenance Parts			
8.2	1	6316	oil seal
Parts for use with diester or phosphate ester synthetic based lubricants			
10.1	1	22749-111	"o"ring, 3/32 wide x .62 o.d.
14	1	22749-116	"o"ring, 3/32 wide x .94 o.d.
22	1	22749-112	"o"ring, 3/32 wide x .69 o.d.

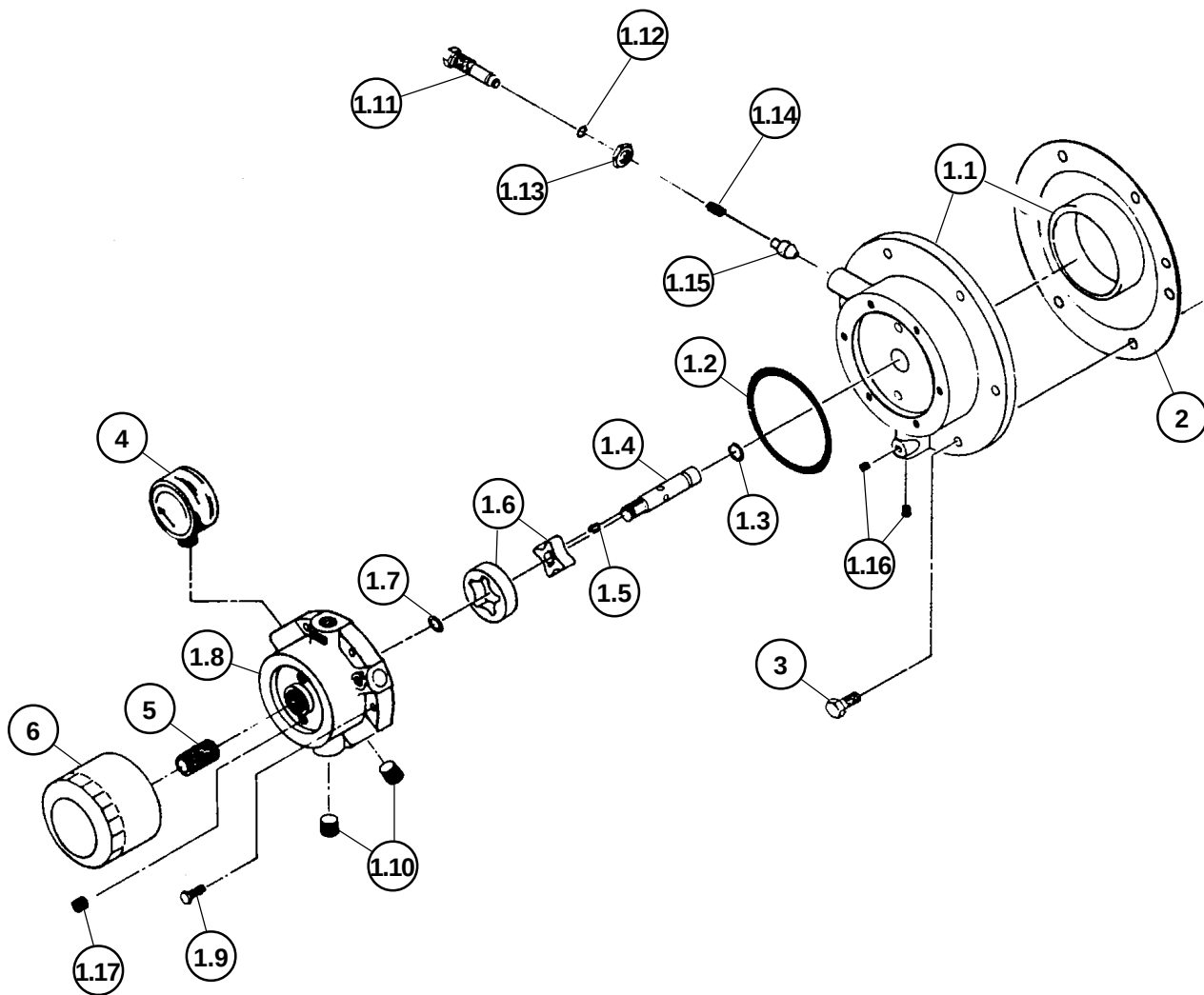
* Quantity as required

@ Indicates torque value (dry threads).

‡ Assemble item 21 into item 16 with Loctite® 609.

BEARING CARRIER GROUP 110816-001

(with oil filter)



BEARING CARRIER GROUP 110816-001

(with oil filter)

Item Number	Qty.	Part Number	Description
* 1	1	110810-003	bearing carrier assembly (N.S.S.; order 110810X003)
1.1	1	110810	bearing carrier (N.S.S.; order 110810X003)
	1	2523	bearing cup
	2	160005	bushing
* 1.2	1	123157-152	"o"ring, 3/32 wide x 3.44 o.d.
* 1.3	1	123157-112	"o"ring, 3/32 wide x .69 o.d.
1.4	1	160002-002	driveshaft
1.5	1	160075-001	driveshaft key
1.6	1	160003	pump gerotor
1.7	1	6285	retaining ring
1.8	1	110813-001	oil pump housing
1.9	6	123777-J12	hex. screw, 1/4-20 unc x 1.00, grade 5 (@ 6 ft.-lbs.)
§ 1.10	2	2719	pipe plug, 1/4 npt, hex socket
1.11	1	5489	adjustment screw
* 1.12	1	123157-011	"o"ring, 1/16 wide x .44 o.d.
1.13	1	124369-P02	jamnut, 9/16-18 unf
1.14	1	1160	spring
1.15	1	112857	needle valve
1.16	2	6565	hole plug
1.17	1	2755S	pipe plug, 1/8 npt
2	1	6312	gasket, bearing carrier
3	6	123478-L12	hex. screw, 3/8-16 unc x 1.00, grade 5 (@ 30 ft.-lbs.)
§ 4	1	110822	oil pressure gauge
5	1	110825	stud
Maintenance Parts			
* 6	1	110814-001	6 pack of oil filters
		160078	Oil Pump Repair Kit
			includes "o"rings, driveshaft, key, pump gerotor, & retaining ring
		110810X003	Replacement Bearing Carrier Assembly
			includes bearing carrier assy., oil filter, stud, & bearing carrier gasket

N.S.S. = Not Sold Separate

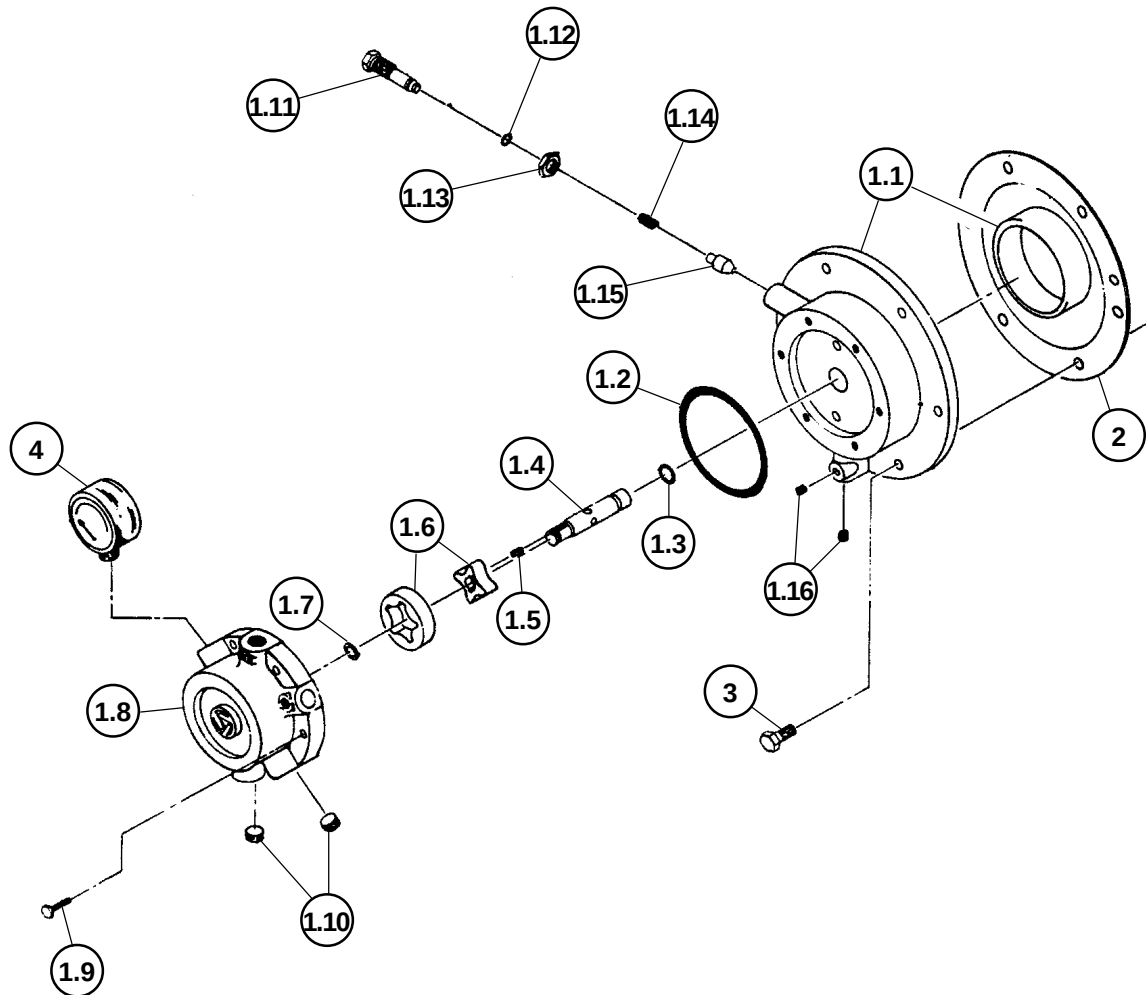
@ Indicates torque value (dry threads). Tighten multiple bolts, capscrews & hex nuts in a criss-cross or alternating pattern. Bring each fastener to the recommended torque specification in even increments.

* Can not be used with diester or phosphate ester synthetic lubricants.

§ Install with Teflon® tape.

BEARING CARRIER GROUP 110816

(less oil filter)



BEARING CARRIER GROUP 110816

(less oil filter)

Item Number	Qty.	Part Number	Description
1	1	110810-002	bearing carrier assembly (N.S.S.; order 110810X002)
1.1	1	110810	bearing carrier (N.S.S.; order 110810X003)
	1	2523	bearing cup
	2	160005	bushing
*	1.2	123157-152	"o"ring, 3/32 wide x 3.44 o.d.
*	1.3	123157-112	"o"ring, 3/32 wide x .69 o.d.
	1.4	160002-002	driveshaft
	1.5	160075-001	driveshaft key
	1.6	160003	pump gerotor
	1.7	6285	retaining ring
	1.8	110813	housing
	1.9	123777-J12	hex. screw, 1/4-20 unc x 1.00, grade 5 (@ 6 ft.-lbs.)
§	1.10	2719	pipe plug, 1/4 npt, hex socket
	1.11	5489	adjustment screw
*	1.12	123157-011	"o"ring, 1/16 wide x .44 o.d.
	1.13	124369-P02	jamnut, 9/16-18 unf
	1.14	1160	spring
	1.15	112857	needle valve
	1.16	6565	hole plug
2	1	6312	gasket, bearing carrier
3	6	123478-L12	hex. screw, 3/8-16 unc x 1.00, grade 5 (@ 30 ft.-lbs.)
§ 4	1	110822	oil pressure gauge

Maintenance Parts

160078

Oil Pump Repair Kit

includes "o"rings, driveshaft, key, & retaining ring

110810X002

Replacement Bearing Carrier Assembly

includes "o"rings, driveshaft, key, pump gerotor, & retaining ring

Parts for use with diester or phosphate ester synthetic based lubricants

1.2	1	22749-152	"o"ring, 3/32 wide x 3.44 o.d.
1.3	1	22749-112	"o"ring, 3/32 wide x .69 o.d.
1.12	1	22749-011	"o"ring, 1/16 wide x .44 o.d.

