

QT Series Model QT-54

Parts Manual

Record of Change 100

This manual contains important safety information and must be carefully read in its entirety and understood prior to installation by all personnel who install, operate and/or maintain this product.

On-line product registration, parts ordering and warranty information is available at www.quincycompressor.com

Manual No. 50318-100

April 2011 Edition

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INTRODUCTION

This manual provides information for the Model QT-54 reciprocating compressor, per Record of Change 100.

The Model QT-54 is an aircooled, two stage, four cylinder, splash lubricated compressor, with up to 175 PSI continuous pressure capability. It has a 2.75" low pressure bore, a 2" high pressure bore and a 2" stroke. This compressor can be run at 550-1420 RPM.

CHANGES

since previous printing dated February 2005:

The crankcase and crankshaft groups were updated.

SERIAL NUMBER IDENTIFICATION

The unit serial number identification tag is located on the air tank top plate. The basic compressor serial number decal is located on the basic compressor, opposite the flywheel side. *Fill in the numbers from your compressor unit and basic compressor in the corresponding spaces provided here, and reference this page when ordering replacement parts.*

Unit Serial Number

Basic Serial Number

All replacement parts are to be ordered through an authorized Quincy distributor. Insist on genuine Quincy Compressor 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-D or Quin-Cip compressor lubricant from your local authorized Quincy distributor.

Quin-Cip-D Lubricant (synthetic)	
SAE 30 (ISO 100)	
Quart	115468Q
Case (12 Qts.)	115438C
Quin-Cip Lubricant	
SAE 10W (ISO 32)	
Quart	112541Q032
Case (12 Qts.)	112541C032
SAE 20 (ISO 68)	
Quart	112542Q068
Case (12 Qts.)	112542C068
SAE 30 (ISO 100)	
Quart	112543Q100
Case (12 Qts.)	112543C100
SAE 40 (ISO 150)	
Quart	2024601401
Case (12 Qts.)	2024601405

CAUTION !

Refer to the QT & QTS Series instruction manual for vital lubrication information.

CAUTION !

Follow all safety precautions outlined in the QT & QTS 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.

CRANKCASE LUBRICANT CAPACITY

Model	Capacity
QT-54	1 qt. & 8 oz. (1.18 lit.)

Recommended Spare Parts

Item #	Qty.	Part Number	Description
1		112845-11	air filter element
1		114097-003	gasket set
2		114096-003	replacement valve assembly

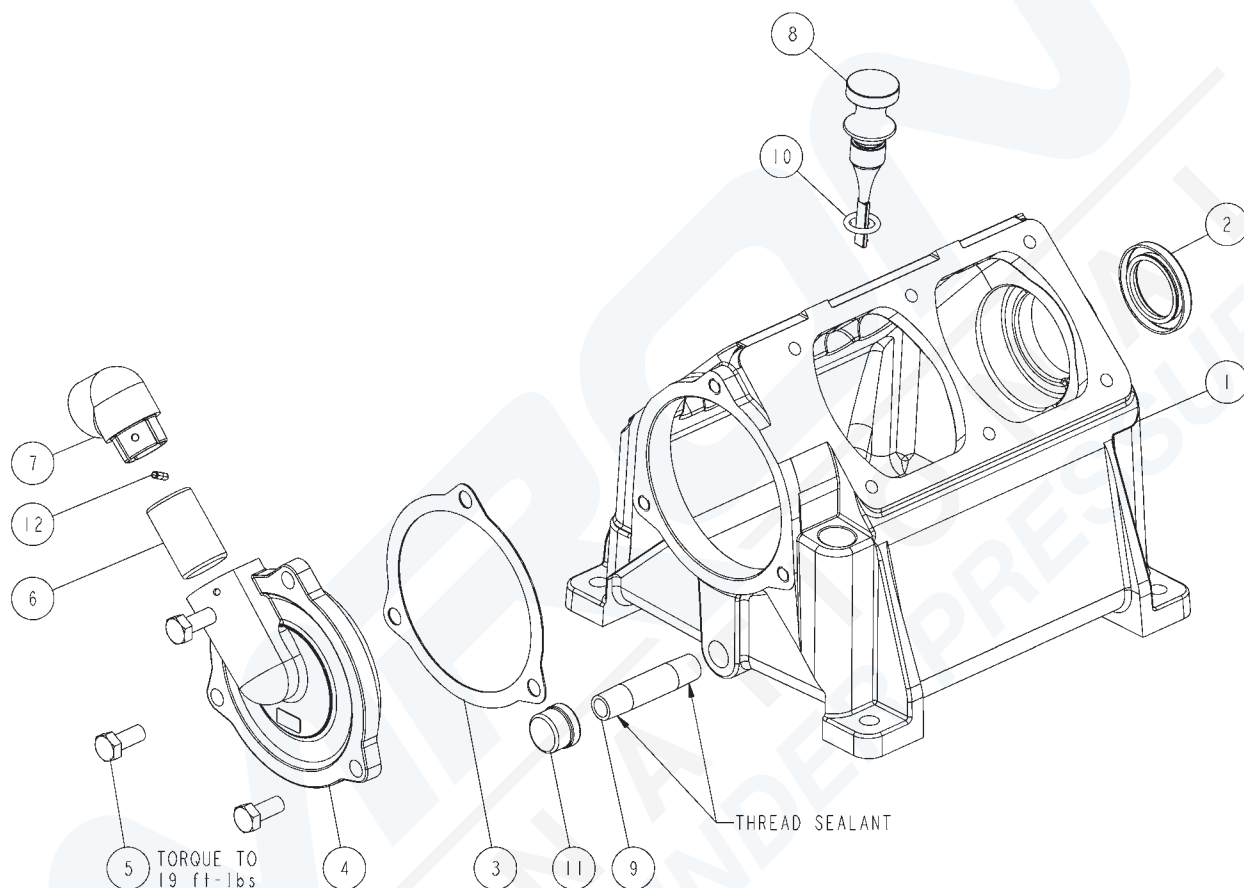
Gasket Set 114097-003

Item #	Qty.	Part Number	Description
1		114201	gasket, valve plate to head
1		112793	gasket, cylinder to valve plate
1		112591	gasket, crankcase to cylinder
1		114918	gasket, bearing carrier
1		115058-001	oil seal
1		22749-112	o-ring

Overhaul Kit KQT54A

Item #	Qty.	Part Number	Description
2		113046	piston ring set, LP
2		115110	piston ring set, HP
1		114097-003	gasket set
2		112588X	valve plate assembly
1		112845-11	air filter element
2		110190-025	piston pin
2		115078	piston pin
1		110095-002	crankcase breather
1		112583	connecting rod assembly, LP
1		112583-001	connecting rod assembly, LP
1		112583-002	connecting rod assembly, HP
1		112583-003	connecting rod assembly, HP
4		111105-002	piston pin plug, .62 dia

