

**8" Thru 36" 8211 And
10" Thru 30" 8312
Vertical Propeller Pumps**

**Installation,
Operation and
Maintenance**

PUMP IDENTIFICATION

Carefully record all of the following data from your pump nameplate. It will aid in obtaining the correct replacement parts for your pump. In addition to the nameplate, the pump serial number is also stamped on the discharge flange.

Pump

Serial Number _____
Model Number _____
Pump Size _____
Number of Stages _____
GPM _____
Head (feet) _____

Motor

Manufacturer _____
Horsepower _____
Serial Number _____
Motor Frame _____
Full Load Speed _____
Full Load Amps _____
Phase/Hz/Volts _____/_____/_____
Date Placed In Service _____

Gear

Manufacturer _____
Serial Number _____
Model Number _____
Ratio _____
Rotation Figure _____

Engine

Manufacturer _____
Serial Number _____
Model Number _____
Horsepower _____
Speed (RPM) _____
Rotation _____

Loss or Damage in Transit

Immediately upon receipt, a complete inspection and accounting against the packing list should be made of all major components, and accompanying boxes or pallets. All material is shipped F.O.B. our factory, or our vendor's shipping point unless optional contractual arrangements are made. Under these terms, any claims for loss or damage in transit should be immediately directed to the delivering freight carrier. Fairbanks Morse will assist the customer in receiving fair compensation, but assumes no responsibility to mediate such claims. This policy includes shipments wherein Fairbanks Morse pays freight costs as part of the sales terms.

INTRODUCTION

Congratulations! You are the owner of the finest pump commercially available. If you give it the proper care as outlined and recommended by this manual, it will provide you with reliable service and long life.

IMPORTANT

- **Read this complete manual and manuals for all component equipment before assembly or installation is started. It contains information which is the result of engineering and research efforts. It is designed to supply adequate instructions for the installation, operation and maintenance of your pump. Failure or neglect to properly install, operate or maintain your pump may result in personal injury, property damage or unnecessary damage to the pump.**

This manual applies to the pump installation, operation and maintenance. They are intended to be general and not specific. If your operating conditions ever change, always refer to the factory for reapplication. Always refer to the manuals provided by manufacturers of the accessory equipment for their separate instructions.

Variations exist in both the equipment used with these pumps and in the particular installation of the pump and driver. Therefore, specific operating instructions are not within the scope of this manual. The manual contains general rules for installation,

operation and maintenance of the pump. If there are questions regarding the pump or its application which are not covered in this manual, please contact the factory as follows:

Fairbanks Morse Pump Corporation
3601 Fairbanks Avenue
P.O. Box 6999
Kansas City, KS 66106-0999
(913) 371-5000

Fairbanks Morse Pump Corporation
2790 South Railroad
Fresno, CA 93725
(209) 266-0828

To obtain additional data on hydraulics and pump selection and operation, we suggest you purchase both of the following reference books:

1. Fairbanks Morse "Hydraulic Handbook" available from the Kansas City factory.

Fairbanks Morse Pump Corporation
3601 Fairbanks Avenue
P.O. Box 6999
Kansas City, KS 66106-0999

2. Hydraulic Institute Standards
Hydraulic Institute
9 Sylvan Way
Parsippany, NJ 07054-3802



Turbine And Propeller Pump Pre-Start-Up and Start-Up Check List

Customer _____

Pump Serial Number _____

Project Name _____

Pump Model Number _____

Note: this is a generic form and all questions may not apply. Items listed below do not cover all potential problems that may arise during installation and start-up. If you have any questions please consult your O & M manual or consult the manufacturer.

Procedure	Yes	No	N/A	Comments
1. Shipment				
Was there any damage in transit?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Were all items received?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
2. Storage				
Has equipment been protected from inclement weather?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Was equipment subject to flooding?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Has motor been protected from moisture?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
3. Installation				
Were retaining fasteners, used in shipping, removed prior to installation?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
For oil lube pumps, were discharge case plugs removed?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Is grouting under base properly compacted?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Is grouting of the non-shrink type?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Have proper anchor bolts been used?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Have all bolts been properly tightened?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Has discharge piping been checked for pipe strain?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Are lube lines and seal water lines properly installed?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
- Water flush pumps - water flush line	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
- Oil lube pumps - oil reservoir line	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
- Mechanical Seal - vent line	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
- 400 PSI packing box - bypass line	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Are accessory items, RTD's, bearing temperature detectors, vibration sensors, etc. mounted and properly installed?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Are lube lines purged of air and lubricant added?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Has driver been properly lubricated?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Are all safety guards in place?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Have impellers been checked for proper axial running clearance?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
4. Rotation				
Has the rotation of the drives been checked for correctness?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Has the shaft/coupling been rotated to assure free rotation of pump and motor?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
5. System				
Has the system been flushed and checked to insure that it is free of foreign matter which could be damaging to the pump?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Is liquid available to the pump?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Has assurance been obtained from responsible parties that all piping is secure and that the routing of flow has been established and is correct?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
6. Start-Up				
Has flow been established? Flow rate: _____ GPM	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Have guage readings been taken? Discharge pressure: _____ PSI	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Has packing been adjusted to insure proper lubrication of packing?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
If pumps are equipped with water flush or seal water piping, is pressure set to at least 10 psi above pump discharge pressure?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Is excessive vibration present?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
What is recorded line voltage? _____ volts	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
What is motor amp draw on each leg? 1.) _____ 2.) _____ 3.) _____	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
7. Safety				
Have all safety warning labels been read and understood?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

