
60SERIES

INSTALLATION, OPERATION, PARTS LIST, AND MAINTENANCE MANUAL



THE GORMAN-RUPP COMPANY • MANSFIELD, OHIO

GORMAN-RUPP OF CANADA LIMITED • ST. THOMAS, ONTARIO, CANADA

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INTRODUCTION

This Installation, Operation, and Maintenance Manual is designed to help you achieve the best performance and longest life from your Gorman-Rupp pump.

This pump is a 60 Series, centrifugal model with an enclosed impeller. This pump is designed for high pressure distribution of liquids containing specified entrained solids. The basic material of construction for wetted parts is gray iron with gray iron impeller and brass wearing parts.

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

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

For information or technical assistance on the engine, contact the engine manufacturer's local dealer or representative.

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

NOTE

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

CAUTION

Instructions which must be followed to avoid causing damage to the product or other equipment incidental to the installation. These instructions describe the requirements and the possible damage which could result from failure to follow the procedures.

WARNING

```

////////////////////////////////////
//
// These instructions must be followed to avoid causing in- //
// jury or death to personnel, and describe the procedure //
// required and the injury which could result from failure //
// to follow the procedure. //
// //
////////////////////////////////////

```


WARNINGS

WARNINGS - SECTION A

THESE WARNINGS APPLY TO 60 SERIES ENGINE DRIVEN PUMPS. REFER TO THE MANUAL ACCOMPANYING THE ENGINE BEFORE ATTEMPTING TO BEGIN OPERATION.

WARNING

Before attempting to open or service the pump:
1. Familiarize yourself with this manual.
2. Switch off the engine ignition and remove the key to ensure that the pump will remain inoperative.
3. Allow the pump to cool if overheated.
4. Vent the pump slowly and cautiously.
5. Close the suction and discharge valves.
6. Check the temperature before opening any covers, plates, or plugs.
7. Drain the pump.

WARNING

This pump is designed to pump liquids containing specified entrained solids. Do not attempt to pump volatile, corrosive, or flammable liquids which may damage the pump or endanger personnel as a result of pump failure.

WARNING

After the pump has been installed, make certain that the pump and all piping or hose connections are tight, properly supported and secure before operation.

WARNING

Do not operate the pump against a closed discharge valve for long periods of time. This could bring the liquid to a boil, build pressure, and cause the pump to rupture or explode.

WARNINGS

WARNING

```

////////////////////////////////////////////////////////////////////
//
// 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 cool before servic-
// ing.
//
////////////////////////////////////////////////////////////////////

```

WARNING

```

////////////////////////////////////////////////////////////////////
//
// Do not operate an internal combustion engine in an ex-
// plosive atmosphere. When operating internal combustion
// engines in an enclosed area, make certain that exhaust
// fumes are piped to the outside. These fumes contain
// carbon monoxide, a deadly gas that is colorless,
// tasteless, and odorless.
//
////////////////////////////////////////////////////////////////////

```

WARNING

```

////////////////////////////////////////////////////////////////////
//
// Never tamper with the governor to gain more power. The
// governor establishes safe operating limits that should
// not be exceeded. The maximum continuous operating speed
// for this unit is 2400 RPM.
//
////////////////////////////////////////////////////////////////////

```

WARNING

```

////////////////////////////////////////////////////////////////////
//
// Fuel used by internal combustion engines presents an ex-
// treme explosion and fire hazard. Make certain that all
// fuel lines are securely connected and free of leaks.
// Never refuel a hot or running engine. Avoid overfilling
// the fuel tank. Always use the correct type of fuel.
//
////////////////////////////////////////////////////////////////////

```

WARNING

```

////////////////////////////////////////////////////////////////////
//
// When lifting the pump, position chains or cables so that
// the load is balanced. Use lifting and moving equipment
// in good repair and with adequate capacity to prevent in-
// juries to personnel or damage to equipment. Customer
// installed equipment such as suction and discharge hoses
// MUST be removed before attempting to lift the pump.
//
////////////////////////////////////////////////////////////////////

```

INSTALLATION - SECTION B

Since pump installations are seldom identical, this section offers only general recommendations and practices required to inspect, position, and arrange the pump and piping.

Most of the information pertains to a standard **static lift application** where the pump is positioned above the free level of liquid to be pumped.

If installed in a **flooded suction application** where the liquid is supplied to the pump under pressure, some of the information such as mounting, line configuration, and priming must be tailored to the specific application. Since the pressure supplied to the pump is critical to performance and safety, **be sure** to limit the incoming pressure to 50% of the maximum pressure developed by the pump. (See Section E, Page 1). If the pump is fitted with a Gorman-Rupp double grease lubricated seal, the maximum incoming pressure must be reduced to 10 p.s.i..

For further assistance, contact your Gorman-Rupp distributor or the Gorman-Rupp Company.

Pump Dimensions

See Figure 1 for the approximate physical dimensions of this pump and engine.

OUTLINE DRAWING

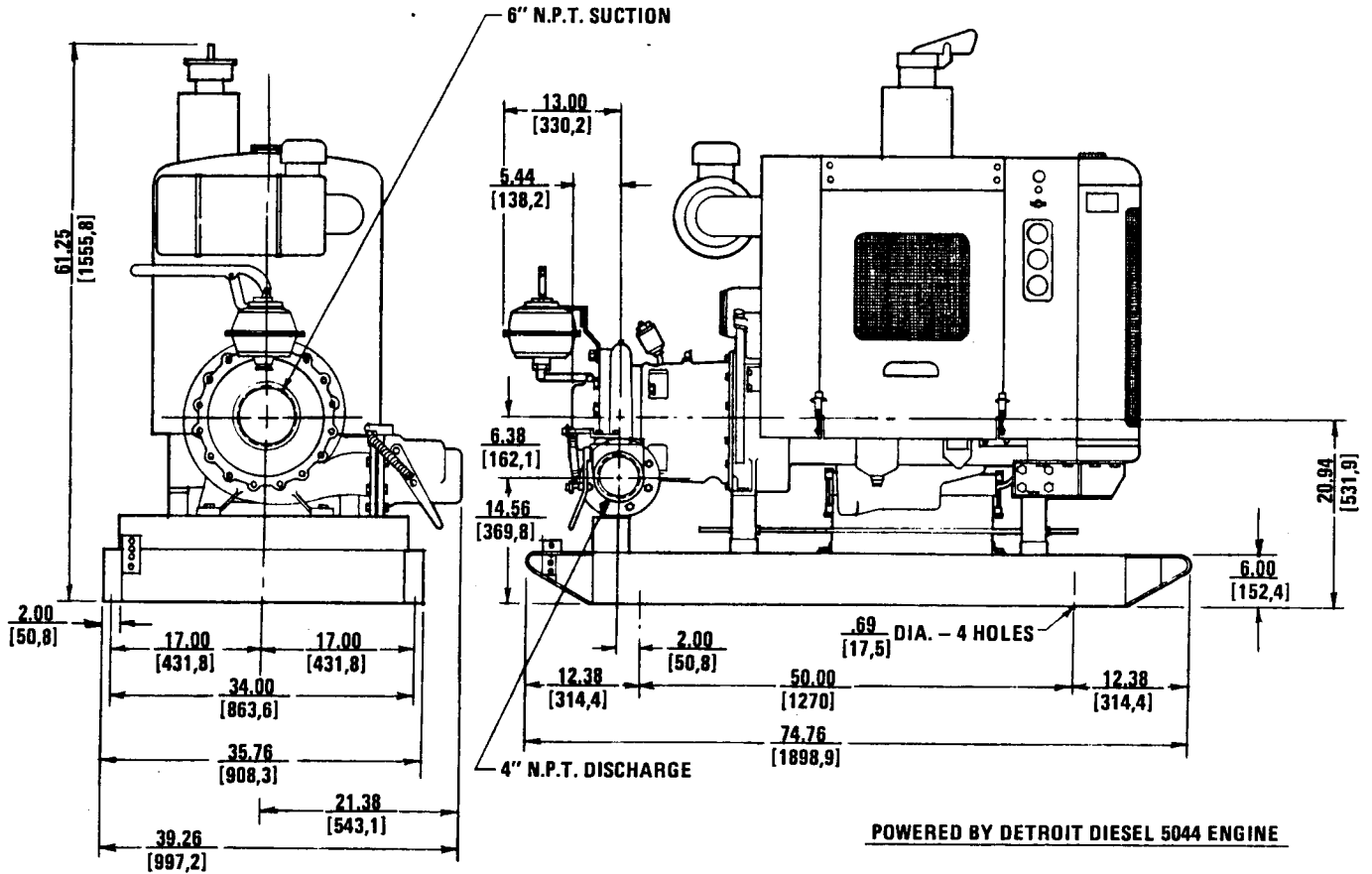


Figure 1. Pump Model 64B2-5044

PREINSTALLATION INSPECTION

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

- Inspect the pump and engine for cracks, dents, damaged threads, and other obvious damage.
- Check for and tighten loose bolts, nuts, capscrews, and other attaching hardware. Since gaskets tend to shrink after drying, check for and tighten loose nuts and capscrews securing mating surfaces.
- Carefully read all tags, decals, and markings on the pump assembly, and follow the instructions indicated.