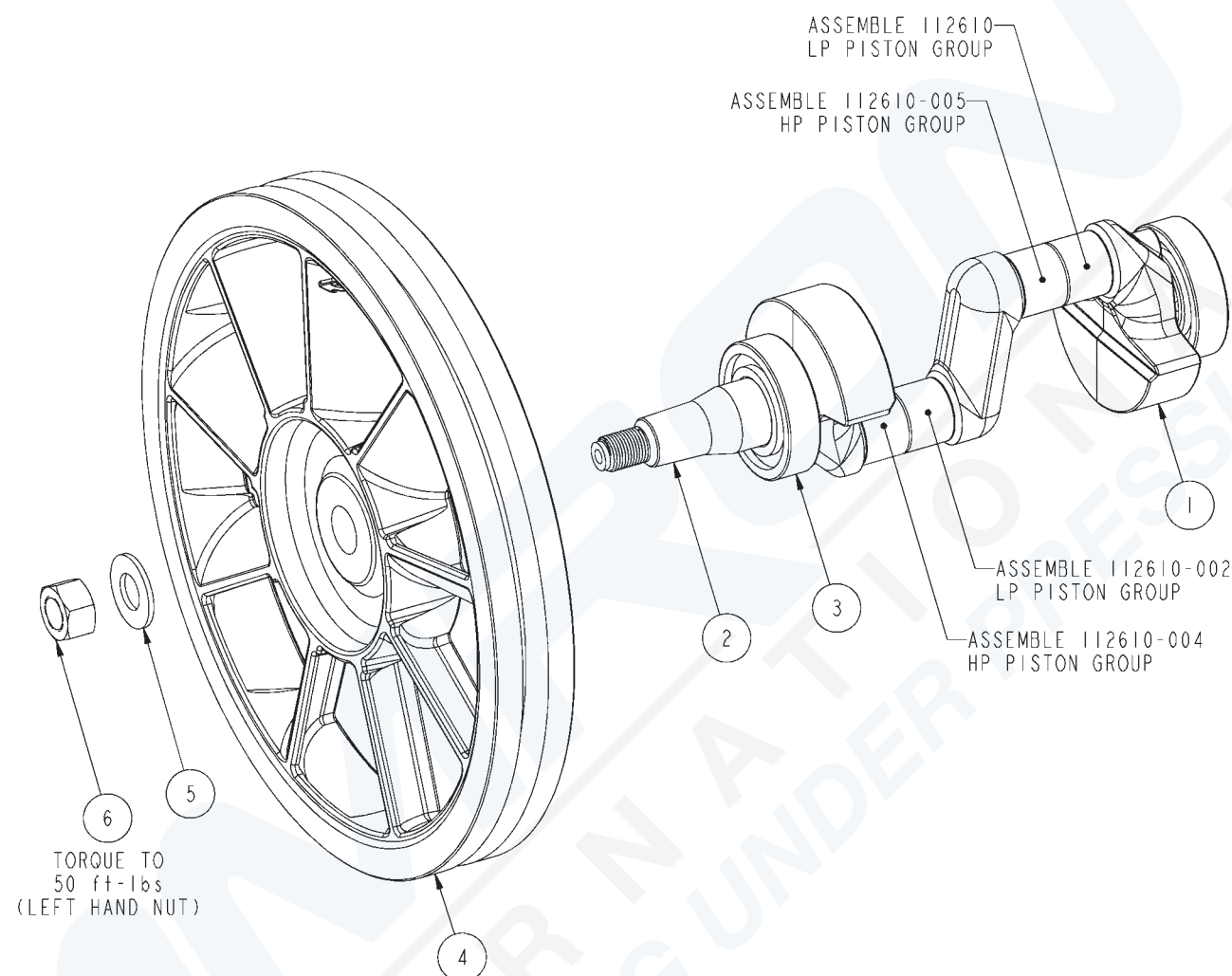
114940 CRANKCASE GROUP



ITEM	PART NUMBER	QTY	DESCRIPTION
1	114871	1	CRANKCASE
2	115058-001	1	VITON OIL SEAL
3	114918	1	GASKET
4	114872	1	BEARING CARRIER
5	115037-K10	3	SCREW, CAP HEX, SEALANT, GRADE 5
6	111333-002	1	FILTER
7	111349-001	1	BREATHER ELBOW
8	110070-9	1	DIPSTICK
9	125933-013	1	PIPE NIPPLE, 1/4 NPT X 2.38
10	22749-112	1	O-RING, VITON
11	4693	1	PIPE CAP
12	115808-F14	1	SPRING PIN

114941 CRANKSHAFT GROUP

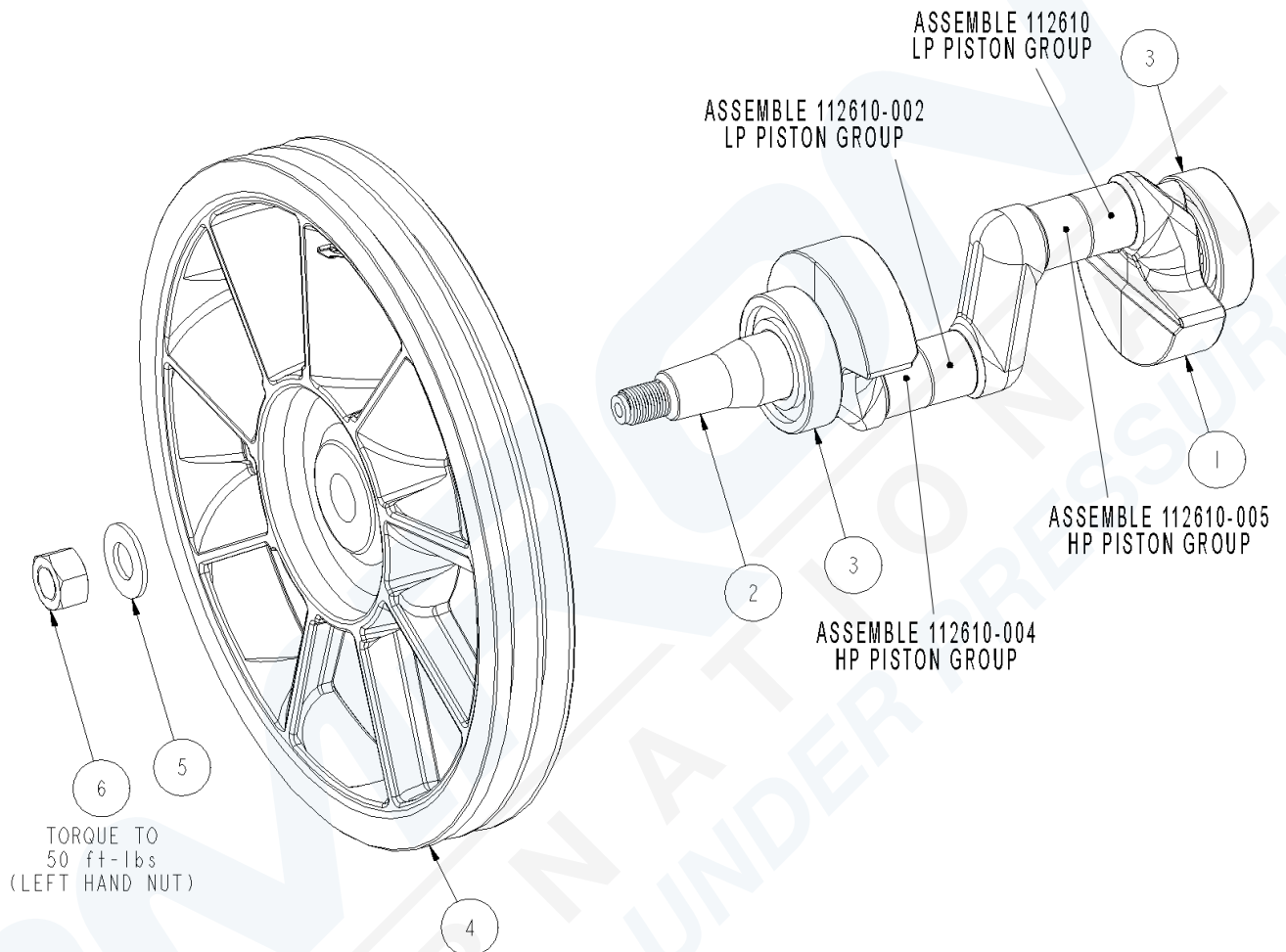
(electric motor models)



CRANKSHAFT GROUP 114941 BILL OF MATERIALS			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	114873X005	1	CRANKSHAFT ASSEMBLY
2	114873-005	1	CRANKSHAFT
3	111107	2	BALL BEARING
4	114211	1	SHEAVE
5	110428N062	1	FLAT WASHER, 5/8
6	112607	1	HEX. NUT

114941-004 CRANKSHAFT GROUP

(gas engine models)

