

INSTALLATION, OPERATION, AND MAINTENANCE MANUAL



ROTARY GEAR PUMPS

MODELS
<p>GHC SERIES STAINLESS STEEL PUMPS Construction Code 9-B</p>

THE GORMAN-RUPP COMPANY MANSFIELD, OHIO

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INTRODUCTION

Thank You for purchasing a Gorman-Rupp Rotary Gear Pump. This manual is designed to help you achieve the best performance and longest life from your Gorman-Rupp Rotary Gear pump. **Read this manual** carefully to learn how to safely install, operate and repair your pump. Failure to do so could result in personal injury or damage to the pump.

This manual will alert personnel to known procedures which require special attention, to those which could damage equipment, and to those which could be dangerous to personnel. However, this manual cannot possibly provide detailed instructions and precautions for each specific application or for every situation that might occur during maintenance of the unit. Therefore, it is the responsibility of the owner, installer and/or maintenance personnel to ensure that applications and/or maintenance procedures not addressed in this manual are performed only after establishing that neither personal safety nor pump integrity are compromised by such applications or procedures.

In addition to this manual, a separate **Parts List** is shipped with the pump. Refer to the Parts List when ordering parts.

If your pump is furnished with a drive unit, refer to the drive unit manufacturer's installation and operation instructions in the literature accompanying the pump.

These pumps can transfer a wide range of light, medium, and heavy viscosity liquids, depending on design and components. **Some models are not recommended for use with water; others when fitted with specific options, may be used with water; consult the factory.**

If there are any questions regarding the pump or drive unit which are not covered in this manual or in other literature accompanying this unit, please contact your Gorman-Rupp distributor or the Gorman-Rupp Company:

The Gorman-Rupp Company
P.O. Box 1217
Mansfield, Ohio 44901-1217
or:
Gorman-Rupp of Canada Limited
70 Burwell Road
St. Thomas, Ontario N5P 3R7

RECORDING MODEL AND SERIAL NUMBERS

Please record the pump model and serial number in the spaces provided below. Your Gorman-Rupp distributor needs this information when you require parts or service.

Pump Model: _____

Serial Number: _____

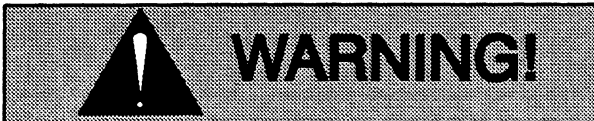
WARRANTY INFORMATION

The warranty provided with your pump is part of Gorman-Rupp's support program for customers who operate and maintain their equipment as described in this and the other accompanying literature. Please note that should the equipment be abused or modified to change its performance beyond the original factory specifications, the warranty will become void and any claim will be denied.

The following are used to alert personnel to procedures which require special attention, to those which could damage equipment, and to those which could be dangerous to personnel:



Immediate hazards which will result in severe personal injury or death. These instructions describe the procedure required and the injury which will result from failure to follow the procedure.



Hazards or unsafe practices which COULD result in severe personal injury or death. These instructions describe the procedure required and the injury which could result from failure to follow the procedure.



Hazards or unsafe practices which COULD result in minor personal injury or product or property damage. These instructions describe the requirements and the possible damage which could result from failure to follow the procedure.

NOTE

Instructions to aid in installation, operation, and maintenance or which clarify a procedure.

SAFETY – SECTION A

This information is specific to Gorman-Rupp GHC Series SST Rotary Gear Pumps. It applies throughout this manual and any manual or literature accompanying the pump.

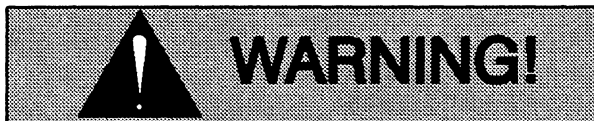
In addition to this manual, see the separate literature covering the drive unit used to operate this pump.



Pumps and related equipment must be installed and operated according to all national, local and industry standards.

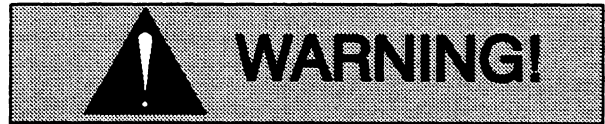


This manual will alert personnel to known procedures which require special attention, to those which could damage equipment, and to those which could be dangerous to personnel. However, this manual cannot possibly provide detailed instructions and precautions for each specific application or for every situation that might occur during maintenance of the unit. Therefore, it is the responsibility of the owner, installer and/or maintenance personnel to ensure that applications and/or maintenance procedures not addressed in this manual are performed only after establishing that neither personal safety nor pump integrity are compromised by such applications or procedures.

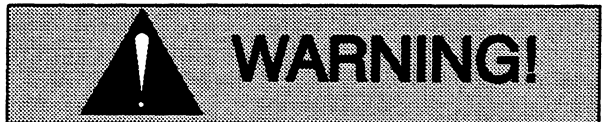


Before attempting to install, operate, or service this pump, familiarize yourself with this manual, and with all other literature shipped with the pump. Unfamiliarity with all aspects of pump operation

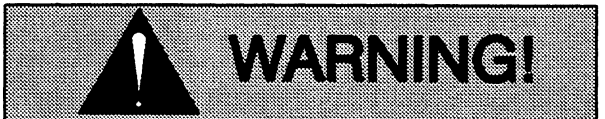
covered in this manual could lead to destruction of equipment, injury, or death.



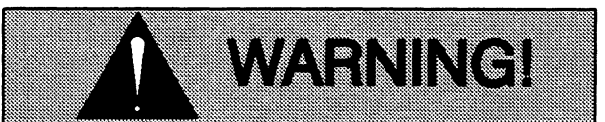
The standard version of this pump is designed to handle a wide range of light, medium, and heavy viscosity liquid, depending on design and components, and a range of temperatures when fitted with different seals. Do not apply at higher temperatures than the seal will handle. Do not attempt to pump liquids which may damage the pump or endanger personnel as a result of pump failure; consult the factory for chemical compatibility.



If the pump and motor are furnished mounted on a base, make certain that all lifting devices have adequate capacity. If chains or cables are used in lifting, make certain that they are positioned so as not to damage components, and so that the load will be balanced.

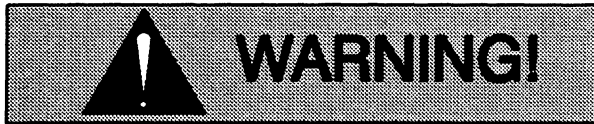


After the pump has been installed, make certain that the pump and all piping or hose connections are secure before operation. Loose connections can result in damage to the equipment and serious injury to personnel.



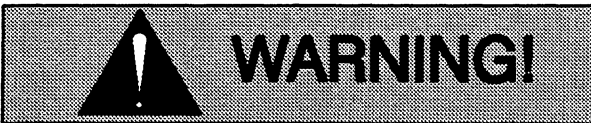
Never operate the pump without a pressure relief valve installed on the pump or in the discharge piping. Make certain that pump-mounted pressure relief

valves are installed with their adjusting ends toward the suction port. If bi-rotational operation is required, a pressure relief device must be provided for both directions of flow. Operation without a pressure relief valve or with an improperly installed relief valve could cause the pump to explode, resulting in serious injury or death to personnel.



Before attempting to open or service the pump:

1. Familiarize yourself with this manual.
2. Lock out incoming power to the drive unit to ensure that the pump will remain inoperative.
3. Allow the pump to completely cool if overheated.
4. Close the discharge and suction valve (if used).



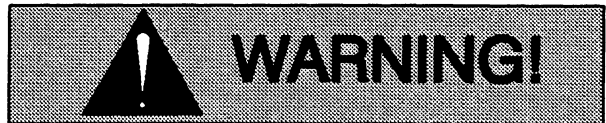
An overheated pump can cause severe burns and injury. If overheating occurs:

1. Stop the pump immediately.

2. Allow the pump to completely cool.
3. Refer to the instructions in this manual before restarting the pump.



Do not remove plates, covers, gauges, pipe plugs or fittings from an overheated pump. Vapor pressure within the pump can cause parts being disengaged to be ejected with great force. Allow the pump to completely cool before servicing.



Do not operate this pump without guards in place over the rotating parts. Exposed rotating parts can catch clothing, fingers or tools, causing severe injury to personnel.

INSTALLATION – SECTION B

Review all SAFETY information in Section A.



Pumps and related equipment must be installed and operated according to all national, local and industry standards.

Since pump installations are seldom identical, this section is intended only to summarize general recommendations and practices required to inspect, position, and arrange the pump and piping. If there are any questions concerning your specific installation, contact your Gorman-Rupp distributor or the Gorman-Rupp Company.

Most of the information applies to a flooded suction installation where liquid is supplied under pressure.

If the pump is positioned above the liquid in a static lift installation, information such as mounting, piping configuration and priming must be tailored to specific conditions.



These pumps are not recommended for use with water. Some models when fitted with specific options may be used with water; consult the factory.

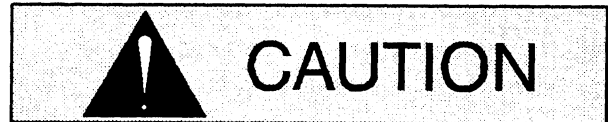
PREINSTALLATION INSPECTION

The pump assembly was inspected and tested before shipment from the factory. Before installation, check for damage which may have occurred during shipment. Check as follows:

- a. Inspect the pump assembly for cracks, dents, damaged threads, and other obvious damage.
- b. Check for loose attaching hardware. Since gaskets tend to shrink after drying, check for loose hardware at the mating surfaces.

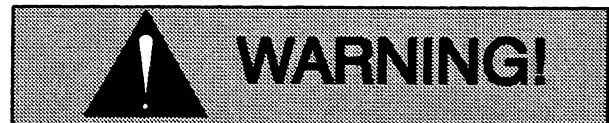
- c. Carefully read all tags, decals, and markings on the pump assembly, and perform all duties indicated.

Flushing



Clean piping is essential because of close-tolerance moving parts in this pump. Flush all dirt, grit, weld beads or scale from the suction piping before installing the pump. Damage to the pump because of debris in the suction line is not covered by the pump warranty.

