

## Pump Assembly Work Instruction

<b>Job code</b>	PMP001235
<b>Summary</b>	Assembly of all stages of the pump.
<b>Work type</b>	Assembly
<b>Role</b>	Line
<b>Expected time</b>	30 Mins
<b>Work cell</b>	12
<b>Previous job</b>	PMP001234
<b>Next job</b>	PMP001236
<b>Work order</b>	69C123
<b>Revision</b>	A

## PREREQUISITES

Safety goggles, gloves and boots must be worn at all times.

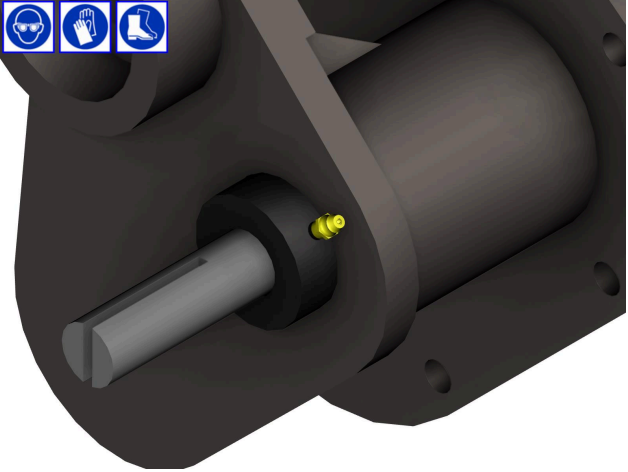
Disconnect the power from the pump before starting this procedure.

Drain all fluids from the pump before starting this procedure.

## PARTS LIST

Part number/ Alternative part number	Description	Quantity
PM005302	Back Plate Assy	1
DP00356	Dowel Pin	2
PM005330	Gasket, Case	1
BLT000324	Bolt	8
PM005302	Retaining ring	1
PM005303	Ball Bearing Assy	1
PM005310	Zerk Fitting	1
PM005350	Casing	1
BLT000324	Bolt	8
PM005330	Gasket, Case	1
DP00356	Dowel Pin	2
PM005400	Face Plate Assembly, Relief Valve	1
SH40120	Shaft, Drive	1
SH40400	Gear, Left Hand	1
PM005520	Bushing, Short	1
PM005510	Bushing, Long	1
PM005530	Washer, Expansion	1
SH40040	Key	1
SH40140	Key	1
SH40500	Gear, Right Hand	1
SH40020	Shaft, Idler	1
PM005510	Bushing, Long	2
PM005530	Washer, Expansion	2
SH40140	Key	1
Tool	Torque Wrench	



№	Task	Illustration
2	<p><b>Install the Ball Bearing Assy</b></p> <p>Install the <a href="#">Ball Bearing Assy</a> on the <a href="#">Drive Shaft</a>.</p> <p>Tighten the <a href="#">Zerk fitting</a> a maximum of 1 turn.</p>	<div data-bbox="879 353 1046 409"></div>  <p data-bbox="1129 846 1249 880">Figure 2.1</p> <div data-bbox="879 925 1046 981"></div>  <p data-bbox="1129 1417 1249 1451">Figure 2.2</p>
3	<p><b>Install the Retaining Ring</b></p> <p>Install the <a href="#">Retaining Ring</a> on the <a href="#">Ball Bearing Assy</a>.</p>	<div data-bbox="879 1503 1046 1559"></div>  <p data-bbox="1137 1989 1241 2022">Figure 3</p>

№	Task	Illustration
4	<b>Install the Key</b>  Install the <a href="#">Key</a> on <a href="#">Drive Shaft</a> .	  Figure 4
5	<b>Install the Dowel Pins</b>  Install the <a href="#">Dowel Pins</a> on the <a href="#">Casing</a> .	  Figure 5
6	<b>Install the Case Gasket</b>  Install the <a href="#">Case Gasket</a> on the <a href="#">Casing</a> .	  Figure 6

№	Task	Illustration
7	<p data-bbox="217 264 612 302"><b>Install the Back Plate Assy</b></p> <p data-bbox="217 353 699 387">Attach the <a href="#">Back Plate Assy</a> to the <a href="#">Casing</a>.</p> <p data-bbox="217 925 671 958">Install the <a href="#">Bolts</a> on the BackPlate Assy.</p> <p data-bbox="217 1496 660 1529">Tighten Bolts using a <a href="#">Torque Wrench</a>.</p>	<div data-bbox="879 353 1046 409"></div> <div data-bbox="906 360 1474 801"></div> <p data-bbox="1129 846 1246 880">Figure 7.1</p> <div data-bbox="879 925 1046 981"></div> <div data-bbox="970 992 1414 1357"></div> <p data-bbox="1129 1413 1246 1447">Figure 7.2</p> <div data-bbox="879 1496 1046 1552"></div> <div data-bbox="995 1529 1394 1921"></div> <p data-bbox="1129 1989 1246 2022">Figure 7.3</p>