Warranty

v

DELIVERY: Buyer agrees to inspect all deliveries immediately. Any claim for shortages must be made in writing within ten (10) days after Buyer receives a shipment, and if not made, shall be deemed waived. Any other claim by Buyer, other than claims under the warranty stated in Paragraph 13, shall be made within thirty (30) days after Buyer receives shipment, and if not made shall be deemed waived. Seller is not responsible for loss or damage in transit after having received an "In Good Order" receipt from the carrier. Buyer will make all claims for loss or damage in transit against the carrier.

Buyer is fully responsible for (including payment of the cost of) installation and start-up of all equipment sold under the Order.

PATENT INFRINGEMENT: Seller will defend Buyer and the user of the equipment against any claim that any equipment and parts of Seller's manufacture furnished under the Order infringe upon any published United States patent, and Seller will pay all damages and costs awarded by a court of competent jurisdiction with respect to such claim. The Buyer or user must promptly notify Seller of any such claim, and cooperate fully with Seller in the defense of such claim, or Seller will have no duty under this paragraph. Buyer will defend and indemnify Seller against patent infringement claims relating to equipment and parts that are not manufactured by Seller to the same extent as Seller agrees to defend and indemnify Buyer with respect to patent infringement claims relating to equipment and parts of Seller's manufacture.

WARRANTY: Seller warrants equipment (and its component parts) of its own manufacture against defects in materials and workmanship under normal use and service for one (1) year from the date of installation or start-up, or for eighteen (18) months after the date of shipment, whichever occurs first. Seller does not warrant accessories or components that are not manufactured by Seller however, to the extent possible, Seller agrees to assign to Buyer its rights under the original manufacturer's warranty, without recourse to Seller. Buyer must give Seller notice in writing of any alleged defect covered by this warranty (together with all identifying details, including the serial number, the type of equipment, and the date of purchase) within thirty (30) days of the discovery of such defect during the warranty period. No claim made more than 30 days after the expiration of the warranty period shall be valid.

Guarantees of performance and warranties are based on the use of original equipment manufactured (OEM) replacement parts. Fairbanks Morse Pump Corporation assumes no responsibility or liability if alterations, non-authorized design modifications and/or non-OEM replacement parts are incorporated.

If requested by Seller, any equipment (or its component parts) must be promptly returned to Seller prior to any attempted repair, or sent to an authorized service station designated by Seller, and Buyer shall prepay all shipping expenses. Seller shall not be liable for any loss or damage to goods in transit, nor will any warranty claim be valid unless the returned goods are received intact and undamaged as a result of shipment. Repaired or replaced material returned to customer will be shipped F.O.B., Seller's factory. Seller will not give Buyer credit for parts or equipment returned to Seller, and will not accept delivery of any such parts or equipment, unless Buyer has obtained Seller's approval in writing.

The warranty extends to repaired or replaced parts of Seller's manufacture for ninety (90) days or for the remainder of the original warranty period applicable to the equipment or parts being repaired or replaced. This warranty applies to the repaired or replaced part and is not extended to the product or any other component of the product being repaired.

Repair parts of its own manufacture sold after the original warranty period are warranted for a period of one (1) year from shipment against defects in materials and workmanship under normal use and service. This warranty applies to the replacement part only and is not extended to the product or any other component of the product being repaired.

Seller may substitute new equipment or improve part(s) of any equipment judged defective without further liability. All repairs or services performed by Seller, which are not covered by this warranty, will be charged in accordance with Seller's standard prices then in effect.

THIS WARRANTY IS THE SOLE WARRANTY OF SELLER AND SELLER HEREBY EXPRESSLY DISCLAIMS AND BUYER WAIVES ALL OTHER WARRANTIES EXPRESSED, IMPLIED IN LAW OR IMPLIED IN FACT, INCLUDING ANY WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Seller's sole obligation under this warranty shall be, at its option, to repair or replace any equipment (or its component parts) which has a defect covered by this warranty, or to refund the purchase price of such equipment or part. Under the terms of this warranty, Seller shall not be liable for (a) consequential, collateral, special or liquidated losses or damages; (b) equipment conditions caused by normal wear and tear, abnormal conditions of use, accident, neglect, or misuse of said equipment; (c) the expense of, and loss or damage caused by, repairs or alterations made by anyone other than the Seller; (d) damage caused by abrasive materials, chemicals, scale deposits, corrosion, lightning, improper voltage, mishandling, or other similar conditions; (e) any loss, damage, or expense relating to or resulting from installation, removal or reinstallation of equipment; (f) any labor costs or charges incurred in repairing or replacing defective equipment or parts, including the cost of reinstalling parts that are repaired or replaced by Seller; (g) any expense of shipment of equipment or repaired or replacement parts; or (h) any other loss, damage or expense of any nature.