Before shipment, the pump may have been tested using a petroleum-based preservative. If flushing is required, do not do so until just before installation; the test oil protects close-tolerance pump parts from corrosion.

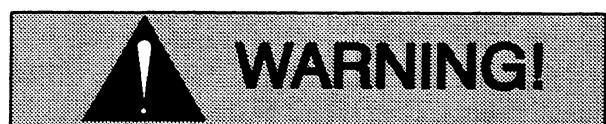


Most cleaning solvents are toxic and flammable. Use them only in a well ventilated area free from flame, sparks, and excessive heat. Read and follow all precautions printed on solvent containers.

To flush the pump, use an approved solvent compatible with the liquid being pumped. **Make certain that the solvent will not attack pump components, particularly seals and gaskets.**

PUMP INSTALLATION

Pump dimensions are shown in the separate Pump Specification Bulletin.



Never operate the pump without a pressure relief valve installed on the pump or in the discharge piping. Make certain that pump-mounted pressure relief

valves are installed with their adjusting ends toward the suction port. If bi-rotational operation is required, a pressure relief device must be provided for both directions of flow. Operation without a pressure relief valve or with an improperly installed relief valve could cause the pump to explode, resulting in serious injury or death to personnel.

Lifting

Remove suction and discharge hose and piping before attempting to lift the pump. Use lifting equipment with a capacity of at least five times the total weight of the equipment being lifted.

Positioning The Pump

Locate the pump as close as possible to the liquid being pumped. Locating the pump below the liquid source will help self-priming and reduce the possibility of cavitation.

Mounting

The pump may be shipped alone, mounted on a base, or with pump and motor mounted on a base. Install the pump and motor on a base before mounting the base on a foundation.

Mount the base on a foundation that will provide permanent, rigid support for the pump, and will be heavy enough to absorb any vibration, strain or shock.

Piping

Before establishing suction and discharge lines, determine pump port positions and rotation. Figure B-1 shows typical port positions for the standard 180° housing; if you have selected a 90° housing port option, your port positions will be different.

Begin piping layout at the pump, and work toward the source of supply and the point of discharge.

Either hose or rigid pipe may be used to make connections. If rigid piping is used, install expansion joints to protect the pump from vibration and ther-

mal expansion in the piping. Do not use expansion joints or flexible connectors to adjust misaligned piping.

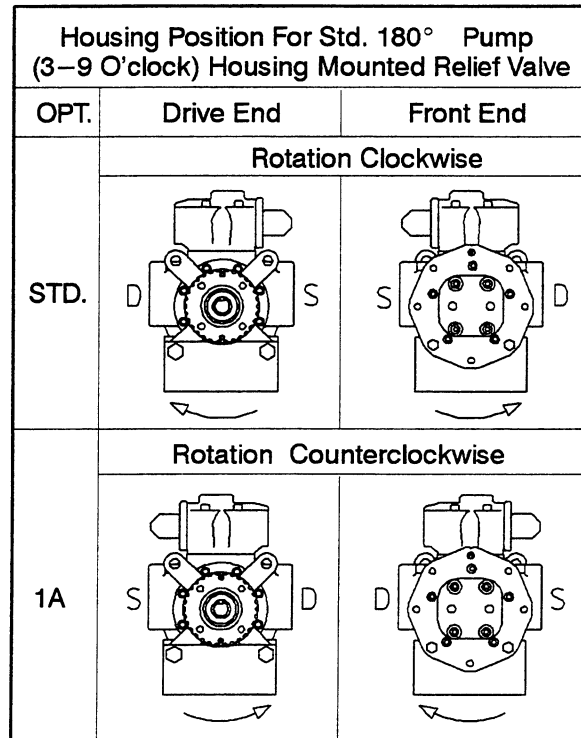


Figure B-1. Typical Port Positions & Rotation

The discharge and suction lines must be independently supported to avoid vibration and strain on the pump. For maximum pumping capacity, keep the lines as short and straight as possible. Elbows and fittings used in the lines increase friction losses; minimize their use. Reducers used in suction lines should be the eccentric type installed with the flat part uppermost to avoid creating air pockets.

Before tightening a connection or flange, align it exactly with the pump port. Never pull a pipe line into place by tightening the flange bolts and/or couplings.

Strainers

Because of the close-tolerance moving parts of this pump, it is recommended that a strainer be installed in the suction line. The strainer should be large enough to prevent excessive vacuum, and capable of operating under high vacuum without collapsing. The net open area of the strainer screen depends on liquid viscosity and desired flow rate; in any case, the sum of the area of all the

holes in the screen should be three to five times the area of the suction pipe.

Gauges

To monitor operation and assist in troubleshooting, a vacuum gauge and a pressure gauge should be installed on the pump.

Sealing

Even a slight leak will affect priming, head, and capacity, especially in a suction lift application. Seal all piping joints, valves and gauges with pipe dope or teflon tape. The sealing material should be compatible with the liquid being pumped.

Valves

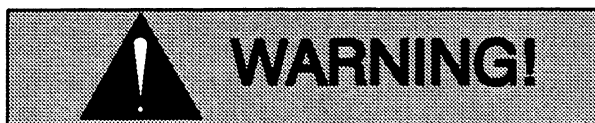
To avoid air pockets, install piping valves with the stem horizontal.

To prevent leakage during shutdown, install a shut-off valve in the discharge line, particularly on a flooded suction application. Shutoff valves are not recommended for suction lines.

It is **not** recommended that a foot valve be installed at the end of the suction line. If desired to install a foot valve, consult the factory.

When handling very hot or cold liquids, install a pressure relief valve in any part of the system that can be valved off or isolated; this will protect piping against damage from liquid thermal expansion or contraction from temperature changes during shutdown.

ALIGNMENT



Make certain that power to the drive unit is disconnected before attempting to connect the pump drive; otherwise, personal injury may result.

NOTE

See **ROTATION** in Section C before mounting the pump on the base.

Coupled Drives

When using couplings, the axis of the power source must be aligned to the axis of the pump shaft in both the horizontal and vertical planes. Most couplings require a specific gap or clearance between the driving and the driven shafts. Refer to the coupling manufacturer's service literature.

Align spider insert type couplings by using calipers to measure the dimensions on the circumference of the outer ends of the coupling hub every 90°. The coupling is in alignment when the hub ends are the same distance apart at all points (see Figure B-2).

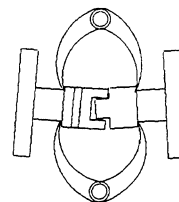


Figure B-2. Spider-type Couplings

Align non-spider type couplings by using a feeler gauge or taper gauge between the coupling halves every 90°. The coupling is in alignment when the hubs are the same distance apart at all points (see Figure B-3).

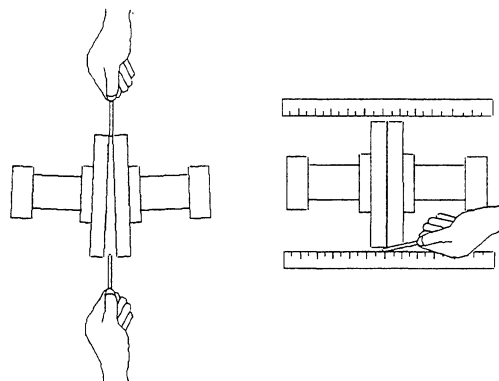


Figure B-3. Aligning Non-Spider Type Coupling

Check parallel adjustment by laying a straightedge across both coupling rims at the top, bottom, and side. When the straightedge rests evenly on both halves of the coupling, the coupling is in horizontal parallel alignment. If the coupling is misaligned, use a feeler gauge between the coupling and the straightedge to measure the amount of misalignment.

V-Belt Drives

When using V-belt drives, the power source and the pump must be parallel. Use a straightedge along the sides of the pulleys to ensure that they are properly aligned (see Figure B-4). In drive systems using two or more belts, make certain that the belts are a matched set; unmatched sets will cause accelerated belt wear.

Tighten the belts in accordance with the belt manufacturer's instructions. If the belts are too loose they will slip; if they are too tight, there will be excessive power loss and possible bearing failure.

Select pulleys to match the proper speed ratio; overspeeding the pump may damage both pump and power source.

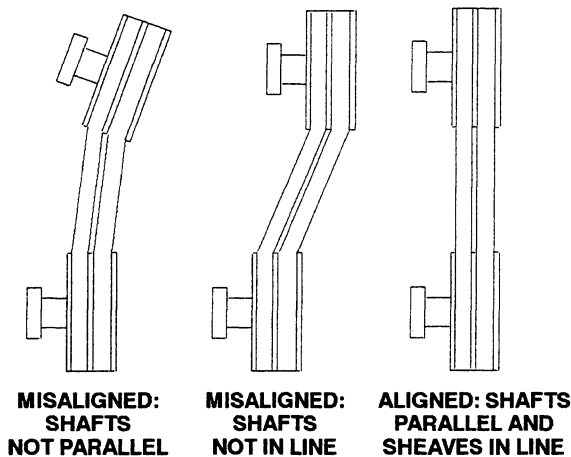
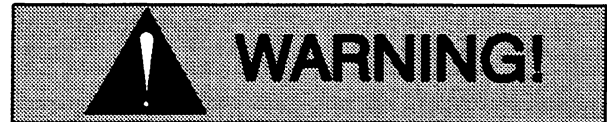


Figure B-4. V-belt Alignment



WARNING!

Do not operate this pump without guards in place over the rotating parts. Exposed rotating parts can catch clothing, fingers or tools, causing severe injury to personnel.

OPERATION – SECTION C

Review all SAFETY information in Section A.

Follow the instructions on all tags, labels and decals attached to the pump.

PUMP OPERATION



Never use a pressure relief valve to regulate liquid flow. Pressure relief valves are designed as safety devices only. Attempting to regulate flow with a pressure relief valve may cause the pump or piping to explode, causing severe personal injury or death.

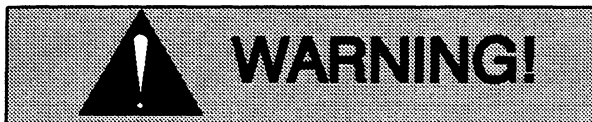
PRE-OPERATION

Make certain that all instructions in INSTALLATION, Section B have been carried out.