INSTALLATION

-
-
- d. Check all lubricant levels and lubricate as necessary. Refer to LUBRICATION in the MAINTENANCE AND REPAIR section of this manual and perform duties as instructed.
 - e. If the pump and engine have been stored for more than 12 months, some of the components or lubricants may have exceeded their maximum shelf life. These **must be inspected or replaced** to ensure maximum pump service.

If the maximum shelf life has been exceeded, or if anything appears to be abnormal, contact your Gorman-Rupp distributor or the factory to determine the repair or updating policy. **Do not** put the pump into service until appropriate action has been taken.

POSITIONING PUMP

Lifting

Use lifting equipment with a capacity of a least **12,000 pounds**. This pump weighs approximately **2,388 pounds**, not including the weight of accessories and wheel kit. Customer installed equipment such as suction and discharge hoses **must** be removed before attempting to lift.

CAUTION

The pump assembly can be seriously damaged if the cables or chains used to lift and move the unit are improperly wrapped around the pump.

Mounting

Locate the pump in an accessible place as close as practical to the liquid being pumped. Level mounting is essential for proper operation. The pump may have to be supported or shimmed to provide for level operation or to eliminate vibration.

If the pump has been mounted on a moveable base, make certain the base is stationary by setting the brake and blocking the wheels before attempting to operate the pump.

SUCTION AND DISCHARGE PIPING

Materials

Either pipe or hose may be used for suction and discharge lines; however, the materials must be compatible with the liquid being pumped. If hose is used in suction lines, it must be the rigid-wall, reinforced type to prevent collapse under suction. Using piping couplings in suction lines is not recommended.

Line Configuration

Keep suction and discharge lines as straight as possible to minimize friction losses. Make minimum use of elbows and fittings, which substantially increase friction loss. If elbows are necessary, use the long-radius type to minimize friction loss.

Connections to Pump

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

Lines near the pump must be independently supported to avoid strain on the pump which could cause excessive vibration, decreased bearing life, and increased shaft and seal wear. If hose-type lines are used, they should have adequate support to secure them when filled with liquid and under pressure.

Gauges

Most pumps are drilled and tapped for installing discharge pressure and vacuum suction gauges. If these gauges are desired for pumps that are not tapped, drill and tap the suction and discharge lines not less than 18 inches from the suction and discharge ports and install the lines. Installation closer to the pump may result in erratic readings.

SUCTION LINES

To avoid air pockets which could affect pump priming, the suction line must be as short and direct as possible. When operation involves a suction lift, the line must always slope upward to the pump from the source of the liquid being pumped; if the line slopes down to the pump at any point along the suction run, air pockets will be created.

INSTALLATION

Fittings

Suction lines should be the same size as the pump inlet. If reducers are used in suction lines, they should be the eccentric type, and should be installed with the flat part of the reducers uppermost to avoid creating air pockets. Valves are not normally used in suction lines, but if a valve is used, install it with the stem horizontal to avoid air pockets.

Strainers

If a strainer is furnished with the pump, be certain to use it; any spherical solids which pass through a strainer furnished with the pump will also pass through the pump itself.

If a strainer is not furnished with the pump, but is installed by the pump user, make certain that the total area of the openings in the strainer is at least three or four times the cross section of the suction line, and that the openings will not permit passage of solids larger than the solids handling capability of the pump.

This pump is designed to handle up to 3/8 inch diameter spherical solids.

Sealing

Since even a slight leak will affect priming, head, and capacity, especially when operating with a high suction lift, all connections in the suction line should be sealed with pipe dope to ensure an airtight seal. Follow the sealant manufacturer's recommendations when selecting and applying the pipe dope. The pipe dope should be compatible with the liquid being pumped.

Suction Lines In Sumps

If a single suction line is installed in a sump, it should be positioned away from the wall of the sump at a distance equal to one and one-half times the diameter of the suction line.

If there is a liquid flow from an open pipe into the sump, the flow should be kept away from the suction inlet because the inflow will carry air down into the sump, and air entering the suction line will reduce pump efficiency.

If it is necessary to position inflow close to the suction inlet, install a baffle between the inflow and the suction inlet at a distance one and one-half times the diameter of the suction pipe. The baffle will allow entrained air to escape from the liquid before it is drawn into the suction inlet.

If two suction lines are installed in a single sump, the flow paths may interact, reducing the efficiency of one or both pumps. To avoid this, position the suction inlets so that they are separated by a distance equal to at least three times the diameter of the suction pipe.

Suction Line Positioning

The depth of submergence of the suction line is critical to efficient pump operation. Figure 2 shows recommended minimum submergence vs. velocity.

NOTE

The pipe submergence required may be reduced by installing a standard pipe increaser fitting at the end of the suction line. The larger opening size will reduce the inlet velocity. Calculate the required submergence using the following formula based on the increased opening size (area or diameter).

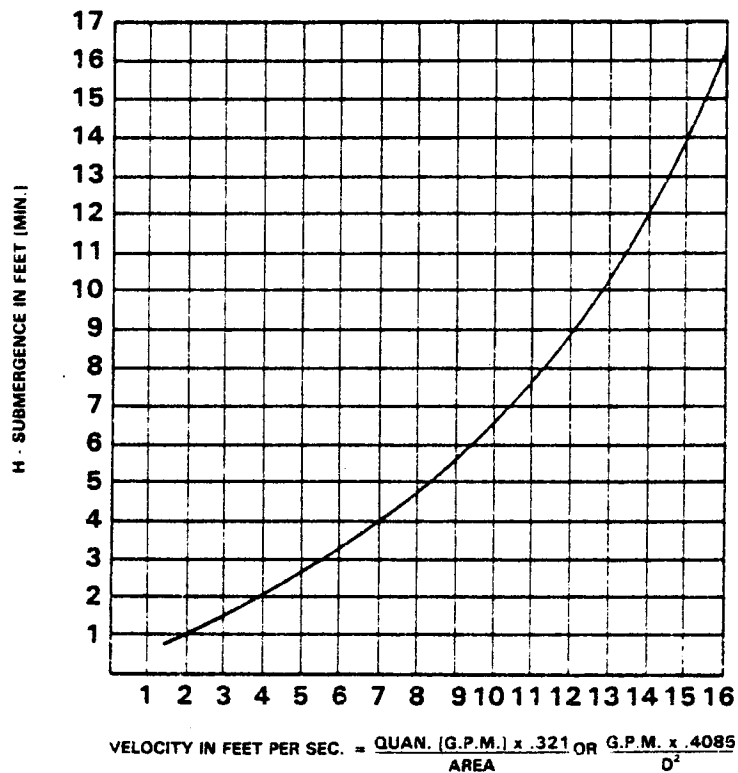


Figure 2. Recommended Minimum Suction Line Submergence Vs. Velocity

DISCHARGE LINES

Siphoning

Do not terminate the discharge line at a level lower than that of the liquid being pumped unless a siphon breaker is used in the line. Otherwise, a siphoning action causing damage to the pump could result.

Valves

A check valve in the discharge line is normally recommended, but it is not necessary in low discharge head applications.

If a throttling valve is desired in the discharge line, use a valve as large as the largest pipe to minimize friction losses. Never install a throttling valve in a suction line.

With high discharge heads, it is recommended that a throttling valve and a system check valve be installed in the discharge line to protect the pump from excessive shock pressure and reverse rotation when it is stopped.

ALIGNMENT

The alignment of the pump and the engine is critical for trouble free mechanical operation. See Section E, **Attaching Pump To Engine** for detailed information.

