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# INSTALLATION, OPERATION, AND MAINTENANCE MANUAL

## WITH PARTS LIST



## 10 SERIES PUMPS

MODELS
<b>13A2-M12</b> <b>13A2-M12 S/G</b>

**THE GORMAN-RUPP COMPANY • MANSFIELD, OHIO**

GORMAN-RUPP OF CANADA LIMITED • ST. THOMAS, ONTARIO, CANADA Printed in U.S.A.

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**The engine exhaust from this product contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.**

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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 10 Series, semi-open impeller, self-priming centrifugal model with a suction check

valve. It is close-coupled to a single cylinder air cooled Kohler gasoline engine. The pump is designed for handling most non-volatile, non-flammable liquids containing specified entrained solids. The basic material of construction for wetted parts is gray iron with ductile iron impeller and steel 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**  
P.O. Box 1217  
Mansfield, Ohio 44901-1217

or

**Gorman-Rupp of Canada Limited**  
70 Burwell Road  
St. Thomas, Ontario N5P 3R7

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.*



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.



THESE INSTRUCTIONS MUST BE FOLLOWED TO AVOID CAUSING INJURY OR DEATH TO PERSONNEL, AND DESCRIBE THE PROCEDURE REQUIRED AND THE INJURY WHICH COULD RESULT FROM FAILURE TO FOLLOW THE PROCEDURE.



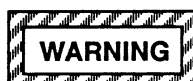
## WARNINGS - SECTION A

THESE WARNINGS APPLY TO 10 SERIES ENGINE DRIVEN PUMPS. REFER TO THE MANUAL ACCOMPANYING THE ENGINE BEFORE ATTEMPTING TO BEGIN OPERATION.



BEFORE ATTEMPTING TO OPEN OR SERVICE THE PUMP:

1. FAMILIARIZE YOURSELF WITH THIS MANUAL.
2. SHUT DOWN THE ENGINE AND DISCONNECT THE SPARK PLUG WIRE TO ENSURE THAT THE PUMP WILL REMAIN IN-OPERATIVE.
3. ALLOW THE PUMP TO COOL IF OVERHEATED.
4. CHECK THE TEMPERATURE BEFORE OPENING ANY COVERS, PLATES, OR PLUGS.
5. CLOSE THE SUCTION AND DISCHARGE VALVES.
6. VENT THE PUMP SLOWLY AND CAUTIOUSLY.
7. DRAIN THE PUMP.



THIS PUMP IS DESIGNED TO HANDLE MOST NON-VOLATILE, NON-FLAMMABLE 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.



USE LIFTING AND MOVING EQUIPMENT IN GOOD REPAIR AND WITH ADEQUATE CAPACITY TO PREVENT INJURIES TO PERSONNEL OR

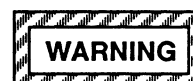
DAMAGE TO EQUIPMENT. THE BAIL IS INTENDED FOR USE IN LIFTING THE PUMP ASSEMBLY ONLY. SUCTION AND DISCHARGE HOSES AND PIPING MUST BE REMOVED FROM THE PUMP BEFORE LIFTING.



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.



DO NOT OPERATE THE PUMP AGAINST A CLOSED DISCHARGE VALVE FOR LONG PERIODS OF TIME. IF OPERATED AGAINST A CLOSED DISCHARGE VALVE, PUMP COMPONENTS WILL DETERIORATE, AND THE LIQUID COULD COME TO A BOIL, BUILD PRESSURE, AND CAUSE THE PUMP CASING TO RUPTURE OR EXPLODE.



OVERHEATED PUMPS CAN CAUSE SEVERE BURNS AND INJURIES. IF OVERHEATING OF THE PUMP OCCURS:

1. STOP THE PUMP IMMEDIATELY.
2. VENTILATE THE AREA.
3. ALLOW THE PUMP TO COOL.
4. CHECK THE TEMPERATURE BEFORE OPENING ANY COVERS, PLATES, GAUGES, OR PLUGS.
5. VENT THE PUMP SLOWLY AND CAUTIOUSLY.
6. REFER TO INSTRUCTIONS IN THIS MANUAL BEFORE RESTARTING THE PUMP.

**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 SERVICING.

**WARNING**

DO NOT OPERATE AN INTERNAL COMBUSTION ENGINE IN AN EXPLOSIVE 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**

FUEL USED BY INTERNAL COMBUSTION ENGINES PRESENTS AN EXTREME 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**

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 PUMP IS 2800 RPM.



## INSTALLATION – SECTION B

### Review all WARNINGS In Section A.

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 permissible operating pressure as shown on the pump performance curve. (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.

### OUTLINE DRAWING

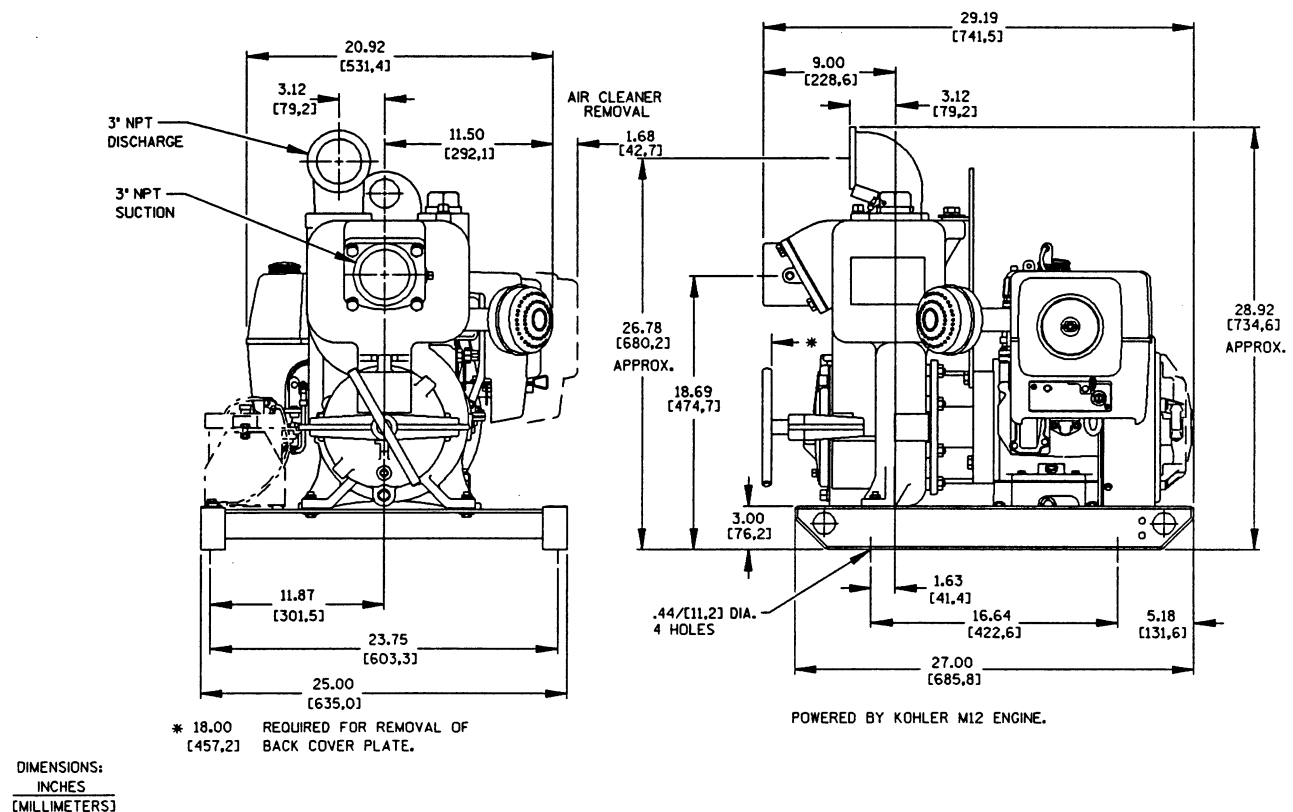


Figure 1. Pump Model 13A2-M12 And 13A2-M12 S/G

## 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 attaching hardware. Since gaskets tend to shrink after drying, check for loose hardware at mating surfaces.
- Carefully read all tags, decals, and markings on the pump assembly, and perform all duties indicated.
- Check levels and lubricate as necessary. Refer to **LUBRICATION** in the **MAINTENANCE AND REPAIR** section of this manual and perform duties as instructed.
- 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.