The standard version of the pump is designed to handle a wide range of light, medium, and heavy viscosity liquids, depending on design and components. Do not operate the pump with higher liquid temperatures than what it was designed; otherwise, pump components and operation may be affected. For temperature range consult The Gorman-Rupp Company.

Before Starting the Pump



Never operate the pump against a closed suction or discharge valve. The pump will overheat, and may rupture or explode, causing personal injury or death.

Open all valves in the suction and discharge lines, and close all drain valves.

If your pump is equipped with a packing seal, loosen the gland nuts before starting until the packing gland may be moved slightly. If leakage seems excessive after starting, wait until the pump has run long enough to reach its normal operating temperature to adjust the gland nuts. Packing pumps **must leak slightly** to cool and lubricate the shaft and to allow the shaft to turn freely.

Consult the drive manufacturer's operating manual before attempting to start the drive.

In a suction lift application, fill the pump housing with liquid to seal clearances and to lubricate the pump.

Checking Pump Rotation

Correct rotation of your pump is shown on the pump serial plate or direction arrow plate.



In applications with a single direction of flow and a single pump-mounted pressure relief valve, make certain that the drive unit turns the pump in the correct direction of rotation. Otherwise, the pump-mounted pressure relief valve will not function.

Follow the drive unit manufacturer's instructions, jog the pump motor **briefly**, and check rotation.

If a 3-phase motor is being used and rotation is incorrect, have a qualified electrician interchange any two of the 3-phase wires to change the direction of rotation. If a 1-phase motor is being used and rotation is incorrect, consult the motor manufacturer's literature.

STARTING

Start the drive unit as indicated in the manufacturer's instructions and observe the suction and discharge gauges. If the pump does not deliver liquid within one minute, stop the drive unit. **Do not oper-**

ate the pump more than one minute without liquid in it; dry operation will damage or destroy the pump.



Although this pump is self-priming, never operate it dry. Dry operation could cause galling, seizing, damage to the seal or excessive wear of rotating parts.

Review the previous steps outlined in **PRE-OPERATION** and review **TROUBLESHOOTING**, Section D. If everything appears normal, add liquid to the pump housing to assist priming and start the driver again.

If the pump does not deliver liquid within two minutes, stop the pump; it may be necessary to vent the discharge line until liquid begins to flow.

If the pump still does not deliver after consulting **TROUBLESHOOTING** and venting the discharge line, contact your local Gorman-Rupp Rotary Gear Distributor or the factory.

OPERATION

NOTE

*If the pump malfunctions or does not meet operating specifications, refer to **TROUBLESHOOTING** – Section D.*

A change in operating noise when liquid first enters the pump is normal. After the pump is fully operational, monitor it for any unusual noises or vibration; if either occurs, shut the pump down immediately.

Liquid Temperature

- Do not install the pump in a service with higher liquid temperatures than what it was designed. Introducing hot liquid into a cold pump will expand parts unevenly, causing excessive wear, pump failure, and operation may be affected. This thermal shock can be reduced by gradually heating the liquid being introduced into the pump. If it is not possible to heat the liquid, use heat tape and/or insulation to heat the pump.

High temperature bushings as well as optional jackets which may be used to heat or cool the pump are available options for many models.

Overheating

Overheating can occur if the pump is operated with valves in the suction or discharge lines closed. Operating against closed valves could bring the liquid to a boil, build pressure, and cause the pump to rupture or explode. If overheating occurs, stop the pump and allow it to completely cool before servicing.



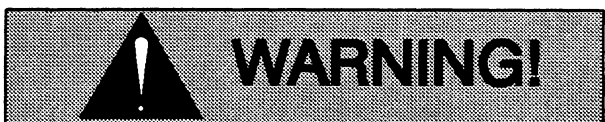
Do not remove plates, covers, gauges, pipe plugs or fittings from an overheated pump. Vapor pressure within the pump can cause parts being disengaged to be ejected with great force. Allow the pump to completely cool before cooling.

Checking Gauges

Monitor vacuum and pressure gauge readings to ensure that the pump is operating within normal range and delivering full flow.

Strainer Check

If a strainer has been installed in the suction line, monitor vacuum gauge readings to detect blockage. Check the strainer if flow rate begins to drop.



Never introduce air or steam pressure into the pump housing to remove a blockage. This could result in personal injury or damage to the equipment. If backflushing is absolutely necessary, limit liquid pressure input to 50% of the maximum permissible operating pressure shown in the pump performance data.

Leakage

No leakage should be visible at pump mating surfaces or at pump connections or fittings. Keep all

line connections and fittings tight to maintain maximum efficiency.

If your pump is equipped with a packing seal, the packing is lubricated by the liquid being pumped. Some leakage around the packing seal is normal. Packing pumps **must leak slightly** to cool and lubricate the shaft and to allow the shaft to turn freely.

Wait until the pump has run long enough to reach its normal operating temperature to adjust the gland nuts. Adjust the nuts only tight enough to reduce excessive leakage.

PRESSURE RELIEF VALVE ADJUSTMENT

Some pumps are not provided with a pressure relief valve. A pressure relief valve must be installed on the pump or in the discharge piping to ensure safe operation. Otherwise, the pump may be damaged and personnel injured.



If operating at high temperatures, allow the pump to completely cool before attempting any adjustments.

Cracking Pressure

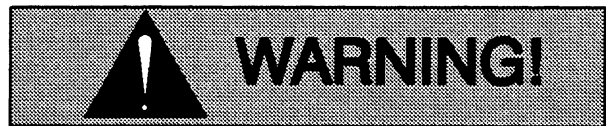
Cracking pressure is the pressure at which the pressure relief valve first begins to open and by-pass fluid. The nominal cracking pressure of the relief valve provided with this pump is set at the factory and is indicated on the tag attached to the relief valve.

If the nominal cracking pressure set at the factory must be changed, see Table E-2 and instructions in **Section E - MAINTENANCE AND REPAIR**.

Complete By-pass Pressure

Complete by-pass pressure is the maximum pressure the pump will see when all the pumped fluid is being by-passed through the pressure relief valve. This pressure will vary depending on the cracking pressure setting, liquid viscosity, and pump speed (pump capacity).

To determine the complete by-pass pressure, refer to the pump performance chart or consult the factory.



Do not remove the adjusting screw jam nut; with the jam nut removed the relief valve spring(s) can be compressed too far for the valve to open. If the valve does not open, excessive pressure can develop, causing damage to the pump and possible injury to personnel.

STOPPING

If the pump will be out of service for an extended length of time, particularly when handling non-lubricating liquids, drain the system and flush the pump and piping with an oil-based preservative to protect close-tolerance pump parts.

When handling liquids that solidify when at rest (tar, glue, etc.), flush the pump and piping with an approved solvent compatible with the pump components and the liquids being pumped.

TROUBLESHOOTING – SECTION D

Review all SAFETY information in Section A.



Before attempting to open or service the pump:

1. Familiarize yourself with this manual.
2. Allow the pump to completely cool if overheated.
3. Check the temperature before opening any covers, plates, or plugs.
4. Close the suction and discharge valves.
5. Drain the pump.

TROUBLESHOOTING WITH GAUGES

Most pump or system malfunctions can be detected by installing vacuum suction and discharge pressure gauges. Read the gauges and refer to the following information for interpretation of the gauge readings. For additional troubleshooting procedures, see the **TROUBLESHOOTING CHART**.

Vacuum Gauges

HIGH READING

Suction valve closed, suction line blocked, foot valve jammed, strainer blocked.
Liquid too viscous.
Lift too high.
Suction line undersized.

LOW READING

Air leak in suction line.
End of suction line not submerged.
Pump parts worn or defective.
Pump needs priming.

ERRATIC READING

Liquid overheated, vaporizing.
Liquid entering intermittently, suction air leak, end of suction line not submerged.
Vibration from cavitation, misalignment, damaged parts.

Pressure Gauges

HIGH READING

Liquid too viscous.
Discharge line undersized or too long.
Discharge valve partially closed.
Strainer blocked.
Relief valve pressure set too high.
Thermal changes in liquid.

LOW READING

Relief valve pressure set too low.
Internal valve not seating properly.
Pump bypass partially open.
End clearance too great.
Pump parts worn or defective.

ERRATIC READING

Cavitation.
Liquid entering intermittently, suction air leak, end of suction line not submerged.
Drive misalignment causing vibration.

TROUBLESHOOTING CHART

TROUBLE	POSSIBLE CAUSE	PROBABLE REMEDY
PUMP FAILS TO PRIME OR LOSES PRIME	<p>Air leak in suction line; end of suction line not submerged; foot valve blocked or jammed; insufficient liquid in sump or tank.</p> <p>Suction strainer clogged.</p> <p>Shaft seal leaking; gaskets, O-rings worn.</p> <p>Leaking relief valve.</p> <p>Suction lift too high.</p> <p>Pump "starving" or liquid vaporizing in suction line.</p> <p>Pump rotation incorrect.</p> <p>Pump speed too slow.</p> <p>Housing dry.</p>	<p>Check and correct as required.</p> <p>Check strainer.</p> <p>Check vacuum gauge; disassemble pump and replace faulty parts.</p> <p>Disassemble and repair.</p> <p>See INSTALLATION, SECTION B and check piping.</p> <p>Increase suction pipe size or reduce length; position pump below liquid level.</p> <p>See OPERATION, SECTION C and check rotation.</p> <p>Check driver speed.</p> <p>Add liquid to housing, see OPERATION, SECTION C.</p>
PUMP DOES NOT DELIVER RATED DISCHARGE OR CAPACITY	<p>Air leak in suction line; end of suction line not submerged; foot valve blocked or jammed; insufficient liquid in sump or tank.</p> <p>Shaft seal leaking; gaskets, O-rings worn.</p> <p>Relief valve pressure set too low.</p> <p>Suction or discharge lines blocked; suction or discharge valves closed.</p> <p>Pump speed too slow.</p> <p>Pump "starving" or liquid vaporizing in suction line.</p> <p>Rotating parts worn or damaged; improper end clearance.</p>	<p>Check and correct as required.</p> <p>Check vacuum gauge; disassemble pump and replace faulty parts.</p> <p>Readjust.</p> <p>Check strainer, valves and piping.</p> <p>Check driver speed; check belts/couplings.</p> <p>Increase suction pipe size or reduce length; position pump below liquid level.</p> <p>Replace defective parts; see SETTING END CLEARANCE in Maintenance And Repair, Section E.</p>
PUMP REQUIRES TOO MUCH POWER	<p>Insufficient end clearances.</p> <p>Pump speed too high.</p> <p>Internal parts worn.</p> <p>Discharge line undersized and/or too long.</p>	<p>Readjust clearance; see SETTING END CLEARANCE in Maintenance and Repair, Section E.</p> <p>Reduce driver output.</p> <p>Disassemble pump and inspect.</p> <p>Increase size, decrease length.</p>

TROUBLESHOOTING CHART (Cont.)