OPERATION

OPERATION - SECTION C

WARNING

```

////////////////////////////////////
//
// This pump is designed to pump liquids containing speci- //
// fied entrained solids. Do not attempt to pump volatile, //
// corrosive, or flammable liquids which may damage the //
// pump or endanger personnel as a result of pump failure. //
//
////////////////////////////////////

```

WARNING

```

////////////////////////////////////
//
// Never tamper with the governor to gain more power. The //
// governor establishes safe operating limits that should //
// not be exceeded. The maximum continuous operating speed //
// for this unit is 2400 RPM. //
//
////////////////////////////////////

```

PRIMING

Install the pump and piping as described in INSTALLATION. Make sure that the piping connections are tight, and that the pump is securely mounted. Check that the pump is properly lubricated (see LUBRICATION in MAINTENANCE AND REPAIR).

Since this is not a self-priming pump, it will require an external priming device when installed in a **static lift application**. Many standard centrifugal models are equipped with a hand operated vacuum pump, exhaust primer, or ejector for this purpose. If a priming device was not furnished with the pump, it may be ordered from the factory as an option.

Before attempting to operate the priming device, close the discharge throttling valve. (Installation of a spring-loaded check valve is also recommended to facilitate priming.) Once the pump is fully primed, close the valve between the priming device and pump to preserve the prime. Start the pump, if not already in operation, and open the discharge valve slowly and fill the discharge line.

When installed in a **flooded suction application**, simply open the system valves and permit the incoming liquid to evacuate the air. After the pump and piping system have completely filled, evacuate any remaining air pockets in the pump or suction line by loosening pipe plugs or opening bleeder valves.

CAUTION

<p>Never operate this pump unless there is liquid in the casing. The pump will not prime when dry. Extended operation of a dry pump will destroy the seal assembly.</p>

Hand-Operated Priming Pump

The hand-operated priming pump (see Figure 1) is designed to draw air out of the suction line and the pump casing.

The hand-operated priming pump can be used while the pump is either stopped or operating.

Close the discharge line throttling valve and spring-loaded check valve before engaging the priming device.

To prime the pump, open the cock in the bottom of the priming pump. Operate the handle of the pump until all of the air is expelled from the line and a small amount of liquid flows from the drain cock.

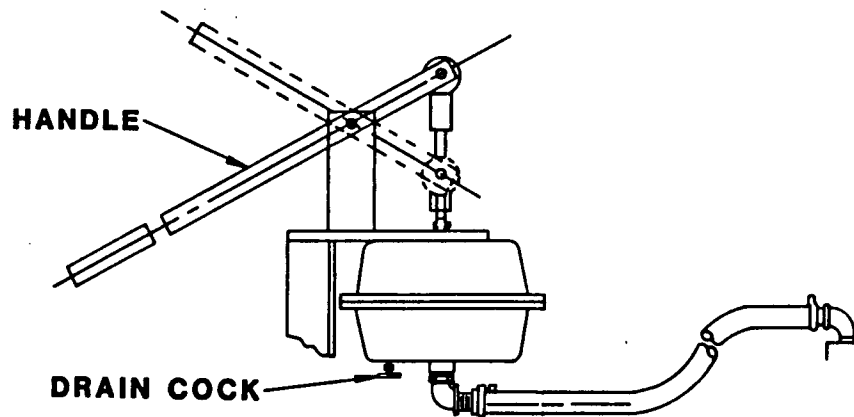


Figure 1. Hand Primer Assembly

Once the pump is fully primed, close the cock, open the discharge line throttling valve and start the pump.

STARTING

Consult the operations manual furnished with the engine.

Rotation

The correct direction of pump rotation is indicated by an arrow on the pump body or accompanying decals. If the pump is operated in the wrong direction, the impeller could become loosened from the shaft and seriously damage the pump.

CAUTION

The pump must operate in the direction indicated by the arrow on the pump, or accompanying decals. Reverse rotation could loosen the impeller and seriously damage the pump.

Consult the operating manual furnished with the pump engine before attempting to start the engine.

OPERATION

Partially open the discharge throttling valve so that the discharge line fills slowly to prevent damage to piping, gaskets, and other devices in the line which could be affected by shock resulting from rapid filling of the line. When the discharge line is completely filled, adjust the discharge throttling valve to the desired flow rate.

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 pump efficiency.

Liquid Temperature And Overheating

The **maximum** liquid temperature for this pump is 110° F. Do not apply it at a higher operating temperature.

Overheating can occur if operated with the 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 cool before servicing it. Refill the pump casing with cool liquid.

WARNING

```

////////////////////////////////////
//
// 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 cool before servic-
// ing.
//
////////////////////////////////////

```

Strainer Check

If a suction strainer has been shipped with the pump or installed by the user, check the strainer regularly, and clean it as necessary. The strainer should also be checked if pump flow rate begins to drop. If a vacuum suction gauge has been installed, monitor and record the readings regularly to detect strainer blockage.

Pump Vacuum Check

Since this pump does not have a suction check valve, the discharge line must be fitted with a check valve if a pump vacuum reading is to be taken.

With the pump inoperative, install a vacuum gauge in the system, using pipe dope on the threads. Block the suction line and start the pump. At operating speed the pump should pull a vacuum of 20 inches or more of mercury. If it does not, check for air leaks in the seal, gasket, or discharge valve.

Open the suction line, and read the vacuum gauge with the pump primed and at operating speed. Shut off the pump. The vacuum gauge reading will immediately drop proportionate to static suction lift, and should then stabilize. If the vacuum reading falls off rapidly after stabilization, an air leak exists. Before checking for the source of the leak, check the point of installation of the vacuum gauge.

STOPPING

Never halt the flow of liquid suddenly. If the liquid being pumped is stopped abruptly, damaging shock waves can be transmitted to the pump and piping system. Close all connecting valves slowly. If the pump is driven by an engine, reduce the throttle speed slowly and allow the engine to idle briefly before stopping.

CAUTION

If application involves a high discharge head, gradually close the discharge throttling valve before stopping the pump.

After stopping the pump, remove the engine ignition key or take other action to ensure that the pump will remain inoperative.

Cold Weather Preservation

In below freezing conditions, drain the pump to prevent damage from freezing. Also, clean out any solids by flushing with a hose. Operate the pump for approximately one minute; this will remove any remaining liquid that could freeze the pump rotating parts.

OPERATION

If the pump will be idle for more than a few hours, or if it has been pumping liquids containing a large amount of solids, drain the pump, and flush it thoroughly with clean water. To prevent large solids from clogging the drain port and preventing the pump from completely draining, insert a rod or stiff wire in the drain port, and agitate the liquid during the draining process. Clean out any remaining solids by flushing with a hose.

BEARING TEMPERATURE CHECK

Bearings normally run at higher than ambient temperatures because of heat generated by friction. Temperatures up to 160°F are considered normal for bearings, and they can operate safely to at least 180°F.

Checking bearing temperatures by hand is inaccurate. Bearing temperatures can be measured accurately by placing a contact-type thermometer against the housing. Record this temperature for future reference.

A sudden increase in bearing temperatures is a warning that the bearings are at the point of failing to operate properly. Make certain that the bearing lubricant is of the proper viscosity and at the correct level (see LUBRICATION in MAINTENANCE AND REPAIR). Bearing overheating can also be caused by shaft misalignment and/or excessive vibration.

When pumps are first started, the bearings may seem to run at temperatures above normal. Continued operation should bring the temperatures down to normal levels.