### Battery Specifications And Installation

Unless otherwise specified on the pump order, the engine battery for model 13A2-M12 S/G was **not** included with the unit. Refer to the following specifications when selecting a battery.

Voltage	Cold Crank Amps @ 0° F	Reserve Capacity @ 80° F (Minutes)	Amp/ Hr. Rating	Approx. Overall Dims. (Inches)
12 Volts	220-255	41	33	7.75L x 5.13W x 7.38H

Table 1. Battery Specifications

Refer to the information accompanying the battery and/or electrolyte solution for activation and charging instructions.

Before installing the battery, clean the positive and negative cable connectors, and the battery terminals. Secure the battery by tightening the holddown brackets. The terminals and clamps may be coated with petroleum jelly to retard corrosion. Connect and tighten the positive cable first, then the negative cable.

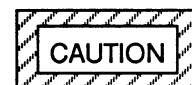
## POSITIONING PUMP



**USE LIFTING AND MOVING EQUIPMENT IN GOOD REPAIR AND WITH ADEQUATE CAPACITY TO PREVENT INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT. THE BAIL IS INTENDED FOR USE IN LIFTING THE PUMP ASSEMBLY ONLY. SUCTION AND DISCHARGE HOSES AND PIPING MUST BE REMOVED FROM THE PUMP BEFORE LIFTING.**

### Lifting

Use lifting equipment with a capacity of at least five (5) times the weight of the unit. The pull start unit weighs approximately **339 pounds (153,8 kg)**. The starter/generator unit weighs approximately **360 pounds (163,3 kg)**. Neither of the weights include accessories and optional wheel kit. Customer installed equipment such as suction and discharge piping **must** be removed before attempting to lift.



**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.

To ensure sufficient lubrication and fuel supply to the engine, **do not** position the pump and engine more than 15° off horizontal for continuous operation. The pump and engine may be positioned up to 30° off horizontal for **intermittent operation only**; however, the engine manufacturer should be consulted for continuous operation at angles greater than 15°.

### Clearance

When positioning the pump, allow a minimum clearance of **18 inches (457,2 mm)** in front of the back cover to permit removal of the cover and easy access to the pump interior.

## SUCTION AND DISCHARGE PIPING

Pump performance is adversely effected by increased suction lift, discharge elevation, and friction losses. See the performance curve and notes on Page E-1 to be sure your overall application allows pump to operate within the safe operation range.

### Materials

Either pipe or hose maybe 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 (457,2 mm) 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.

### 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 1 1/2 inch (38,1 mm) 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 1-1/2 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 1-1/2 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 3 times the diameter of the suction pipe.

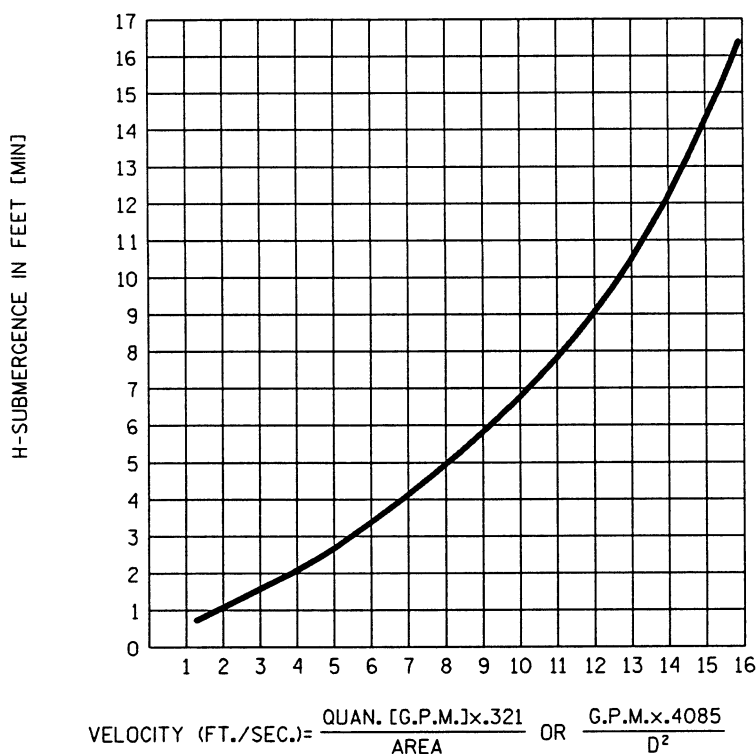
### Suction Line Positioning

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).*

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**Figure 2. Recommended Minimum Suction Line Submergence vs. Velocity**

## DISCHARGE LINES

stalled in the discharge line to protect the pump from excessive shock pressure and reverse rotation when it is stopped.

### Siphoning

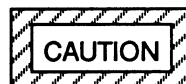
Do not terminate the discharge line at a level lower than that of the liquid being pumped unless a siphon breaker is used in the line. Otherwise, a siphoning action causing damage to the pump could result.

### Valves

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.

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

With high discharge heads, it is recommended that a throttling valve and a system check valve be in-



IF THE APPLICATION INVOLVES A HIGH DISCHARGE HEAD, GRADUALLY CLOSE THE DISCHARGE THROTTLING VALVE BEFORE STOPPING THE PUMP.

### Bypass Lines

If a system check valve is used due to high discharge head, it may be necessary to vent trapped air from the top of the pump during the priming process. This may be accomplished by installing a bypass line from the top of the pump, back to the source of liquid. The end of the bypass line must be submerged. The line must be large enough to prevent clogging, but not so large as to affect pump discharge capacity.



## OPERATION – SECTION C

Review all warnings in Section A.

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



**THIS PUMP IS DESIGNED TO HANDLE MOST NON-VOLATILE, NON-FLAMMABLE 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.**

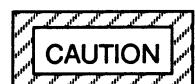


**NEVER TAMPER WITH THE GOVERNOR TO GAIN MORE POWER. THE GOVERNOR ESTABLISHES SAFE OPERATING LIMITS THAT SHOULD NOT BE EXCEEDED. THE MAXIMUM CONTINUOUS OPERATING SPEED FOR THIS PUMP IS 2800 RPM.**

### 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**).

This pump is self-priming, but the pump should never be operated unless there is liquid in the pump casing.



**NEVER OPERATE THIS PUMP UNLESS THERE IS LIQUID IN THE PUMP CASING. THE PUMP WILL NOT PRIME WHEN DRY. EXTENDED OPERATION**

**OF A DRY PUMP WILL DESTROY THE SEAL ASSEMBLY.**

Add liquid to the pump casing when:

1. The pump is being put into service for the first time.
2. The pump has not been used for a considerable length of time.
3. The liquid in the pump casing has evaporated.