TROUBLE	POSSIBLE CAUSE	PROBABLE REMEDY
PUMP RE-QUIRES TOO MUCH POWER (Cont.)	<p>Pump and/or drive mounting not secure; drive misaligned.</p> <p>Power source undersized.</p> <p>Liquid in pump solidified.</p> <p>Insufficient internal clearances.</p>	<p>Tighten mounting hardware; realign drive.</p> <p>Check power requirements for application; resize as required.</p> <p>Clear or heat.</p> <p>Consult factory.</p>
EXCESSIVE NOISE OR VIBRATION	<p>Pump and/or piping not secure; drive misaligned.</p> <p>Pumping entrained air.</p> <p>Pump "starving" or liquid vaporizing in suction line.</p> <p>Relief valve chatter.</p> <p>Rotating parts worn or damaged; improper end clearance.</p> <p>Pump operating outside designed operating range.</p> <p>Lubrication required.</p>	<p>Anchor base or piping, realign drive.</p> <p>Check liquid level.</p> <p>Increase suction pipe size or reduce length; position pump below liquid level.</p> <p>Increase pressure setting.</p> <p>Replace defective parts; check end clearance.</p> <p>Check discharge head and flow; adjust as required to meet performance specifications.</p> <p>Add lubricant, as needed.</p>
EXCESSIVE WEAR	<p>Corrosive liquid.</p> <p>Abrasive liquid.</p> <p>Exceeding operating limits.</p> <p>Insufficient end clearance.</p> <p>Pump running dry.</p> <p>Pump and/or drive mounting not secure; drive misaligned; piping incorrectly installed.</p> <p>Insufficient lubrication.</p>	<p>Check local distributor or factory for parts compatibility with liquid; check liquid for contamination.</p> <p>Consult factory.</p> <p>Check performance data in Pump Specifications Bulletin.</p> <p>See SETTING END CLEARANCE in Maintenance And Repair, Section E.</p> <p>Add liquid to prime (See Operation, Section C); check liquid flow.</p> <p>Tighten mounting hardware; realign drive; check piping.</p> <p>Add lubrication and maintain at proper level.</p>

MAINTENANCE AND REPAIR – SECTION E

MAINTENANCE AND REPAIR OF THE WEARING PARTS OF THE PUMP WILL MAINTAIN PEAK OPERATING PERFORMANCE.

Pump Model

Your pump model number and serial number are shown on the **Parts List**, furnished as a separate document with this manual.

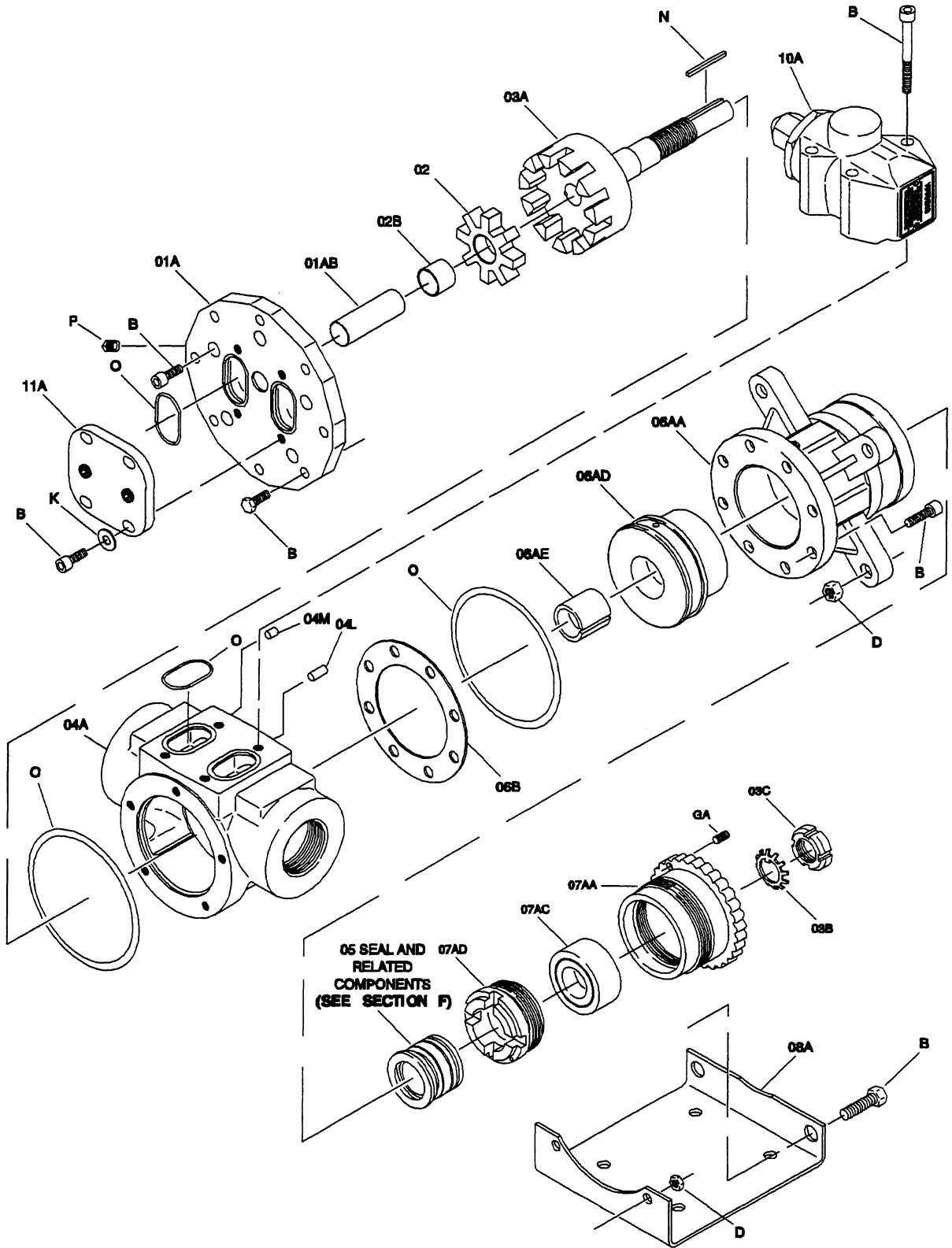
Below the pump model number on the **Parts List**, is a grouping of several alpha-numeric codes. This code identifies the optional features of the pump. **Be sure** to include this grouping, along with the model number and serial number, when ordering parts.

The sectional views cover disassembly and reassembly for the pump models shown below. Refer to the **Parts List** for your specific pump model.

The Following Pumps Are Covered By This Manual.



**GHC SERIES
STAINLESS STEEL PUMPS**



Shown: Standard Model With 180° Ports, Housing-Mounted Relief Valve and Optional Foot Bracket. Also Available With 90° Ports And/Or Head-Mounted Relief Valve And Motor Adaptor. Coverplate Kit Replaces Either Relief Valve When Not Used.

NOTE: Refer to **Seal Appendix, Section F** for details of the seal assembly and related components.

Figure E-1. Typical GHC SST Pump Models

PARTS KEY FOR FIGURE E-1

Note: Item numbers cross reference to specific part numbers on the separate **Parts List**.

ITEM NO.	PART NAME	ITEM NO.	PART NAME
01	HEAD KIT	07	ROTOR ADJUSTING SLEEVE KIT
01A	-HEAD ASSEMBLY	07A	-ROTOR ADJUSTING SLEEVE ASSY
01AA	-HEAD	07AA	-ROTOR ADJUSTING SLEEVE
01AB	-IDLER PIN	07AC	-BALL BEARING
P	-PIPE PLUG	07AD	-BEARING RETAINING NUT
O	-O-RING	07AF	-SPRING PIN
B	-CAPSCREW	GA	-SOCKET HD SETSCREW
02	IDLER ASSEMBLY	07L	-SEAT SLEEVE
02A	-IDLER	O	-O-RING
02B	-BUSHING	08	FOOT BRACKET KIT
03	ROTOR/SHAFT KIT	08A	-FOOT BRACKET
03A	-ROTOR/SHAFT ASSEMBLY	B	-CAPSCREW
03B	-BEARING LOCKWASHER	D	-NUT
03C	-BEARING LOCKNUT	10	RELIEF VALVE KIT
N	-SHAFT KEY	10A	-RELIEF VALVE ASSEMBLY
04	HOUSING ASSEMBLY	10AA	-VALVE BODY
04A	-HOUSING	10AB	-WARNING PLATE
04D	-PIPE PLUG	BM	-DRIVE SCREW
04L	-SUCTION HOUSING PIN	B	-CAPSCREW
04M	-DISCHARGE HOUSING PIN	O	-O-RING
05	SEAL & RELATED COMPONENTS (SEE SECTION F)		NOT SHOWN:
06	BACKHEAD KIT	11	HEAD COVERPLATE KIT
06A	-BACKHEAD ASSEMBLY	11A	-COVERPLATE ASSEMBLY
06AA	-BACKHEAD	11AA	-COVERPLATE
06AD	-THROTTLE BUSHING SLEEVE	11AB	-WARNING PLATE
06AE	-THROTTLE BUSHING	BM	-DRIVE SCREW
P	-PIPE PLUG	K	-WASHER
06B	-GASKET	B	-CAPSCREW
B	-SOCKET HD CAPSCREW	O	-O-RING
		12	NAMEPLATE KIT
		12A	-NAMEPLATE
		BM	-DRIVE SCREW

