

Pump Assembly Work Instruction

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

PREREQUISITES

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

Disconnect the power from the pump before starting this procedure.

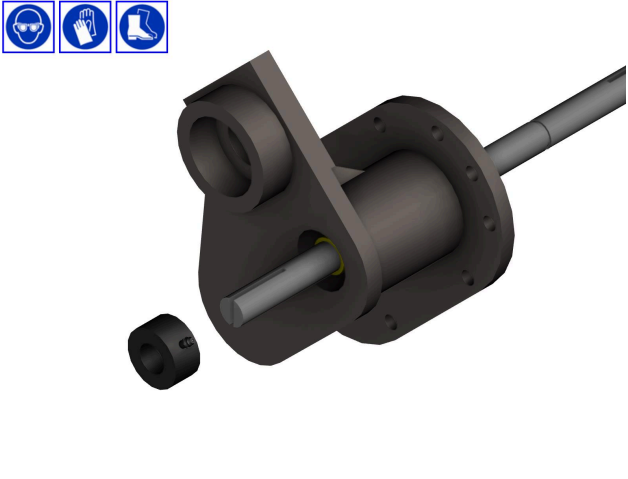
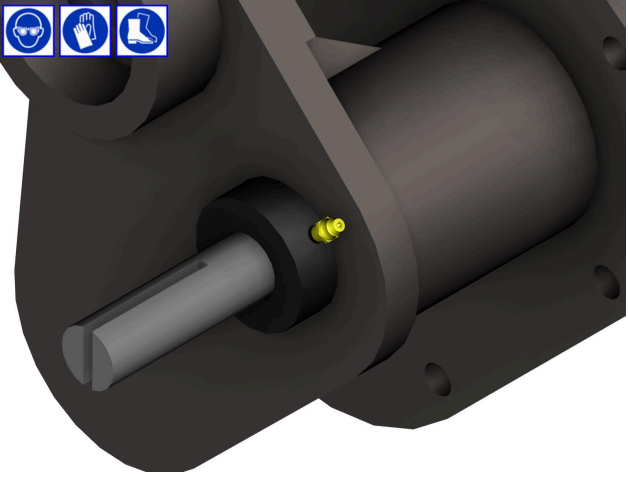
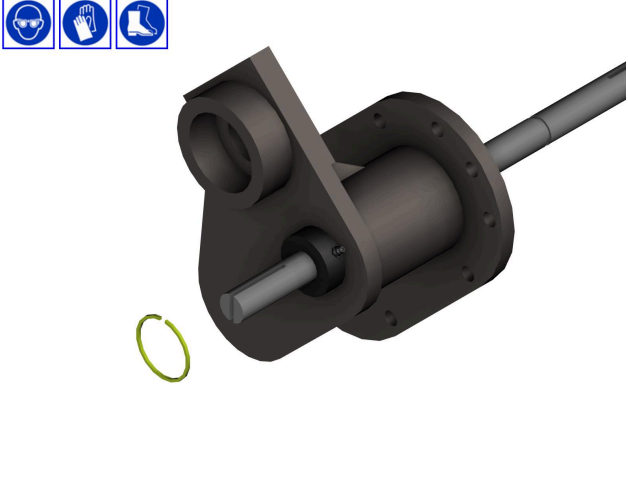
Drain all fluids from the pump before starting this procedure.

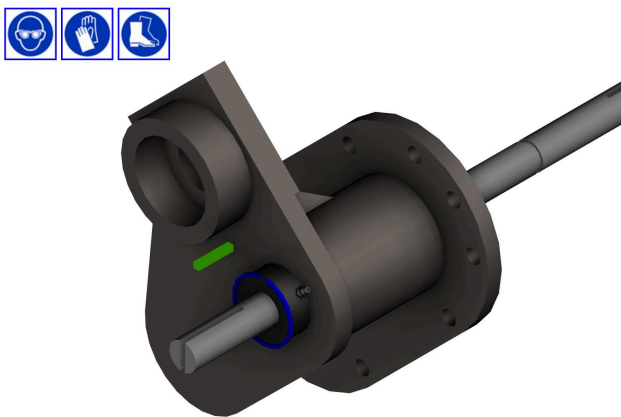
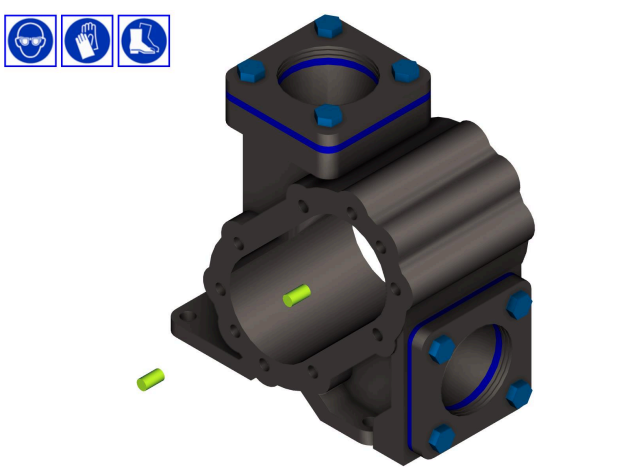
PARTS LIST