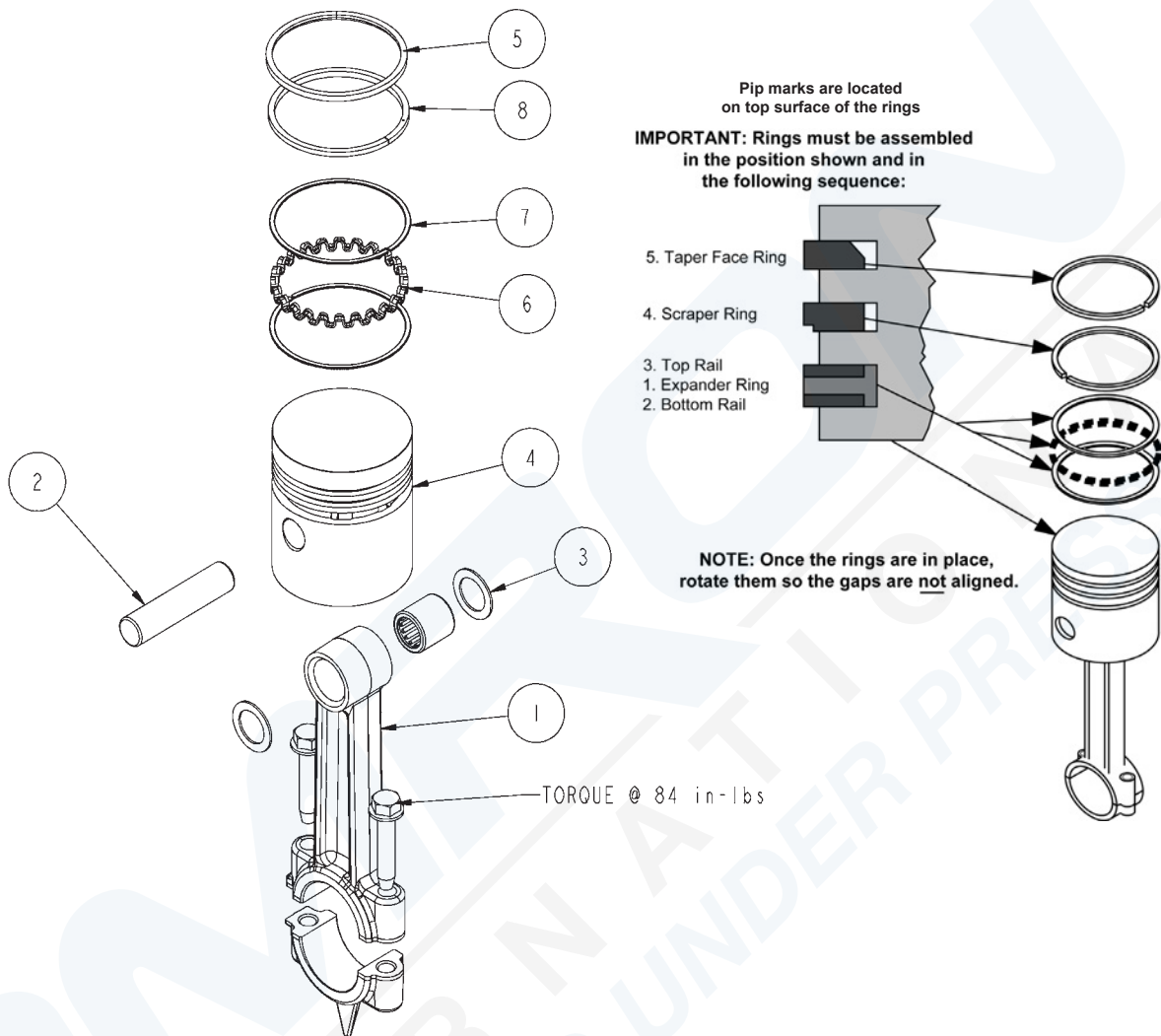


CRANKSHAFT GROUP 114941-004 BILL OF MATERIALS			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	114873X005	1	CRANKSHAFT ASSEMBLY
2	114873-005	1	CRANKSHAFT
3	111107	2	BALL BEARING
4	114211-003	1	SHEAVE, 2 GROOVE, A SECTION
5	110428N062	1	FLAT WASHER
6	112607	1	HEX. NUT

CONNECTING ROD & PISTON GROUP 112610-004

high pressure / left bank / front*

*sheave side is considered front

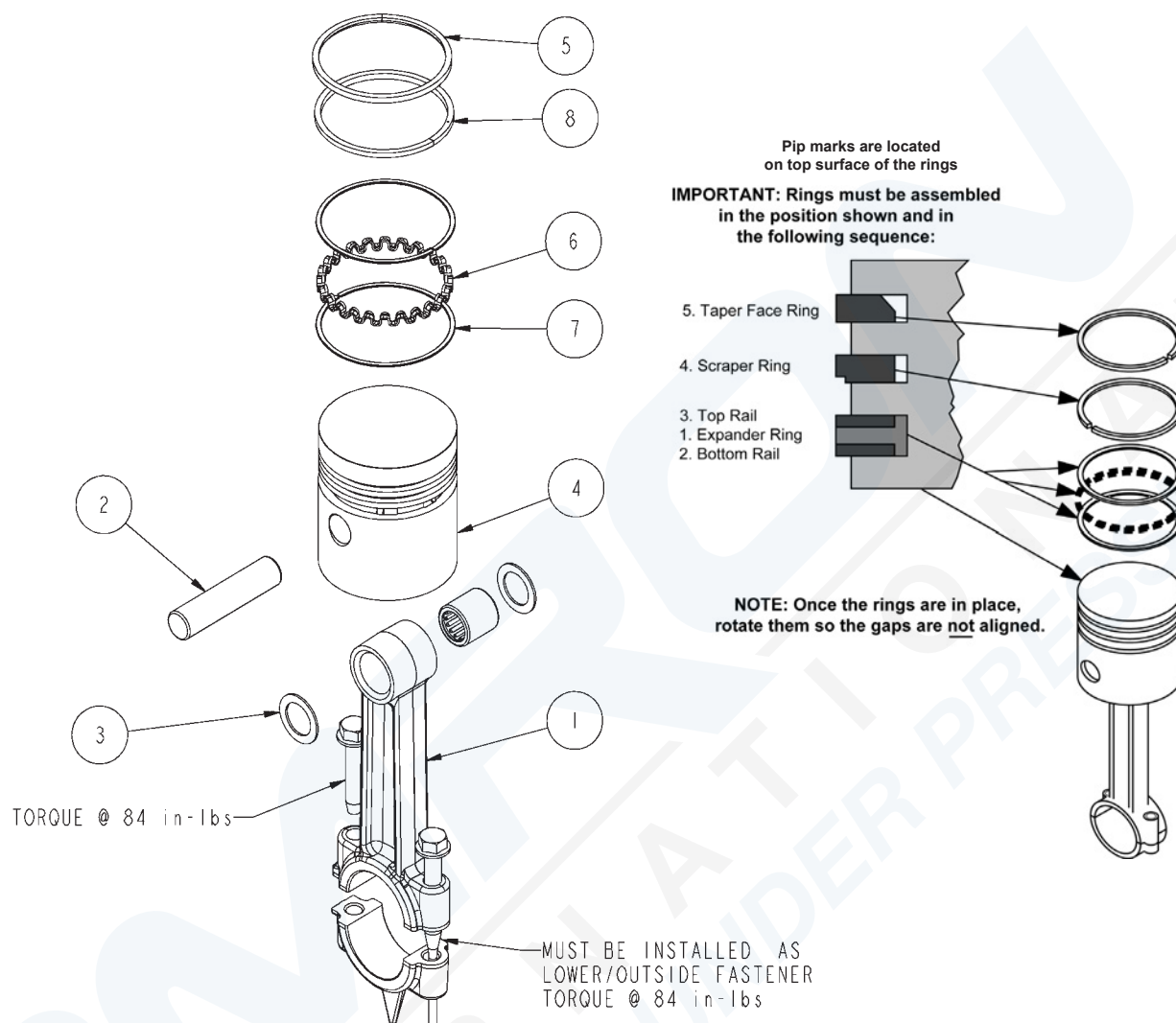


PISTON/CONROD AY 112610-004 BILL OF MATERIALS			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	112583-002	1	AY, CON/ROD
2	115078	1	PISTON PIN
3	112597-001	2	NYLON WASHER
4	114996	1	PISTON
5	115072	1	PISTON RING
6	115080	1	OIL RING SPACER
7	115079	2	OIL RING RAIL
8	115073	1	SCRAPER RING
MAINTENANCE PARTS (ORDER QTY PER PISTON)			
115110	1	REPLACEMENT RING SET (INCLUDES ITEM 5 6, 7 & 8)	
115077	1	REPLACEMENT PISTON PIN BEARING	
112583K002	1	REPLACEMENT CON/ROD (ITEM 1)	