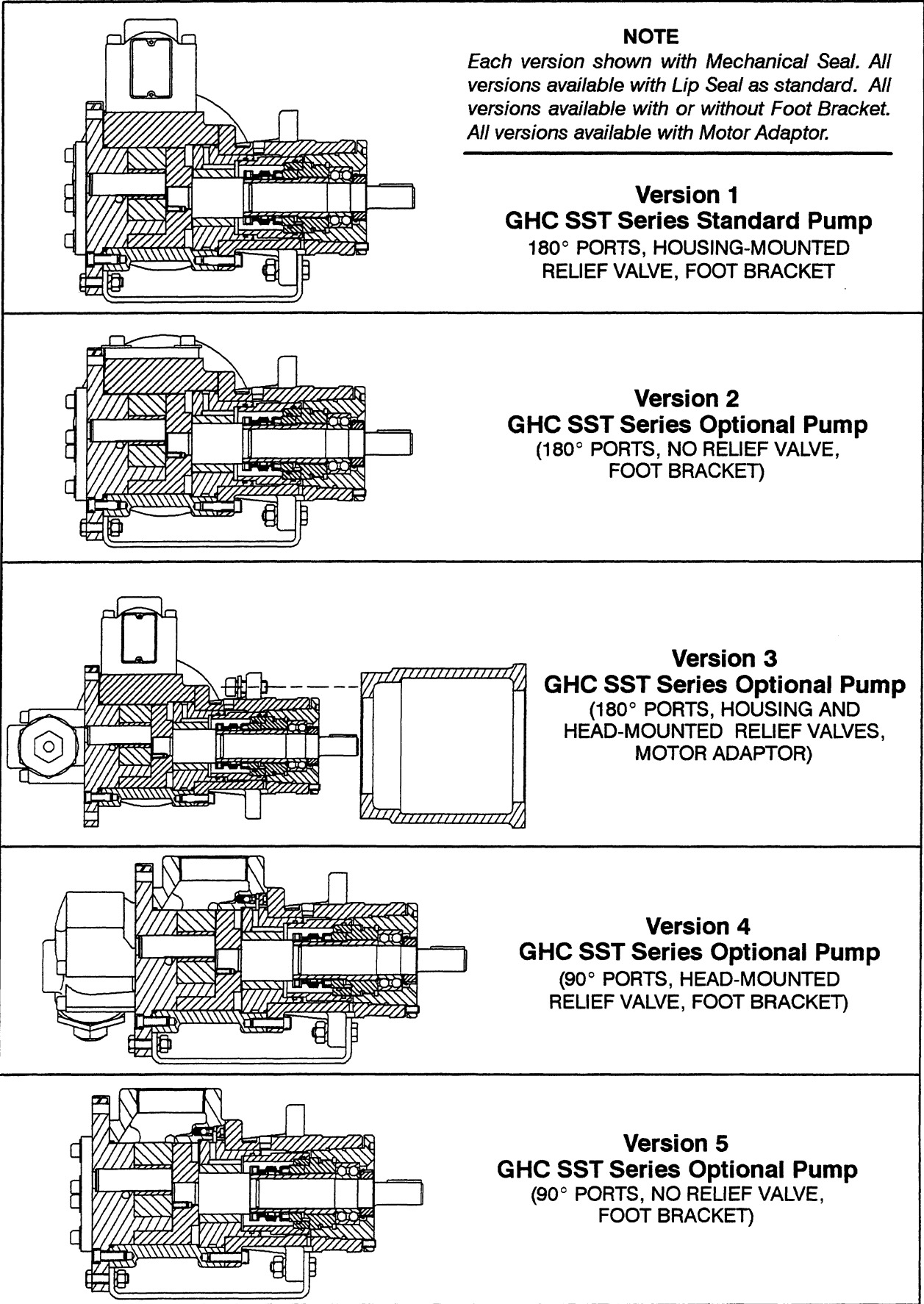


Figure E-2. Assembled GHC SST Pump Models

PUMP DISASSEMBLY AND REASSEMBLY

Review all SAFETY information in Section A.

Follow the instructions on all tags, labels and decals attached to the pump.

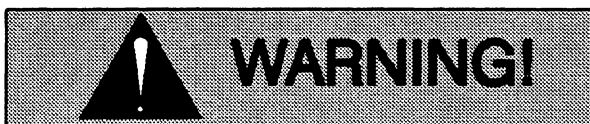
This pump requires little service due to its rugged, minimum-maintenance design. However, if it becomes necessary to inspect or replace the wearing parts, follow these instructions which, unless otherwise specified, are keyed to the sectional view (see Figure E-1) and the accompanying parts key. Refer to the separate parts list accompanying your pump for part numbers.

In the following text, minor headings are followed by a number in parenthesis. This number represents the assembly for the item being discussed as identified in Figure E-1.

Before attempting to service the pump, disconnect the power source to ensure that it will remain inoperative. Remove the hardware securing the pump to the power source, and separate the power source and pump assembly. Retain all connection parts such as shaft keys, etc.

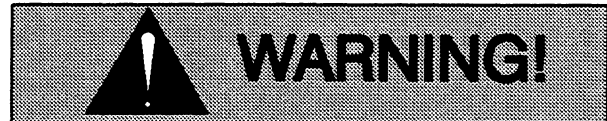
Close all valves in the suction and discharge lines. Disconnect the suction and discharge hose/piping.

For power source disassembly and repair, consult the literature supplied with the power source, or contact your local power source representative.



This manual will alert personnel to known procedures which require special attention, to those which could damage equipment, and to those which could be dangerous to personnel. However, this manual cannot possibly provide detailed instructions and precautions for each specific application or for every situation that might occur during maintenance of the unit. Therefore, it is the responsibility of the owner, installer

and/or maintenance personnel to ensure that applications and/or maintenance procedures not addressed in this manual are performed only after establishing that neither personal safety nor pump integrity are compromised by such applications or procedures.



Do not attempt to service the pump unless all power to the power source has been disconnected; otherwise, serious personal injury or death could result.

PUMP DISASSEMBLY



Use caution when handling the idler (02A) and the rotor shaft assembly (03A). These parts have sharp edges which will grow sharper with use.

In the instructions which follow the **FRONT** is the head coverplate end of the pump and the **REAR** is the drive (or backhead) end of the pump.

NOTE

It is strongly recommended that gaskets and O-rings be replaced whenever the pump is reassembled.

Pressure Relief Valve (10)

If the pump is equipped with a pressure relief valve (10A), it can be mounted on either the head assembly (01A) or the housing assembly (04). Some models are equipped with one of each. Take note as to the direction in which the relief valve is mounted. To remove either style, remove the cap screws (B) securing the relief valve to the pump. The O-rings (O) may remain in the head (01A) or in the housing (04A). Remove and discard the O-rings. For relief valve maintenance, see **RELIEF VALVE DISASSEMBLY** followed by **RELIEF VALVE DISASSEMBLY** at the end of this section.

Rotor Adjusting Sleeve (07)

Before attempting to remove the bearing locknut (03C), loosen the socket head setscrews (GA) securing the rotor adjusting sleeve (07) and turn the rotor adjusting sleeve clockwise (as viewed from the drive end) until the rotor binds against the head. This will prevent the rotor from turning as the locknut is unscrewed.

Straighten the tab on the bearing lockwasher (03B) and use a hammer and drift pin to loosen the bearing locknut until it can be unscrewed from the shaft. Remove the bearing lockwasher.

Unscrew the rotor adjusting sleeve kit from the backhead.

NOTE

*Part or all of the seal assembly (5) will be removed with the rotor adjusting sleeve. Check the **Parts List** furnished with your pump to identify the seal, refer to **Seal Appendix, Section F** for removal of the seal and related components, then proceed as follows with rotor adjusting sleeve disassembly.*



When removing or installing the bearing (07AC), never hit or press against the inner race. Press **only** against the outer race.

Secure the rotor adjusting sleeve (07AA) in a vice with the drive side down. Position a suitably sized screwdriver horizontally through the slots in the bearing retaining nut and use the screwdriver to unscrew the bearing retaining nut from the rotor adjusting sleeve. The bearing (07AC) is a light press fit into the rotor adjusting sleeve and can usually be removed with thumb pressure only. If the bearing does not come out easily, use a suitable sized sleeve and a mallet to lightly tap the bearing from the bore.

Refer to **Cleaning and Inspection** in this section before reassembling the rotor adjusting sleeve.

Coverplate Kit (11)

(Figures E-1 and E-3)

The coverplate kit may be mounted on either the head assembly or the housing assembly. Removal is the same for either.

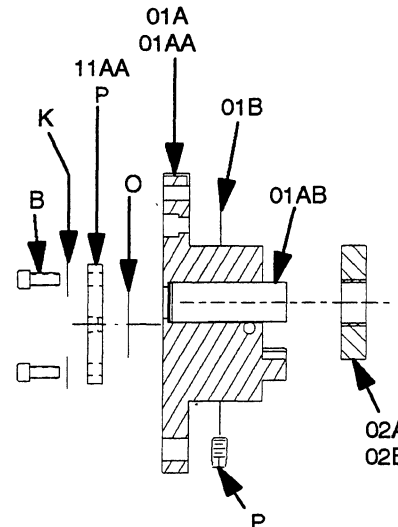


Figure E-3. Head Coverplate Kit, Head Kit And Idler Disassembly

Remove the hardware (BD and K) securing the coverplate (11AA) to the head (01AA) or housing (04A). The O-rings (O) may remain in the head or housing. Remove and discard the O-rings.

Head Kit (01)

(Figure E-3)

Remove the hardware (B) securing the head (01A) to the housing (04A).



Use caution to prevent the idler assembly from dropping off the idler pin; the idler may be damaged if it falls on a hard surface.

Pull the head assembly (01A) from the housing assembly (04A, Figure E-1). Take care not to let the idler assembly (02) slide off the idler pin (01AB). Remove and discard the O-ring (O). Remove the check pipe plug (P) from the suction side of the head (01AA).

Idler Assembly (02)

(Figures E-1 and E-3)



Use caution when handling the idler (02A) and the rotor shaft assembly (03A). These parts have sharp edges which will grow sharper with use.