PUMP TROUBLESHOOTING - SECTION D

WARNING

```

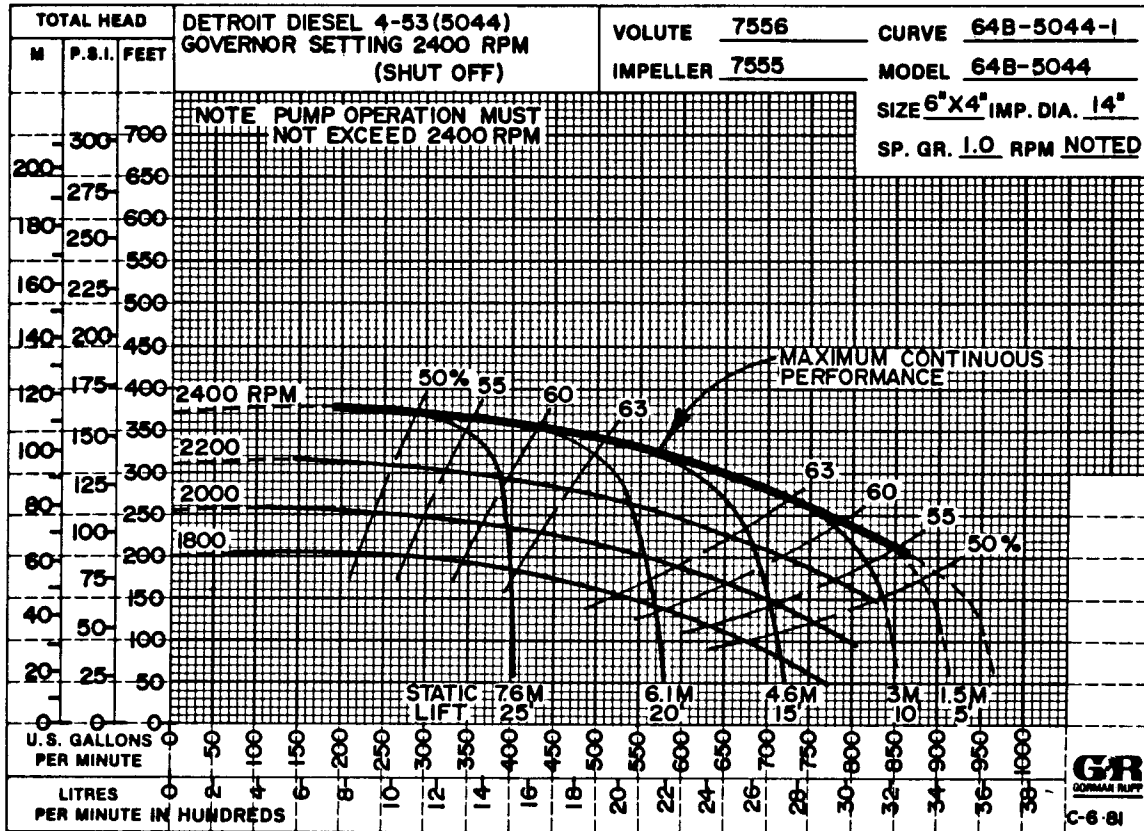
////////////////////////////////////
//
// Before attempting to open or service the pump:
//
// 1. Familiarize yourself with this manual.
// 2. Switch off the engine ignition and remove the key
//    to ensure that the pump will remain inoperative.
// 3. Allow the pump to cool if overheated.
// 4. Vent the pump slowly and cautiously.
// 5. Close the suction and discharge valves.
// 6. Check the temperature before opening any covers,
//    plates, or plugs.
// 7. Drain the pump.
//
////////////////////////////////////
    
```

TROUBLE	POSSIBLE CAUSE	PROBABLE REMEDY
PUMP FAILS TO PRIME	Auxiliary priming device faulty or improperly installed.	Repair priming device or check installation.
	Air leak in suction line.	Correct leak.
	Lining of suction hose collapsed.	Replace suction hose.
	Leaking or worn seal or pump gasket.	Check pump vacuum. Replace leaking or worn seal or gasket.
	Suction lift or discharge head too high.	Check piping installation and install bypass line if needed. See INSTALLATION.
	Strainer clogged.	Check strainer and clean if necessary.
PUMP STOPS OR FAILS TO DELIVER RATED FLOW OR PRESSURE	Air leak in suction line.	Correct leak.
	Pump speed too high.	Check engine output.
	Lining of suction hose collapsed.	Replace suction hose.
	Impeller or other wearing parts worn or damaged.	Replace worn or damaged parts. Check that impeller is properly centered and rotates freely.

TROUBLE	POSSIBLE CAUSE	PROBABLE REMEDY
PUMP STOPS OR FAILS TO DELIVER RATED FLOW OR PRESSURE(cont.)	<p>Impeller clogged.</p> <p>Pump speed too slow.</p> <p>Suction lift too high.</p> <p>Strainer clogged.</p>	<p>Free impeller of debris.</p> <p>Check driver output; check belts or couplings for slippage.</p> <p>Measure lift w/vacuum gauge. Reduce lift and/or friction losses in suction line.</p> <p>Check strainer and clean if necessary.</p>
PUMP REQUIRES TOO MUCH POWER	<p>Discharge head too low.</p> <p>Liquid solution too thick.</p>	<p>Adjust discharge valve.</p> <p>Dilute if possible.</p>
PUMP CLOGS FREQUENTLY	<p>Discharge flow too slow.</p> <p>Pump speed too high.</p>	<p>Open discharge valve fully to increase flow rate, and run engine at maximum governed speed.</p> <p>Check engine output.</p>
EXCESSIVE NOISE	<p>Cavitation in pump.</p> <p>Pumping entrained air.</p> <p>Pump or drive not securely mounted.</p> <p>Impeller clogged or damaged.</p>	<p>Reduce suction lift and/or friction losses in suction line. Record vacuum and pressure gauge readings and consult local representative or factory.</p> <p>Locate and eliminate source of air bubble.</p> <p>Secure mounting hardware.</p> <p>Clean out debris; replace damaged parts.</p>
BEARINGS RUN TOO HOT	<p>Bearing temperature is high, but within limits.</p> <p>Low or incorrect lubricant.</p> <p>Suction and discharge lines not properly supported.</p> <p>Drive misaligned.</p>	<p>Check bearing temperature regularly to monitor any increase.</p> <p>Check for proper type and level of lubricant.</p> <p>Check piping installation for proper support.</p> <p>Align drive properly.</p>

PUMP MAINTENANCE AND REPAIR - SECTION E

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



*STANDARD PERFORMANCE FOR PUMP MODEL 64B2-5044

*Based on 70°F clear water at sea level with minimum suction lift. Since pump installations are seldom identical, your performance may be different due to such factors as viscosity, specific gravity, elevation, temperature, and impeller trim.

If your pump serial number is followed by an "N", your pump is NOT a standard production model. Contact the Gorman-Rupp Company to verify performance or part numbers.

WARNING

```

////////////////////////////////////
//
// Never tamper with the governor to gain more power. The
// governor establishes safe operating limits that should
// not be exceeded. The maximum continuous operating speed
// for this unit is 2400 RPM.
//
////////////////////////////////////
    
```

