

# Repair Parts for Xtreme™ and XP Xtreme 290cc Lowers

406894J

EN



## Important Safety Instructions

Read all warnings and instructions in manual 311762. Save those instructions.

## 25D238 Full Repair Kit - Graco Formulated UHMWPE/Leather (Abrasive Applications)

## 25D248 Full Repair Kit - PTFE

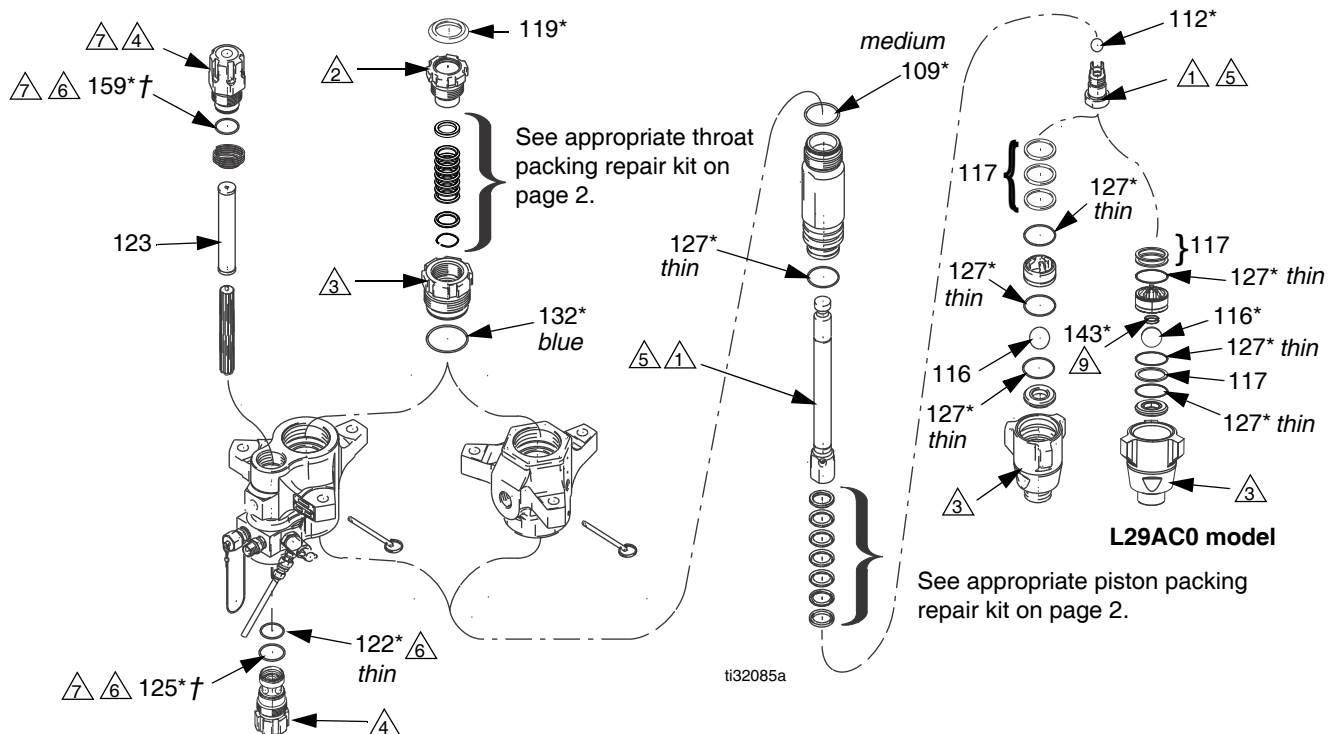
(Chemical Resistance and Higher Temperatures)

**25D262 Full Repair Kit - Graco Formulated UHMWPE/PTFE** (Chemical Resistance and Durability Below 140° F (60° C))

## Bulk Pack Replacement Parts

- 1 Torque to 190-210 ft-lb (258-285 N•m)
  - 2 Torque to 125 ft-lb (169 N•m)
  - 3 Torque to 135-150 ft-lb (183-203 N•m)
  - 4 Torque to 40-60 ft-lb (52-82 N•m)
  - 5 Apply lubricant to threads before assembly.
  - 6 Lubricate
  - 7 Circular grooves on top filter caps (not included) indicates pump series. See page 3 for detailed information.
8. Thick, medium, and thin refers to the relative cross-section thickness of the o-rings.

Non-filter models do not use items 122, 125, and 159.