NOTE

The idler bushing (02B) may be damaged during removal. Do not remove the idler bushing unless replacement is required.

Remove the assembled idler (02) from the head assembly. Inspect the idler bushing (02B) for excessive wear or scoring. If replacement is required, use an arbor (or hydraulic) press to remove the idler bushing (02B) from the idler (02A).

To remove the idler pin (01AB), lay the head assembly (01A) on an arbor (or hydraulic) press with the idler pin (01AB) facing down and remove the idler pin (01AB) from the head (01AA).

Seal Removal (09)

The seal assembly (05) is available in a variety of configurations. Check the **Parts List** furnished with your pump to identify the seal, then refer to **Seal Appendix, Section F**, for removal of the seal and related components.

Rotor/Shaft Removal (03)

With the seal removed, simply slide the rotor/shaft assembly (03A) out of the housing (04A). Due to close machine tolerances and assembly practices, the rotor/shaft is available only as an assembly. Therefore further disassembly is not required.

Foot Bracket Kit (08)

Remove the hardware (B and D) securing the foot bracket (08A) to the head (01AA) and the backhead (06AA).

Backhead Kit Removal (06)

(Figures E-1 and E-4)

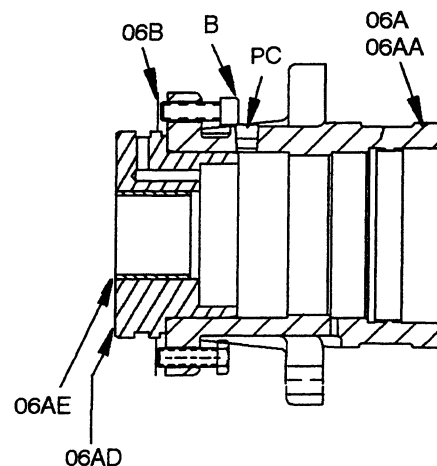
Remove the screws (B) securing the backhead assembly (06A) to the housing assembly (04), and separate the assemblies. Remove and discard the gasket (06B) or O-ring (O).

NOTE

The throttle bushing (06A) may be damaged during removal. Do not remove the throttle bushing unless replacement is required. Due to tight tolerances, the throttle bushing sleeve (06AD) must be removed from the backhead in order to replace the throttle bushing (06AE).

Use an arbor (or hydraulic) press and a suitably sized dowel to press the throttle bushing sleeve from the backhead.

Use an arbor (or hydraulic) press and a suitably sized dowel to press the throttle bushing out of the throttle bushing sleeve.

**Figure E-4. Backhead****Housing Assembly (04)****NOTE**

Seal cavity pressure relief is accomplished using two pins (04L and 04M) pressed into the back side of the housing. Removal of the pins is not required unless the direction of pump rotation is to be changed.

If pump rotation is to be changed, place the housing on the bed of an arbor (or hydraulic) press with

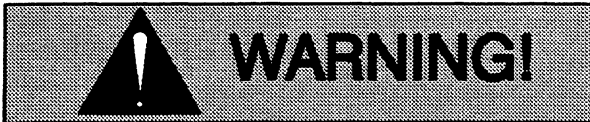
the head end down. Use a suitably sized dowel to press each pin through its mounting hole and into the housing. Remove the pins from the housing.

PUMP REASSEMBLY



Use caution when handling the idler (02A) and the rotor shaft assembly (03A). These parts have sharp edges which will grow sharper with use.

Cleaning and Inspection

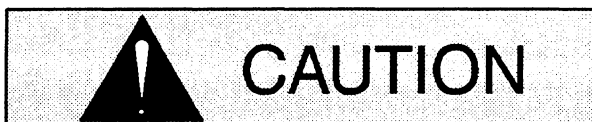


Most cleaning solvents are toxic and flammable. Use them only in a well ventilated area free from flame, sparks, and excessive heat. Read and follow all precautions printed on solvent containers.

Clean and inspect the pump parts (except the bearing and seal assembly) with a cloth soaked in fresh cleaning solvent. Inspect all parts for excessive wear or for any nicks or burrs. Remove nicks or burrs using emery cloth or a fine file. Replace any parts that are badly worn or damaged.

Clean the bearing in fresh cleaning solvent and coat with light oil.

Rotate the bearing by hand to check for roughness or binding. If rotation is rough or there is any side-to-side movement between the inner and outer races, replace the bearing.



The bearing is permanently sealed and requires no additional lubrication except a coating of light oil on external surfaces to ease reassembly. External surfaces must

be kept free of all dirt and foreign material. Failure to do so could damage the bearing or its mating surfaces.

The bearing tolerance provides a light press fit into the rotor adjusting sleeve (07AA). Replace the rotor adjusting sleeve if the proper fit is not achieved.

Clean and inspect the seal assembly as indicated in the appropriate section of the **Seal Appendix, Section F**.

Bushing Preparation

When replacing bushings, lightly oil the O.D. of the replacement bushing before installation.



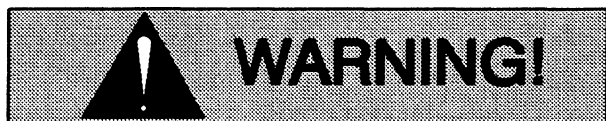
Be very careful when installing graphite bushings. Graphite is extremely brittle and will crack if improperly installed. Use a press to install the bushing with one continuous motion until the bushing is fully seated. Stopping in mid-stroke will cause the bushing to crack. After installation, check the bushing for cracks.

NOTE

*When installing **high temperature graphite bushings**, heat the part that receives the bushing to 500°F and place the bushing in a freezer for at least one hour. This will allow easier installation with less chance of breakage.*

Housing Assembly (04)

Inspect and clean the housing (04A) with a cloth soaked in fresh cleaning solvent. Replace it if badly worn or damaged.



Most cleaning solvents are toxic and flammable. Use them only in a well ventilated area free from flame, sparks, and excessive heat. Read and follow all precautions printed on solvent containers.



If the housing pins (04L and 04M) were removed in order to change the direction of pump rotation, the short pin (04M) **must** be installed in the hole adjacent to the suction port of the housing. Otherwise, over-pressurization of the seal cavity could result in premature seal failure.

If the housing pins were removed, clean the holes in the housing for the pins. Apply "Loctite Retaining Compound No. 640" or equivalent compound on each pin prior to installation. Press the short suction pin (04M) into the hole adjacent to the suction port until it is **just flush**. Do not press the suction pin completely into the hole. Press the long discharge pin (04L) into the hole adjacent to the discharge port until just flush or slightly recessed.

Backhead Kit (06)

(Figures E-1 and E-5)

Use an arbor (or hydraulic) press and a suitably sized sleeve to press the throttle bushing (06AE) into the throttle bushing sleeve (06AD) until it is flush with the face of the sleeve.

Position the backhead (06AA) on the bed of an arbor (or hydraulic) press with the rotor end facing up. Use an arbor (or hydraulic) press and a suitably sized dowel to install the assembled throttle bushing sleeve and throttle bushing in the backhead until fully seated.

Install a new gasket (06B) over the throttle bushing sleeve (06AD).

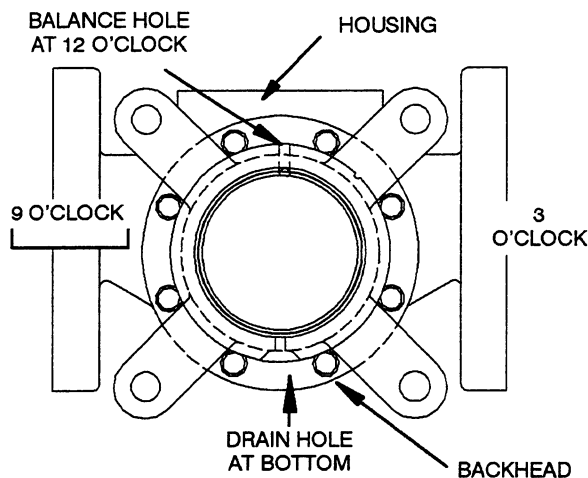


Figure E-5. Housing/Backhead Alignment

Position the balance hole as shown in Figure E-5, and secure the backhead assembly (06) to the housing (04) with the capscrews (B).

Secure the foot bracket (08A) to the backhead assembly (06) with the previously removed hardware (B and D).

Rotor/Shaft Assembly (03)

Inspect the rotor/shaft assembly (03A) for excessive wear, scoring or scratches along the shaft sealing surface. If replacement is required, the shaft and rotor must be replaced as an assembly. Small scratches can be dressed with a fine file or emery cloth. Replace the rotor/shaft assembly or any other parts if wear or damage is extensive.

Slide the rotor/shaft assembly into the housing and backhead. **Use caution** not to scratch or chip the I.D. of the bushing (04B).

Seal Installation (05)

The seal assembly (05) is available in a variety of configurations. Check the **Parts List** furnished with your pump to identify the seal, then refer to **Seal Appendix, Section F**, for installation of the seal and related components.

Idler Assembly (02)

If the idler pin (01AB) was removed, lubricate the O.D. of the replacement idler pin and the I.D. of the idler pin bore in the head (01AA). Position the pin in

the head with the chamfer side toward the head and the milled flat side facing the crescent. (If the pin is stepped, position it with the large chamfered end toward the head.) Use an arbor (or hydraulic) press to press the pin into the head until it bottoms out.

NOTE

When properly installed, the pin will be positioned 0.010 inch below the surface of the crescent.



The pipe plug (P) **must** be installed in the hole in the suction side of the head. Otherwise, under-lubrication of the idler pin could result in damage to the pump.

Install the pipe plug (P) in the hole in the suction side of the head (01AA).

Lightly oil the I.D. of the idler (02A), and use an arbor (or hydraulic) press to install the idler bushing (02B) in the idler. The bushing should be centered at both ends of the idler.

Head Kit (01)

(Figures E-1 and E-3)

Place the head (01A) on a flat surface. Lightly oil the idler bushing (02B) and pin (01AB); install the idler assembly (02) on the pin. Spin the idler to make certain that it moves freely on the pin.