160078-001

Oil Pump Repair Kit

includes "o"rings, driveshaft, key, pump gerotor, & retaining ring

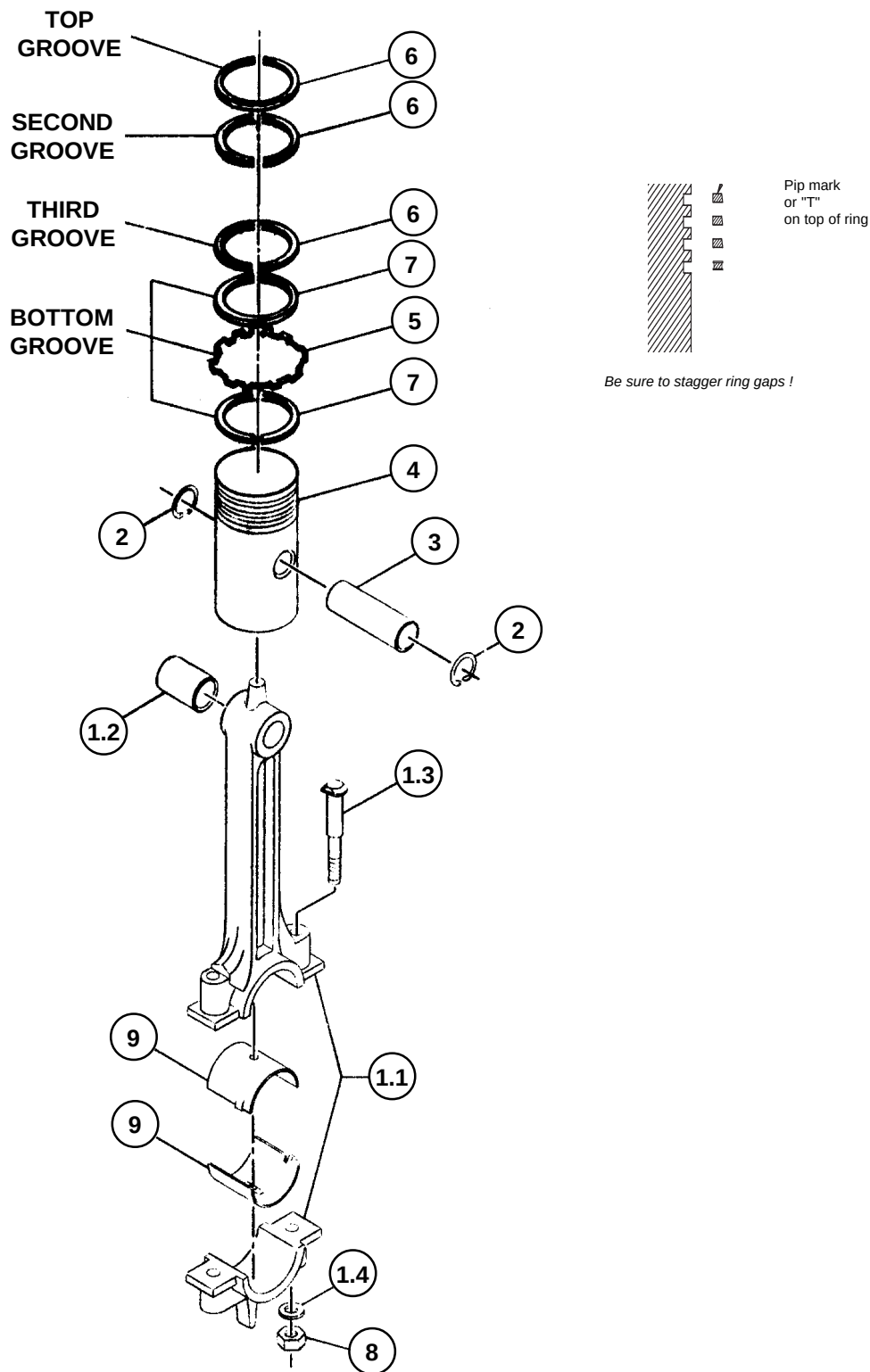
N.N.S. = Not Sold Separate

@ Indicates torque value (dry threads). Tighten multiple bolts, capscrews & hex nuts in a criss-cross or alternating pattern. Bring each fastener to the recommended torque specification in even increments.

§ Install with Teflon® tape.

CONNECTING ROD & PISTON GROUP 110248

(high pressure)



CONNECTING ROD & PISTON GROUP 1 10248

(high pressure)

Item Number	Qty.	Part Number	Description
1	1	40201	connecting rod assembly (N.S.S.; order 6442HPX)
1.1	1	6442C- HP	rod, connecting (N.S.S.; see maintenance parts)
1.2	1	6443	bushing, connecting rod (N.S.S.; order 6440SR)
1.3	2	3493	connecting rod bolt
1.4	2	1836	washer
2	2	8648	retaining ring
3	1	110190-021	piston pin
4	1	1530-001	piston , high pressure
5	1	111280	oil ring expander
6	3	1652	piston ring
7	2	111281	oil ring rail
8	2	124471-L08	locknut, 3/8-24 unf (@ 35 ft.-lbs.)
9	2	6444	insert, connecting rod (N.S.S.; see maintenance parts)
Maintenance Parts			
* 9	1	6444PR	inserts, connecting rod (1 pair, standard size)
* 9	1	6444-010PR	inserts, connecting rod (1 pair, .010 undersize)
1.2	1	6440SR	replacement connecting rod bushing
4	1	1530-011	piston, high pressure (.010 oversize)
4	1	1530-021	piston, high pressure (.020 oversize)
	1	8161A	Piston Ring Set (standard) includes piston rings, oil ring rails & expander
	1	4422-010	Piston Ring Set (.010 oversize, light blue color code) includes includes piston rings, oil ring rails & expander
	1	4422-020	Piston Ring Set (.020 oversize, yellow color code) includes includes piston rings, oil ring rails & expander
	1	1530X001	Piston Assembly, high pressure (standard) includes ring set, piston pin, retaining rings, & piston
		1530X011	Piston Assembly, high pressure (.010 oversize) includes ring set, piston pin, retaining rings, & piston
		1530X021	Piston Assembly, high pressure (.020 oversize) includes ring set, piston pin, retaining rings, & piston
		6442HPX	Replacement Connecting Rod Assembly includes connecting rod assembly, connecting rod inserts, & locknuts

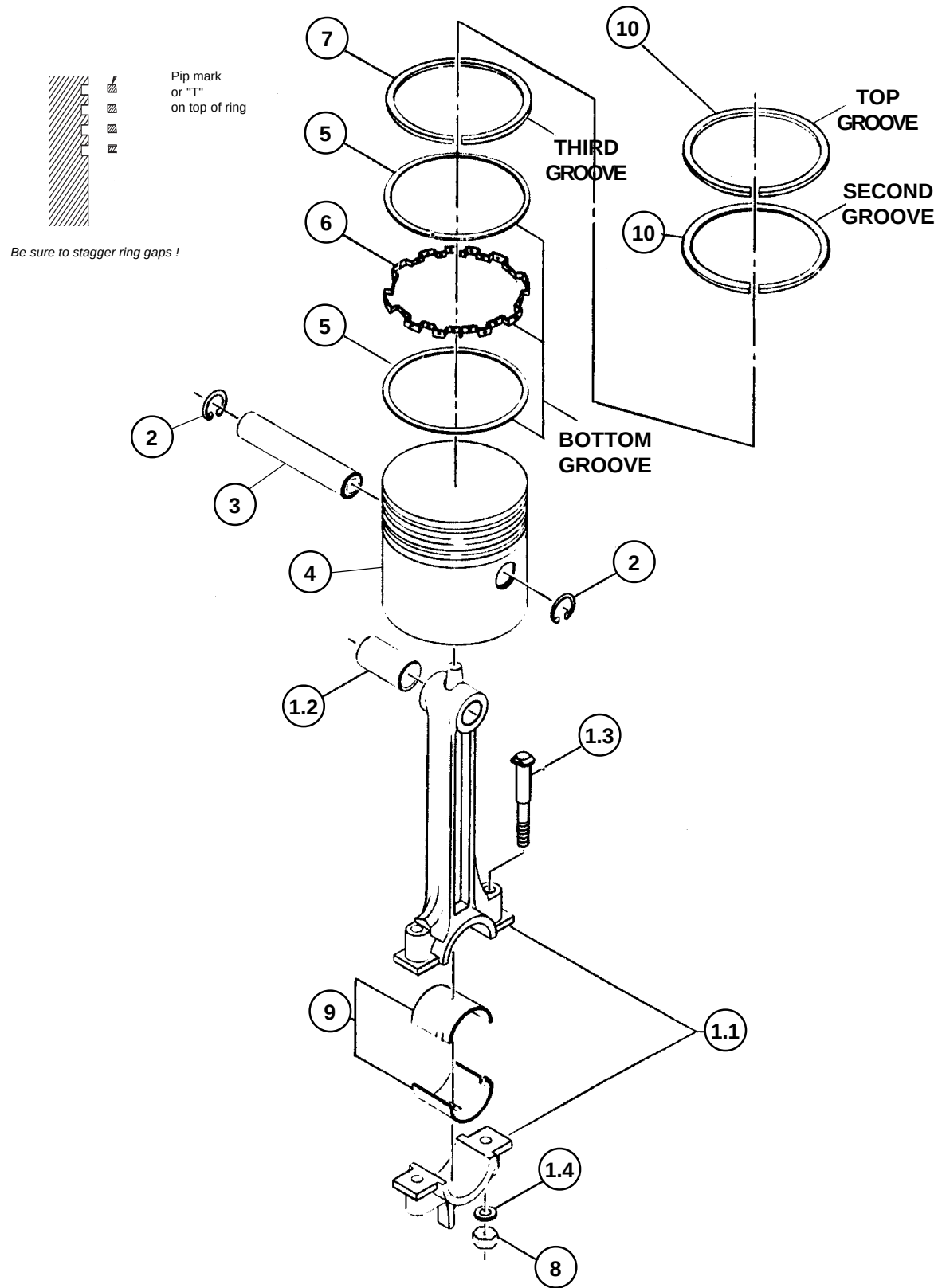
N.S.S. = Not Sold Separate

@ Indicates torque value (dry threads). Tighten multiple bolts, capscrews & hex nuts in a criss-cross or alternating pattern. Bring each fastener to the recommended torque specification in even increments.

* One pair required for each connecting rod assembly.

CONNECTING ROD & PISTON GROUP 110247

(low pressure)



CONNECTING ROD & PISTON GROUP 1 10247

(low pressure)

Item Number	Qty.	Part Number	Description
1	1	40139	connecting rod assembly (N.S.S.; see maintenance parts)
1.1	1	6442C	rod, connecting (N.S.S.; see maintenance parts)
1.2	1	6443	bushing, connecting rod (N.S.S.; order 6443SR)
1.3	2	3493	connecting rod bolt
1.4	2	1836	washer
2	2	8648	retaining ring
3	1	8646	piston pin
4	1	8643	piston, low pressure
5	2	112781	oil ring expander
6	1	112780	oil ring rail
7	1	7351	piston ring
8	2	124471-L08	locknut, 3/8-24 unf (@ 35 ft.-lbs.)
9	2	6444	insert, connecting rod (N.S.S.; see maintenance parts)
10	2	2584	piston ring
Maintenance Parts			
* 9	1	6444PR	inserts, connecting rod (1 pair, standard size)
* 9	1	6444-010PR	inserts, connecting rod (1 pair, .010 undersize)
1.2	1	6443SR	replacement connecting rod bushing
4	1	8643-010	piston, low pressure (.010 oversize)
4	1	8643-020	piston, low pressure (.020 oversize)
		8166A	Piston Ring Set (standard) includes piston rings, oil ring expander, & rails
		4434-010	Piston Ring Set (.010 oversize, light blue color code) includes piston rings, oil ring expander, & rails
		4434-020	Piston Ring Set (.020 oversize, yellow color code) includes piston rings, oil ring expander, & rails
		8643X	Piston Assembly, low pressure (standard size) includes piston, piston pin, retaining rings & ring set
		8643X010	Piston Assembly, low pressure (.010 oversize) includes piston, piston pin, retaining rings & ring set
		8643X020	Piston Assembly, low pressure (.020 oversize) includes piston, piston pin, retaining rings & ring set
		6442X	Replacement Connecting Rod Assembly (standard) includes connecting rod assy., connecting rod inserts, & locknuts

