

## Disassembly and Assembly Section

**Note:** Care should be taken when handling the lines group. The slightest bump or drop can result in a misalignment of the bellows and a possible need for replacement.

5. Discard clamp assemblies (2) and (6). The clamp assemblies are a one time use part.

**Note:** Steps 6 through 7 are only necessary if clamp (4) was loosened to remove the entire lines group.

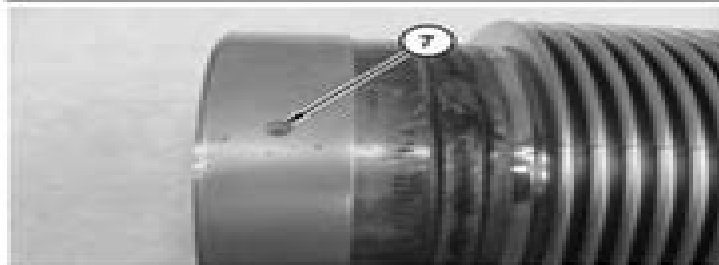


Illustration 3

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Typical example  
(7) Weld

6. Remove clamp (4) from bellows (5) by removing weld (7). Use a grinding device to remove the spot weld.

**Note:** Use care not to remove excessive amounts of material and grind on the bellows.

**Note:** Do not use a vice to secure the lines group. The bellows cannot be damaged in any way during this procedure.

**Note:** Use the proper personal protective equipment when removing clamp (4) from the bellows assembly.



Illustration 4

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Typical example  
Remove the weld from the bellows assembly with a grinding device

7. Inspect the clamping surface on the outside of the bellows. Deburr the surface if necessary.

**Note:** If the bellows assembly is damaged during the removal of clamp (4), replace the bellows assembly.

## Installation

**Note:** Step 1 is only necessary if clamp (4) was loosened to remove the entire lines group.

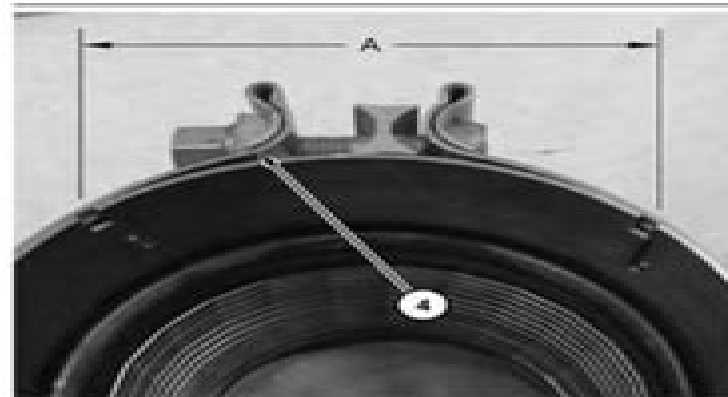


Illustration 5

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Typical example

# Perkins 850 Manual

**Albert A Gayle**



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