Install the head gasket (01B) over the head. Carefully position the head and idler against the housing and engage the idler and rotor/shaft assembly (03A). Turn the rotor/shaft until the idler and rotor teeth engage. **Do not force.**

Slide the head into the housing assembly. Rotate the head (01AA) until the groove in the head matches the groove in the housing. Secure the head to the housing with the capscrews (B).

Coverplate Kit (10)

(Figures E-1 and E-3)

The coverplate kit may be mounted on either the head assembly or the housing assembly. Installation is the same for either.

Lightly lubricate the O-rings (O) with oil and install them in the housing (04A) or head (01AA). Secure the coverplate (14AA) with the hardware (B). Be sure that the warning plate (14AC) is attached to the coverplate (14AA).

Foot Bracket Kit (08)

Secure the foot bracket (08A) to the head (01A) and backhead assembly (06A) with the hardware (B and D).

Rotor Adjusting Sleeve (07)

Clean the rotor adjusting sleeve and all component parts as described in **Cleaning and Inspection**. Inspect the parts for wear or damage and replace as necessary.

Use an arbor (or hydraulic) press and install the bearing in the rotor adjusting sleeve (07A) until it bottoms out on the shoulder of the rotor adjusting sleeve.

Apply 1 to 2 drops of "Loctite Thread Locker No. 272" or equivalent compound to the threads of the bearing retaining nut (07AD) and screw the nut into the rotor adjusting sleeve (07AA) until fully seated against the bearing.

NOTE

*Part or all of the seal assembly (05) must be installed with the rotor adjusting sleeve. Check the **Parts List** furnished with your pump to identify the seal, refer to **Seal Appendix, Section F** for installation of the seal and related components, then proceed as follows with rotor adjusting sleeve installation. **Use caution** not to damage seal parts when installing the rotor adjusting sleeve.*

Loosen the socket head setscrews (GA). Slide the rotor adjusting sleeve kit over the shaft. Use caution not to damage installed seal components on the shaft. Screw the rotor adjusting sleeve into the backhead until the rotor bottoms against the head.

Install the bearing lockwasher (03B) and screw the bearing locknut (03C) onto the shaft until tight. Align one of the slots in the locknut with one of the tabs on the lockwasher, and use a hammer and punch to bend the tab on the lockwasher over into the slot on the locknut.

Proceed with **Setting End Clearance**.

SETTING END CLEARANCE

(Figures E-1 and E-6)

The end clearance between the head (01AA) and the face of the rotor (03A) should be checked and adjusted as required as part of a regular preventive maintenance schedule, when performance drops or the pump is disassembled. If disassembled, reassemble the rotor adjusting sleeve kit as previously indicated, then proceed as follows for adjustment.

Tighten the rotor adjusting sleeve assembly (07A) in the backhead assembly (06A) until the rotor bottoms against the head, and install the bearing lock-washer (03B) and locknut (03C) as previously described. See Figure E-6 and mark the rotor adjusting sleeve (07AA) at the beveled mark on the backhead (06AA).

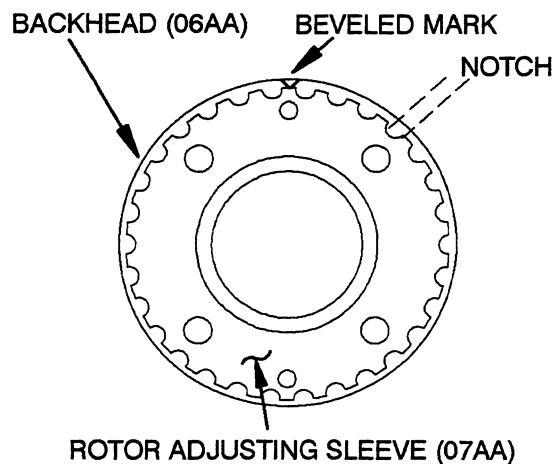


Figure E-6. End Clearance Adjustment

The end clearance between the head (01) and rotor shaft (03A) should be set to the dimensions shown in Table E-1. Each of the notches on the rotor adjusting sleeve (07AA) represents approximately 0.002 inch of end clearance. Back off the rotor adjusting sleeve assembly (07A) approximately 1/2 turn, then turn the sleeve back in until the mark is the appropriate number of notches counter-clockwise of the beveled mark on the backhead to obtain the recommended end clearance.

Tighten the setscrews (GA) until they bottom against the backhead (06AA). Rotate the pump

shaft to ensure free rotation. If the rotor binds or scrapes against the head, back off the rotor adjusting sleeve until rotation is free.

	Rotor Trim Code	Pump Hydraulic Code				
		D	G	J	N	R
V i s c o s i t y T r i m s	Std	.005	.005	.006	.006	.008
	35B	.005	.005	.006	.006	.008
	35C	.005	.006	.008	.008	.010
	35D	.009	.009	.012	.012	.015
T e r m i p m s	35E	.005	.010	.014	.014	.016

Notes:
Consult Pump Parts List For Rotor Trim Code.
For Rotor Trim Codes Not Listed or for Special Applications,
Consult Your Local Gorman-Rupp Distributor or the Factory.

Table E-1. End Clearance

RELIEF VALVE DISASSEMBLY

(Figure E-7)

NOTE

If the relief valve is low pressure, it will have one internal spring (10AE). If the relief valve is high pressure, it will have two internal springs (10AE and 10AF).

Unscrew the cap (10AN) from the bonnet (10AK) and remove the gasket (10AP). Back off the adjustment capscrew (10AM) to relieve pressure on the spring(s) (10AE and/or 10AF).

Unscrew the bonnet from the valve body (10AA). Remove the valve (10AD) and spring(s) (10AE and/or 10AF). The spring guide (10AH) is an O-ring fit in the bonnet. Remove and discard the O-rings.

If the warning plate (10AB) must be replaced, remove the drive screws (BM), and remove the plate.

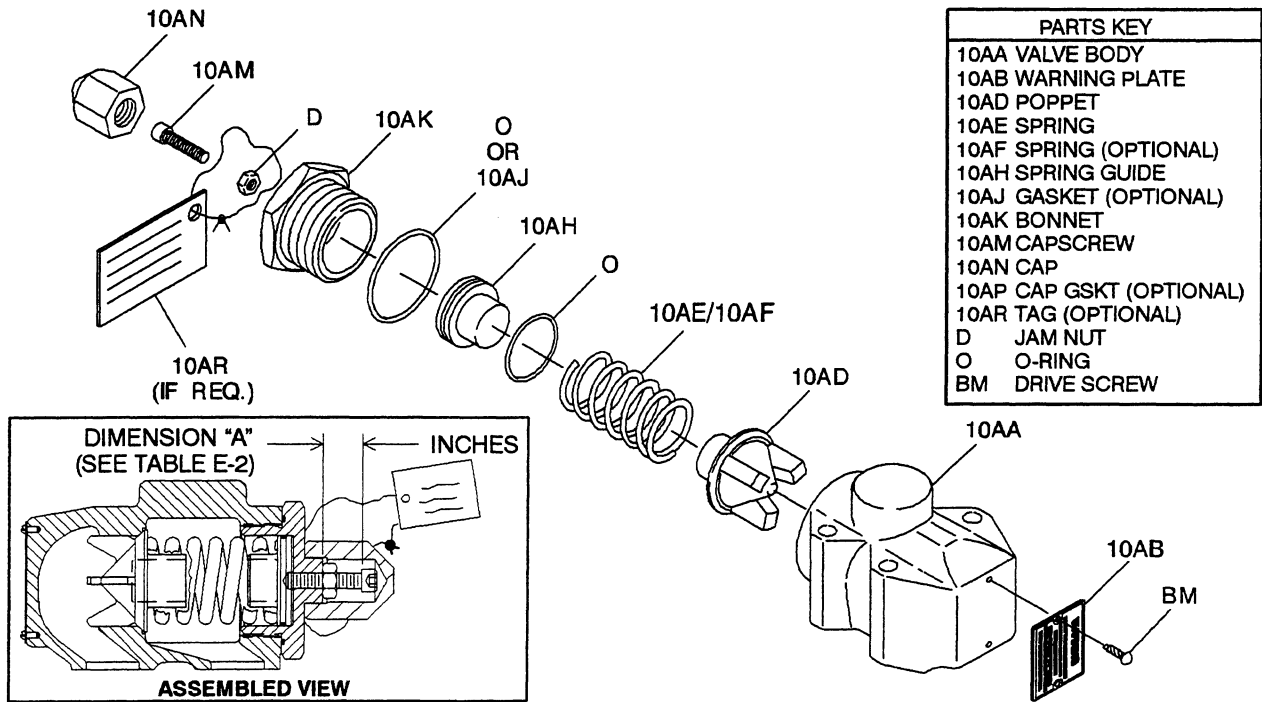


Figure E-7. Pressure Relief Valve Assembly

RELIEF VALVE REASSEMBLY

(Figure E-7)



Do not return the pump to service without the warning plate (10AB) installed. Failure to observe the warning on the plate could result in destruction of the pump, and injury or death to personnel.

Inspect the components for wear, grooves, or other damage that might cause leakage. If any components are worn, replace the defective parts.

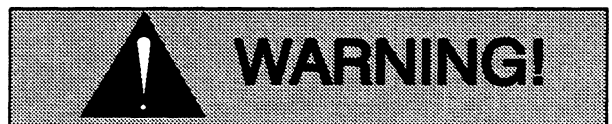
If removed, attach the warning plate (10AB) to the valve body (10AA) using the drive screws (BM).

If used, lightly oil the O-ring (O) and install it in the groove on the bonnet (10AK).

Lightly oil the O-ring (O), or use the optional gasket (10AG), and install it in the groove on the spring guide (10AH). Start the large end of the spring guide into the bonnet (10AK), and push the guide in until it bottoms out.

Insert the valve (10AD), finned end first, into the valve body (10AA). Install the spring(s) (10AE and/or 10AF). Make certain that the spring (10AE) fits over the spring guide (10AH), and the optional spring (10AF) fits into the guide, and thread the bonnet into the valve body.

Install the jam nut (10AL) on the adjustment cap-screw (10AM), and thread the capscrew into the bonnet until the desired height ("A", Figure E-7) is reached. Refer to the separate Parts List accompanying your pump, and determine the specific hydraulic size (DG, JN, etc.). See Table E-2 and adjust the capscrew (10AM) to the proper "A" dimension for desired cracking pressure.