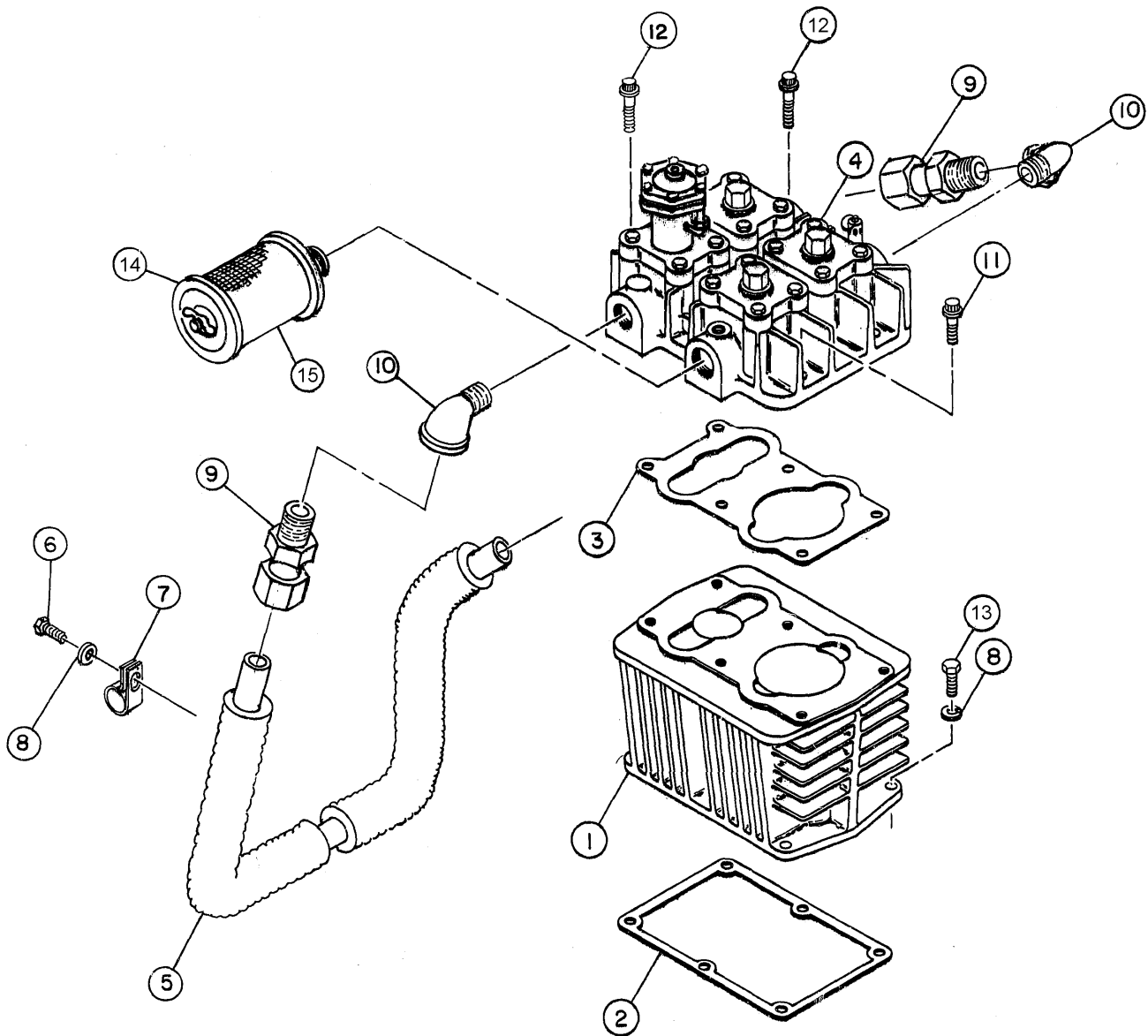
N.S.S. = Not Sold Separate

@ Indicates torque value (dry threads). Tighten multiple bolts, capscrews & hex nuts in a criss-cross or alternating pattern. Bring each fastener to the recommended torque specification in even increments.

* One pair required for each connecting rod assembly.

CYLINDER & HEAD GROUP 112071

(control version L)



CYLINDER & HEAD GROUP 112071

(control version L)

Item Number	Qty.	Part Number	Description
1	1	6610-5	cylinder
2	1	1833	gasket, cylinder to crankcase
3	1	7000	gasket
* 4	1	111496U	head assembly (see page 23 for parts breakdown)
5	1	112073	intercooler (N.S.S.; order Intercooler Replacement Kit)
6	1	123478-L10	hex. screw, 3/8-16 unc x .75, grade 5 (@ 30 ft.-lbs.)
7	1	6293-002	clamp
8	7	123115-06C	lockwasher, 3/8
9	2	124393-025	fitting
10	2	3092	pipe elbow, 3/4 npt x 3/4 npt, 90°
11	2	90386-N15	counterbore screw, 1/2-13 unc x 1.50, grade 8 (@ 50 ft.-lbs.)
12	4	90386-N20	counterbore screw, 1/2-13 unc x 2.75, grade 8 (@ 50 ft.-lbs.)
13	6	123478-L14	hex. screw, 3/8-16 unc x 1.25, grade 5 (@ 50 ft.-lbs.)
14	1	110377F100	air filter
14	1	110377H100	filter
14	1	110377S100	air filter/silencer, hooded
15	1	110377E100	air filter element, (fits 110377F100 & 110377S100 filter)
			Maintenance Parts
	1	111496X11L	Replacement Head Assembly includes head assy., head gasket, copper tube & fittings
	1	111496-051	Replacement Head Assembly (for high pressure rated compressors) includes high pressure rated head assy., head gasket, copper tube & fittings
	1	112088	Intercooler Replacement Kit includes intercooler and nut / sleeve fittings

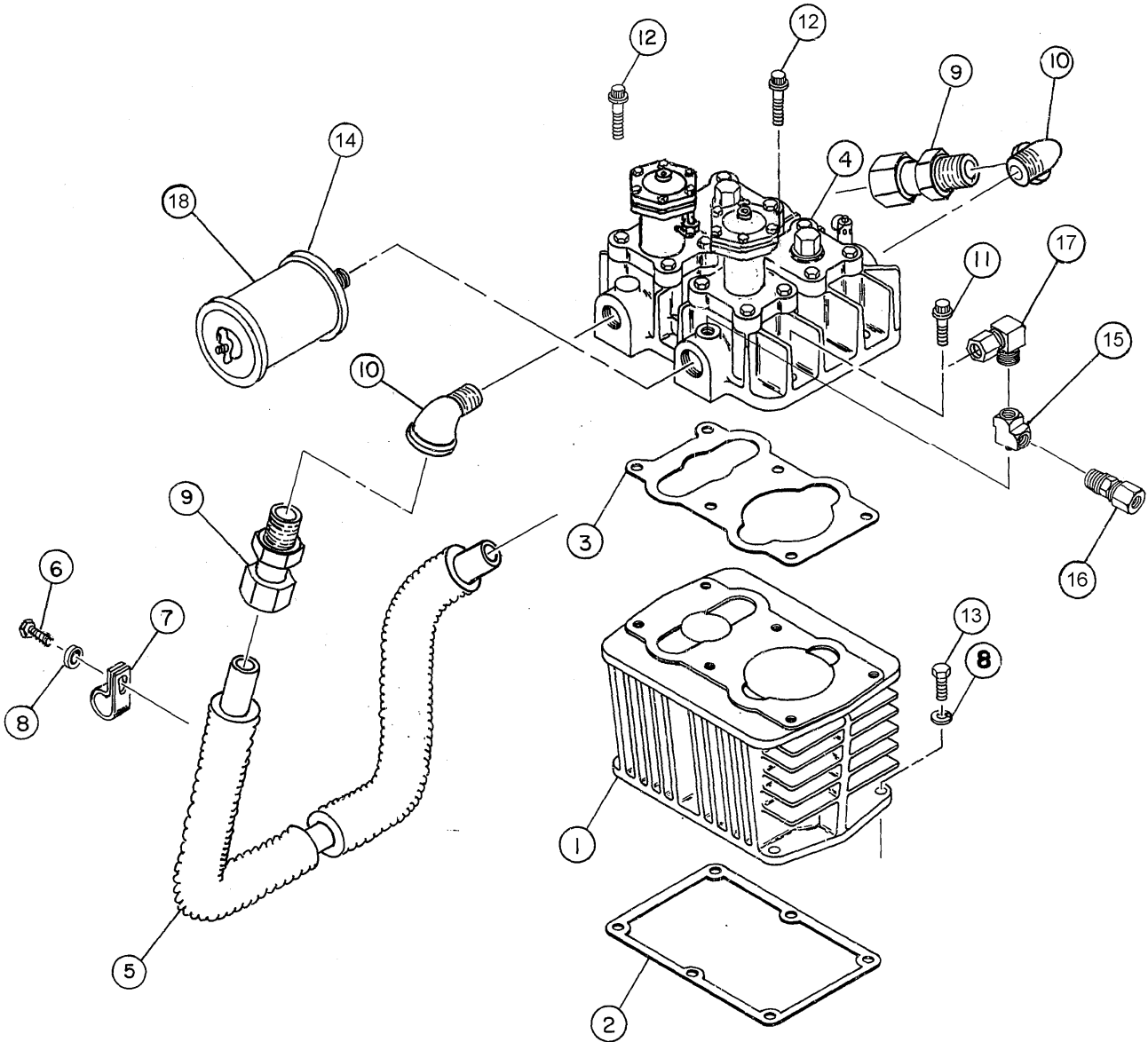
N.S.S. = Not Sold Separate

@ Indicates torque value (dry threads). Tighten multiple bolts, capscrews & hex nuts in a criss-cross or alternating pattern. Bring each fastener to the recommended torque specification in even increments.

* High pressure compressors and DNV certified applications require 111496HPS head in lieu of 111496 head and 6610-5HPS cylinder in lieu of 6610-5 cylinder

CYLINDER & HEAD GROUP 112072

(control versions LS, & LVD)



CYLINDER & HEAD GROUP 112072

(control versions LS, & LVD)

Item Number	Qty.	Part Number	Description
1	1	6610-5	cylinder
2	1	1833	gasket, cylinder to crankcase
3	1	7000	gasket
* 4	1	111496UU	head assembly (see page 25 for parts breakdown)
5	1	112073	intercooler (N.S.S.; order Intercooler Replacement Kit)
6	1	123478-L10	hex. screw, 3/8-16 unc x .75, grade 5 (@ 30 ft.-lbs.)
7	1	6293-002	clamp
8	7	123115-06C	lockwasher, 3/8
9	2	124393-025	fitting
10	2	3092	pipe elbow, 3/4 npt x 3/4 npt, 90°
11	2	90386-N15	counterbore screw, 1/2-13 unc x 1.50, grade 8 (@ 50 ft.-lbs.)
12	4	90386-N20	counterbore screw, 1/2-13 unc x 2.75, grade 8 (@ 50 ft.-lbs.)
13	6	123478-L14	hex. screw, 3/8-16 unc x 1.25, grade 5 (@ 50 ft.-lbs.)
14	1	110377F100	air filter
or			
14	1	110377H100	filter
or			
14	1	110377S100	air filter/silencer, hooded
15	1	3003	pipe tee, 1/4 npt x 1/4 npt x 1/4 npt
16	1	2706	connector
17	1	2708	tube fitting, 90° male elbow, 1/4 tube x 1/4 npt
Maintenance Parts			
18	1	110377E100	air filter element, (fits 110377F100 & 110377S100 filter)
	1	111496X11S	Replacement Head Assembly includes head assy., head gasket, copper tube & fittings
	1	111496-052	Replacement Head Assembly (for high pressure rated compressors) includes high pressure rated head assy., head gasket, copper tube & fittings
	1	112088	Intercooler Replacement Kit includes intercooler and nut / sleeve fittings