SECTIONAL DRAWING

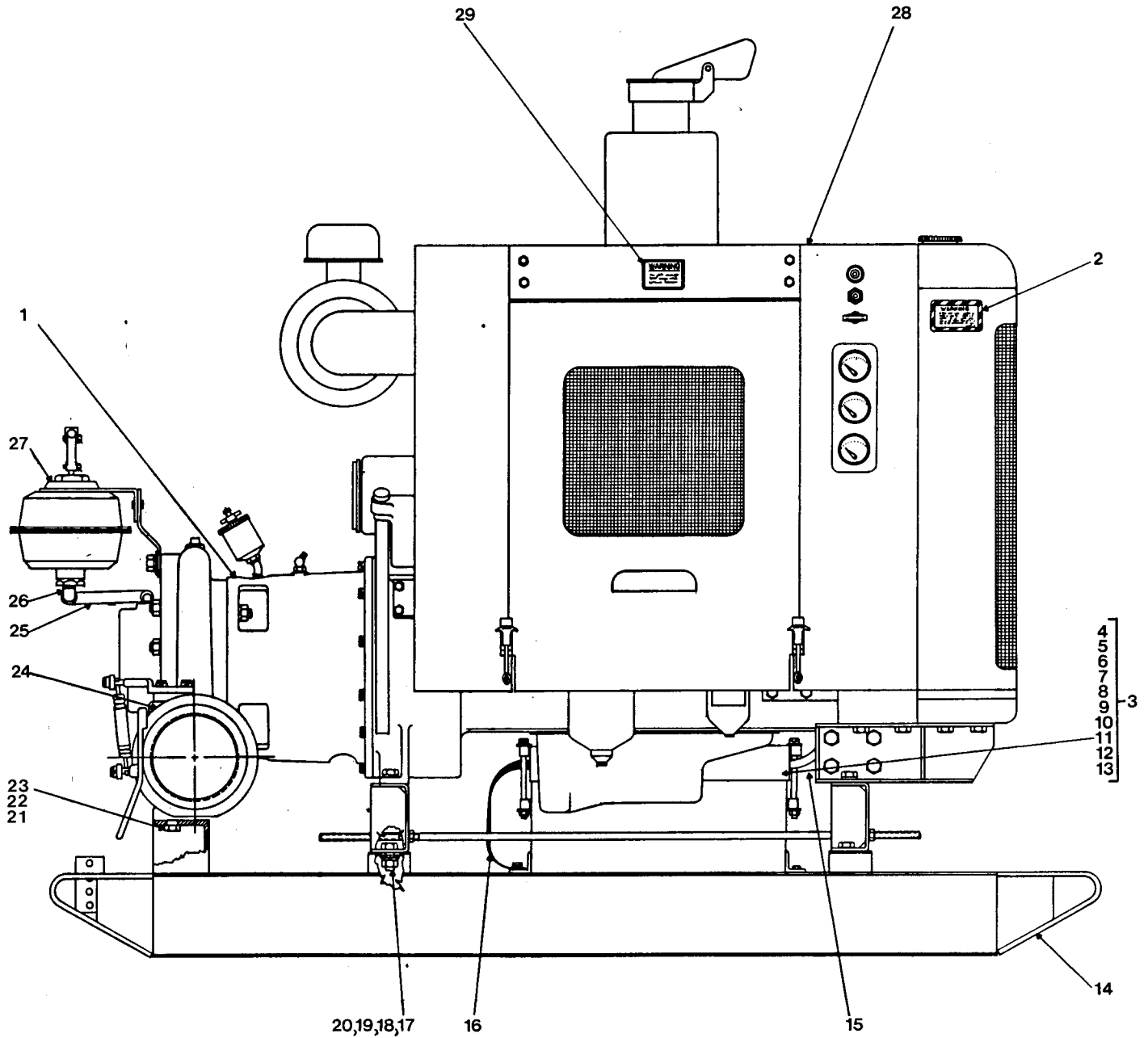


Figure 1. Pump Model 64B2-5044

PARTS LIST
Pump Model 64B2-5044
 (From S/N 806819 up)

If your pump serial number is followed by an "N", your pump is **NOT** a standard production model. Contact the Gorman-Rupp Company to verify part numbers.

ITEM NO.	PART NAME	PART NUMBER	MATL CODE	QTY
1	PUMP END ASSY	64B2-(5044)	-----	1
2	WARNING DECAL	38816-096	-----	1
3	BATTERY BOX ASSY	GRP40-04	-----	1
4	-BATTERY BX COVER	4896-X	24000	1
5	* -CABLE ASSY-CNCT	5795-CR	24040	1
6	-BATTERY BOX	10478	24000	1
7	-HEX HD CAPSCREW	B00604	15991	1
8	-HEX HD CAPSCREW	B00605	15991	1
9	-HEX HD CAPSCREW	B00624	15991	2
10	-HEX NUT	D00006	15991	4
11	-LOCKWASHER	J00006	15991	4
12	-FLAT WASHER	K00006	15991	6
13	* -BATTERY	S00978	-----	2
14	COMBINATION BASE	41566-616	24150	1
15	* CABLE ASSY - POS	6926-R	-----	1
16	* CABLE ASSY - GRD	5795-AC	-----	1
17	HEX HD CAPSCREW	B01206	15991	4
18	FLAT WASHER	K00012	15991	4
19	LOCKWASHER	J00012	15991	4
20	HEX NUT	D00012	15991	4
21	HEX HD CAPSCREW	B01009	15991	2
22	LOCKWASHER	J00010	15991	2
23	HEX NUT	D00010	15991	2
24	CHECK VALVE ASSY	GRP14-04-A	1	
25	HOSE	31412-112	-----	1
26	PIPE ELBOW	RS00006	----	2
27	HAND PRIMER ASSY	GRP43-01	-----	1
28	GM 5044 ENGINE	206-E2	-----	1
29	WARNING DECAL	38816-132	-----	2

*INDICATES PARTS RECOMMENDED FOR STOCK

Above Serial Numbers Do Not Apply To Pumps Made In Canada.