Once the pump casing has been filled, the pump will prime and reprime as necessary.



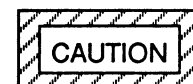
**AFTER FILLING THE PUMP CASING, REINSTALL AND TIGHTEN THE FILL PLUG. DO NOT ATTEMPT TO OPERATE THE PUMP UNLESS ALL CONNECTING PIPING IS SECURELY INSTALLED. OTHERWISE, LIQUID IN THE PUMP FORCED OUT UNDER PRESSURE COULD CAUSE INJURY TO PERSONNEL.**

To fill the pump, remove the pump casing fill cover or fill plug in the top of the casing, and add clean liquid until the casing is filled. Replace the fill cover or fill plug before operating the pump.

### STARTING

Consult the operations manual furnished with the engine.

### OPERATION



**PUMP SPEED AND OPERATING CONDITION POINTS MUST BE WITHIN THE CONTINUOUS PERFORMANCE RANGE SHOWN ON THE CURVE. (SEE SECTION E, PAGE 1.)**

#### Lines With a Bypass

Close the discharge throttling valve (if so equipped) so that the pump will not have to prime against the

weight of the liquid in the discharge line. Air from the suction line will be discharged through the bypass line back to the wet well during the priming cycle. When the pump is fully primed and liquid is flowing steadily from the bypass line, open the discharge throttling valve. Liquid will then continue to circulate through the bypass line while the pump is in operation.

### Lines Without a Bypass

Open all valves in the discharge line and start the engine. Priming is indicated by a positive reading on the discharge pressure gauge or by a quieter operation. The pump may not prime immediately because the suction line must first fill with liquid. If the pump fails to prime within five minutes, stop it and check the suction line for leaks.

After the pump has been primed, partially close the discharge line throttling valve in order to fill the line slowly and guard against excessive shock pressure which could damage pipe ends, gaskets, sprinkler heads, and any other fixtures connected to the line. When the discharge line is completely filled, adjust the throttling valve to the required 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 (43°C). 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.



**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 SERVICING.**

### 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.

**Never** introduce air or steam pressure into the pump casing or piping to remove a blockage. This could result in personal injury or damage to the equipment. If backflushing is absolutely necessary, **liquid pressure** must be limited to 50% of the maximum permissible operating pressure shown on the pump performance curve. (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.

### Pump Vacuum Check

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 (508,0 mm) 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 operation 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.

On engine driven pumps, reduce the throttle speed slowly and allow the engine to idle briefly before stopping.



IF THE 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 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. 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.



## TROUBLESHOOTING – SECTION D

Review all WARNINGS in Section A.



### BEFORE ATTEMPTING TO OPEN OR SERVICE THE PUMP:

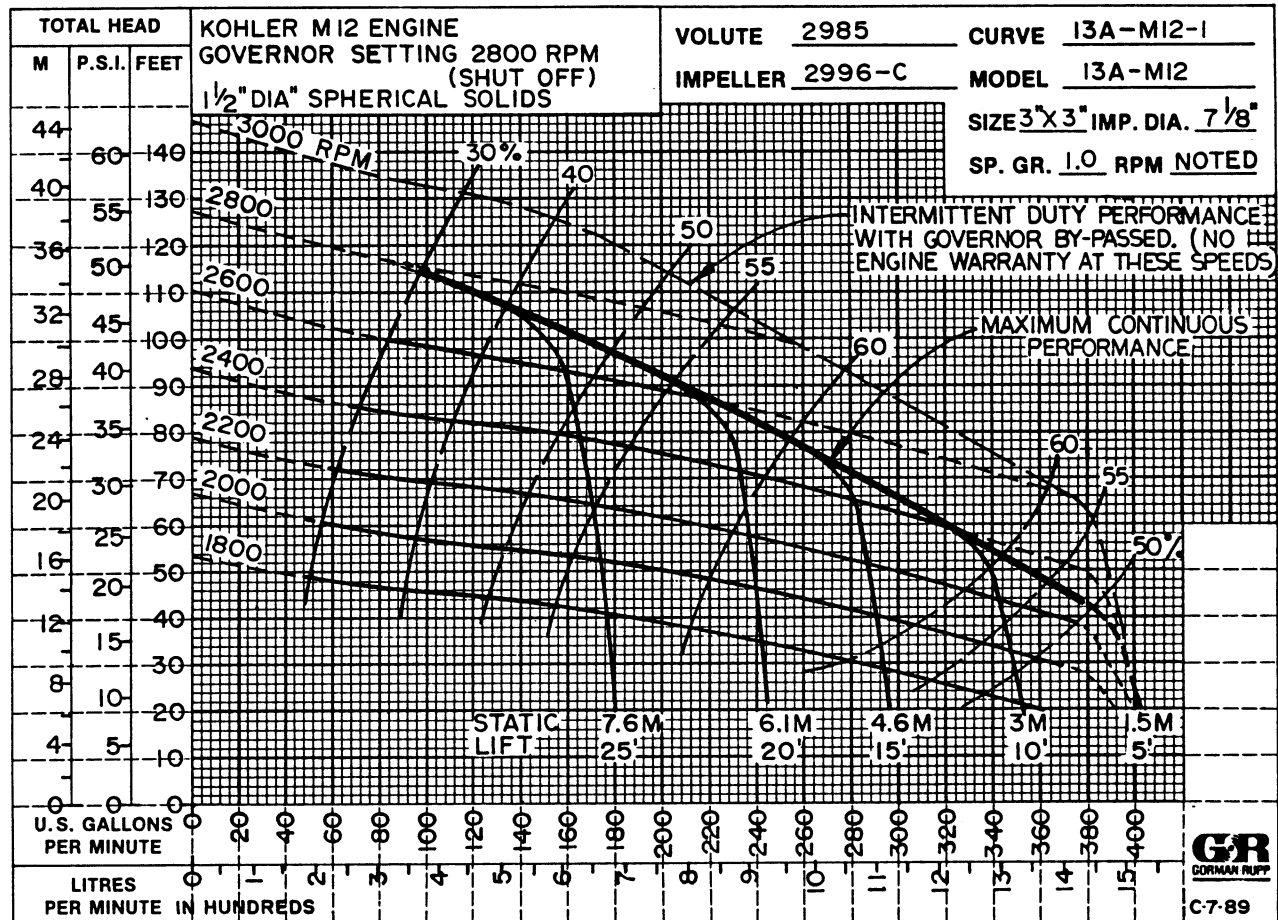
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6. VENT THE PUMP SLOWLY AND CAUTIOUSLY.
7. DRAIN THE PUMP.