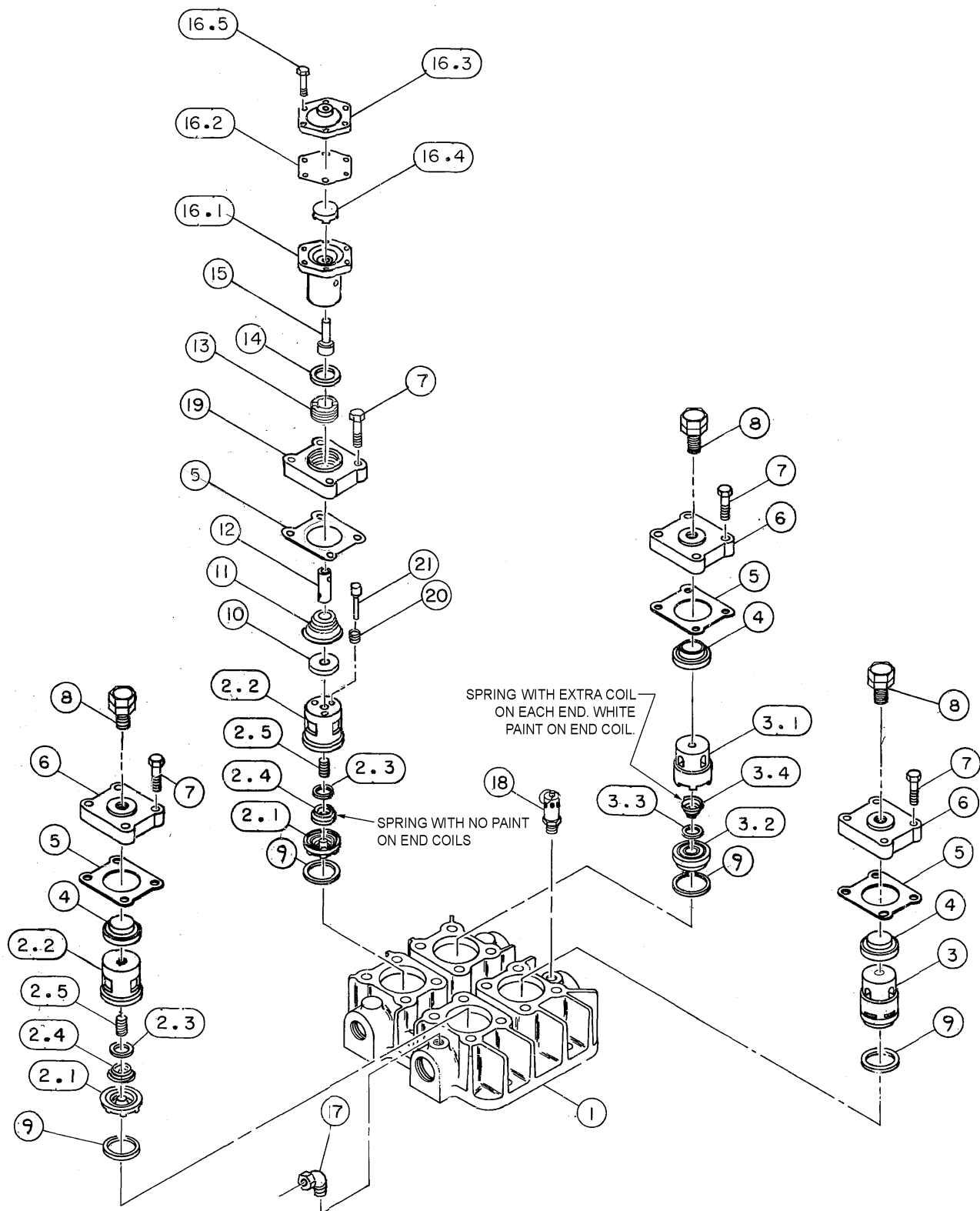
N.S.S. = Not Sold Separate

@ Indicates torque value (dry threads). Tighten multiple bolts, capscrews & hex nuts in a criss-cross or alternating pattern. Bring each fastener to the recommended torque specification in even increments.

* High pressure compressors and DNV certified applications require 111496HPS head in lieu of 111496 head and 6610-5HPS cylinder in lieu of 6610-5 cylinder

HEAD ASSEMBLY 111496U

(control version L)



HEAD ASSEMBLY 111496U

(control version L)

Item Number	Qty.	Part Number	Description
* 1	1	111496	head
2	2	7277X1	valve assembly
2.1	1	7277	valve bumper
2.2	1	1815	seat
2.3	1	1846	valve disc
2.4	1	7270	valve spring
2.5	1	1849	stud
3	2	7271X004	discharge valve assembly
3.1	1	7271-004	discharge valve bumper
3.2	1	1819-002	discharge valve seat
3.3	1	1846	valve disc
3.4	1	7270-2	valve spring
4	3	110639	spacer
5	4	1852	gasket
6	3	5906	valve cover plate
‡ 7	16	7480	hex. screw, 7/16-14 unc x 1.38, grade 5(@ 50 ft.-lbs.)
** 8	3	114545-R15	screw & nut assembly (screw @ 60 ft.-lbs. - nut @ 50 ft.-lbs.)
9	4	1848	gasket
10	1	6925	platform
11	1	6964	spacer
12	1	6965-001	pin
13	1	3008	holddown screw (@ 70 ft.-lbs.)
14	1	1556	gasket
15	1	7532X	unloader piston assembly
16	1	40055	unloader assembly (@ 75 ft.-lbs.) (N.S.S.; order 7483X)
16.1	1	7483	unloader body
16.2	1	1855	diaphragm
16.3	1	1818B	diaphragm cover plate
16.4	1	5910	diaphragm disc
16.5	6	7499	hex. screw, 1/4-20 unc x .75, grade 2 (@ 72 in.-lbs.)
17	1	2710	fitting
18	1	2961-100	pressure relief valve
19	1	6928	plate
20	3	6910	valve spring
21	3	1857	valve pin

Maintenance Parts

1	111496HPS	Replacement Head (for high pressure rated compressors)
1	7277X	Replacement Suction Valve Assembly includes suction valve assy. & valve gasket
1	7277XU	Replacement Suction Valve Assembly includes suction valve assy., valve gasket, valve pins, & valve springs
2	7271X04	Replacement Discharge Valve Assembly includes discharge valve assy. & valve gasket
1	7483X	Replacement Unloader Assembly includes unloader assembly, unloader piston assembly, valve gasket & pipe plug

Parts for use with diester or phosphate ester synthetic based lubricants

16.2	1	1855S	diaphragm
------	---	-------	-----------

N.S.S. = Not Sold Separate

@ Indicates torque value (dry threads). Tighten multiple bolts, capscrews & hex nuts in a criss-cross or alternating pattern. Bring each fastener to the recommended torque specification in even increments.

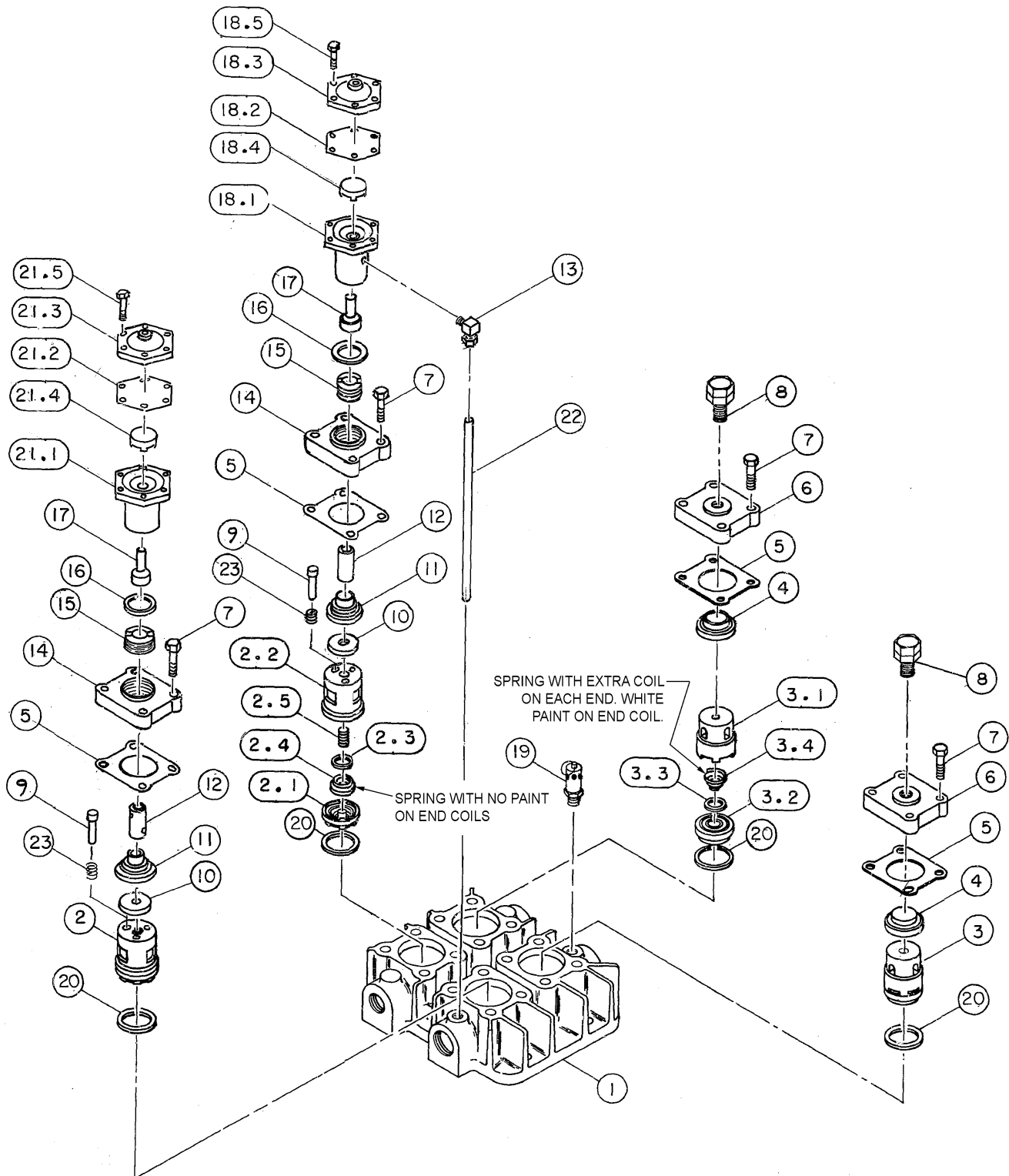
* High pressure compressors and DNV certified applications require 111496HPS head in lieu of 111496 head.

‡ Tighten and torque valve cover plate hex screws (item 7) prior to tightening valve clamp hex screws (item 8).

** Install with Loctite® 246 applied to threads.

HEAD ASSEMBLY 111496UU

(control versions S, LS, LVD)



HEAD ASSEMBLY 111496UU

(control versions S, LS, LVD)

Item Number	Qty.	Part Number	Description
* 1	1	111496	head
2	2	7277X1	valve assembly
2.1	1	7277	valve bumper
2.2	1	1815	seat
2.3	1	1846	valve disc
2.4	1	7270	valve spring
2.5	1	1849	stud
3	2	7271X004	discharge valve assembly
3.1	1	7271-004	discharge valve bumper
3.2	1	1819-002	discharge valve seat
3.3	1	1846	valve disc
3.4	1	7270-2	valve spring
4	2	110639	spacer
5	4	1852	gasket
6	2	5906	valve cover plate
‡ 7	16	7480	hex. screw, 7/16-14 unc x 1.38, grade 5 (@ 50 ft.-lbs.)
** 8	2	114545-R15	screw & nut assembly (screw @ 60 ft.-lbs. - nut @ 50 ft.-lbs.)
9	6	1857	valve pin
10	2	6925	platform
11	2	6964	spacer
12	2	6965-001	pin
13	1	1642	tube fitting, 90° male elbow, 1/4 tube x 1/8 npt
14	2	6928	plate
15	2	3008	holddown screw (@ 70 ft.-lbs.)
16	2	1556	gasket
17	2	7532X	unloader piston assembly
18	1	40055	unloader assembly (@ 75 ft.-lbs.) (N.S.S.; order 7483X)
18.1	1	7483	unloader body
18.2	1	1855	diaphragm
18.3	1	1818B	diaphragm cover plate
18.4	1	5910	diaphragm disc
18.5	6	7499	hex. screw, 1/4-20 unc x .75, grade 2 (@ 72 in.-lbs.)
19	1	2961-100	pressure relief valve
20	4	1848	gasket
21	1	40192	unloader assembly (@ 75 ft.-lbs.), (N.S.S.; order 8272X)
21.1	1	8272	unloader body
21.2	1	1855	diaphragm
21.3	1	1818B	diaphragm cover plate
21.4	1	5910	diaphragm disc
21.5	6	7499	hex. screw, 1/4-20 unc x .75, grade 2 (@ 72 in.-lbs.)
22	1 ft.	110515-025	copper tube, 1/4 o.d.
23	6	6910	valve spring

Maintenance Parts

1	111496HPS	Replacement Head (for high pressure rated compressors)
1	7277X	Replacement Suction Valve Assembly includes suction valve assy. & valve gasket
2	7277XU	Replacement Suction Valve Assembly includes suction valve assy., valve gasket, valve pins & valve springs
2	7271X04	Replacement Discharge Valve Assembly includes discharge valve assy. & valve gasket
1	7483X	Replacement Unloader Assembly includes unloader assy. (40055), unloader piston assy., valve gasket & pipe plug
1	8272X	Replacement Unloader Assembly includes unloader piston assembly, unloader assembly (40192), & valve gasket
Parts for use with diester or phosphate ester synthetic based lubricants		
18.2 & 21.2	1	1855S diaphragm

N.S.S. = Not Sold Separate

@ Indicates torque value (dry threads). Tighten multiple bolts, capscrews & hex nuts in a criss-cross or alternating pattern. Bring each fastener to the recommended torque specification in even increments.