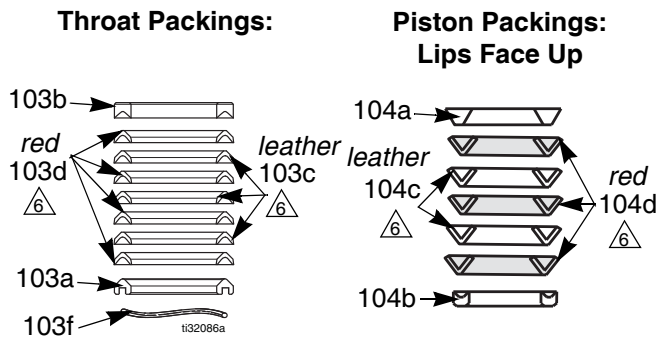


(\*Includes items shown in Replacement Parts table)

1	Ref.	Description	Qty.
1	104a	GLAND, male, piston	1
1	104b	GLAND, female, piston	1
1	104c	V-PACKING, PTFE, piston (white)	5

## Full Repair Kit - Graco Formulated UHMWPE/Leather - 25D238

(\*Includes items shown in Replacement Parts table)



### Lubricate Packings

(soak leather packings in oil for 1 hour)

## Throat Seal Repair Kit - Graco Formulated UHMWPE/Leather - 25D138

### Includes:

Ref.	Description	Qty.
103a	GLAND, male, throat	1
103b	GLAND, female, throat	1
103c	V-PACKING, leather, throat	3
103d	V-PACKING, UHMWPE, throat (red)	4
103f	WAVE SPRING	1

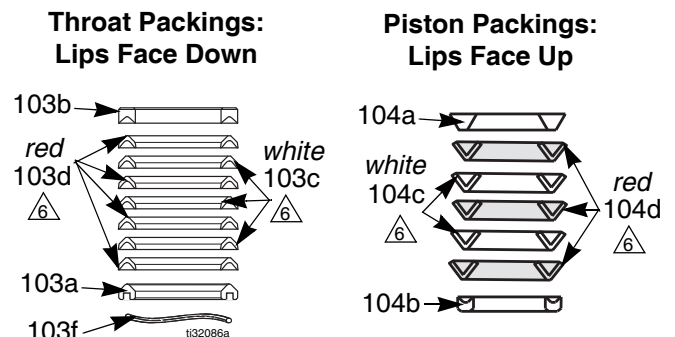
## Piston Seal Repair Kit - Graco Formulated UHMWPE/Leather - 25D145

### Includes:

Ref.	Description	Qty.
104a	GLAND, male, piston	1
104b	GLAND, female, piston	1
104c	V-PACKING, leather, piston	2
104d	V-PACKING, UHMWPE, piston (red)	3

## Full Repair Kit - Graco Formulated UHMWPE/PTFE - 25D262

(\*Includes items shown in Replacement Parts table)



### Lubricate Packings

## Throat Seal Repair Kit - Graco Formulated UHMWPE/PTFE - 25D179

### Includes:

Ref.	Description	Qty.
103a	GLAND, male, throat	1
103b	GLAND, female, throat	1
103c	V-PACKING, PTFE, throat (white)	3
103d	V-PACKING, UHMWPE, throat (red)	4
103f	WAVE SPRING	1

## Piston Seal Repair Kit - Graco Formulated UHMWPE/PTFE - 25D193

### Includes:

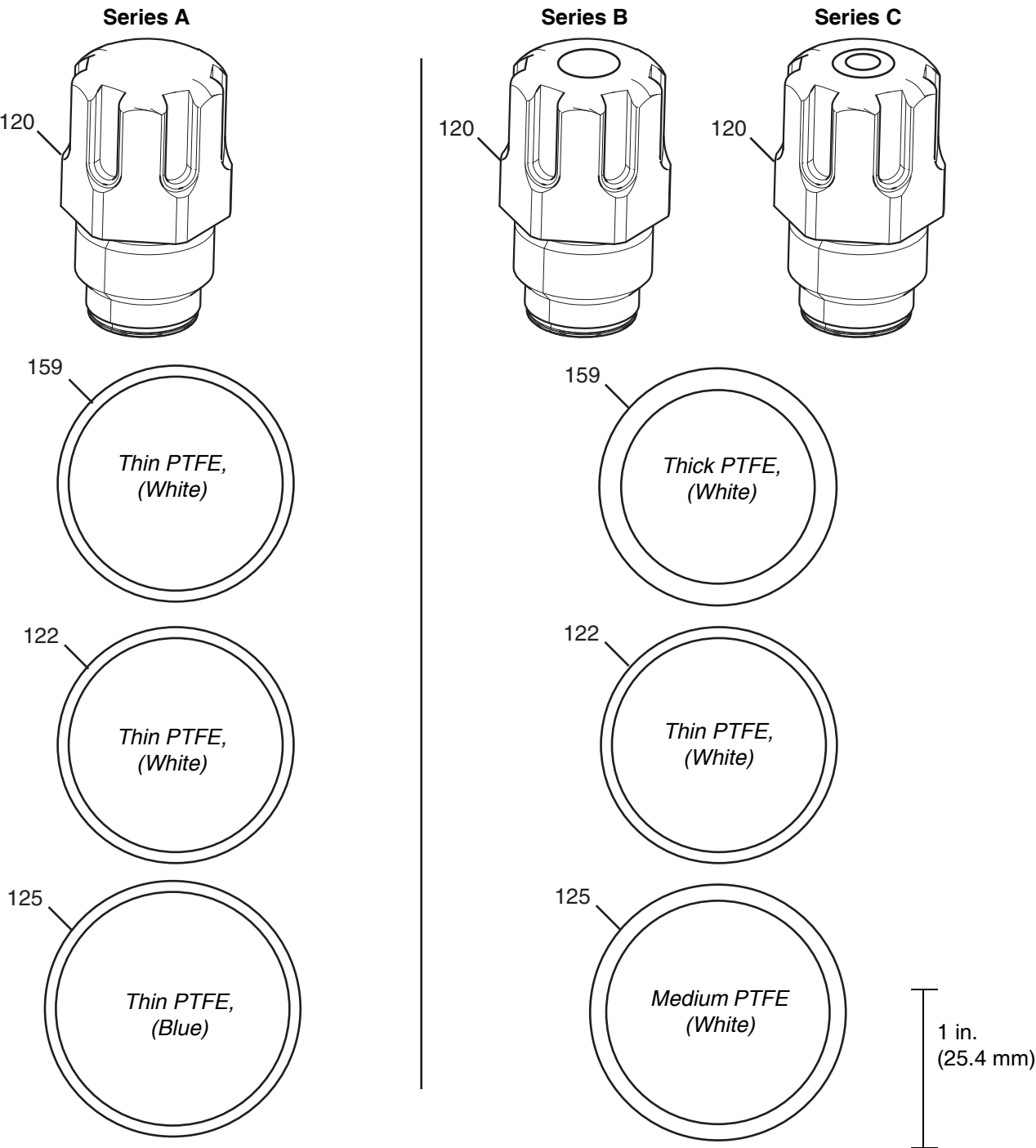
Ref.	Description	Qty.
104a	GLAND, male, piston	1
104b	GLAND, female, piston	1
104c	V-PACKING, PTFE, piston (white)	2
104d	V-PACKING, UHMWPE, piston (red)	3