CONNECTING ROD & PISTON GROUP 112610-005

high pressure / left bank / rear*

*sheave side is considered front

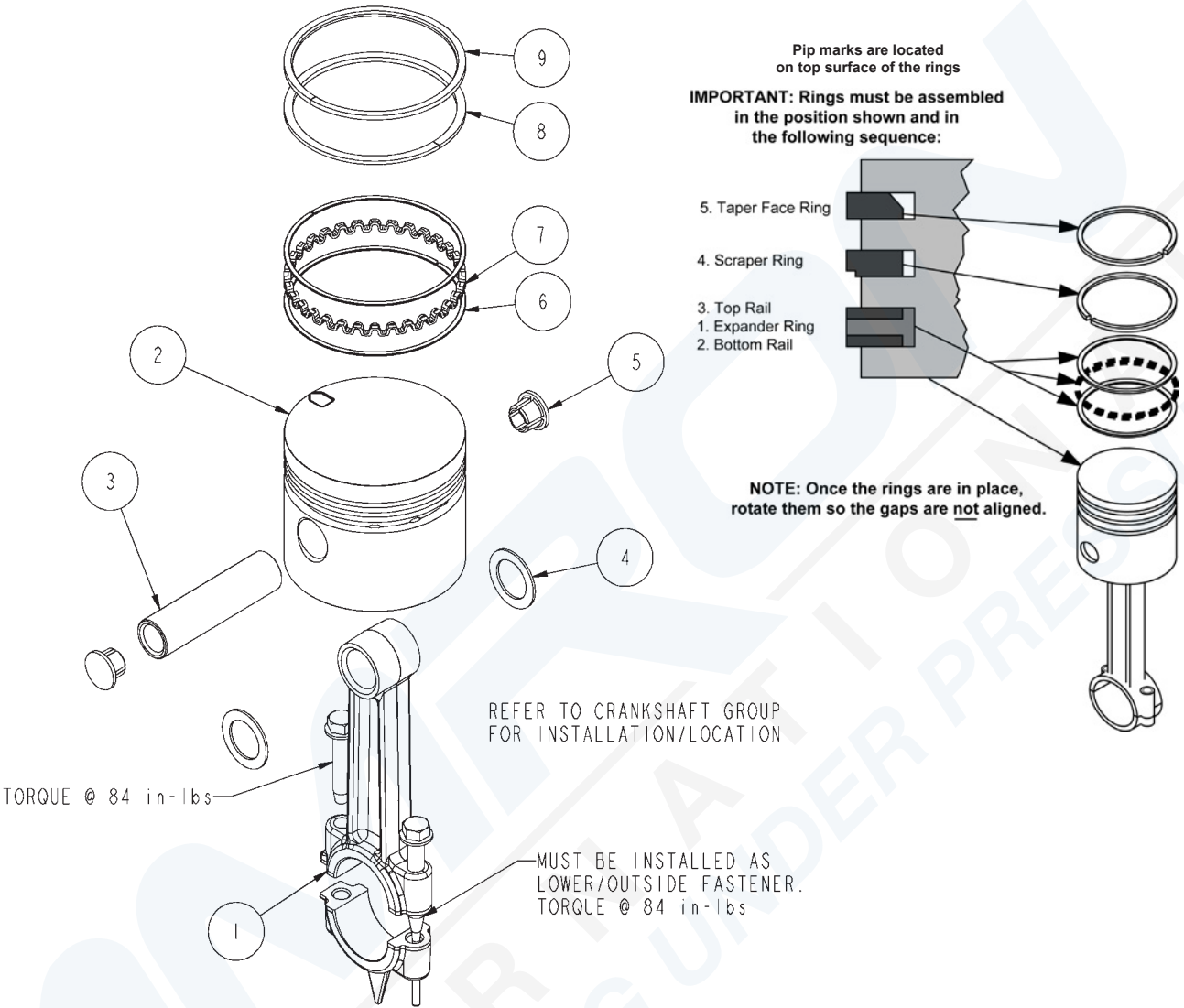


PISTON/CONROD AY 112610-005 BILL OF MATERIALS			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	112583-003	1	AY, CON/ROD
2	115078	1	PISTON PIN
3	112597-001	2	NYLON WASHER
4	114996	1	PISTON
5	115072	1	PISTON RING
6	115080	1	OIL RING SPACER
7	115079	2	OIL RING RAIL
8	115073	1	SCRAPER RING
MAINTENANCE PARTS (ORDER QTY PER PISTON)			
115110	1	REPLACEMENT RING SET (INCLUDES ITEM 5, 6, 7 & 8)	
115077	1	REPLACEMENT PISTON PIN BEARING	
112583K003	1	REPLACEMENT CON/ROD (ITEM 1)	

CONNECTING ROD & PISTON GROUP 112610-002

low pressure / right bank / front*

*sheave side is considered front

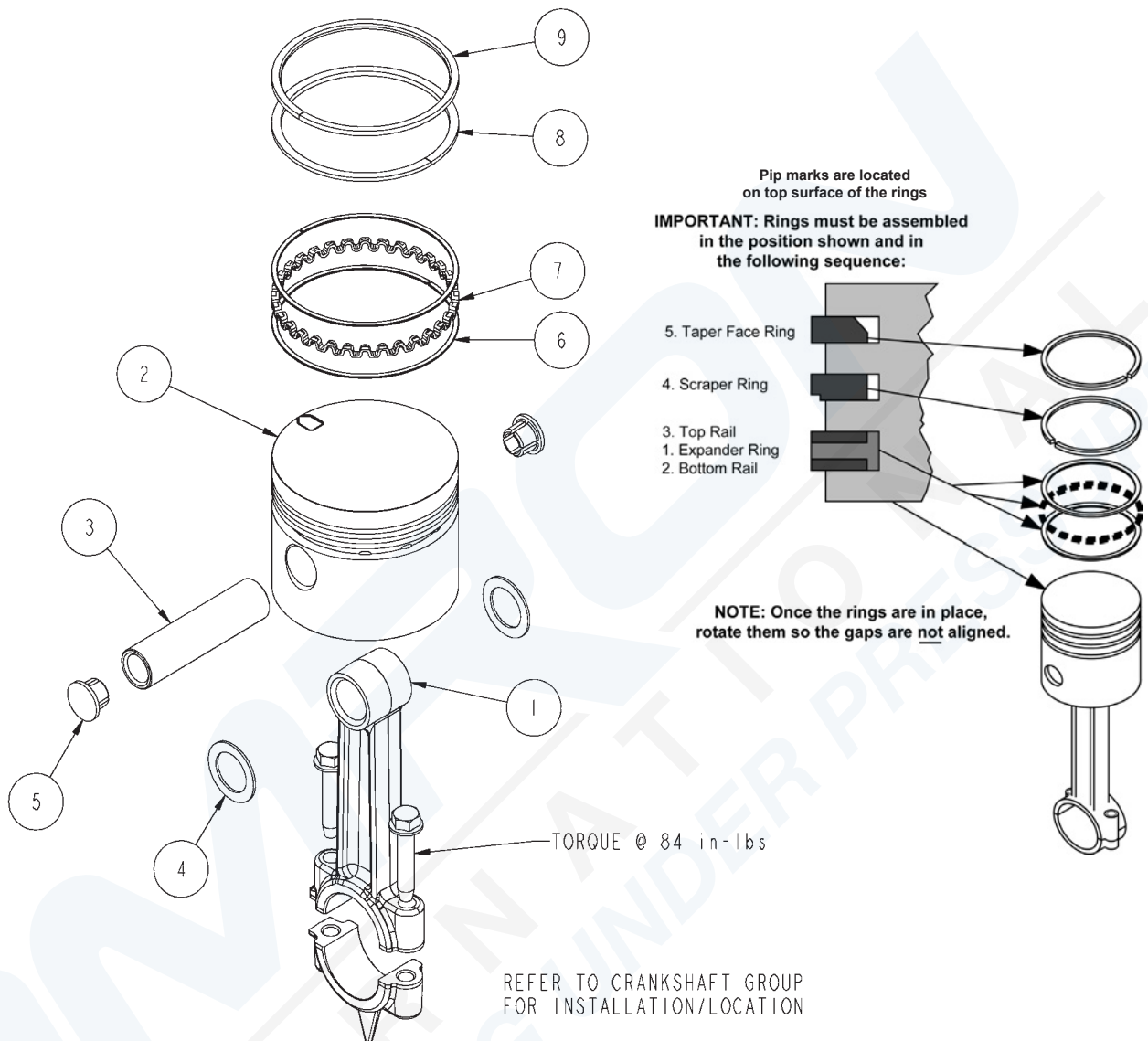


PISTON/CONROD AY 112610-002 BILL OF MATERIALS			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	112583-001	1	AY, CON/ROD
2	112582	1	PISTON
3	110190-025	1	PISTON PIN
4	112597	2	NYLON WASHER
5	111105-002	2	PISTON PIN PLUG
6	112650	2	OIL RING RAIL
7	112651	1	OIL RING SPACER
8	112601	1	PISTON RING SCRAPER
9	112600	1	PISTON RING
MAINTENANCE PARTS (ORDER QTY PER PISTON)			
113046	1		REPLACEMENT RING SET (INCLUDES ITEMS 6, 7, 8 & 9)
112583K001	1		REPLACEMENT CON/ROD (TEM 1)