* High pressure compressors and DNV certified applications require 111496HPS head in lieu of 111496 head.

‡ Tighten and torque valve cover plate hex screws (item 7) prior to tightening valve clamp hex screws (item 8).

** Install with Loctite® 246 applied to threads.

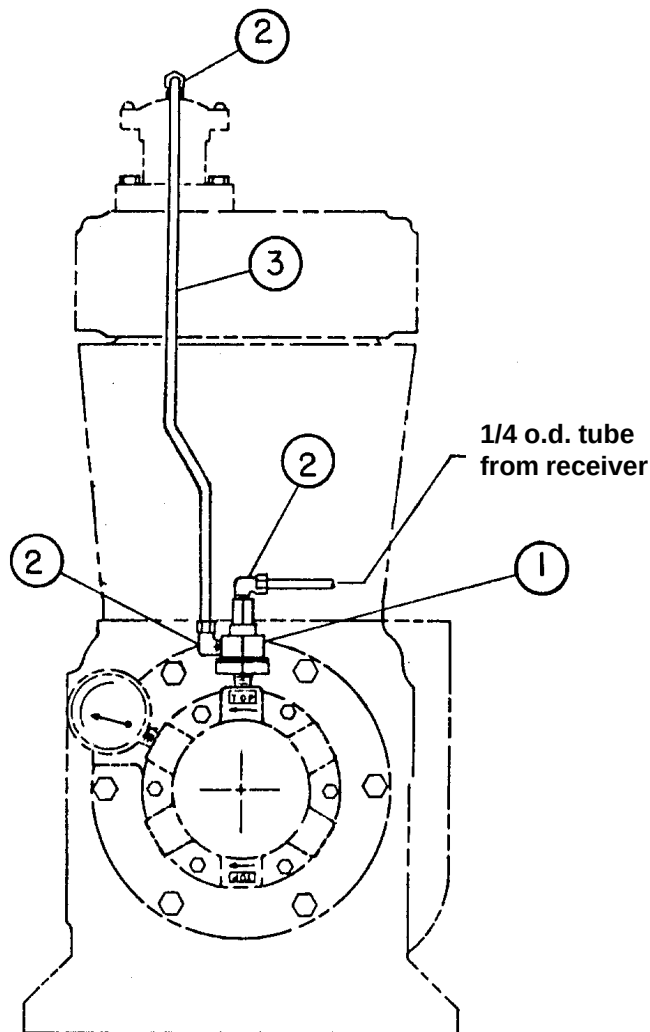
QR 325

Quincy Compressor

CONTROL GROUP 110855

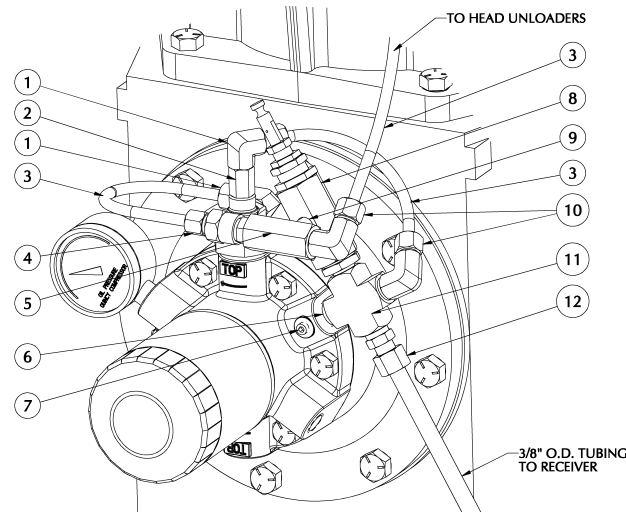
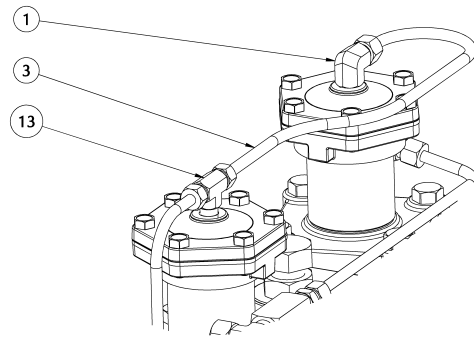
(control versions L)

Item Number	Qty.	Part Number	Part Number	Description
		0-200 PSI	201-500 PSI	
1	1	110827-001	110827-002	hydraulic unloader assembly
2	3	1642	1642	tube fitting, 90° male elbow, 1/4 tube x 1/8 npt
3	3 ft.	110515-025	110515-025	copper tube, 1/4 o.d.
Maintenance Parts				
		113225	113225	Hydraulic Unloader Repair Kit includes diaphragm, stem assembly, inlet filter & fitting assembly, spring (0-200 PSI) and spring (201-500 PSI, red color code)
Parts for use with diester or phosphate ester synthetic based lubricants				
1	1	110827-003		hydraulic unloader assembly (standard, 0-200 PSI)
1	1		110827-004	hydraulic unloader assembly (high pressure, 201-500 PSI)



CONTROL GROUP 116112-175&116112-998

(control version LS)



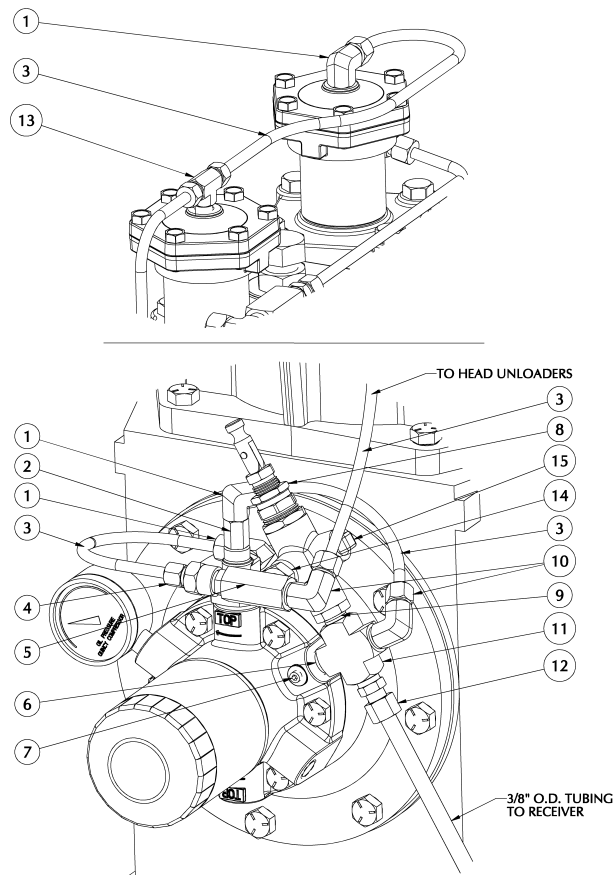
116112-175 "LS" CONTROL GROUP (175 PSI)			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	3	1642	TUBE FITTING, ELBOW, 1/4" TUBE X 1/8" NPT
2	1	110827-001	HYDRAULIC UNLOADER ASSEMBLY, 0-200 PSI
3	5 FT	110515-025	COPPER TUBE, 1/4" O.D.
4	1	9353	TUBE FITTING, 1/4" TUBE X 1/4" FEMALE NPT
5	1	6194X2	CHECK VALVE
6	1	6317	STUD, MOUNTING
7	1	160047-J05	SET SCREW
8	1	113708-175	PILOT VALVE, TOGGLE, 165-175 PRESET
9	1	126015-001	NIPPLE, SCH40, GALV, 1/8" X CLOSE
10	2	2708	TUBE FITTING, ELBOW, 1/4" TUBE X 1/4" NPT
11	1	6150	CROSS, BRASS, 1/4"
12	1	2616	TUBE FITTING, 3/8" TUBE X 1/4" NPT
13	1	1665	TUBE FITTING, TEE, 1/4" TUBE X 1/8" NPT
MAINTENANCE PARTS			
		6317X1	MOUNTING STUD KIT INCLUDES ITEMS 6 & 7 (1 EACH)
		113225	HYDRAULIC UNLOADER REPAIR KIT INCLUDES DIAPHRAGM, STEM ASSEMBLY, INLET FILTER, FITTING ASSEMBLY, & SPRINGS.
		110827-003	HYDRAULIC UNLOADER ASSEMBLY, 0-200 PSI USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC BASED LUBRICANTS.

116112-998 "LS" CONTROL GROUP (60-200 PSI)			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	3	1642	TUBE FITTING, ELBOW, 1/4" TUBE X 1/8" NPT
2	1	110827-001	HYDRAULIC UNLOADER ASSEMBLY, 0-200 PSI
3	5 FT	110515-025	COPPER TUBE, 1/4" O.D.
4	1	9353	TUBE FITTING, 1/4" TUBE X 1/4" FEMALE NPT
5	1	6194X2	CHECK VALVE
6	1	6317	STUD, MOUNTING
7	1	160047-J05	SET SCREW
8	1	113708-998	PILOT VALVE, TOGGLE, 60-200 (CUSTOM SET)
9	1	126015-001	NIPPLE, SCH40, GALV, 1/8" X CLOSE
10	2	2708	TUBE FITTING, ELBOW, 1/4" TUBE X 1/4" NPT
11	1	6150	CROSS, BRASS, 1/4"
12	1	2616	TUBE FITTING, 3/8" TUBE X 1/4" NPT
13	1	1665	TUBE FITTING, TEE, 1/4" TUBE X 1/8" NPT
MAINTENANCE PARTS			
		6317X1	MOUNTING STUD KIT INCLUDES ITEMS 6 & 7 (1 EACH)
		113225	HYDRAULIC UNLOADER REPAIR KIT INCLUDES DIAPHRAGM, STEM ASSEMBLY, INLET FILTER, FITTING ASSEMBLY, & SPRINGS.
		110827-003	HYDRAULIC UNLOADER ASSEMBLY, 0-200 PSI USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC BASED LUBRICANTS.

* See page 28 for optional pilot valves that must be used with respective pressure ranges.

CONTROL GROUP 116112-999 & 116112-000

(control version LS)



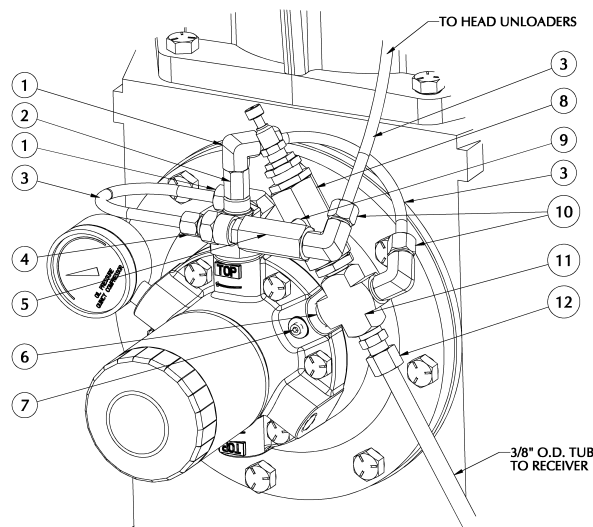
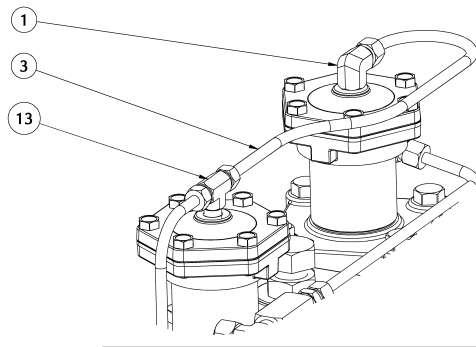
116112-999 "LS" CONTROL GROUP (201-400 PSI)			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	3	1642	TUBE FITTING, ELBOW, 1/4" TUBE X 1/8" NPT
2	1	110827-002	HYDRAULIC UNLOADER ASSEMBLY, 201-500 PSI
3	5 FT	110515-025	COPPER TUBE, 1/4" O.D.
4	1	9353	TUBE FITTING, 1/4" TUBE X 1/4" FEMALE NPT
5	1	6194X2	CHECK VALVE
6	1	6317	STUD, MOUNTING
7	1	160047-J05	SET SCREW
8	1	110832-999	PILOT VALVE, TOGGLE (CUSTOM SETTING)
9	1	121032-3	NIPPLE, BRASS, 1/4" X CLOSE
10	2	2708	TUBE FITTING, ELBOW, 1/4" TUBE X 1/4" NPT
11	1	6150	CROSS, BRASS, 1/4"
12	1	2616	TUBE FITTING, 3/8" TUBE X 1/4" NPT
13	1	1665	TUBE FITTING, TEE, 1/4" TUBE X 1/8" NPT
14	1	116110	REDUCER, NIPPLE, HEX, 025 X 012
15	1	2719	PLUG, PIPE 1/4"
MAINTENANCE PARTS			
		6317X1	MOUNTING STUD KIT INCLUDES ITEMS 6 & 7 (1 EACH)
		113225	HYDRAULIC UNLOADER REPAIR KIT INCLUDES DIAPHRAGM, STEM ASSEMBLY, INLET FILTER, FITTING ASSEMBLY, & SPRINGS.
		110827-004	HYDRAULIC UNLOADER ASSEMBLY, 201-500 PSI USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC BASED LUBRICANTS.