CANADIAN SERIAL NO. AND UP

SECTIONAL DRAWING

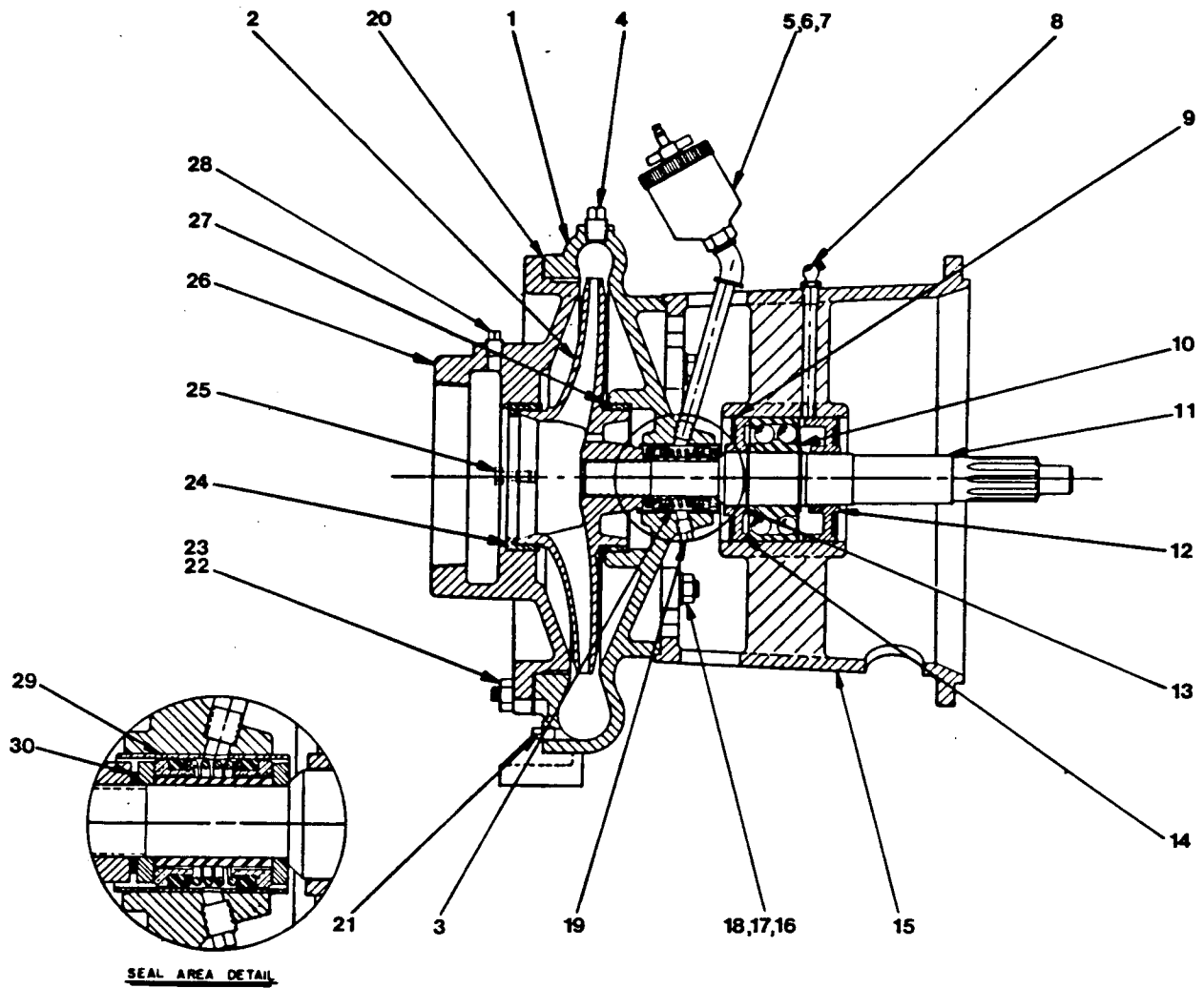


Figure 2. Pump End Assy 64B2-5044

PARTS LIST
Pump End Assy 64B2-5044

ITEM NO.	PART NAME	PART NUMBER	MATL CODE	QTY
1	PUMP CASING	7556	10120	1
2	* IMPELLER	7555	10010	1
3	* SEAL ASSY	GS01250	-----	1
4	PIPE PLUG	P00008	11990	1
5	GREASE CUP	S01509	-----	1
6	PIPE ELBOW	AG00004	11990	1
7	HEAVY PIPE NIPPLE	THA00424	15070	1
8	LUB FITTING	S00194	-----	1
9	RETAINING RING	S01165	-----	2
10	* BALL BEARING	23421-461	-----	1
11	IMPELLER SHAFT	8396-B	16040	REF
12	BEARING RETAINER	7019	10010	1
13	RETAINING RING	S01164	-----	2
14	BEARING RETAINER	7018	10010	1
15	INTERMEDIATE	7013	10010	REF
16	STUD	C01009	15991	4
17	HEX NUT	D00010	15991	4
18	LOCKWASHER	J00010	15991	4
19	PIPE PLUG	P00004	11990	1
20	* SUCTION HEAD GASKET	7557-G	18000	1
21	CASING DRAIN PLUG	P00004	11990	1
22	STUD	C01008	15991	16
23	HEX NUT	D00010	15991	16
24	* WEAR RING	64-H5	14000	1
25	HEX HD CAPSCREW	B00604	15991	2
26	SUCTION HEAD	8569	10010	1
27	* BALANCE RING	64-H6	14000	1
28	ACCESSORY PLUG	P00006	11990	1
29	* SEAL LINER	2205-A	14080	REF
30	* IMPELLER SHIM SET	37-J	17090	REF
NOT SHOWN:				
	STRAINER	S01529	-----	1
	NAME PLATE	2613-R	13990	1
	DRIVE SCREW	BM#04-03	15990	2
	PIPE PLUG	P00008	11990	1

*INDICATES PARTS RECOMMENDED FOR STOCK

SECTIONAL DRAWING

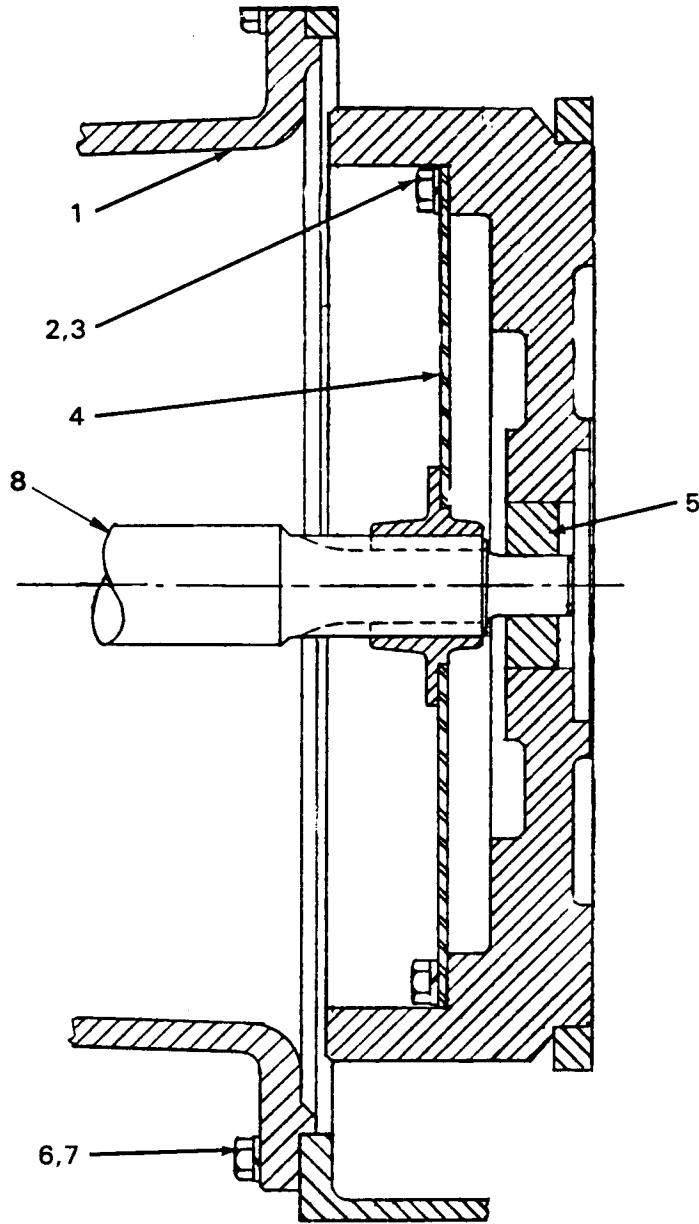


Figure 3. Pump Model 64B2-5044 Drive Assembly

PARTS LIST
Pump Model 64B2-5044 Drive Assembly

ITEM NO.	PART NAME	PART NUMBER	MATL CODE	QTY
1	INTERMEDIATE	7013	10010	1
2	HEX HD CAPSCREW	B00603	-----	8
3	LOCKWASHER	J00006	-----	8
4	DRIVE PLATE ASSY	7409-A	24040	1
5	* PILOT BUSHING	9208	15010	1
6	HEX HD CAPSCREW	B00605	-----	12
7	LOCKWASHER	J00006	-----	12
8	* IMPELLER SHAFT	8396-B	16040	1

*INDICATES PARTS RECOMMENDED FOR STOCK

PUMP AND SEAL DISASSEMBLY AND REASSEMBLY

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 are keyed to Figures 1, 2 and 3 in this section.

Before attempting to service the pump, take precautions to ensure that the engine will remain inoperative while the pump is being serviced and close all valves in the suction and discharge line.

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

WARNING

```

////////////////////////////////////
//                                                                    //
// Before attempting to open or service the pump:                    //
//                                                                    //
// 1. Familiarize yourself with this manual.                          //
// 2. Switch off the engine ignition and remove the key              //
//    to ensure that the pump will remain inoperative.                //
// 3. Allow the pump to cool if overheated.                           //
// 4. Vent the pump slowly and cautiously.                             //
// 5. Close the suction and discharge valves.                          //
// 6. Check the temperature before opening any covers,                //
//    plates, or plugs.                                                //
// 7. Drain the pump.                                                 //
//                                                                    //
////////////////////////////////////

```

WARNING

```

////////////////////////////////////
//                                                                    //
// When lifting the pump, position chains or cables so that           //
// the load is balanced. Use lifting and moving equipment             //
// in good repair and with adequate capacity to prevent injuries     //
// to personnel or damage to equipment. Customer installed           //
// equipment such as suction and discharge hoses MUST be removed     //
// before attempting to lift the pump.                                 //
//                                                                    //
////////////////////////////////////

```

Pump Disassembly

(Figure 2)

Remove the suction and discharge piping. Remove the pump casing drain plug (21) to drain the pump. Clean and reinstall the plug after draining.

For access to the impeller (2) and seal assembly (3), the suction head (26) must be separated from the pump casing (1). Remove the hand primer assembly (27, Figure 1) from the pump casing. Remove the hex nuts (23) and force the suction head out of the pump casing by turning the two jacking screws (25). Turn the screws evenly to prevent binding.

MAINTENANCE AND REPAIR

NOTE

For maintenance or repair instructions of the hand primer assembly (27, Figure 1), consult the specific data attached.

Before removing the impeller, turn the cross arm on the seal grease cup (5) clockwise until it rests against the cover (see Figure 6, in **LUBRICATION**). This will prevent the grease in the cup from escaping after the impeller is removed.

To remove the impeller, use an impeller wrench if one was provided. If a wrench is not available, the impeller can be removed by reaching through the discharge port and tightly wedging a block of wood between the vanes of the impeller. Turn the splined end of the shaft in the **opposite** direction of pump rotation. Use caution not to damage the impeller.

Remove the impeller adjusting shims (30). For ease of reassembly, tie and tag the shims, or measure and record their thickness.

Inspect the balancing ring (27) and wear ring (24) and remove them if badly worn or damaged. Both rings are secured by a press fit.

Seal Disassembly**(Figure 2)**

Make certain the cross arm on the grease cup has been turned down against the cover before removing the seal assembly.

Carefully remove the rotating elements, stationary seats, packing rings, spring, and the spacer sleeve. Use a stiff wire with a hooked end if necessary.

Inspect the seal liner (29) for wear or grooves which could cause leakage or damage to the seal rings. The seal liner is a press fit in the pump casing (1) and does not normally require replacement. If replacement is necessary, the pump casing must be removed.