CONNECTING ROD & PISTON GROUP 112610

low pressure / right bank / rear*

*sheave side is considered front

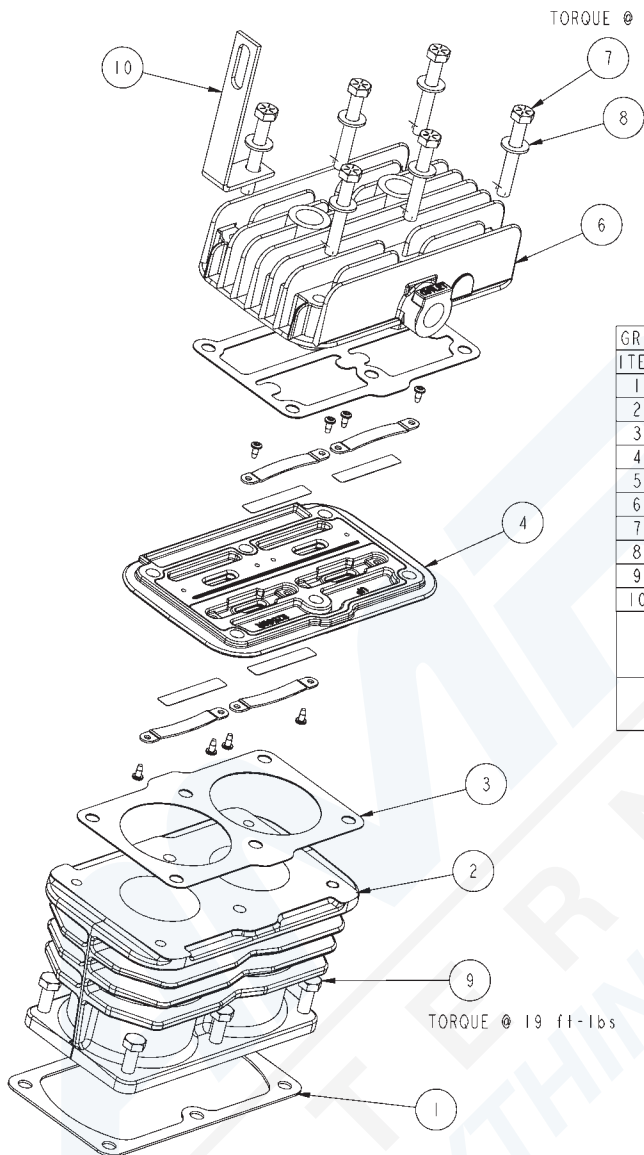


PISTON/CONROD AY 112610 BILL OF MATERIALS			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	112583	1	AY, CON/ROD
2	112582	1	PISTON
3	110190-025	1	PISTON PIN
4	112597	2	NYLON WASHER
5	111105-002	2	PISTON PIN PLUG
6	112650	2	OIL RING RAIL
7	112651	1	OIL RING SPACER
8	112601	1	PISTON RING SCRAPER
9	112600	1	PISTON RING
MAINTENANCE PARTS (ORDER QTY PER PISTON)			
113046	1	REPLACEMENT RING SET (INCLUDES ITEMS 6, 7, 8 & 9)	
112583K	1	REPLACEMENT CON/ROD (ITEM 1)	

CYLINDER & HEAD GROUP 112640-012

plain / high pressure / left bank*

*sheave side is considered front



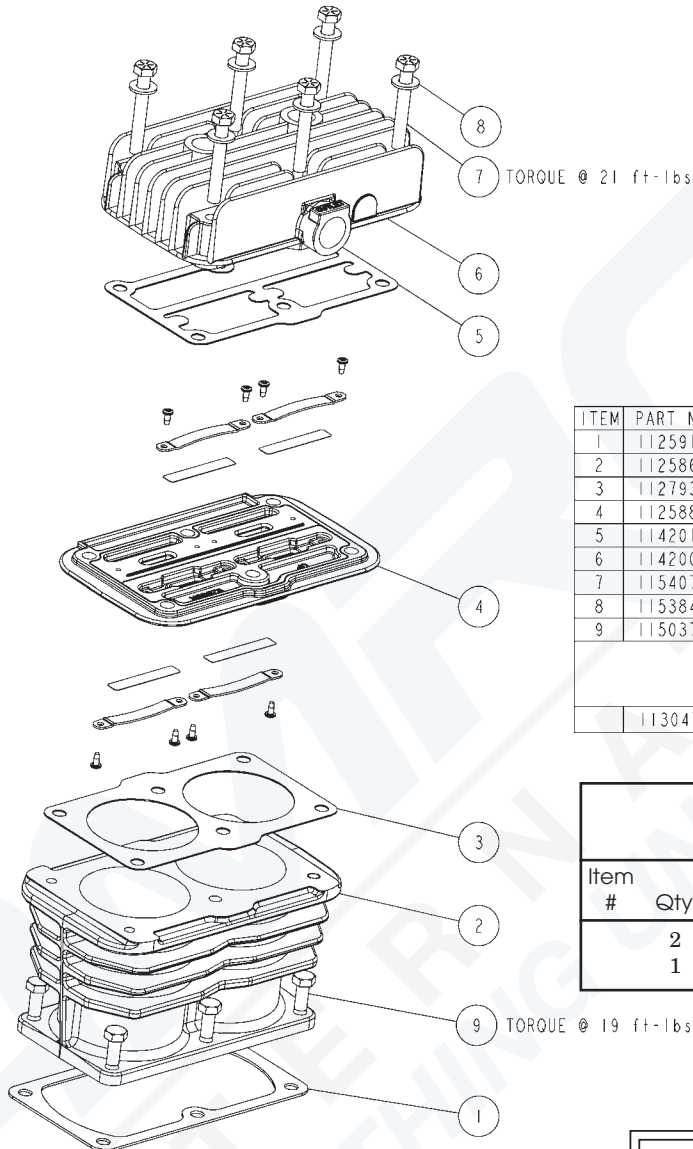
GR, CYL/HEAD (PLAIN) 112640-012 BILL OF MATERIALS			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	112591	1	GASKET
2	112586-001	1	CYLINDER, AIRCOOLED (2.00 DIA)
3	112793	1	GASKET, CYL/VALVE PLATE
4	112588X	1	VALVE PLATE ASSEMBLY
5	114201-001	1	HEAD GASKET
6	114200R	1	HEAD
7	115407-K18	6	HEX, SCREW GRADE 8
8	115384N031	6	WASHER
9	115037-K10	6	SCREW, CAP HEX, SEALANT, GRADE 5
10	110312-004	1	BRACKET, GUARD
MAINTENANCE PARTS (ORDER QTY PER BANK)			
	113047-001	1	VALVE REPAIR KIT (INCLUDES ITEM 3, 4 & 5

Head Kit KQT54B			
Item #	Qty.	Part Number	Description
	2	113047-001	Replacement Valve Assembly
	1	112845-11	Air Filter Element (polyester)

CYLINDER & HEAD GROUP 112640-011

plain / low pressure / right bank (electric motor models)

*sheave side is considered front



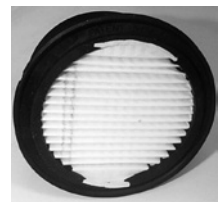
ITEM	PART NUMBER	QTY	DESCRIPTION
1	112591	1	GASKET
2	112586	1	CYLINDER, AIRCOOLED (2.75 DIA)
3	112793	1	GASKET, CYL/VALVE PLATE
4	112588X	1	VALVE PLATE ASSEMBLY
5	114201-001	1	HEAD GASKET
6	114200-002	1	HEAD
7	115407-K18	6	HEX, SCREW GRADE 8
8	115384N031	6	WASHER
9	115037-K10	6	SCREW, CAP HEX, SEALANT, GRADE 5
MAINTENANCE PARTS (ORDER QTY PER BANK)			
	113047-001	1	VALVE REPAIR KIT (INCLUDES ITEMS 3,4,5)

Head Kit KQT54B

Item #	Qty.	Part Number	Description
2	1	113047-001	Replacement Valve Assembly
1	1	112845-11	Air Filter Element (polyester)