116112-000 "LS" CONTROL GROUP (401-500 PSI)			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	3	1642	TUBE FITTING, ELBOW, 1/4" TUBE X 1/8" NPT
2	1	110827-002	HYDRAULIC UNLOADER ASSEMBLY, 201-500 PSI
3	5 FT	110515-025	COPPER TUBE, 1/4" O.D.
4	1	9353	TUBE FITTING, 1/4" TUBE X 1/4" FEMALE NPT
5	1	6194X2	CHECK VALVE
6	1	6317	STUD, MOUNTING
7	1	160047-J05	SET SCREW
8	1	110832-000	PILOT VALVE, TOGGLE (CUSTOM SETTING)
9	1	121032-3	NIPPLE, BRASS, 1/4" X CLOSE
10	2	2708	TUBE FITTING, ELBOW, 1/4" TUBE X 1/4" NPT
11	1	6150	CROSS, BRASS, 1/4"
12	1	2616	TUBE FITTING, 3/8" TUBE X 1/4" NPT
13	1	1665	TUBE FITTING, TEE, 1/4" TUBE X 1/8" NPT
14	1	116110	REDUCER, NIPPLE, HEX, 025 X 012
15	1	2719	PLUG, PIPE 1/4"
MAINTENANCE PARTS			
		6317X1	MOUNTING STUD KIT INCLUDES ITEMS 6 & 7 (1 EACH)
		113225	HYDRAULIC UNLOADER REPAIR KIT INCLUDES DIAPHRAGM, STEM ASSEMBLY, INLET FILTER, FITTING ASSEMBLY, & SPRINGS.
		110827-004	HYDRAULIC UNLOADER ASSEMBLY, 201-500 PSI USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC BASED LUBRICANTS.

* See page 28 for optional pilot valves that must be used with respective pressure ranges.

CONTROL GROUP 116115-175&116115-998

(control version LVD)



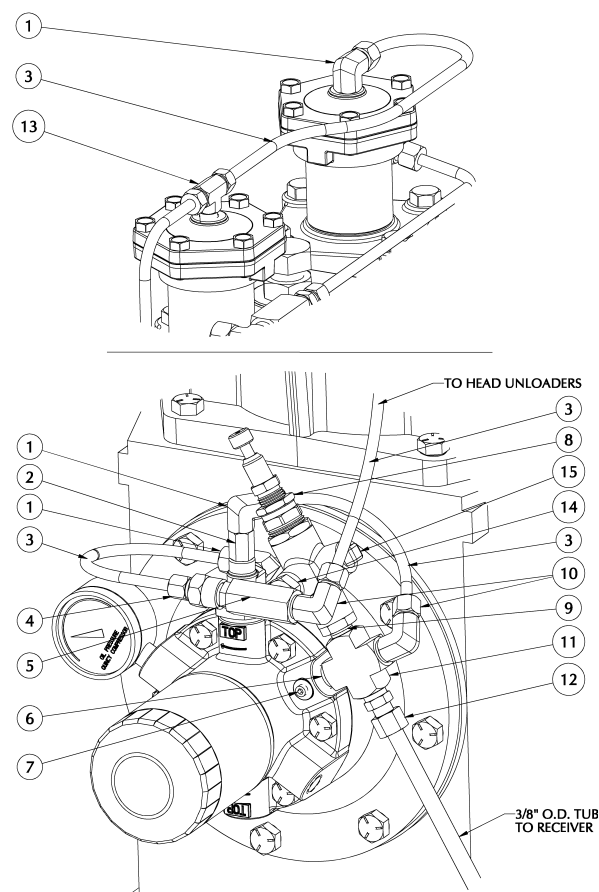
116115-165 "LVD" CONTROL GROUP (165 PSI)			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	3	1642	TUBE FITTING, ELBOW, 1/4" TUBE X 1/8" NPT
2	1	110827-001	HYDRAULIC UNLOADER ASSEMBLY, 0-200 PSI
3	5 FT	110515-025	COPPER TUBE, 1/4" O.D.
4	1	9353	TUBE FITTING, 1/4" TUBE X 1/4" FEMALE NPT
5	1	6194X2	CHECK VALVE
6	1	6317	STUD, MOUNTING
7	1	160047-J05	SET SCREW
8	1	110998-165A	PILOT VALVE, KNOB, 155-165 PRESET
9	1	126015-001	NIPPLE, SCH40, GALV, 1/8" X CLOSE
10	2	2708	TUBE FITTING, ELBOW, 1/4" TUBE X 1/4" NPT
11	1	6150	CROSS, BRASS, 1/4"
12	1	2616	TUBE FITTING, 3/8" TUBE X 1/4" NPT
13	1	1665	TUBE FITTING, TEE, 1/4" TUBE X 1/8" NPT
MAINTENANCE PARTS			
		6317X1	MOUNTING STUD KIT INCLUDES ITEMS 6 & 7 (1 EACH)
		113225	HYDRAULIC UNLOADER REPAIR KIT INCLUDES DIAPHRAGM, STEM ASSEMBLY, INLET FILTER, FITTING ASSEMBLY, & SPRINGS.
		110827-003	HYDRAULIC UNLOADER ASSEMBLY, 0-200 PSI USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC BASED LUBRICANTS.

116115-998 "LVD" CONTROL GROUP (60-200 PSI)			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	3	1642	TUBE FITTING, ELBOW, 1/4" TUBE X 1/8" NPT
2	1	110827-001	HYDRAULIC UNLOADER ASSEMBLY, 0-200 PSI
3	5 FT	110515-025	COPPER TUBE, 1/4" O.D.
4	1	9353	TUBE FITTING, 1/4" TUBE X 1/4" FEMALE NPT
5	1	6194X2	CHECK VALVE
6	1	6317	STUD, MOUNTING
7	1	160047-J05	SET SCREW
8	1	110998-998	PILOT VALVE, KNOB, 60-200 CUSTOM SET
9	1	126015-001	NIPPLE, SCH40, GALV, 1/8" X CLOSE
10	2	2708	TUBE FITTING, ELBOW, 1/4" TUBE X 1/4" NPT
11	1	6150	CROSS, BRASS, 1/4"
12	1	2616	TUBE FITTING, 3/8" TUBE X 1/4" NPT
13	1	1665	TUBE FITTING, TEE, 1/4" TUBE X 1/8" NPT
MAINTENANCE PARTS			
		6317X1	MOUNTING STUD KIT INCLUDES ITEMS 6 & 7 (1 EACH)
		113225	HYDRAULIC UNLOADER REPAIR KIT INCLUDES DIAPHRAGM, STEM ASSEMBLY, INLET FILTER, FITTING ASSEMBLY, & SPRINGS.
		110827-003	HYDRAULIC UNLOADER ASSEMBLY, 0-200 PSI USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC BASED LUBRICANTS.

* See page 28 for optional pilot valves that must be used with respective pressure ranges.

CONTROL GROUP 116115-999 & 116115-000

(control version LVD)

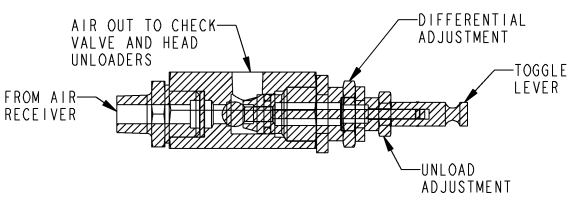


116115-999 "LVD" CONTROL GROUP (201-400 PSI)			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	3	1642	TUBE FITTING, ELBOW, 1/4" TUBE X 1/8" NPT
2	1	110827-002	HYDRAULIC UNLOADER ASSEMBLY, 201-500 PSI
3	5 FT	110515-025	COPPER TUBE, 1/4" O.D.
4	1	9353	TUBE FITTING, 1/4" TUBE X 1/4" FEMALE NPT
5	1	6194X2	CHECK VALVE
6	1	6317	STUD, MOUNTING
7	1	160047-J05	SET SCREW
8	1	111423-001	PILOT VALVE, DUAL CONTROL (CUSTOM SETTING)
9	1	121032-3	NIPPLE, BRASS, 1/4" X CLOSE
10	2	2708	TUBE FITTING, ELBOW, 1/4" TUBE X 1/4" NPT
11	1	6150	CROSS, BRASS, 1/4"
12	1	2616	TUBE FITTING, 3/8" TUBE X 1/4" NPT
13	1	1665	TUBE FITTING, TEE, 1/4" TUBE X 1/8" NPT
14	1	116110	REDUCER, NIPPLE, HEX, .025 X .012
15	1	2719	PLUG, PIPE 1/4"
MAINTENANCE PARTS			
		6317X1	MOUNTING STUD KIT INCLUDES ITEMS 6 & 7 (1 EACH)
		113225	HYDRAULIC UNLOADER REPAIR KIT INCLUDES DIAPHRAGM, STEM ASSEMBLY, INLET FILTER, FITTING ASSEMBLY, & SPRINGS.
		110827-004	HYDRAULIC UNLOADER ASSEMBLY, 201-500 PSI USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC BASED LUBRICANTS.

116115-000 "LVD" CONTROL GROUP (401-500 PSI)			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	3	1642	TUBE FITTING, ELBOW, 1/4" TUBE X 1/8" NPT
2	1	110827-002	HYDRAULIC UNLOADER ASSEMBLY, 201-500 PSI
3	5 FT	110515-025	COPPER TUBE, 1/4" O.D.
4	1	9353	TUBE FITTING, 1/4" TUBE X 1/4" FEMALE NPT
5	1	6194X2	CHECK VALVE
6	1	6317	STUD, MOUNTING
7	1	160047-J05	SET SCREW
8	1	111423-002	PILOT VALVE, DUAL CONTROL (CUSTOM SETTING)
9	1	121032-3	NIPPLE, BRASS, 1/4" X CLOSE
10	2	2708	TUBE FITTING, ELBOW, 1/4" TUBE X 1/4" NPT
11	1	6150	CROSS, BRASS, 1/4"
12	1	2616	TUBE FITTING, 3/8" TUBE X 1/4" NPT
13	1	1665	TUBE FITTING, TEE, 1/4" TUBE X 1/8" NPT
14	1	116110	REDUCER, NIPPLE, HEX, .025 X .012
15	1	2719	PLUG, PIPE 1/4"
MAINTENANCE PARTS			
		6317X1	MOUNTING STUD KIT INCLUDES ITEMS 6 & 7 (1 EACH)
		113225	HYDRAULIC UNLOADER REPAIR KIT INCLUDES DIAPHRAGM, STEM ASSEMBLY, INLET FILTER, FITTING ASSEMBLY, & SPRINGS.
		110827-004	HYDRAULIC UNLOADER ASSEMBLY, 201-500 PSI USE WITH DIESTER OR PHOSPHATE ESTER SYNTHETIC BASED LUBRICANTS.

* See page 28 for optional pilot valves that must be used with respective pressure ranges.

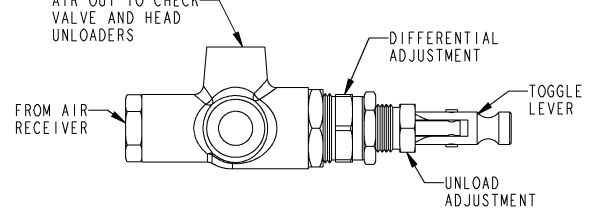
PILOT VALVES



113708 SERIES PILOT VALVE (CONTROL VERSION "LS")

PART NUMBER	LOAD PSI	UNLOAD PSI
113708-175	165	175
113708-998	*	60-200 ADJUSTABLE

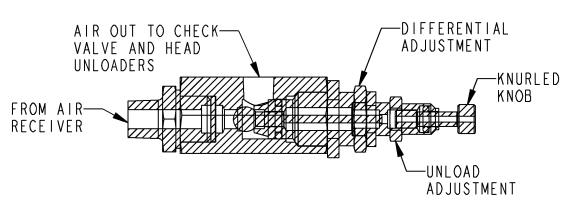
* CUSTOMER TO SET, SEE DIFFERENTIAL SETTING CHART.
ADDITIONAL FACTORY PRESET VALVES ARE AVAILABLE UPON REQUEST.