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	


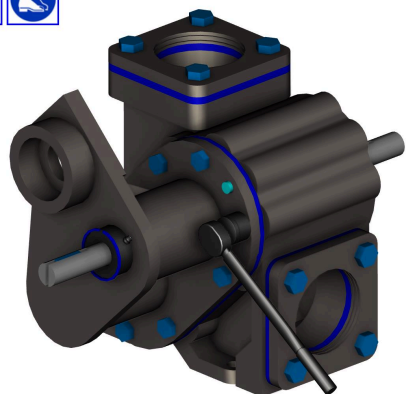

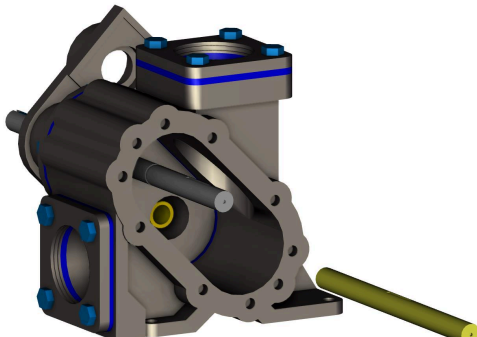

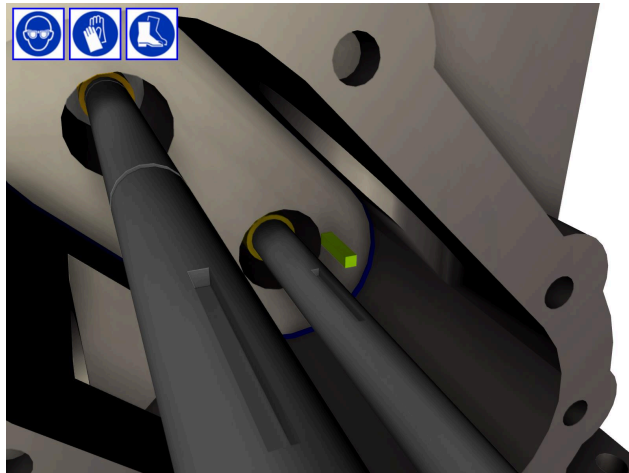
Nº	Task	Illustration
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[illegible]

№	Task	Illustration
2	<p>Install the Ball Bearing Assy on the Drive Shaft.</p> <p>Tighten the Zerk fitting a maximum of 1 turn.</p>	 
3	Install the Retaining Ring on the Ball Bearing Assy .	



№	Task	Illustration
4	Install the Key on Drive Shaft .	 <p>The illustration shows a 3D model of a drive shaft assembly. A grey shaft is partially inserted into a black housing. A green key is shown being inserted into a slot on the shaft. A blue circle highlights the keyway on the shaft. Above the illustration are three safety icons: a person wearing safety glasses, a hand wearing a glove, and a person wearing a hard hat.</p>
5	Install the Dowel Pins on the Casing .	 <p>The illustration shows a 3D model of a casing assembly. A black casing is shown with a green dowel pin being inserted into a hole. A blue circle highlights the hole. Above the illustration are three safety icons: a person wearing safety glasses, a hand wearing a glove, and a person wearing a hard hat.</p>

№	Task	Illustration
6	Install the Case Gasket on the Casing .	
7	Attach the Back Plate Assy to the Casing . Install the Bolts on the BackPlate Assy.	 

№	Task	Illustration
	Tighten Bolts using a Torque Wrench .	 
8	Install the Idler Shaft . Install the Key on the Idler Shaft .	   

Nº	Task	Illustration
	<p>Install the Righthand Gear on the Idler Shaft. Inspect for signs of wear on the Gear before installation.</p> <p>Install the Long Bushing and Expansion Washer on the Idler Shaft.</p>	<div data-bbox="879 264 1045 315"></div> <div data-bbox="1442 264 1497 315"></div> <div data-bbox="970 286 1409 705"></div> <div data-bbox="879 770 1045 822"></div> <div data-bbox="1038 792 1409 1176"></div>

№	Task	Illustration
9	Install the Lefthand Gear on the Drive Shaft .	<div data-bbox="879 264 1046 315"></div> <div data-bbox="1445 264 1497 315"></div> 
	Install the Key on the Drive Shaft.	<div data-bbox="879 779 1046 831"></div> 
	Install the Long Bushing and Expansion Washer on the Idler Shaft .	<div data-bbox="879 1294 1046 1346"></div> 

№	Task	Illustration
10	Install the Dowel Pins on the Casing .	<div data-bbox="879 264 1046 320"></div> 

№	Task	Illustration
11	Install the Case Gasket on the Casing .	<div data-bbox="879 264 1046 315"></div> 
12	<p>Install the Face Plate Assembly, Relief Valve on the Casing.</p> <p>Install the Bolts on the Face Plate Assembly, Relief Valve.</p>	<div data-bbox="879 772 1046 824"></div>  <div data-bbox="879 1279 1046 1330"></div> 

№	Task	Illustration
	Tighten Bolts using a Torque Wrench .	 