If no further disassembly is required, refer to **Seal Reassembly**.

Separating Pump From Engine**(Figure 3)**

If it is necessary to separate the pump end from the engine, remove the hardware (21, 22, and 23, Figure 1) securing the pump casing to the base.

NOTE

For maintenance or repair instructions of the discharge check valve assembly (24, Figure 1), consult the specific data attached.

Remove the hardware (17 and 18, Figure 2) securing the pump casing to the intermediate and separate the two assemblies. Tie and tag any leveling shims used under the pump mounting feet.

Support the intermediate (1) with a sling and hoist. Disengage the hardware (6 and 7) securing the intermediate to the engine and separate the two assemblies by pulling straight away from the engine.

For access to the pilot bushing (5), disengage the hardware (2 and 3) securing the drive plate assembly to the engine flywheel. Remove the pilot bushing if badly worn. It is retained by a press fit.

Impeller Shaft And Bearing Disassembly

(Figure 2)

CAUTION

Shaft and bearing disassembly in the field is not recommended. These operations should be performed only in a properly-equipped shop by qualified personnel.

Use snap ring pliers to remove the retaining rings (9).

Pull the bearing retainers (12 and 14) from the bearing bore. Note the location and position of the parts during disassembly, tie and tag the parts by sets for future reference.

Place a block of wood against the drive end of the shaft and tap the shaft and assembled bearing from the bearing bore. **Be careful** not to damage the shaft.

NOTE

There is no provision for draining the grease from the intermediate cavity. Place a drip pan under the intermediate before removing the bearing.

Remove the retaining rings (13) and press the bearing (10) from the shaft.

Impeller Shaft And Bearing Reassembly

(Figure 2)

Remove the grease fitting (8) from the intermediate and flush the old bearing lubricant from the cavity. Clean the bore of the intermediate, all component parts, and the impeller shaft with a soft cloth soaked in cleaning solvent. Inspect the parts for wear, and replace as necessary.

WARNING

```

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

```

Inspect the shaft for damaged threads, distortion, or nicks and scratches. Dress small nicks and burrs with a fine file or honing stone. Replace the impeller shaft if severely damaged.

To prevent contamination, wash the bearing separately in **fresh** cleaning solvent. Dry the bearing with filtered compressed air and coat with light oil for ease of reassembly.

Rotate the bearing by hand to check for roughness or binding. If rotation is rough, replace the bearing.

CAUTION

<p>Bearings must be kept free of all dirt and foreign material. Failure to do so will greatly shorten bearing life. DO NOT spin dry bearings. This may scratch the balls or races and cause premature bearing failure.</p>
--

The bearing tolerances provide a tight press fit onto the impeller shaft, and snug push fit into the intermediate. If the bearing slips on and off easily, the shaft is worn and must be replaced. The intermediate must be replaced if the bearing does not fit snugly.

Install one of the bearing retaining rings on the shaft. Dip the bearing in clean oil and then position it on the shaft. The loading groove on the bearing **must** face toward the impeller. Using an arbor press, press against the inner race until the bearing seats squarely against the retaining ring. Install the other bearing retaining ring.

CAUTION

<p>When installing the bearings onto the shaft, NEVER press or hit against the outer race, balls, or ball cage. Press ONLY on the inner race.</p>

Install the bearing retainer (14) and retaining ring (9) into the pump side of the bearing bore. Be sure the retainer is properly positioned (see Figure 2).

Slide the shaft and assembled bearing into the intermediate from the drive end until the bearing contacts the bearing retainer.

CAUTION

When installing the shaft and bearings into the bearing bore, push against the outer race. NEVER hit the balls or ball cage.

Position the slotted side of the bearing retainer (12) against the bearing and secure the assembly with the retaining ring (9).

Check the shaft endplay. An acceptable range of .002 - .010 inch of endplay is designed into the intermediate.

Lubricate the bearing cavity as indicated in LUBRICATION, Section E.

Attaching Pump To Engine**(Figure 3)**

Apply a thin coating of 'Never-Seez' lubricant to the inside diameter of the pilot bushing (5) and press it into the engine flywheel until it is just flush with the flywheel face (see Figure 3). Make certain the bushing does not protrude and preload the shaft and bearings.

CAUTION

If the pilot bushing and drive plate are not properly positioned on the shaft, excessive wear and a preload condition could cause premature bearing failure.

Secure the drive plate assembly to the flywheel as shown in Figure 3.

Slide the shaft splines into the drive plate and secure the intermediate assembly to the engine bellhousing.

Before securing the pump casing to the intermediate, inspect the bore of the seal liner for excessive wear or grooves that might cause leakage or damage to the seal packing rings. If the seal liner must be replaced, position the pump casing on a bed of an arbor (or hydraulic) press and use a new seal liner to press the old liner out. After the new liner is properly installed, a 1/4 inch diameter hole must be drilled through it to permit the flow of lubricant to the seal assembly. **Be careful** not to damage the threads for the pipe nipple in the pump casing when drilling the hole. Deburr the hole from the inside of the seal liner after drilling.

Shim the pump casing as required to achieve proper alignment and secure it to the intermediate. Install the base mounting hardware. Reinstall the automatic grease cup, pipe elbow and pipe nipple (5, 6 and 7, Figure 2).

Seal Reassembly

(Figure 2 and 4)

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

WARNING

```

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

```

The seal is not normally reused because wear patterns on the finished faces cannot be realigned during reassembly. This could result in premature failure. If necessary to reuse an old seal in an emergency, **carefully** wash all metallic parts in fresh cleaning solvent and allow to dry thoroughly.

Handle the seal parts with extreme care to prevent damage. Be careful not to contaminate precision finished faces; even fingerprints on the faces can shorten seal life. If necessary, clean the faces with a non-oil based solvent and a clean lint free tissue. Wipe **lightly** in a concentric pattern to avoid scratching the faces.

Inspect the seal components for wear, scoring, grooves, and other damage that might cause leakage. Clean and polish the seal spacer sleeve, or replace it if there are nicks or cuts on either end. If any components are worn, replace the complete seal; **never mix old and new seal parts**.

If a replacement seal is being used, remove it from the container and inspect the precision finished faces to ensure that they are free of any foreign matter.

To ease installation of the seal, lubricate the packing rings and seal liner with water or a very **small** amount of oil, and apply a drop of light lubricating oil on the finished faces. Assemble the seal as follows, (see Figure 4).