110832 SERIES PILOT VALVE (CONTROL VERSION "LS")

PART NUMBER	LOAD PSI	UNLOAD PSI
110832-999	*	201-400 ADJUSTABLE
110832-000	*	401-500 ADJUSTABLE

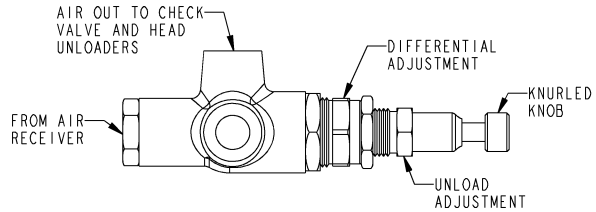
* CUSTOMER TO SET, SEE DIFFERENTIAL SETTING CHART.
ADDITIONAL FACTORY PRESET VALVES ARE AVAILABLE UPON REQUEST.



110998 SERIES PILOT VALVE (CONTROL VERSION "LVD")

PART NUMBER	LOAD PSI	UNLOAD PSI
110998-165A	155	165
110998-998	*	60-200 ADJUSTABLE

* CUSTOMER TO SET, SEE DIFFERENTIAL SETTING CHART.
ADDITIONAL FACTORY PRESET VALVES ARE AVAILABLE UPON REQUEST.



111423-001 & 111423-002 SERIES PILOT VALVE (CONTROL VERSION "LVD")

PART NUMBER	LOAD PSI	UNLOAD PSI
111423-001	*	201-400 ADJUSTABLE
111423-002	*	401-500 ADJUSTABLE

* CUSTOMER TO SET, SEE DIFFERENTIAL SETTING CHART.
ADDITIONAL FACTORY PRESET VALVES ARE AVAILABLE UPON REQUEST.

DIFFERENTIAL SETTING CHART		
APPLIES TO 113708 AND 110998 SERIES PILOT VALVES ONLY.		
UNLOAD (PSI)	MIN. DIF. (PSI)	MAX. DIF. (PSI)
60	3	10
100	4	20
150	5	30
175	5	45

PILOT VALVE REPAIR KIT 110832-051		
CAN BE USED TO REPAIR 110832 AND 111423 SERIES PILOT VALVES ONLY. CUSTOMER MUST SPECIFY WHICH SPRING WHEN ORDERING REPAIR KIT.		
PART #	QTY	DESCRIPTION
	2	SCREEN
	4	FILTER
	1	O-RING
	1	DISC
110832-054	1	REPLACEMENT SPRING, PILOT VALVE, 201-400 PSI (GREEN)
110832-055	1	REPLACEMENT SPRING, PILOT VALVE, 401-500 PSI (BLACK)

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 compressor. Failure to heed this warning could result in an explosion.

DIFFERENTIAL SETTING CHART			
APPLIES TO 110832 AND 111423 SERIES PILOT VALVES ONLY.			
SPRING NUMBER	UNLOAD (PSI)	MIN. DIF. (PSI)	MAX. DIF. (PSI)
110832-054	201	5	25
"	250	10	30
"	300	10	40
"	400	30	50
110832-055	500	40	75

SUCTION VALVE UNLOADER ASSEMBLIES

Description

The Quincy suction valve unloader assembly consists of unloading arrangements on the suction valves, having a plunger to contact the suction valve disc and an unloader pilot valve (part no.s 113708-***, 110998-***, and 110832-*** & 111423-***) to automatically regulate the passing of receiver pressure to the unloading arrangement.

Application

Suction valve unloader assemblies 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.

Operation

Unloading occurs when receiver pressure is sufficient to overcome pilot valve spring pressure. The check ball is then unseated, allowing receiver pressure to pass to the unloading arrangements. The compressor will 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 combustion engine, runs continuously and must be started and stopped manually.

Pilot valves 111423-*** & 110998-*** can be locked out, for models equipped with dual control, to provide automatic start/stop operation. The knurled knob at the top of the pilot can be turned clockwise, until it stops, to lock it out. A pressure switch is required to stop the motor. Failure to use a pressure switch, with the pilot valve locked out, could result in unsafe conditions.

WARNING !

A pressure switch must be incorporated whenever pilot valve 111423-*** or 110998-*** is employed as part of the control system.

The compressor will operate in the continuous run mode if the knurled knob is turned counterclockwise until it stops.

Installation

The pilot valve is to be connected to the air receiver using a minimum of 3/8" o.d. copper tube. Compress-

sors in the field, not equipped with a suction valve unloader assembly, can be converted to constant speed. Consult your local Quincy distributor for assistance with conversion procedures.

Service

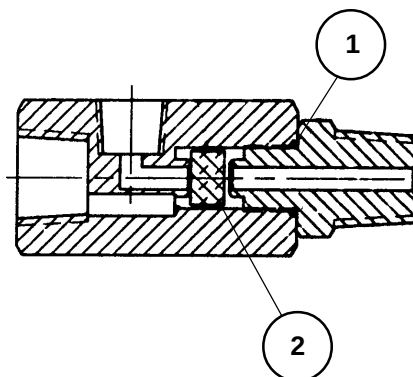
Periodically check the filter & screens in the inlet of the pilot valve to make sure they are free of obstructions. If they become clogged, remove and clean or replace. Inspect the "o"ring located in the opposite end of the pilot valve body for wear or damage; replace if necessary.

Adjustment

The unloading pressure is adjustable and is regulated by turning the hex nut (marked "unload adj." in cross sectional illustrations of pilot valves). Turn the hex nut clockwise to increase and counterclockwise to decrease the unloading pressure.

The differential (difference between unloading and loading pressure) is set by turning the hex nut (marked "differential adj." in the cross sectional illustrations of the pilot valves). Increase the differential pressure by turning the hex nut clockwise - decrease by turning counterclockwise. Tighten the locknuts after adjustment.

CHECK VALVE ASSEMBLIES



Check Valve Assembly Replacement Parts

Item #	Qty.	Part Number	Description
		6194X2	Check Valve Assembly
1	1	123157-010	"o"ring
2	1	6196-002	disc
		6194X3	Check Valve Assembly
		(for use with diester or phosphate ester synthetic lubricants)	
1	1	22749-010	"o"ring
2	1	6196-003	disc

Head Kit K325A			
Item #	Qty.	Part Number	Description
1		110377E100	air filter element
2		1556	gasket
2		1855	diaphragm
4		1848	gasket, valve
4		1852	gasket, valve cover
2		1556	gasket, valve cover
4		1846	valve disc
1		7000	gasket, cylinder to head
2		7270	valve spring
2		7270-2	valve spring
1		5700	gasket, intercooler

Basic Compressor Repair Kit 110823-325			
Item #	Qty.	Part Number	Description
1		110190-021	piston pin
1		110377E100	air filter element
1		110610-002	"o"ring kit
1		110814	oil filter
1		2720	bearing cup
1		2585	bearing cone
1		2523	bearing cup
1		2788	bearing cone
2		6443SR	connecting rod bushing
2		6444PR	connecting rod inserts (1 pair)
2		7270	valve spring
2		7270-2	valve spring
1		8161	ring set
4		1846	valve disc
1		7126	gasket set
1		8646	piston pin
1		8166	ring set

V.I.P. Kit 110516-325			
Item #	Qty.	Part Number	Description
1		110822	oil pressure gauge
2		1855	diaphragm
6		1857	valve pin
4		1846	valve disc
2		6283	hydraulic unloader filter
6		6910	valve spring
2		7270	valve spring
2		7270-2	valve spring
1		7126	gasket set

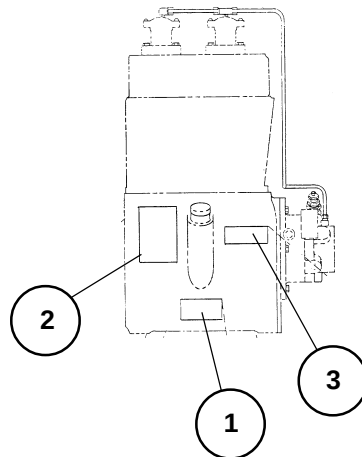
Overhaul Kit K325C			
Item #	Qty.	Part Number	Description
2		6444PR	con-rod bearing
1		110377E100	air filter element
1		110610-001	"o"ring kit
1		8161	ring set
1		8166	ring set
1		7126	gasket set
4		1846	valve disc
2		7270	spring
2		7270-2	valve spring

Overhaul Kit K325B			
Item #	Qty.	Part Number	Description
1		110377E100	air filter element
2		1855	diaphragm
4		1846	valve disc
2		6444PR	connecting rod inserts (1 pair)
2		7270	valve spring
2		7270-2	valve spring
1		7126	gasket set
1		8161A	ring set
1		8166A	ring set
1		6316	oil seal

Gasket Set 7126			
Item #	Qty.	Part Number	Description
2		1556	gasket
1		1833	gasket, cylinder to crankcase
1		1840	gasket, inspection plate
4		1848	gasket
4		1852	gasket
2		5700	gasket
2		6294	bearing adj. shim, .005 steel
2		6294A	bearing adj. shim, .007 steel
1		6294B	bearing adj. shim, .020 steel
6		6294C	bearing adj. shim, .005 paper
2		6294D	bearing adj. shim, .002 steel
1		6312	gasket, bearing carrier
1		7000	gasket

Recommended Spare Parts			
Item #	Qty.	Part Number	Description
	2	7277XU	replacement suction valve assy.
	2	7271X04	replacement discharge valve assy.
	1	110822	pressure gauge
	1	160078	oil pump repair kit
	1	7126	gasket set
	1	113225	hydraulic unloader repair kit
	2	6444PR	connecting rod inserts (1 pair)
	2	1855	unloader diaphragm
	1	110832-051	pilot repair kit
	1	110377E100	air filter element

DECALS



Decals for QR 325 Basic Compressor			
Item #	Qty.	Part Number	Description
1	1	110831	serial number & nameplate
2	1	127889-A	decals, CAUTION!/manual/ "Failure to follow..."
3	1	127889-B	decals, DANGER! / "Air used for breathing..."
* Not sold separately; order 127889.			

TYPICAL UNIT REPAIR PARTS LIST

The parts listed here are for standard QR 325 (up to 175 PSI) units and may or may not be applicable to custom built units. Check with your local authorized Quincy distributor for parts that can be used for custom built units. Make sure the components you order are rated within the safe operating limits of your system. If you are doubtful about which components to order, contact your local Quincy distributor.

(QR 325 simplex - horizontal tank - electric motor)

Qty	Part Number	Part Number	Part Number	Description
	60 gal.	80 gal.	120 gal.	
1	113891-200	113268-200	113271-200	tank (200 PSI max. working pressure)
1	n/a	n/a	*113281	top plate
1	2713	2713	111136-050	tank drain valve
1	111136-075	111136-075	111136-100	ball valve
1	110514-300	110514-300	110514-300	pressure gauge
1	110512-003	110512-003	§ 110512-003	pressure switch (135-175 PSI)
1	110513-200	110513-200	110513-200	pressure relief valve (200 PSI)
3 ft.	110515-075	110515-075	110515-075	! discharge tube (3/4" copper tube to be formed by customer)
2	23271	23271	23271	compression fittings
	3 h.p.	5 h.p.		
1	110357B065	110357B068		drive belt
1	110580-118	115240		motor pulley
1	n/a	8928		motor pulley bushing
1	113242K001	113242K001		belt guard assembly
	115/230v, 1Ø	200v, 3Ø	230/460v, 3Ø	
1	4003	8098	124517-006	3 h.p. motor (ODP)
1	**127466I020	8099	124517-005	5 h.p. motor (ODP)

* 113281 top plate is also used for all QR 325 base mounted electric motor driven units.

! Pre-formed discharge tubes are available. Contact factory with model & tank size information.

** 230 volt only.

§ 2298-175 pressure switch on base mounted unit.