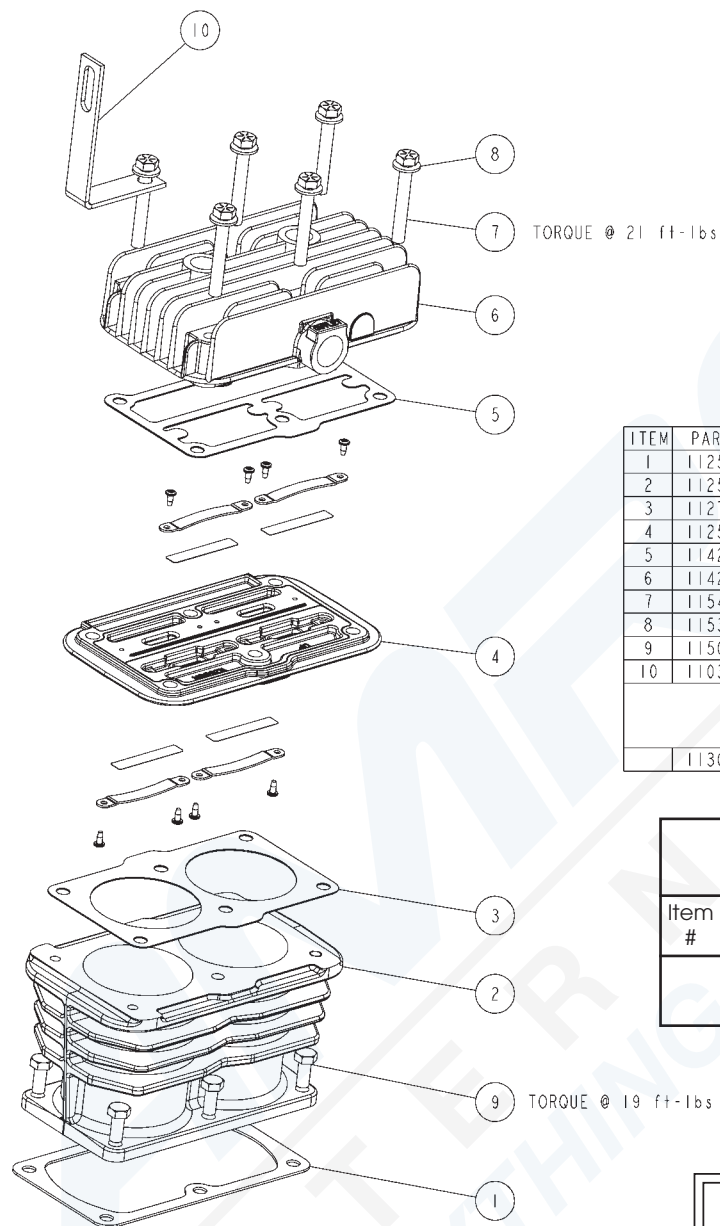


112835-012
Air Filter / Silencer



112845-10
Air Filter Element
(paper)

CYLINDER & HEAD GROUP 112640-027
plain / low pressure / right bank (gas engine models)
*sheave side is considered front



ITEM	PART NUMBER	QTY	DESCRIPTION
1	112591	1	GASKET
2	112586	1	CYLINDER, AIRCOOLED (2.75 DIA)
3	112793	1	GASKET, CYL/VALVE PLATE
4	112588X	1	VALVE PLATE ASSEMBLY
5	114201-001	1	HEAD GASKET
6	114200-002	1	HEAD
7	115407-K18	6	HEX, SCREW GRADE 8
8	115384N031	6	WASHER
9	115037-K10	6	SCREW, CAP HEX, SEALANT, GRADE 5
10	110312-003	1	GUARD BRACKET
MAINTENANCE PARTS (ORDER QTY PER BANK)			
	113047-001	1	VALVE REPAIR KIT (INCLUDES ITEMS 3,4,5)

Head Kit KQT54B			
Item #	Qty.	Part Number	Description
2		113047-001	Replacement Valve Assembly
1		112845-11	Air Filter Element (polyester)



112835-012
Air Filter / Silencer

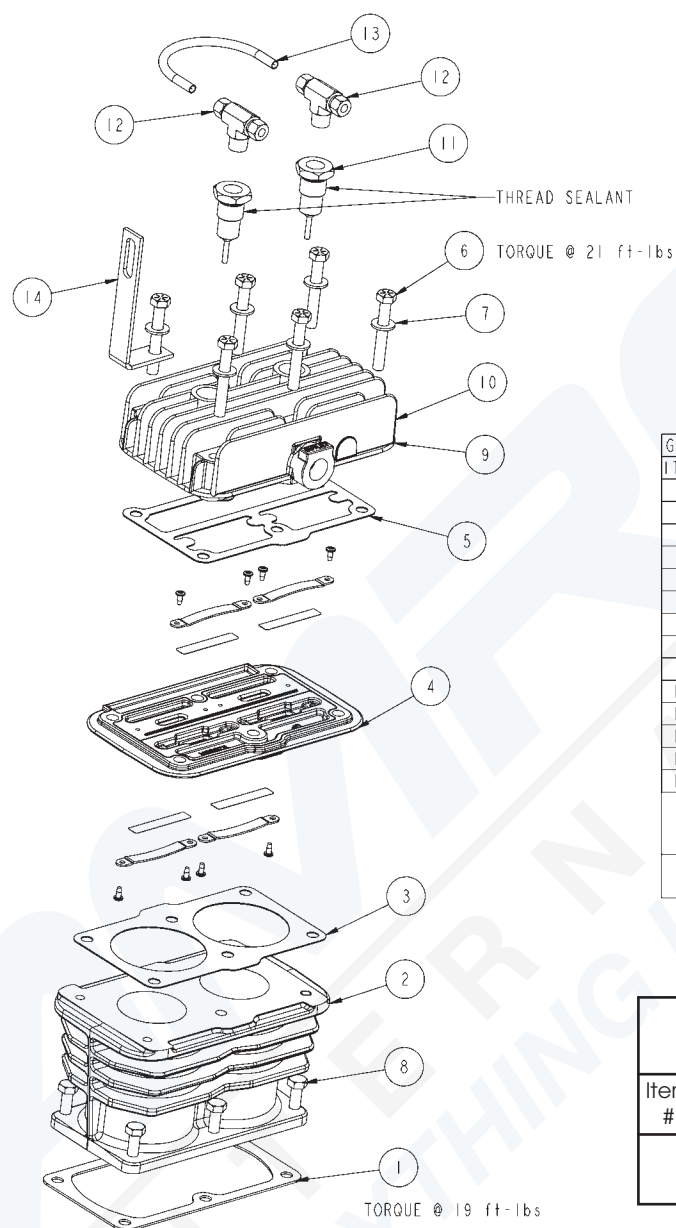


112845-10
Air Filter Element
(paper)

CYLINDER & HEAD GROUP 112640-014

with head unloaders / high pressure / left bank

*sheave side is considered front



GR, CYL/HEAD (UNLDR) 112640-014 BILL OF MATERIALS			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	112591	1	GASKET
2	112586-001	1	CYLINDER, AIRCOOLED (2.00 DIA)
3	112793	1	GASKET, CYL/VALVE PLATE
4	112588X	1	VALVE PLATE ASSEMBLY
5	114201-001	1	HEAD GASKET
6	115407-K18	6	HEX, SCREW GRADE 8
7	115384N031	6	WASHER
8	115037-K10	6	SCREW, CAP HEX, SEALANT, GRADE 5
9	114200X002	1	HEAD ASSEMBLY
10	114200-001	1	HEAD
11	111590X2	2	INTAKE UNLOADER
12	124351-004	2	MALE BRANCH TEE 1/4T X 1/4P
13	110515-025	1	1/4" COPPER TUBING
14	110312-004	1	BRACKET, GUARD
MAINTENANCE PARTS (ORDER QTY PER BANK)			
	113047-001	1	VALVE REPAIR KIT (INCLUDES ITEM 3, 4 & 5)