№	Task	Illustration
8	<p><b>Install the Righthand Gear</b></p> <p>Install the <a href="#">Idler Shaft</a>.</p> <p>Install the <a href="#">Key</a> on the <a href="#">Idler Shaft</a>.</p> <p>Install the <a href="#">Righthand Gear</a> on the <a href="#">Idler Shaft</a>. Inspect for signs of wear on the Gear before installation.</p>	<div data-bbox="879 353 1045 409">  </div> <div data-bbox="959 421 1437 763">  </div> <div data-bbox="1129 842 1246 875">Figure 8.1</div> <div data-bbox="879 920 1045 976">  </div> <div data-bbox="871 920 1509 1391">  </div> <div data-bbox="1129 1413 1246 1447">Figure 8.2</div> <div data-bbox="879 1491 1045 1547">  </div> <div data-bbox="967 1514 1406 1939">  </div> <div data-bbox="1445 1491 1493 1547">  </div> <div data-bbox="1129 1984 1246 2018">Figure 8.3</div>

Nº	Task	Illustration
	Install the <a href="#">Long Bushing</a> and <a href="#">Expansion Washer</a> on the <a href="#">Idler Shaft</a> .	<div data-bbox="879 264 1045 315">  </div>  <p data-bbox="1129 750 1252 784">Figure 8.4</p>
9	<p data-bbox="215 840 598 873"><b>Install the Lefthand Gear</b></p> <p data-bbox="215 929 734 963">Install the <a href="#">Lefthand Gear</a> on the <a href="#">Drive Shaft</a>.</p> <p data-bbox="215 1489 614 1523">Install the <a href="#">Key</a> on the Drive Shaft.</p>	<div data-bbox="879 925 1045 976">  </div> <div data-bbox="1444 925 1497 976">  </div>  <p data-bbox="1129 1411 1252 1444">Figure 9.1</p> <div data-bbox="879 1496 1045 1547">  </div>  <p data-bbox="1129 1982 1252 2016">Figure 9.2</p>



№	Task	Illustration
	Install the <a href="#">Long Bushing</a> and <a href="#">Expansion Washer</a> on the <a href="#">Idler Shaft</a> .	<div data-bbox="879 264 1046 315"></div> <div data-bbox="1007 293 1437 674"></div> <div data-bbox="1129 752 1246 786">Figure 9.3</div>
10	<b>Install the Dowel Pins</b> Install the <a href="#">Dowel Pins</a> on the <a href="#">Casing</a> .	<div data-bbox="879 842 1046 893"></div> <div data-bbox="1038 871 1437 1252"></div> <div data-bbox="1129 1330 1246 1364">Figure 10</div>
11	<b>Install the Case Gasket</b> Install the <a href="#">Case Gasket</a> on the <a href="#">Casing</a> .	<div data-bbox="879 1413 1046 1464"></div> <div data-bbox="959 1442 1437 1868"></div> <div data-bbox="1129 1901 1246 1935">Figure 11</div>

№	Task	Illustration
12	<p data-bbox="217 264 608 302"><b>Install the Face Plate Assy</b></p> <p data-bbox="217 353 810 421">Install the <a href="#">Face Plate Assembly, Relief Valve</a> on the <a href="#">Casing</a>.</p> <p data-bbox="217 925 810 992">Install the <a href="#">Bolts</a> on the <a href="#">Face Plate Assembly, Relief Valve</a>.</p> <p data-bbox="217 1496 660 1529">Tighten <a href="#">Bolts</a> using a <a href="#">Torque Wrench</a>.</p>	<div data-bbox="879 353 1046 409"></div> <div data-bbox="911 387 1441 813"></div> <div data-bbox="1123 846 1254 880">Figure 12.1</div> <div data-bbox="879 925 1046 981"></div> <div data-bbox="911 987 1441 1350"></div> <div data-bbox="1123 1417 1254 1451">Figure 12.2</div> <div data-bbox="879 1496 1046 1552"></div> <div data-bbox="954 1529 1425 1944"></div> <div data-bbox="1123 1989 1254 2022">Figure 12.3</div>