(QR 325 duplex - horizontal tank - electric motor)

Qty	Part Number	Part Number	Part Number	Description
	80 gal.	120 gal.	200 gal.	
1	113471-200	113467-200	113469-200	tank (200 p.s.i. max. working pressure)
2	N/A	113281	113281	top plate
1	2713	111136-050	111136-050	tank drain valve
1	111136-075	111136-100	111136-100	ball valve
1	110514-300	110514-300	110514-300	pressure gauge
2	110512-003	110512-003	110512-003	pressure switch (135-175 PSI)
1	110513-200	110513-200	110513-200	pressure relief valve (200 PSI)
6 ft.	110515-075	110515-075	110515-075	discharge tube (3/4" copper tube to be formed by customer)
4	23271	23271	23271	compression fittings
	3 h.p.	5 h.p.		
2	110357B065	110357B068		drive belt
2	110580-118	115240		motor pulley
2	n/a	8928		motor pulley bushing
2	113242K001	113242K001		belt guard assembly
	115/230v, 1Ø	200v, 3Ø	230/460v, 3Ø	
2	4003	8098	124517-006	3 h.p. motor (ODP)
2	* 127466I020	8099	124517-005	5 h.p. motor (ODP)

! Pre-formed discharge tubes are available. Contact factory with model & tank size information.

* 230 volt only.

TYPICAL UNIT REPAIR PARTS LIST

The parts listed here are for standard QR 325 (up to 175 PSI) units and may or may not be applicable to custom built units. Check with your local authorized Quincy distributor for parts that can be used for custom built units. Make sure the components you order are rated within the safe operating limits of your system. If you are doubtful about which components to order, contact your local Quincy distributor.

(QR 325 vertical tank - electric motor)

Qty	Part Number	Part Number	Part Number	Description
	60 gal.	80 gal.		
1	114948P200	114949P200		tank (200 PSI max. working pressure)
1	110425-025	110425-050		tank drain valve
1	111136-075	111136-075		ball valve
1	110514-300	110514-300		pressure gauge
1	110512-003	110512-003		pressure switch (135-175 PSI)
1	110513-200	110513-200		pressure relief valve (200 PSI)
3 ft.	110515-075	110515-075		! discharge tube (3/4" copper tube to be formed by customer)
2	23271	23271		compression fittings
	3 h.p.	5 h.p.		
1	110357B065	110357B068		drive belt
1	110580-118	115240		motor pulley
1	n/a	8928		motor pulley bushing
1	113242K001	113242K001		belt guard assembly
	115/230v, 1Ø	200v, 3Ø	230/460v, 3Ø	
1	4003	8098	124517-006	3 h.p. motor (ODP)
1	*127466I020	8099	124517-005	5 h.p. motor (ODP)

! Pre-formed discharge tubes are available. Contact factory with model & tank size information.

* 230 volt only.

(QR 325 gasoline engine driven - Kohler)

Qty	Part Number	Part Number	Part Number	Description
	base unit	tank unit		
1		113727P200		tank (200 PSI)
1	113764			top plate
1		111136-025		tank drain valve
1		111136-050		ball valve
1		110514-300		pressure gauge
1		110513-200		pressure relief valve (200 PSI)
2	110258B074	110258B074		drive belt
1	5629	5629		engine pulley
1	8927	8927		engine pulley bushing
1	113702K005	113702K005		belt guard assembly
1	113143-003	113143-003		throttle control, bullwhip cable
1	113698	113698		Kohler engine group, 11 h.p. (includes exhaust system & throttle control)
3 ft.		110515-075		! discharge tube (3/4" copper tube to be formed by customer)
2		23271		compression fittings

! Pre-formed discharge tubes are available. Contact factory with model & tank size information.

TYPICAL UNIT REPAIR PARTS LIST

The parts listed here are for standard QR 325 (up to 175 PSI) units and may or may not be applicable to custom built units. Check with your local authorized Quincy distributor for parts that can be used for custom built units. Make sure the components you order are rated within the safe operating limits of your system. If you are doubtful about which components to order, contact your local Quincy distributor.

(QR 325 gasoline engine driven - Honda)

Qty	Part Number	Part Number	Part Number	Description
	base unit	tank unit		
1		113727P200		tank (200 PSI)
1	113764			top plate
1		111136-025		tank drain valve
1		111136-050		ball valve
1		110514-300		pressure gauge
1		110513-200		pressure relief valve (200 PSI)
2	110258B074	110258B074		drive belt
1	5629	5629		engine pulley
1	8927	8927		engine pulley bushing
1	113702-012	113702-012		belt guard assembly
1	113143-002	113143-002		throttle control, bullwhip cable
1	113700-1	113700-1		Honda engine group, 11 h.p. (includes engine & throttle control)
1		112266-323		! discharge piping group (includes discharge piping and fittings- 3/4" copper tube to be formed by customer)

! Pre-formed discharge tubes are available. Contact factory with model & tank size information.

(QR 325 diesel engine driven - Yanmar)

Qty	Part Number	Part Number	Part Number	Description
	base unit	tank unit		
1		113727P200		tank (200 PSI)
1	113764			base
1		111136-025		tank drain valve
1		111136-050		ball valve
1		110514-300		pressure gauge
1		110513-200		pressure relief valve (200 PSI, in tank)
2	110258B074	110258B074		drive belt
1	5629	5629		engine pulley
1	8927	8927		engine pulley bushing
1	113702K008	113702K008		belt guard assembly
1	113143-001	113143-001		throttle control
1	114080-002	114080		Yanmar diesel engine group, 10 h.p. (includes throttle control)
2.5 ft.		110515-075		! discharge tube (3/4" copper tube to be formed by customer)
2		23271		compression fittings

! Pre-formed discharge tubes are available. Contact factory with model & tank size information.

QUINCY COMPRESSOR

STANDARD TERMS AND CONDITIONS

LEGAL EFFECT: Except as expressly otherwise agreed to in writing by an authorized representative of Seller, the following terms and conditions shall apply to and form a part of this order and any additional and/or different terms of Buyer's purchase order or other form of acceptance are rejected in advance and shall not become a part of this order.

The rights of Buyer hereunder shall be neither assignable nor transferable except with the written consent of Seller.

This order may not be canceled or altered except with the written consent of Seller and upon terms which will indemnify Seller against all loss occasioned thereby. All additional costs incurred by Seller due to changes in design or specifications, modification of this order or revision of product must be paid for by Buyer.

In addition to the rights and remedies conferred upon Seller by this order, Seller shall have all rights and remedies conferred at law and in equity and shall not be required to proceed with the performance of this order if Buyer is in default in the performance of such order or of any other contract or order with seller.

TERMS OF PAYMENT: Unless otherwise specified in the order acknowledgment, the terms of payment shall be 1% 15, net forty-five (45) days after shipment. These terms shall apply to partial as well as complete shipments. If any proceeding be initiated by or against Buyer under any bankruptcy or insolvency law, or in the judgment of Seller the financial condition of Buyer, at the time the equipment is ready for shipment, does not justify the terms of payment specified, Seller reserves the right to require full payment in cash prior to making shipment. If such payment is not received within fifteen (15) days after notification of readiness for shipment, Seller may cancel the order as to any unshipped item and require payment of its reasonable cancellation charges.

If Buyer delays shipment, payments based on date of shipment shall become due as of the date when ready for shipment. If Buyer delays completion of manufacture, Seller may elect to require payment according to percentage of completion. Equipment held for Buyer shall be at Buyer's risk and storage charges may be applied at the discretion of Seller.

Accounts past due shall bear interest at the highest rate lawful to contract for but if there is no limit set by law, such interest shall be eighteen percent (18%). Buyer shall pay all cost and expenses, including reasonable attorney's fees, incurred in collecting the same, and no claim, except claims within Seller's warranty of material or workmanship, as stated below, will be recognized unless delivered in writing to Seller within thirty (30) days after date of shipment.

TAXES: All prices exclude present and future sales, use, occupation, license, excise, and other taxes in respect of manufacture, sales or delivery, all of which shall be paid by Buyer unless included in the purchase price at the proper rate or a proper exemption certificate is furnished.

ACCEPTANCE: All offers to purchase, quotations and contracts of sales are subject to final acceptance by an authorized representative at Seller's plant.

DELIVERY: Except as otherwise specified in this quotation, delivery will be F. O. B. point of shipment. In the absence of exact shipping instruction, Seller will use its discretion regarding best means of insured shipment. No liability will be accepted by Seller for so doing. All transportation charges are at Buyer's expense. Time of delivery is an estimate only and is based upon the receipt of all information and necessary approvals. The shipping schedule shall not be construed to limit seller in making commitments for materials or in fabricating articles under this order in accordance with Seller's normal and reasonable production schedules.

Seller shall in no event be liable for delays caused by fires, acts of God, strikes, labor difficulties, acts of governmental or military authorities, delays in transportation or procuring materials, or causes of any kind beyond Seller's control. No provision for liquidated damages for any cause shall apply under this order. Buyer shall accept delivery within thirty (30) days after receipt of notification of readiness for shipment. Claims for shortages will be deemed to have been waived if not made in writing with ten (10) days after the receipt of the material in respect of which any such shortage is claimed. Seller is not responsible for loss or damage in transit after having received "In Good Order" receipt from the carrier. All claims for loss or damage in transit should be made to the carrier.

TITLE & LIEN RIGHTS: The equipment shall remain personal property, regardless of how affixed to any realty or structure. Until the price (including any notes given therefore) of the equipment has been fully paid in cash, Seller shall, in the event of Buyer's default, have the right to repossess such equipment.

PATENT INFRINGEMENT: If properly notified and given an opportunity to do so with friendly assistance, Seller will defend Buyer and the ultimate user of the equipment from any actual or alleged infringement of any published United States patent by the equipment or any part thereof furnished pursuant hereto (other than parts of special design, construction, or manufacture specified by and originating with Buyer), and will pay all damages and costs awarded by competent court in any suit thus defended or of which it may have had notice and opportunity to defend as aforesaid.

STANDARD WARRANTY: Seller warrants that products of its own manufacture will be free from defects in workmanship and materials under normal use and service for the period specified in the product instruction manual. Warranty for service parts will be Ninety (90) days from date of factory shipment. Electric Motors, gasoline and diesel engines, electrical apparatus and all other accessories, components and parts not manufactured by Seller are warranted only to the extent of the original manufacturer's warranty.

Notice of the alleged defect must be given to the Seller, in writing with all identifying details including serial number, type of equipment and date of purchase within thirty (30) days of the discovery of the same during the warranty period.

Seller's sole obligation on this warranty shall be, at its option, to repair or replace or refund the purchase price of any product or part thereof which proves to be defective. If requested by Seller, such product or part thereof must be promptly returned to seller, freight prepaid, for inspection.

Seller warrants repaired or replaced parts of its own manufacture against defects in materials and workmanship under normal use and service for ninety (90) days or for the remainder of the warranty on the product being repaired.

This warranty shall not apply and Seller shall not be responsible or liable for:

- (a) Consequential, collateral or special losses or damages;
- (b) Equipment conditions caused by fair wear and tear, abnormal conditions of use, accident, neglect or misuse of equipment, improper storage or damage resulting during shipping;
- (c) Deviation from operating instructions, specifications or other special terms of sale;
- (d) Labor charges, loss or damage resulting from improper operation, maintenance or repairs made by person(s) other than Seller or Seller's authorized service station.

In no event shall Seller be liable for any claims whether arising from breach of contract or warranty or claims of negligence or negligent manufacture in excess of the purchase price.

THIS WARRANTY IS THE SOLE WARRANTY OF SELLERS AND ANY OTHER WARRANTIES, WHETHER EXPRESS OR IMPLIED IN LAW OR IMPLIED IN FACT, INCLUDING ANY WARRANTIES OF MERCHANTABILITY AND FITNESS FOR PARTICULAR USE ARE HEREBY SPECIFICALLY EXCLUDED.

LIABILITY LIMITATIONS: Under no circumstances shall the Seller have any liability for liquidated damages or for collateral, consequential or special damages or for loss of profits, or for actual losses or for loss of production or progress of construction, whether resulting from delays in delivery or performance, breach of warranty, negligent manufacture or otherwise.

ENVIRONMENTAL AND OSHA REQUIREMENTS: At the time of shipment of the equipment from the factory, Quincy Compressor / Ortman Fluid Power will comply with the various Federal, State and local laws and regulations concerning occupational health and safety and pollution. However, in the installation and operation of the equipment and other matters over which the seller has no control, the Seller assumes no responsibility for compliance with those laws and regulations, whether by the way of indemnity, warranty or otherwise.

June 30, 2003



an EnPro Industries company

Reciprocating / Systems: 217.222.7700
Air Master 217.277.0270
E-mail: info@quincycompressor.com
Website: quincycompressor.com
quincyairmaster.com



© 2006 Quincy Compressor, an EnPro Industries company
All Rights Reserved. Litho in U.S.A.