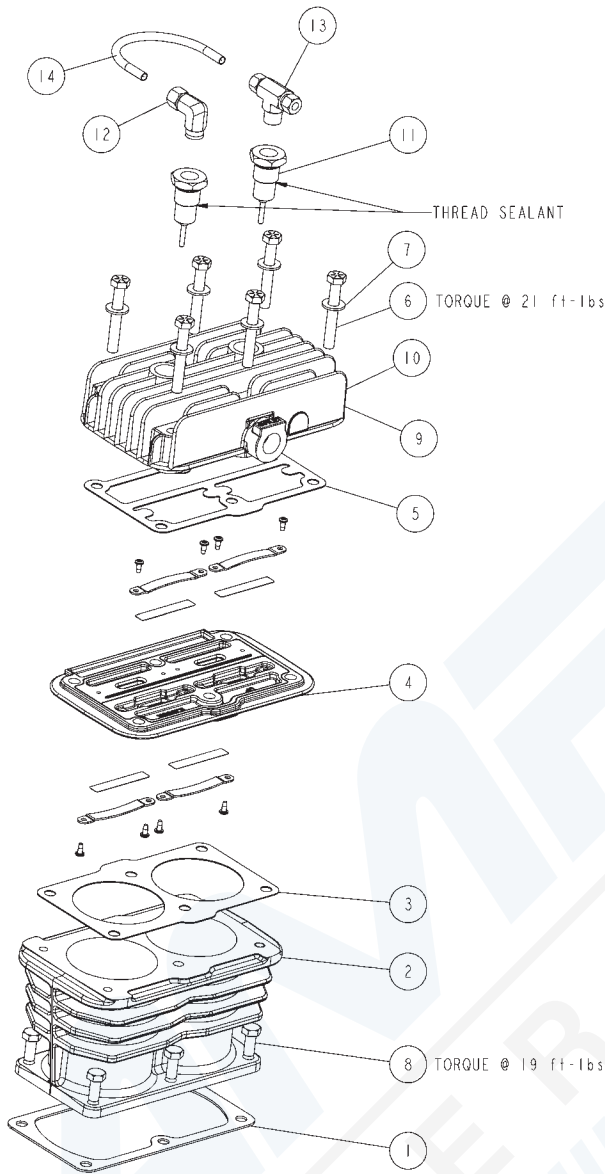
Head Kit KQT54B

Item #	Qty.	Part Number	Description
2		113047-001	Replacement Valve Assembly
1		112845-11	Air Filter Element (polyester)

CYLINDER & HEAD GROUP 112640-013

with head unloaders / low pressure / right bank

*sheave side is considered front

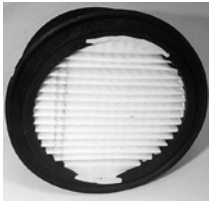


ITEM	PART NUMBER	QTY	DESCRIPTION
1	112591	1	GASKET
2	112586	1	CYLINDER, AIRCOOLED (2.75 DIA)
3	112793	1	GASKET, CYL/VALVE PLATE
4	112588X	1	VALVE PLATE ASSEMBLY
5	114201-001	1	HEAD GASKET
6	115407-K18	6	HEX, SCREW GRADE 8
7	115384N031	6	WASHER
8	115037-K10	6	SCREW, CAP HEX, SEALANT, GRADE 5
9	114200X001	1	HEAD ASSY
10	114200-001	1	HEAD
11	111590X2	2	INTAKE UNLOADER
12	2708	1	TUBE FITTING, 90° ELBOW, 1/4T x 1/4MP
13	124351-004	1	MALE BRANCH TEE 1/4T X 1/4P
14	110515-025	1	1/4" COPPER TUBING
MAINTENANCE PARTS (ORDER QTY PER BANK)			
	113047-001	1	VALVE REPAIR KIT (INCLUDES ITEMS 3,4,5)

Head Kit KQT54B			
Item #	Qty.	Part Number	Description
2		113047-001	Replacement Valve Assembly
1		112845-11	Air Filter Element (polyester)

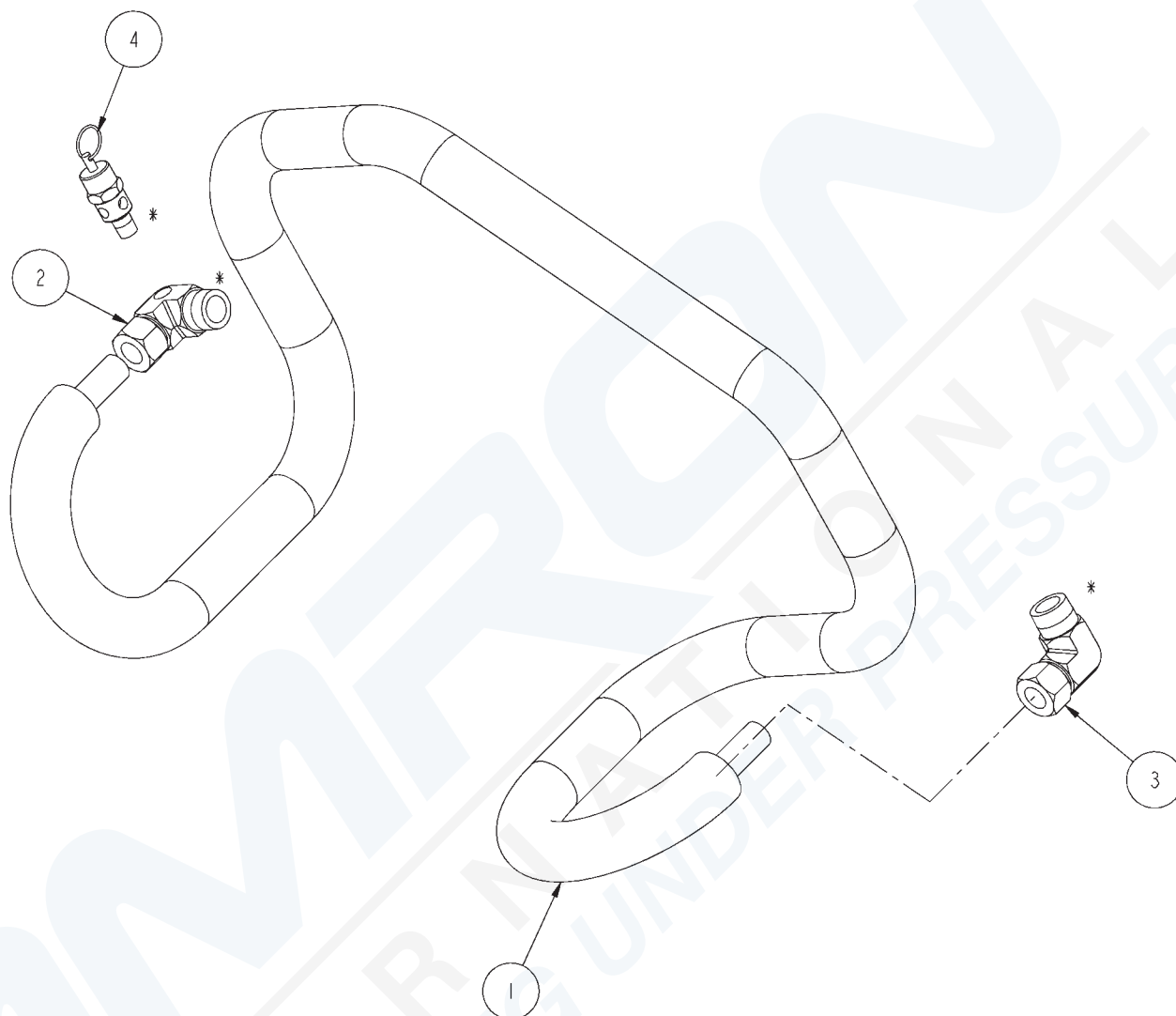


112835-012
Air Filter / Silencer



112845-10
Air Filter Element
(paper)

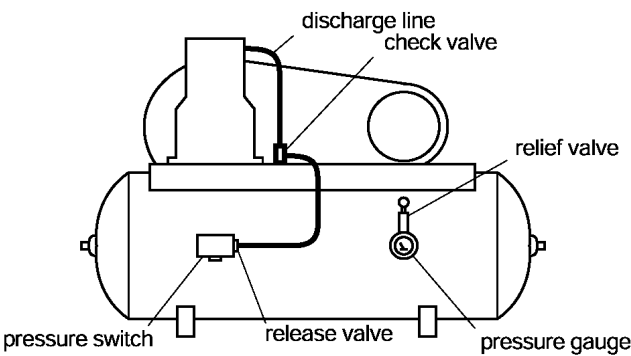
INTERCOOLER GROUP 115118



INTERCOOLER 115118 BILL OF MATERIALS			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	115085	1	INTERCOOLER
2	115329	1	ELBOW 062 STR X 050 NPT
3	7235	1	TUBE FITTING, 90 DEGREES MALE ELBOW
4	111089-100	1	PRESSURE RELIEF VALVE
MAINTENANCE PARTS			
	K115118	1	INTERCOOLER KIT (INCLUDES ALL ABOVE ITEMS)