TROUBLE	POSSIBLE CAUSE	PROBABLE REMEDY
PUMP FAILS TO PRIME	<p>Not enough liquid in casing.</p> <p>Suction check valve contaminated or damaged.</p> <p>Air leak in suction line.</p> <p>Lining of suction hose collapsed.</p> <p>Leaking or worn seal or pump gasket.</p> <p>Suction check valve or foot valve clogged or binding.</p> <p>Pump speed too slow.</p> <p>Suction lift or discharge head too high.</p> <p>Strainer clogged.</p>	<p>Add liquid to casing. See <b>PRIMING</b>.</p> <p>Clean or replace check valve.</p> <p>Correct leak.</p> <p>Replace suction hose.</p> <p>Check pump vacuum. Replace leaking or worn seal or gasket.</p> <p>Clean valve.</p> <p>Check engine output; consult engine operation manual.</p> <p>Check piping installation and install bypass line if needed. See <b>INSTALLATION</b>.</p> <p>Check strainer and clean if necessary.</p>
PUMP STOPS OR FAILS TO DELIVER RATED FLOW OR PRESSURE	<p>Air leak in suction line.</p> <p>Lining of suction hose collapsed.</p> <p>Leaking or worn seal or pump gasket.</p> <p>Suction intake not submerged at proper level or sump too small.</p>	<p>Correct leak.</p> <p>Replace suction hose.</p> <p>Check pump vacuum. Replace leaking or worn seal or gasket.</p> <p>Check installation and correct submergence as needed.</p>

TROUBLE	POSSIBLE CAUSE	PROBABLE REMEDY
PUMP STOPS OR FAILS TO DELIVER RATED FLOW OR PRESSURE (cont.)	<p>Impeller or other wearing parts worn or damaged.</p> <p>Strainer clogged.</p> <p>Impeller clogged.</p> <p>Suction lift or discharge head too high.</p> <p>Pump speed too slow.</p>	<p>Replace worn or damaged parts. Check that impeller is properly centered and rotates freely.</p> <p>Check strainer and clean if necessary.</p> <p>Free impeller of debris.</p> <p>Check piping installation and install bypass line if needed. See <b>INSTALLATION</b>.</p> <p>Check engine output; consult engine operation manual.</p>
PUMP REQUIRES TOO MUCH POWER	<p>Pump speed too high.</p> <p>Discharge head too low.</p> <p>Liquid solution too thick.</p>	<p>Check driver output; check that sheaves or couplings are correctly sized.</p> <p>Adjust discharge valve.</p> <p>Dilute if possible.</p>
PUMP CLOGS FREQUENTLY	<p>Discharge flow too slow.</p> <p>Suction check valve or foot valve clogged or binding.</p> <p>Discharge line clogged or restricted; hose kinked.</p>	<p>Open discharge valve fully to increase flow rate, and run engine at maximum governed speed.</p> <p>Clean valve.</p> <p>Check discharge lines; straighten hose.</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>

## 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 MODELS 13A2-M12 AND 13A2-M12 S/G

\* Based on 70° F (21° C) clear water at sea level with minimum suction lift. Since pump installations are seldom identical, your performance may be difference 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.



**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 PUMP IS 2800 RPM.**

## SECTION DRAWING

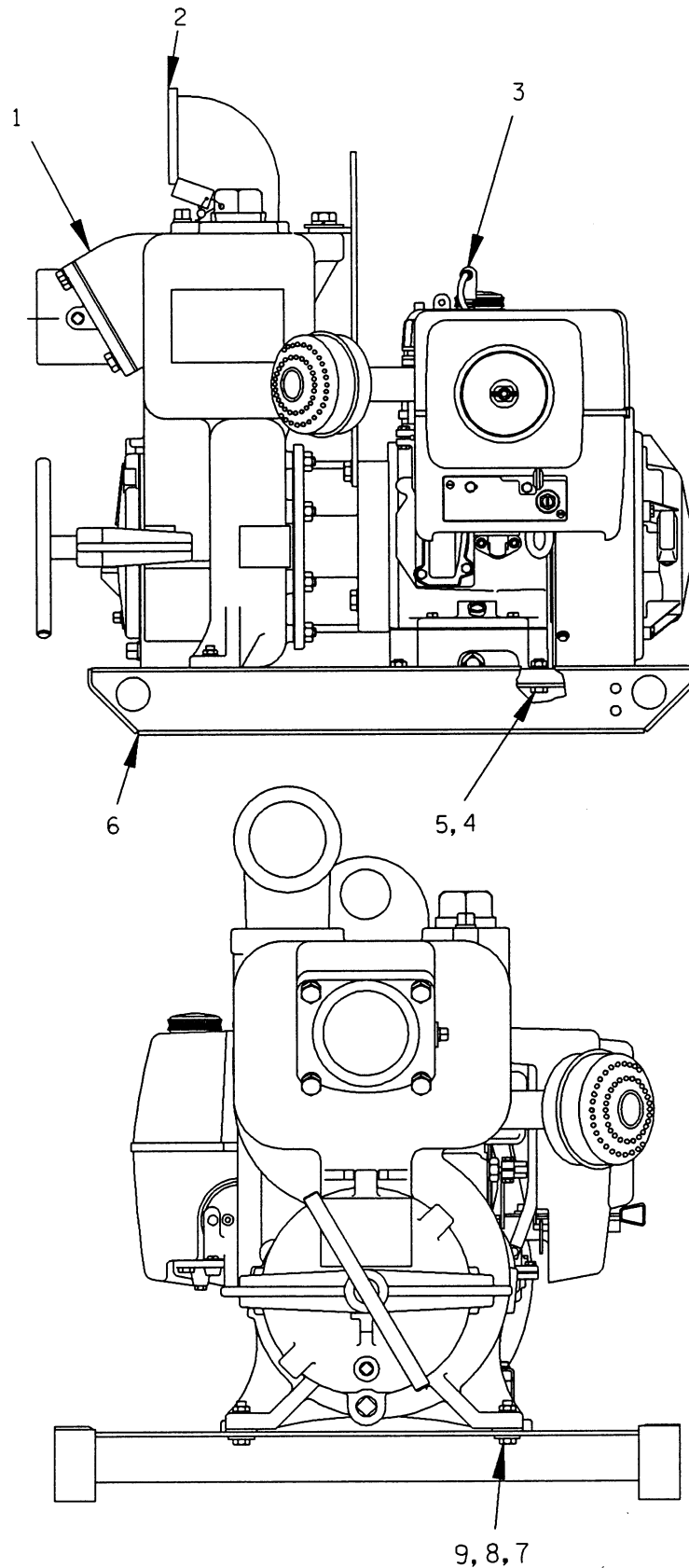


Figure 1. Pump Model 13A2-M12

**PARTS LIST**  
**Pump Model 13A2-M12**  
 (From S/N 943830 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	MAT'L CODE	QTY
1	PUMP END ASSY	13A2	-----	1
2	STREET ELBOW	RS48	11990	1
3	KOHLER M12 ENGINE	29127-122	-----	1
4	HEX HD CAPSCREW	B0605	15991	4
5	HEX NUT W/FLANGE	21765-314	-----	4
6	COMBINATION BASE	41566-097	24150	1
7	HEX HD CAPSCREW	B0606	15991	2
8	FLAT WASHER	K06	15991	2
9	HEX NUT W/FLANGE	21765-314	-----	2
NOT SHOWN:				
	WARNING DECAL	2613-FE	-----	1
OPTIONAL:				
	WHEEL KIT	GRP30-03B	-----	1