Never operate the pump without the adjusting screw jam nut in place. Otherwise, the relief valve spring(s) can be compressed too far for the valve to open. If the valve does not open, excessive pressure can develop, causing damage to the pump and possible injury to personnel.

PUMP HYDRAULIC SIZE	SINGLE SPRING OPTION CODE	CRACKING PRESSURE (PSI)	DIMENSION "A" (INCHES) Fig. E-7)	DOUBLE SPRING OPTION CODE	CRACKING PRESSURE (PSI)	DIMENSION "A" (INCHES) Fig. E-7)
D & G	STD	45 MIN.	.60 FULLY OUT	25A	100 MIN.	.60 FULLY OUT
		* 50	.57		125	.51
	25D	75	.40	25E	* 150	.42
		100	.22		175	.34
	25U	130 MAX.	.16 FULLY IN	25V	200	.26
					230 MAX.	.16 FULLY IN
J & N	STD			25A	35 MIN.	1.17 FULLY OUT
		30 MIN.	1.17 FULLY OUT		75	.87
	25D	50	.74	25E	100	.68
		* 70 MAX.	.31 FULLY IN		125	.51
	25U			25V	* 150 MAX.	.31 FULLY IN
R	STD	50 MIN.	1.23 FULLY OUT	25A	90 MIN.	1.23 FULLY OUT
		* 75	.71		100	1.13
	25D	90 MAX.	.37 FULLY IN	25E	* 150	.62
					175 MAX.	.37 FULLY IN

Table E-2 . Cracking (Valve Opening) Settings (* Indicates Factory Setting)

NOTE

Instructions for in-line adjustment of the relief valve settings are given in **OPERATION - Section C.**

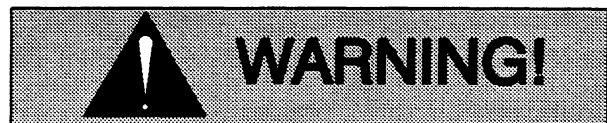
Secure the relief valve (10A) with the capscrews (B).

After adjustment, tighten the jam nut (10AL) flush against the bonnet.

Place the optional warning tag (10AR) between the bonnet and the cap (10AN). Install the cap, and tighten until fully seated against the bonnet.

Relief Valve (10) Installation

Lubricate and install the O-ring(s) (O) on the housing assembly (04A) or the head assembly (01A).



Do not return the pump to service without the warning plate (10AB) installed. Failure to observe the warning on the plate could result in destruction of the pump, and injury or death to personnel.

If the warning plate (10AB) has been removed, secure it with the drive screws (BM).

SEAL APPENDIX – SECTION F

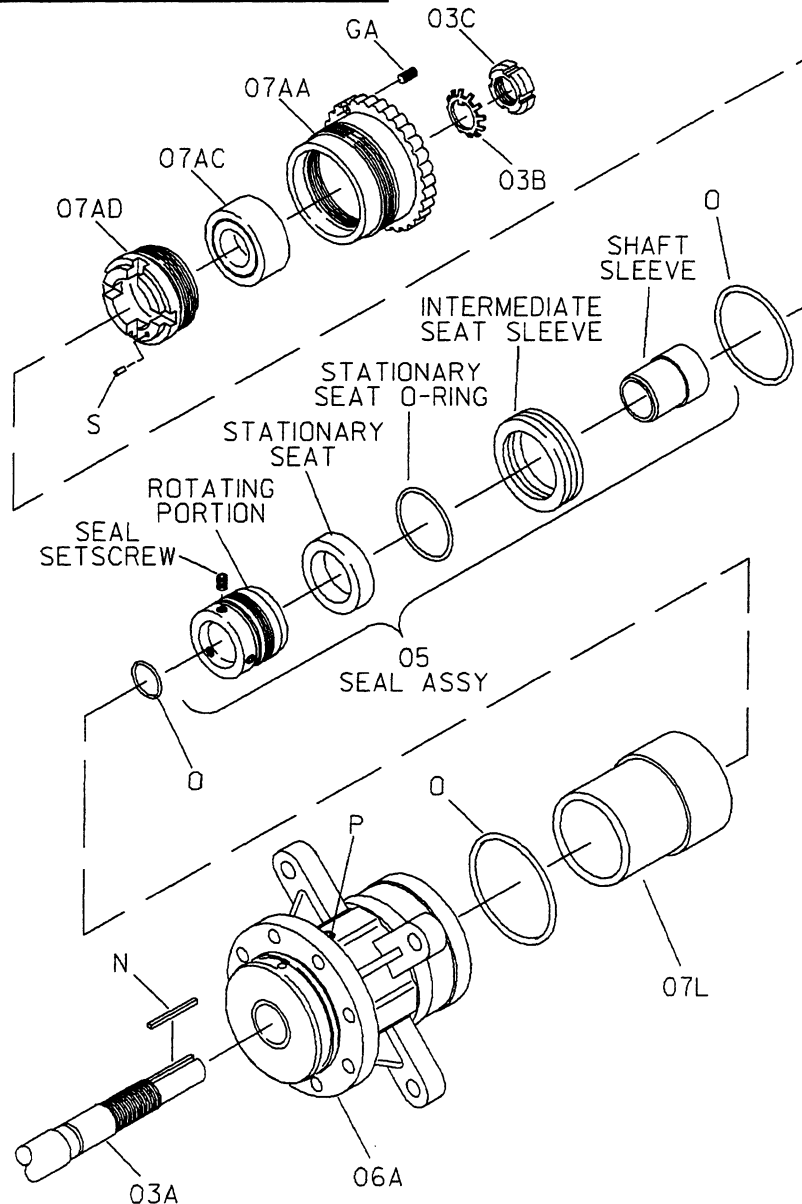
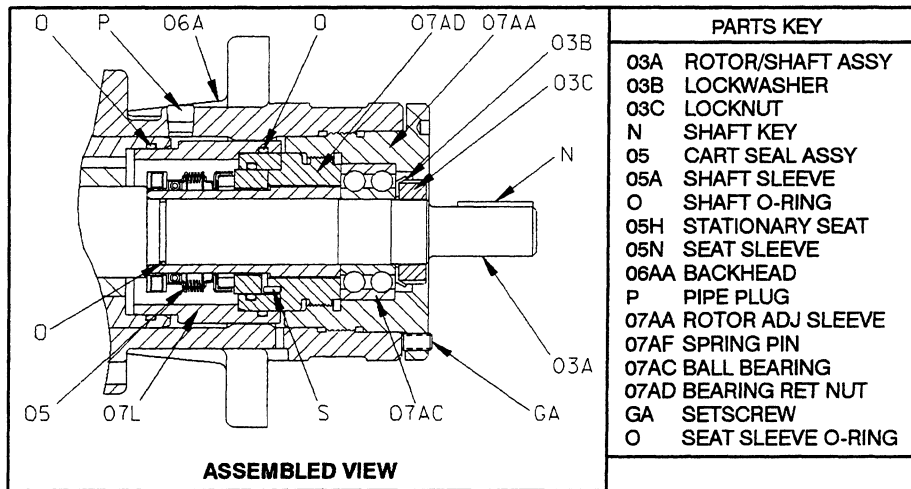


Figure F-1. Standard Cartridge And Optional 60M, 60N And 61L Cartridge Seal

Seal Removal

(Figures E-1 and F-1)

See **PUMP DISASSEMBLY** and disassemble the pump up to and including the **Rotor Adjusting Sleeve (07)**. As the rotor adjusting sleeve (07AA) is unscrewed from the backhead (06AA), the complete seal assembly (09) will be pulled out with it.

Position the rotor adjusting sleeve assembly on a flat surface with the seal facing up. Use a pair of screwdrivers to pry the assembled intermediate seat sleeve, seal and shaft sleeve from the rotor adjusting sleeve assembly.

Remove the shaft O-ring.

NOTE

Due to the complexity of design of the cartridge seal assemblies, seal disassembly for the purpose of reuse is not recommended. Replacement seals include the shaft sleeve, seat sleeve and all O-rings. Replace the complete cartridge seal when leakage occurs.

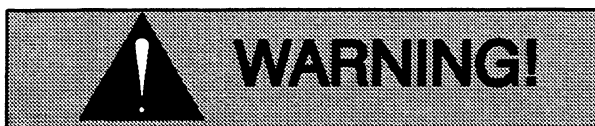
Continue as required with **PUMP DISASSEMBLY**.

Seal Installation

(Figures E-1 and F-1)

See **Pump Reassembly, Section E**, and assemble the housing assembly (04), backhead kit (06) and rotor/shaft assembly (03).

Clean the seal cavity with a cloth soaked in fresh cleaning solvent.



Most cleaning solvents are toxic and

flammable. Use them only in a well ventilated area free from flame, sparks, and excessive heat. Read and follow all precautions printed on solvent containers.

NOTE

Due to the complexity of design of the cartridge seal assemblies, seal disassembly for the purpose of reuse is not recommended. Replace the complete cartridge seal when leakage occurs.

Unwrap the cartridge seal and check that all components are preassembled, clean, undamaged and free of any foreign matter.

Position the pump on a flat surface with the drive end facing up. Lubricate the shaft O-ring and install it in the groove in the shaft.

Assemble the rotor adjusting sleeve (07) as described in **Pump Reassembly, Section E** and position it on a flat surface with the drive end down. If removed, install the spring pin (07AF) in the bearing retaining nut (07AD).

Position the cartridge seal assembly in the rotor adjusting sleeve assembly so **the notch in the back of the stationary element aligns with the spring pin**. Use a suitably sized sleeve and an arbor (or hydraulic) press to press the seat sleeve over the end of the bearing retaining nut (07AD) **until the notch in the back of the stationary element is fully seated over the spring pin**.

Oil the O-ring (O) and install it in the groove in the O.D. of the seat sleeve (05N). Position the seat sleeve over the shoulder on the bearing retaining nut (07AD) and press it on until fully seated.

Proceed to install the rotor adjusting sleeve assembly as described in **Pump Reassembly, Section E**.

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