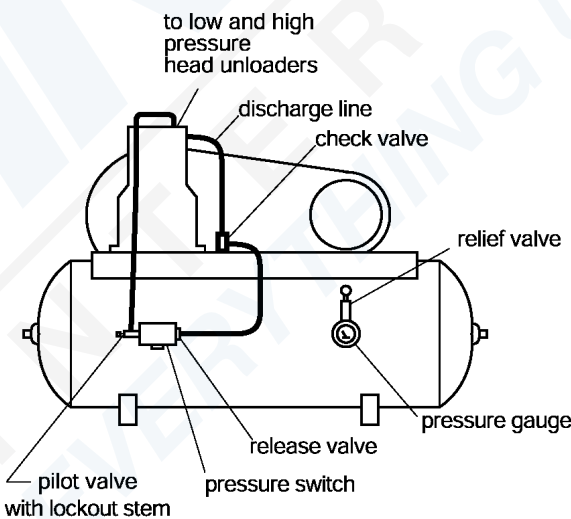
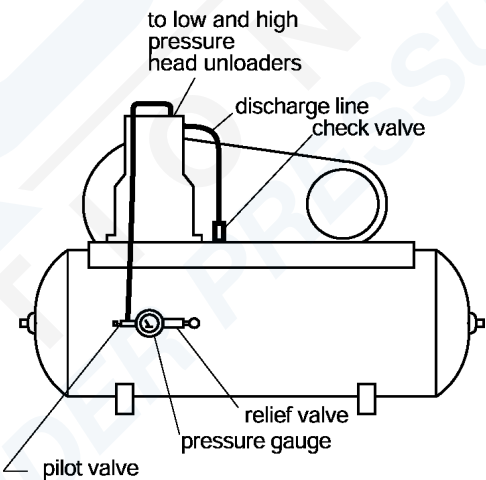
* THREAD SEALANT

CONTROL PIPING SCHEMATIC



**Control Piping
For Automatic Start/Stop**
(with loadless starting)

**Control Piping
For Continuous Run**



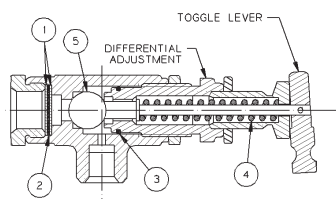
**Control Piping
For Dual Control**

*For Start / Stop operation
the pilot valve is open
(stem screwed out)*

*For Continuous Run operation
the pilot valve is closed
(stem screwed in)*

PIX 1186.tif

PILOT VALVES

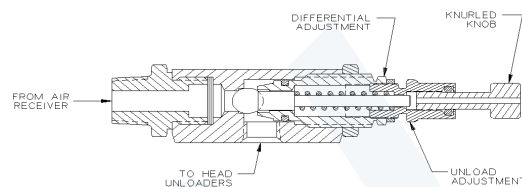


110832 Series Pilot Valve (continuous run operation)

Add dash # listed below to 110832 (per pressure setting) to obtain correct pilot valve.

Dash #	Load PSI	Unload PSI
-100	90	100
-997	*	30-70 adjustable
-998	*	71-150 adjustable
-999	*	151-175 adjustable

* Customer to set, see differential setting chart. Additional factory preset valves are available upon request.



110998 Series Pilot Valve (dual control operation)

Add dash # listed below to 110998 (per pressure setting) to obtain correct pilot valve.

Dash #	Load PSI	Unload PSI
-115	100	115
-140	125	140
-165	150	165

Pilot Valve Repair Kit 110832-051

Can be used to repair 110832 series pilot valves only. Customer must specify which spring when ordering repair kit.

Item #	Qty.	Part Number	Description
1	2		screen
2	1		filter
3	1		"o"ring
4	1	see chart below	pilot valve spring
5	1		ball

Differential Setting Chart

Applies to 110998 series pilot valves only.

Unload (PSI)	Min. Dif. (PSI)	Max. Dif. (PSI)
40	2	5
60	3	10
100	4	20
150	5	30
175	5	45

Differential Setting Chart

Spring Part # (item 4)	Unload (PSI)	Min. Dif. (PSI)	Max. Dif. (PSI)
110832-052 (red)	30	2	4
"	40	5	8
"	50	5	8
"	60	5	8
"	70	5	10
110832-053 (yellow)	80	5	10
"	90	5	12
"	100	5	13
"	110	5	15
"	120	5	15
"	130	5	18
"	140	5	18
"	150	5	20
110832-054 (green)	160	5	15
"	170	5	20
"	175	5	23

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.

SUCTION VALVE UNLOADER ASSEMBLIES

Description

The Quincy suction valve unloader assembly consists of unloading assemblies on the suction valves, having a plunger to contact the suction valve reed and an unloader pilot valve (110832 or 110998 series) to automatically regulate the passing of air tank pressure to the unloading arrangement.

Continuous Run Operation

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.

Unloading occurs when air tank pressure is sufficient to overcome pilot valve spring pressure. The check ball is then unseated, allowing air tank pressure to pass to the unloader assemblies. The compressor will run unloaded until the air tank pressure drops to a predetermined level. At this time, the action of the ball is reversed, shutting off air tank pressure to the unloader assemblies and venting the unloader to atmosphere. This allows the compressor to load. The drive, either electric motor or engine, runs continuously and must be started and stopped manually. 110832 series pilot valves feature a toggle lever which can be flipped to provide manual unloading.

Dual Control Operation

Dual control operation is designed to provide a choice between "start/stop" or "continuous run" operation. The 110998 series pilot valve can be set for "start/stop" operation by turning the knurled knob at the end of the pilot valve (*refer to illustration for 110998 series pilot valve*) clockwise until it stops. Under these circumstances, a pressure switch is required to stop the motor. Failure to use a pressure switch, with the pilot valve locked out, will result in unsafe conditions.

WARNING !

A pressure switch must be incorporated whenever 110998 series pilot valve 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 mounted directly into the air tank. Compressors in the field, not equipped with these controls, can be converted. Consult your local Quincy distributor for assistance with conversion procedures.

Service

If a change in pilot valve operation is detected, remove the pilot valve from the air tank and check the screen in the inlet of the pilot valve for obstructions. Clean the screen if necessary.

Adjustment

The unloading pressure is adjustable and is regulated by turning the unload adjustment hex nut (*refer to pilot valve illustrations*). 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 differential adjustment hex nut (*refer to pilot valve illustrations*). Increase the differential pressure by turning the hex nut clockwise - decrease by turning counterclockwise. Make all adjustments in small increments. Tighten the locknuts after adjustment.

TYPICAL UNIT REPAIR PARTS LIST

The parts listed here are for standard QT-54 (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.

(QT-54 simplex - 60 gal. vertical tank)

Qty	Part Number	Description		
1	114965-200	tank (200 PSI maximum operating pressure)		
1	2713	tank drain valve		
1	111136-050	ball valve		
1	110514-200	pressure gauge		
1	110512-016	pressure switch with release valve (135-175 PSI)		
1	111089-215	pressure relief valve (215 PSI)		
1	110513-200	pressure relief valve (200 PSI)		
3 ft.	110515-050	! discharge tube (1/2" copper tube to be formed by customer)		
2	110948-050	tube fitting (nut with sleeve)		
1	110921-275	check valve		
1	3145	tube fitting, elbow		
1	110945-018	belt guard assembly		
	230v, 1Ø 3600 RPM	230v, 1Ø 1800 RPM		
1	127466I009	2023000868	124517-005	5 h.p. motor
1	3597-78		114026	motor pulley
1		8924	8924	motor pulley bushing
1	110259A054	110258A061	110258A061	belt

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

Part numbers shown in italics apply to tank mounted units and base mounted units.

(QT-54 gas engine driven)

Qty	Part Number	Part Number	Description
	Kohler	Honda	
1	113727P200	113727P200	30 gal. tank (200 PSI maximum operating pressure)
1	111136-025	111136-025	tank drain valve
1	111136-050	111136-050	ball valve
1	110514-300	110514-300	pressure gauge
1	111089-215	111089-215	pressure relief valve (215 PSI)
1	110513-200	110513-200	pressure relief valve (200 PSI)
3 ft.	110515-050	110515-050	discharge tube (1/2" copper tube to be formed by customer)
1	3145	3145	tube fitting, elbow
2	110258A067	110258A067	drive belt
1	115849-001	115849-001	engine pulley
1	110623	110623	engine pulley bushing
1	113702-014	113702-014	belt guard assembly
1	113698		engine group, 11 h.p. (includes throttle control)
1		114013-011	engine group, 11 h.p. (includes throttle control)
1	115117-175	115117-175	discharge unloader valve (for discharge line unload style)
1	9178	9178	tube fitting, compression

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

Part numbers shown in italics apply to tank mounted units and base mounted units.

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



AMERON
INTERNATIONAL
EVERYTHING UNDER PRESSURE™

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Website: quincycompressor.com