\* INDICATES PARTS RECOMMENDED FOR STOCK

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

CANADIAN SERIAL NO. .... AND UP

## SECTION DRAWING

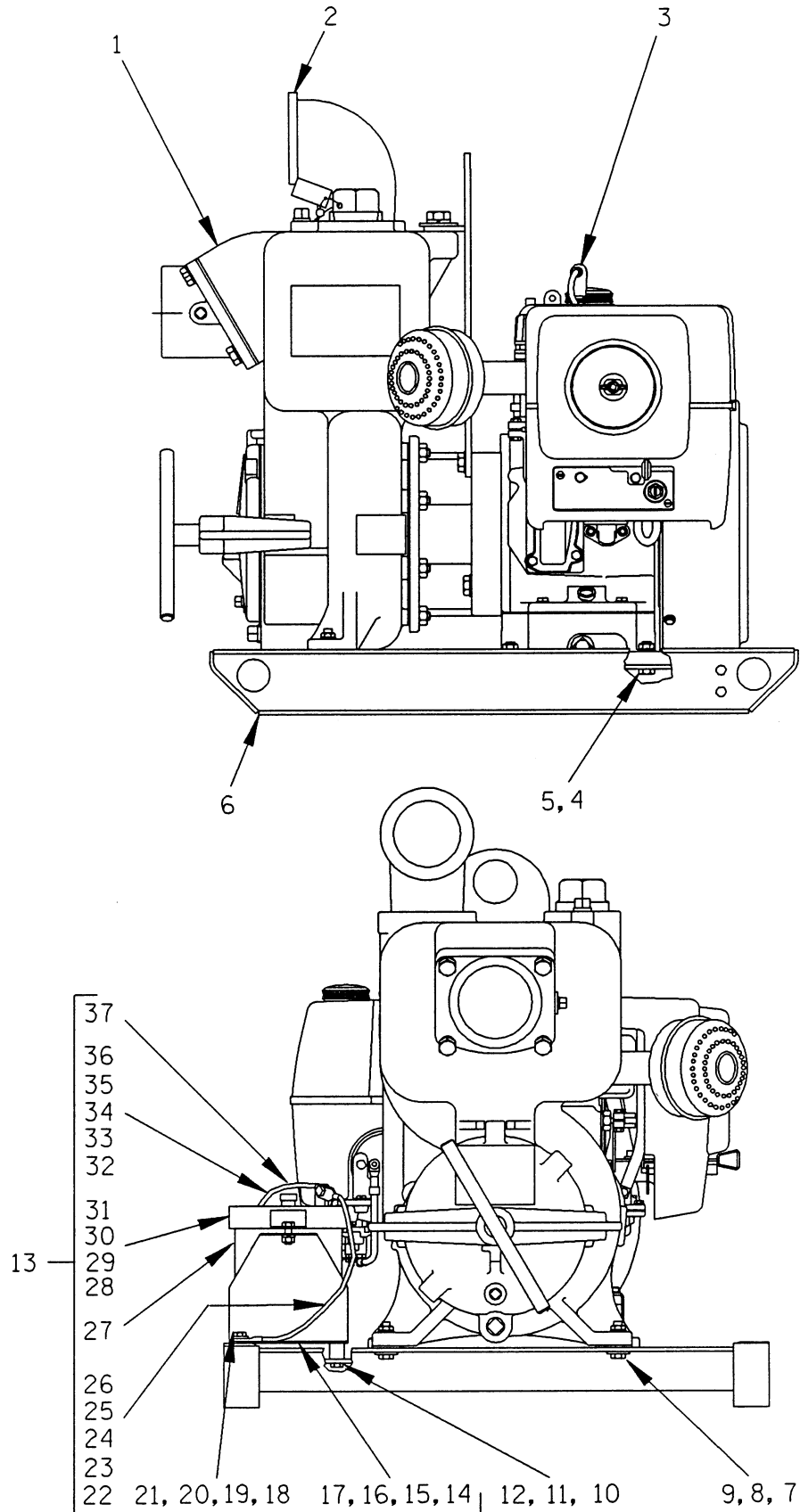


Figure 2. Pump Model 13A2-M12 S/G



# **PARTS LIST** **Pump Model 13A2-M12 S/G**

ITEM NO.	PART NAME	PART NUMBER	MAT'L CODE	QTY	ITEM NO.	PART NAME	PART NUMBER	MAT'L CODE	QTY
1	PUMP END ASSY	13A2	-----	1	23	-HEX HD CAPSCREW	B0403	15991	1
2	STREET ELBOW	RS48	11990	1	24	-HEX NUT	D04	15991	1
3	KOHLER M12 ENGINE	29127-123	-----	1	25	-LOCKWASHER	J04	15991	1
4	HEX HD CAPSCREW	B0605	15991	4	26	-FLAT WASHER	K04	15991	1
5	HEX NUT W/FLANGE	21765-314	-----	4	27 *	-BATTERY	SEE OPTIONS LIST		1
6	COMBINATION BASE	41566-097	24150	1	28	-BATTERY BOX COVER	11870	24000	1
7	HEX HD CAPSCREW	B0606	15991	2	29	-HEX HD CAPSCREW	B0503	15991	2
8	FLAT WASHER	K06	15991	2	30	-HEX NUT	D05	15991	2
9	HEX NUT W/FLANGE	21765-314	-----	2	31	-LOCKWASHER	J05	15991	2
10	HEX HD CAPSCREW	B0506	15991	1	32	-HEX HD CAPSCREW	B0503	15991	1
11	SPACER	1737-E	15070	1	33	-HEX NUT	D05	15991	1
12	HEX NUT W/FLANGE	21765-312	-----	1	34	-LOCKWASHER	J05	15991	1
13	BATTERY BOX ASSY	GRP40-05	-----	1	35	-FLAT WASHER	K05	15991	1
14	-BATTERY BOX	11281	24000	1	36	-BATTERY TAG	38818-680	-----	1
15	-HEX HD CAPSCREW	B0503	15991	1	37 *	POS CABLE ASSY	5795-AS	24040	1
16	-HEX NUT	D05	15991	1	NOT SHOWN:				
17	-LOCKWASHER	J05	15991	1		WARNING DECAL	2613-FE	-----	1
18	-HEX HD CAPSCREW	B0504	15991	1	OPTIONAL:				
19	-HEX NUT	D05	15991	1		12V BATTERY	S1680	-----	1
20	-LOCKWASHER	J05	15991	1		WHEEL KIT	GRP30-03B	-----	1
21	-FLAT WASHER	K05	15991	1					
22	-CABLE ASSY	5795-AS	24040	1					