# O-ring Chart

The pump series for all Xtreme and XP lowers are identified by the circular grooves on the top filter cap. Use the chart below to match the correct o-rings when rebuilding the pump.

The original filter cap seals were changed in 2010 for improved sealing. The o-rings are not interchangeable between different series filter caps. See **24F975 Filter Cap Conversion Kit**, page 4.

**Note:** The top filter cap is shown (not included in the repair kit). O-rings below are shown at actual size.

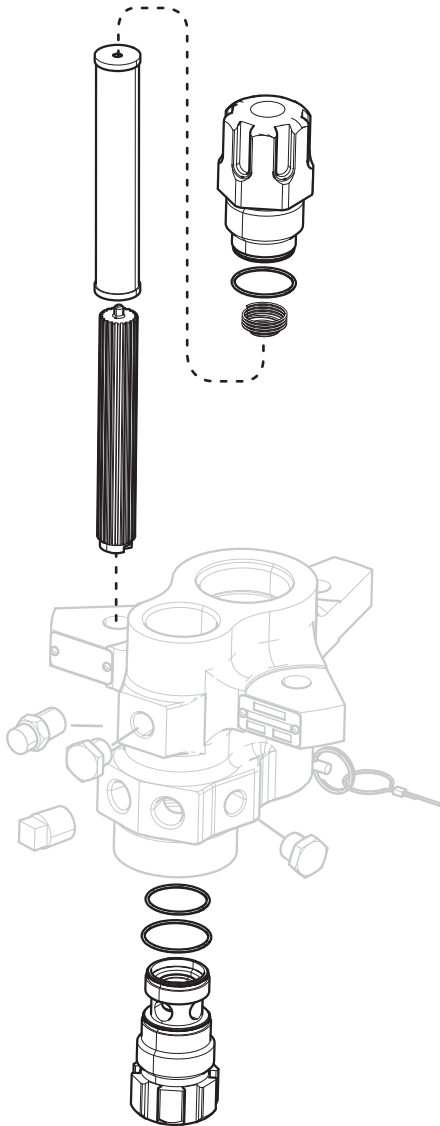


## 24F975 Filter Cap Conversion Kit

Purchase **24F975 Filter Cap Conversion Kit** to improve sealing of Series A filters. Includes components shown. See manual 406882 for more information.

Benefits:

- Compatible with all sizes.
- Improves sealing
- Ensures filters are installed correctly



*All written and visual data contained in this document reflects the latest product information available at the time of publication.  
Graco reserves the right to make changes at any time without notice.*

*For patent information, see [www.graco.com/patents](http://www.graco.com/patents).*

*Original instructions. This manual contains English. MM 406894*

**Graco Headquarters:** Minneapolis

**International Offices:** Belgium, China, Japan, Korea

**GRACO INC. AND SUBSIDIARIES • P.O. BOX 1441 • MINNEAPOLIS MN 55440-1441 • USA**

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[www.graco.com](http://www.graco.com)

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## APPLICATION FAST SET

483 Avenue Lazare Ponticelli  
77220 Gretz-Armainvilliers  
Tel : 01 64 16 41 63 - Fax : 01 64 16 48 67  
[contact@afs-bicomposant.fr](mailto:contact@afs-bicomposant.fr)  
[www.afs-bicomposant.fr](http://www.afs-bicomposant.fr)