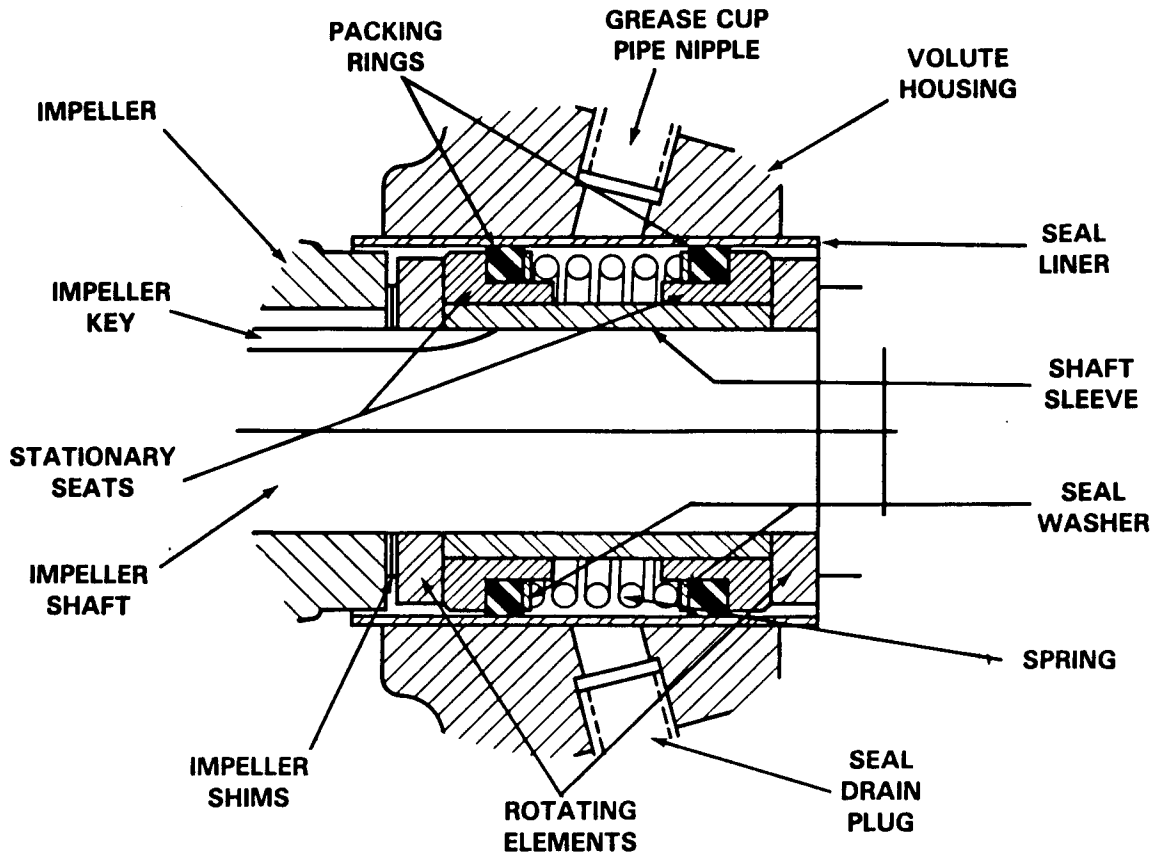


Figure 4. GS01250 Seal Assembly

CAUTION

This seal is not designed for operation at temperatures above 110° F. Do not use at higher operating temperatures.

Inspect the pump casing, seal liner, and the impeller shaft for burrs or sharp corners, and remove any that exist. Replace the seal liner (29) if wear or grooves exist which could cause leakage or damage to the seal packing rings.

NOTE

The pump casing must be removed from the intermediate to install a new seal liner. See **Attaching Pump To Engine** for specific instructions.

Slide the inboard rotating element onto the shaft (chamfered side facing the shaft shoulder) until it seats against the shaft shoulder.

Subassemble the inboard stationary seat, packing ring, and spring washer and press the unit into the lubricated seal liner.

Install the spacer sleeve and spring.

Subassemble the outboard stationary seat, packing ring, and spring washer. Press this unit into the lubricated seal liner.

Install the outboard rotating element with chamfered side facing the impeller.

After the impeller has been installed, lubricate the seal as indicated in LUBRICATION.

Pump Reassembly

(Figure 2)

If the balance ring (27) and wear ring (24) were removed, press them into their respective bores until fully seated.

Inspect the impeller and replace it if cracked or badly worn. Slide the correct number of impeller shims on the impeller shaft and screw the impeller completely onto the shaft.

For maximum pump efficiency, the impeller vanes must be centered within the volute scroll.

To verify the impeller positioning, measure the pump casing and impeller as shown in Figure 5. Use these measurements to calculate the required impeller location (dimension E). Add or remove impeller adjusting shims until dimension E is obtained.

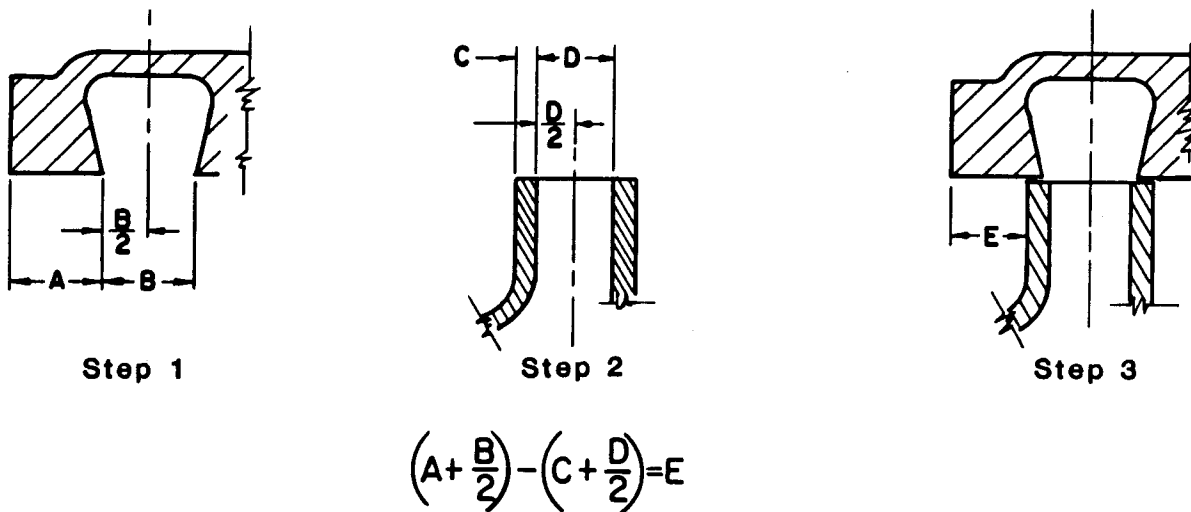


Figure 5. Centering Impeller Within Volute Scroll

NOTE

After the impeller has been properly positioned, check for free rotation. Correct any scraping binding before further reassembly.

Replace the suction head gasket (20) and reassemble the suction head and pump casing and secure it with the attaching hardware.

NOTE

Apply 'Loctite Thread Sealant' (G-R part number 18771-050) or equivalent to the studs before securing.

Turn the shaft to make sure that the impeller is not binding or scraping. If it does, check the installation of the wear ring and balance ring, or remove adjusting shims until the impeller rotates freely when the pump is fully assembled.

Reinstall the hand primer to the pump and install the intake elbow (26, Figure 1) in the suction head.

Final Pump Reassembly

Be sure the pump end assembly is secure to the engine and base.

Install the suction and discharge lines and open all valves in the lines. Make certain that all piping connections are tight, properly supported and secure.

Be sure the pump end and engine have been properly lubricated, see LUBRICATION.

Before starting the pump, prime the pump using the hand-operated primer. Refer to specific data attached.

Refer to **OPERATION**, Section C, and start the pump.

LUBRICATION

Seal Assembly

Before starting the pump, fill the grease cup through the grease fitting with a good grade of No. 2 pressure gun grease until grease escapes from the relief hole. Turn the grease cup arm counterclockwise until it is at the top of the stem; this will release the spring to apply grease to the seal (see Figure 6).

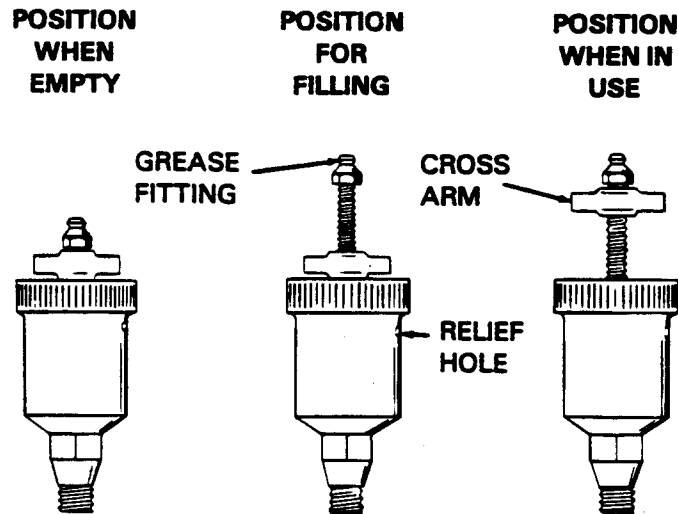


Figure 6. Automatic Lubricating Grease Cup

Bearings

The bearing cavity was fully lubricated when shipped from the factory. When additional lubrication is required, add No. 0 pressure gun grease to the lubrication fitting (8) until grease escapes from the bearing retainers.

There are no provisions in the bearing cavity to drain or flush the lubricant. The pump must be disassembled to completely clean and maintain this cavity.

Under normal conditions, change the grease each 5000 hours of operation, or at 12 month intervals, whichever ever occurs first. In extremely dirty or humid conditions, change more frequently.

For cold weather operation, consult the factory or a lubricant supplier for the recommended grade of grease.

ENGINE

Consult the literature supplied with the engine, or contact your local engine representative.

**For U.S. and International Warranty Information,
Please Visit www.grpumps.com/warranty
or call:
U.S.: 419-755-1280
International: +1-419-755-1352**

**For Canadian Warranty Information,
Please Visit www.grcanada.com/warranty
or call:
519-631-2870**