\* INDICATES PARTS RECOMMENDED FOR STOCK

## SECTION DRAWING

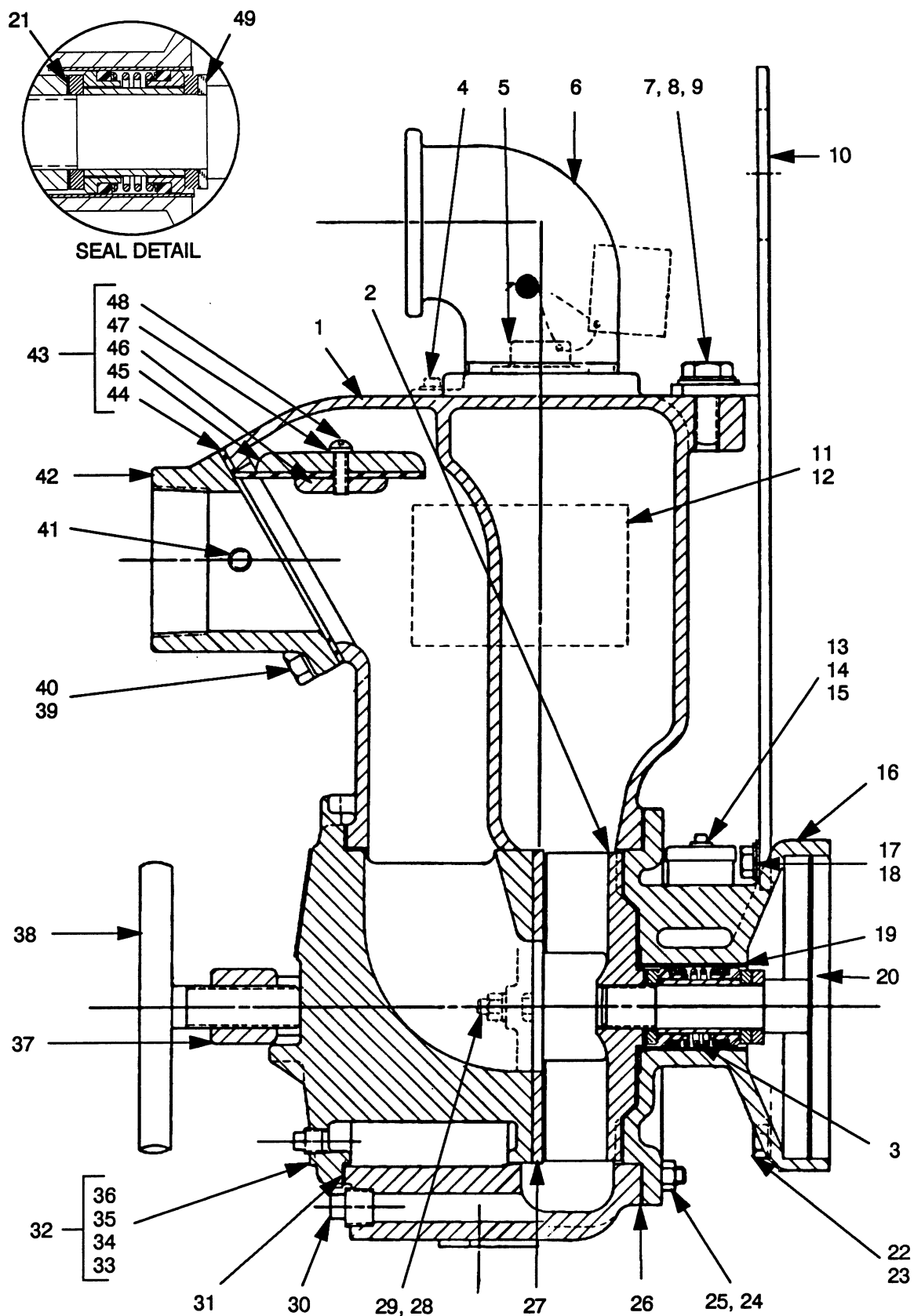


Figure 3. Pump End Assembly 13A2-(M12/M12 S/G)

# **PARTS LIST** **Pump End Assembly 13A2-(M12/M12 S/G)**

ITEM NO.	PART NAME	PART NUMBER	MAT'L CODE	QTY	ITEM NO.	PART NAME	PART NUMBER	MAT'L CODE	QTY
1	PUMP CASING	2985	10010	1	28	HEX NUT	D06	15991	2
2 *	IMPELLER	2996-C	11010	1	29	LOCKWASHER	J06	15991	2
3 *	SEAL ASSY	GS1000	-----	1	30	CASING DRAIN PLUG	P08	11990	1
4	ACCESSORY PLUG	P04	11990	1	31 *	COVER PLATE GSKT	2985-G	19090	1
5	FILL PLUG ASSY	48271-069	-----	1	32	COVER PLATE ASSY	42111-921	-----	1
6	STREET ELBOW	RS48	11990	1	33	-BACK COVER PLATE	NOT AVAILABLE		1
7	HEX HD CAPSCREW	B1004	15991	1	34	-WARNING PLATE	2613-EV	13990	1
8	FLAT WASHER	K10	15991	1	35	-DRIVE SCREW	BM#04-03	15990	4
9	LOCKWASHER	J10	15991	1	36	-PIPE PLUG	P04	11990	1
10	HOISTING BAIL	44711-011	24150	1	37	CVR CLAMP BAR	2987	11010	1
11	NAME PLATE	38818-023	13990	1	38	CLAMP BAR SCREW	2536	24000	1
12	DRIVE SCREW	BM#04-03	15990	4	39	HEX HD CAPSCREW	B0805	15991	4
13 *	GREASE CUP	S36	-----	1	40	LOCKWASHER	J08	15991	4
14	PIPE NIPPLE	T0408	15070	1	41	PIPE PLUG	P04	11990	1
15	PIPE COUPLING	AE04	11990	1	42	SUCTION FLANGE	2943	10010	1
16	INTERMEDIATE	5-B	10010	1	43	CHECK VALVE ASSY	1348	-----	1
17	HEX HD CAPSCREW	B0709	15991	2	44 *	-CHECK VALVE & GSKT	1348-G	19070	1
18	FLAT WASHER	K07	15991	2	45 *	-VALVE WEIGHT	18-B	10010	1
19 *	SEAL LINER	83	14080	REF	46 *	-VALVE WEIGHT	2944	10010	1
20	ENGINE CRANKSHAFT	NOT AVAILABLE		REF	47	-LOCKWASHER	J05	17090	1
21 *	IMP ADJ SHIM SET	2-X	17090	REF	48	-RD HD MACH SCREW	X0504	17090	1
22	HEX HD CAPSCREW	B0708	15991	2	49	SEAL RING	2-A	15020	1
23	LOCKWASHER	J07	15991	4	NOT SHOWN:				
24	STUD	C0606	15991	8		STRAINER	4917	24001	1
25	HEX NUT	D06	15991	8		SUCTION STICKER	6588-AG	-----	1
26 *	CASING GSKT SET	3-G	18000	1		DISCHARGE STICKER	6588-BJ	-----	1
27 *	WEAR PLATE ASSY	2634-A	15990	1					

\* INDICATES PARTS RECOMMENDED FOR STOCK

## PUMP AND SEAL DISASSEMBLY AND REASSEMBLY

Review all warnings in Section A.

Follow the instructions on all tags, label 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 are keyed to the sectional views (see Figures 1, 2 and 3) and the accompanying parts lists.

Before attempting to service the pump, shut down the engine and remove the spark plug wire to ensure that it will remain inoperative. Close all valves in the suction and discharge lines.

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



### BEFORE ATTEMPTING TO OPEN OR SERVICE THE PUMP:

1. FAMILIARIZE YOURSELF WITH THIS MANUAL.
2. SHUT DOWN THE ENGINE AND DISCONNECT THE SPARK PLUG WIRE TO ENSURE THAT THE PUMP WILL REMAIN INOPERATIVE.
3. ALLOW THE PUMP TO COOL IF OVERHEATED.
4. CHECK THE TEMPERATURE BEFORE OPENING ANY COVERS, PLATES, OR PLUGS.
5. CLOSE THE SUCTION AND DISCHARGE VALVES.
6. VENT THE PUMP SLOWLY AND CAUTIOUSLY.
7. DRAIN THE PUMP.



USE LIFTING AND MOVING EQUIPMENT IN GOOD REPAIR AND WITH ADEQUATE CAPACITY TO PREVENT INJURIES TO PERSONNEL OR

DAMAGE TO EQUIPMENT. THE BAIL IS INTENDED FOR USE IN LIFTING THE PUMP ASSEMBLY ONLY. SUCTION AND DISCHARGE HOSES AND PIPING MUST BE REMOVED FROM THE PUMP BEFORE LIFTING.

### Suction Check Valve Disassembly

(Figure 3)

Before attempting to service the pump, remove the pump casing drain plug (30) and drain the pump. Clean and reinstall the drain plug.

To service the suction check valve, remove the suction piping. Remove the hardware (39 and 40) securing the suction flange (42) to the pump casing (1). Pull the check valve assembly (43) from the suction port.

Remove the hardware (47 and 48) securing the check valve weights (45 and 46) to the check valve (44).

If no further disassembly is required, see **Suction Check Valve Installation**.

### Back Cover Removal

(Figure 3)

The wear plate assembly (27) can be serviced after the back cover assembly (32) has been removed.

Loosen the clamp bar screw (38) and remove the clamp bar (37) securing the back cover to the casing. Pull the back cover and assembled wear plate from the pump casing. Inspect the wear plate and if replacement is required, remove the hardware (28 and 29) securing it to the back cover.

Remove the cover plate gasket (31) and clean the mating surfaces.

### Pump Casing Removal

(Figure 3)

To service the impeller (2) or seal assembly (3), disconnect the discharge piping. See Figure 1 or 2 and remove the hardware securing the pump casing to the base.

Disengage the hardware (7, 8 and 9) securing the pump casing to the hoisting bail (10). Support the

pump casing using a suitable hoist and sling, and remove the nuts (25) securing the pump casing to the intermediate (16). Separate the parts by pulling the casing straight away from the intermediate. If shims have been used under the mounting feet to level the pump casing, tie and tag these shims.

Remove the casing gasket set (26). Record the thickness of the gaskets for future reference. Clean the mating surfaces of the intermediate and pump casing.

### Impeller Removal

(Figure 3)

Before removing the impeller, turn the cross arm on the automatic grease cup (13) clockwise until it rest against the cover (see Figure 5). This will prevent the grease from escaping when the impeller is removed.

To loosen the impeller (2), tap the vanes of the impeller in a counterclockwise direction (when facing the impeller) with a block of wood or a soft-faced mallet. Unscrew the impeller and replace it if cracked or badly worn. Use caution when removing the impeller; tension on the seal spring will be released as the impeller is unscrewed.

Slide the impeller adjusting shims (21) off the impeller shaft. Tie and tag the shims or measure and record their thickness for ease of reassembly.

### Seal Removal and Disassembly

(Figure 3 and 4)

To remove the seal assembly (3), remove the grease cup and piping (13, 14 and 15) from the intermediate.

Carefully remove the outer stationary and rotating seal elements, packing ring, stationary washer, seal spring, and spacer sleeve from the intermediate. Using a stiff wire with a hooked end, remove the in-board stationary washer, packing ring, stationary and rotating seal elements and seal ring (49).

### NOTE

*The seal assembly may also be removed by disengaging the hardware (17, 18, 22 and 23) securing the intermediate and hoisting bail to the engine and sliding the intermediate and seal assembly off the*

*shaft as a single unit. Use a dowel of suitable size to press the remaining seal components from the intermediate.*

---

Inspect the seal liner (19) for wear or grooves which could cause leakage or damage to the seal packing rings. The seal liner is a press fit in the intermediate and does not normally require replacement. If replacement is necessary, disengage the hardware (17, 18, 22 and 23) and separate the hoisting bail and intermediate from the engine.

If no further disassembly is required, see **Seal Reassembly and Installation**.

### Seal Reassembly and Installation

(Figures 3 and 4)

Before installing the seal, inspect the bore of the seal liner (19) for wear or grooves which might cause leakage or damage to the seal packing rings. If the seal liner requires replacement, remove the intermediate as described in **Seal Removal And Disassembly**, and position it on the bed of an arbor (or hydraulic) press. Use a new sleeve to force the old one out. After the new liner is properly installed, a 1/4-inch (6,4 mm) diameter hole must be drilled through it to permit the flow of lubricant to the seal assembly. **Be careful** to center the drill in the threaded grease piping hole and not damage the threads. Deburr the hole from the inside of the seal liner after drilling.

Inspect the engine crankshaft (20) for damage. Small scratches or nicks may be removed with a fine file. If excessive wear exists, the shaft will have to be replaced in the engine. (Refer to the engine service manual).

Position the intermediate against the engine, install the hoisting bail (10) and secure both parts in place using the attaching hardware (17, 18, 22 and 23).

Clean the seal cavity and shaft 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 EXCESSIVE HEAT, SPARKS, AND FLAME. READ AND FOLLOW ALL PRECAUTIONS PRINTED ON SOLVENT CONTAINERS.**

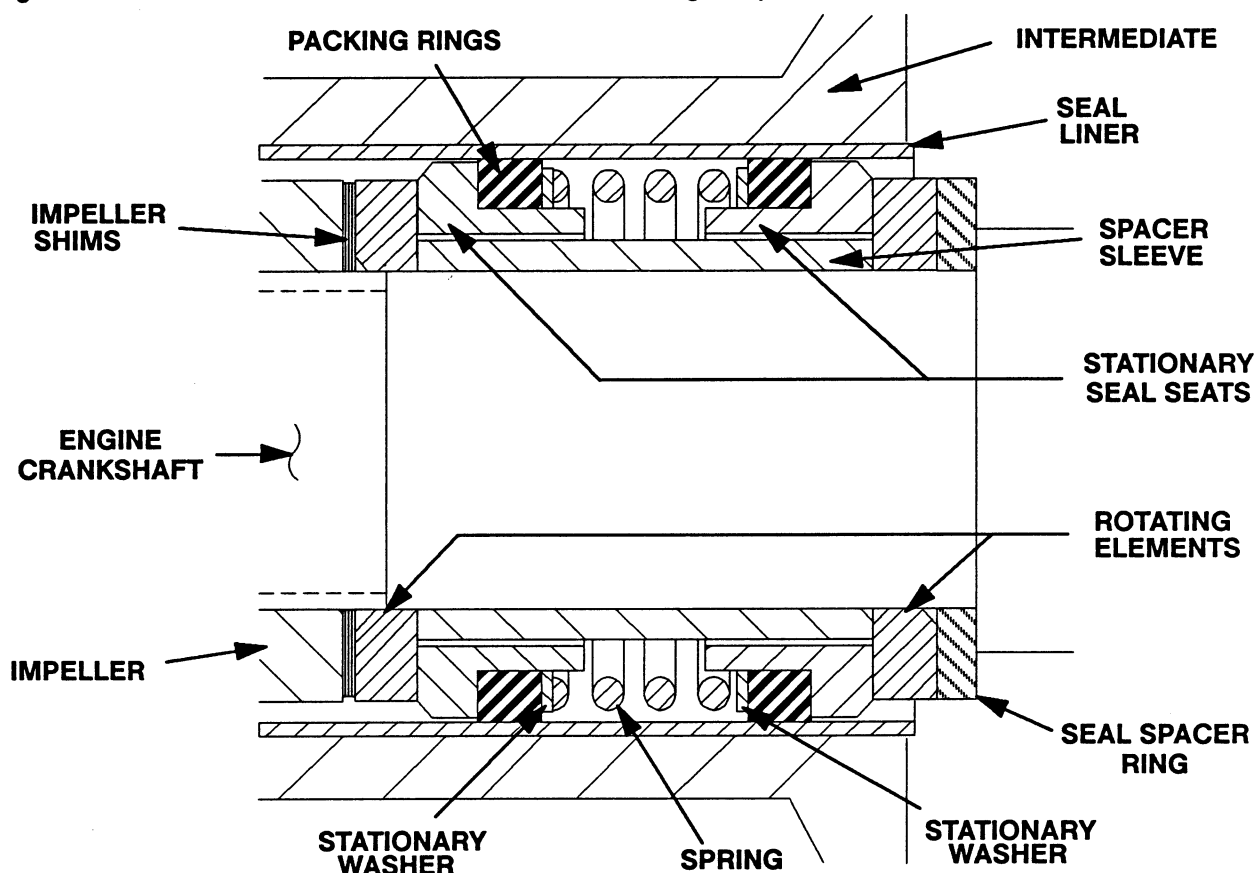
The seal is not normally reused because wear patterns on the finished faces cannot be realigned during reassembly. This could result in premature failure. If necessary to reuse an old seal in an emergency, **carefully** wash all metallic parts in **fresh** cleaning solvent and allow to dry thoroughly.

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.

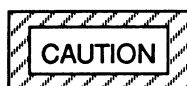
Inspect the seal components for wear, scoring, grooves, and other damage that might cause leakage. Clean and polish the seal spacer sleeve, or replace it if there are nicks or cuts on either end. If any components are worn, replace the complete seal; **never mix old and new seal parts.**

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. GS1000 Seal Assembly**



THIS SEAL IS NOT DESIGNED FOR OPERATION AT TEMPERATURES ABOVE 110°F (43°C). DO NOT USE AT HIGHER OPERATING TEMPERATURES.

Slide the seal spacer ring (49) onto the shaft until it seats squarely against the shaft shoulder. Position the inboard rotating element on the shaft with the chamfered side **toward** the seal spacer ring and slide it on until fully seated.

Subassemble the inboard stationary seat, packing ring and stationary washer. Press this unit into the lubricated seal liner until the seal faces contact. A push tube cut from a length of plastic pipe would aid this installation. The I.D. of the tube should be approximately the same size as the I.D. of the seal spring.

Install the spacer sleeve and seal spring.

Subassemble the outboard stationary seat, packing ring and stationary washer. Press this unit into the lubricated seal liner. Install the outboard rotating element with the chamfered side **toward the impeller**.

After the impeller and grease cup have been installed, lubricate the seal as indicated in **LUBRICATION**, Section E.

### Impeller Installation And Adjustment

(Figure 3)

Inspect the impeller, and replace it if cracked or badly worn. Install the same thickness of impeller shims (21) as previously removed, and screw the impeller onto the shaft until tight.

A clearance of .020 to .040 inch (0,51 to 1,02 mm) between the impeller and the intermediate is necessary for maximum pump efficiency. Measure this clearance and add or remove impeller shims until this clearance is reached.

### Pump Casing Installation

(Figure 3)

Install the same thickness of pump casing gaskets (31) as previously removed and secure the pump casing to the intermediate with the nuts (25). **Do not** fully tighten the nuts at this time.

A clearance of .008 to .015 inch (0,20 to 0,38 mm) between the impeller and the wear plate is also recommended for maximum pump efficiency. Install the back cover and set this clearance by adding or removing gaskets in the pump casing gasket set until the impeller binds against the wear plate when the

shaft is turned. After the impeller binds add .015 inch (0,38 mm) of gaskets.

### NOTE

*An alternate method of adjusting this clearance is to reach through the discharge port with a feeler gauge and measure the gap. Add or subtract pump casing gaskets accordingly.*

After the face clearance has been set, tighten the hardware securing the pump casing to the intermediate. Install the grease cup (13) and the piping (14, and 15).

Install the hardware (7, 8 and 9) securing the pump casing to the hoisting bail (10). Secure the pump casing to the base with the previously removed hardware. Be sure to reinstall any leveling shims used under the mounting feet of the pump casing.

### Back Cover Installation

(Figure 3)

Inspect the wear plate (27) and replace it if badly worn or grooved. To remove the wear plate, disengage the hardware (28 and 29).

Clean any scale or debris from the back cover shoulder and pump casing which might prevent a good seal.

Replace the back cover gasket (31) and slide the back cover assembly (32) into the pump casing. Be sure the wear plate does not bind against the pump casing.

### NOTE

*Apply a film of 'Never-Seez' or equivalent compound on the back cover shoulder or any surface which contacts the pump casing to ease future disassembly and to reduce rust and scale build up.*

Secure the back cover assembly with the cover clamp bar (37) and cover clamp bar screw (38). **Do not** over tighten the clamp bar screw; it should be just tight enough to ensure a good seal at the back cover shoulder.

### Suction Check Valve Installation

(Figure 3)

Inspect the check valve components and replace as required. Subassemble the check valve weights (45 and 46) and check valve gasket (44) with the hardware (47 and 48).

Position the check valve assembly (43) in the suction port with the large weight (45) facing toward the inside of the pump casing. Install the suction flange (42) and secure with the hardware (39 and 40). Check the operation of the check valve to ensure proper seating and free movement.

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

Fill the pump casing with clean liquid. Reinstall the fill plug (5) and tighten it.

Refer to **OPERATION**, Section C, before putting the pump back into service.

## LUBRICATION

### Seal Assembly

(Figure 3)

### Final Pump Assembly

(Figure 1 or Figure 2)

**Be sure** the pump and engine are securely mounted to the base.

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

Fill the grease cup (13) through the grease fitting with No. 2 lithium base grease until grease escapes from the relief hole. Turn the grease cup arm counter-clockwise until it is at the top of the stem; this will release the spring to apply grease to the seal (see Figure 5).

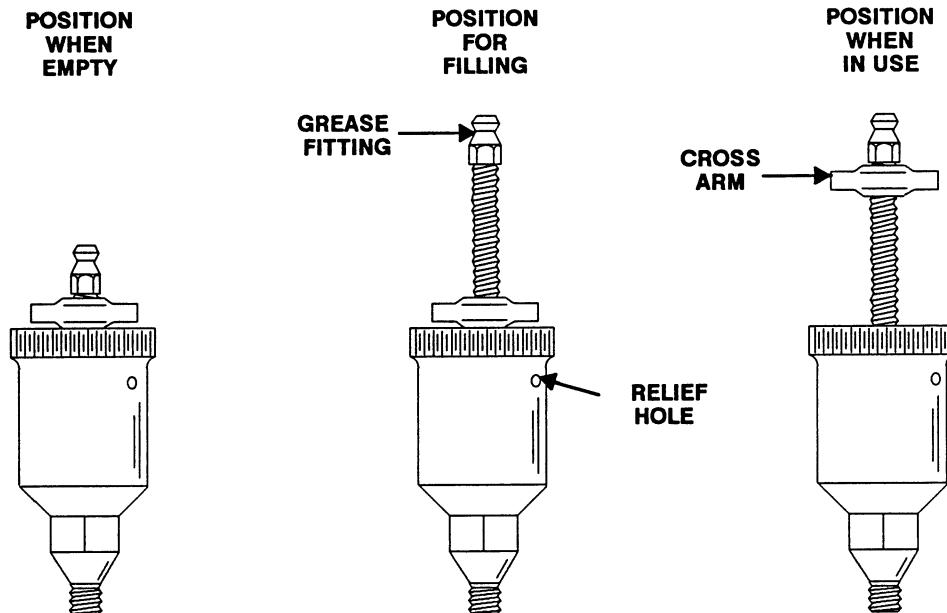


Figure 5. Automatic Lubricating Grease Cup

### Engine

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





**For U.S. and International Warranty Information,  
Please Visit [www.grpumps.com/warranty](http://www.grpumps.com/warranty)**

**or call:**

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**International: +1-419-755-1352**

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**or call:**

**519-631-2870**

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