This Section 13 shall not apply to any equipment which may be separately covered by one of the following warranties: KC685 5-Year Prorated warranty, KC885 15-Month Prorated Warranty, KC985 9-Month Warranty. All other provisions of KC585 shall remain effective.

CONDITION TO WARRANTY WORK: If Buyer is in default (including, but not limited to, the failure of Buyer to maintain a current account with Seller) under the Order or any other agreement between Buyer and Seller, Buyer's rights under the warranty shall be suspended and the original warranty period will not be extended.

PERFORMANCE: Equipment performance is not warranted or guaranteed unless separately agreed to by Seller in accordance with its guarantee policy. Performance curves and other information submitted to Buyer are approximate and no warranty or guarantee shall be deemed to arise as a result of such submittal. All testing shall be done in accordance with Seller's standard policy.

LIABILITY LIMITATIONS: Under no circumstances shall the Seller have any liability under the Order or otherwise for liquidated damages or for collateral, consequential or special damages or for loss of profits, or for actual losses or for loss of production or progress of construction, regardless of the cause of such damages or losses. In any event, Seller's aggregate total liability under the Order or otherwise shall not exceed the contract price. Buyer agrees to indemnify and hold harmless Seller from all claims by third parties in excess of these limitations.

COMPLIANCE WITH LAW: Since the compliance with the various Federal, State, and Local laws and regulations concerning occupational health and safety and pollution are affected by the use, installation and operation of the equipment and other matters over which Seller has no control, Seller assumes no responsibility for compliance with those laws and regulations, whether by way of indemnity, warranty, or otherwise.

KC585A (03/93)

Safety

Safety should be of utmost importance when in close proximity of this pumping equipment. Before attempting to operate this equipment, you should read this manual in its entirety, taking special notice of all CAUTIONS, WARNINGS and/or DANGER notifications. These warnings apply to pumps supplied by Fairbanks Morse. Refer to the manuals supplied by the driver and control manufacturer for additional warnings before operating this equipment.

The words DANGER, WARNING and CAUTION have different connotations and are generally defined as follows:

DANGER

- **DANGER** indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

WARNING

- **WARNING** indicates a potentially hazardous situation which, if not avoided, will result in serious injury.

CAUTION

- **CAUTION** indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury or may indicate that improper practices will result in equipment malfunction or failure. It may also be used to alert against unsafe practices.

IMPORTANT

- Another notation will appear throughout this manual. **IMPORTANT** indicates the highlight or accent of specific information.

The installation, use and operation of this type of equipment is affected by various Federal, State and Local Laws and the regulations concerning OSHA. Compliance with such laws relating to the proper installation and safe operation of this type of equipment is the responsibility of the equipment Owner and all necessary steps should be taken by the Owner to assure compliance with such laws before operating the equipment.

WARNING

- Do not attempt to service the pump until the electrical power has been disconnected and it has been verified that the pump cannot start. Because many installations utilize automatic starting equipment, the pump unit may start at any time without warning. Proper Precautions should be taken to avoid injury as a result of automatic starting of the equipment.

DANGER

- Do not operate the pump without the protective guards in place over the rotating parts. Exposed rotating parts can catch clothing, fingers, or tools, causing severe injury to personnel. Any operation of this machine without a protective guard can result in severe bodily injury. The responsibility for the installation of protective guards is that of the equipment owner.

DANGER

- This pump is designed for the exclusive use of pumping water. It should not be used for pumping other media unless a specific Purchase/Buyer agreement is negotiated.

WARNING

- Do not attempt to try to clean the pump with bare hands. The pumped material may contain items that may present health hazards such as needles, and other sharp objects. Always wear heavy puncture resistant gloves.

WARNING

- Before attempting to service this pump:

1. Familiarize yourself with this manual.
2. Disconnect or lock out the power source to insure the pump will not start. Confirm power source disconnect with appropriate electrical test equipment.
3. Close the discharge valve.

After the pump has been installed, make certain that the pump and all piping connections are tight and are properly supported prior to start-up and operation.

WARNING

- Certain procedures in disassembly and assembly require parts be heated to high temperatures. Heat resistant gloves must be worn when handling heated parts. Heated parts can cause severe personal injury.

CAUTION

- For pumps used in potable water service, all thread lubrication, grease, cleaning materials and paint must be suitable for potable water.

8211 And 8312 Vertical Propeller Pumps Installation, Operation and Maintenance

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STORAGE OF PUMPS

- If the equipment is not to be immediately installed and operated, THE FOLLOWING INSTRUCTIONS SHOULD BE ADHERED TO AS A MINIMUM.

Consider a unit in storage when:

1. It has been delivered to the jobsite and is awaiting installation.
2. It has been installed but operation is delayed pending completion of plant construction.
3. There are long (30 days or more) periods between operation cycles.
4. The plant (or facility) is shut down.

NOTE: Improper storage could result in product failures or restoration not covered by warranty.

Unassembled Pumps:

1. Store the unassembled components in a clean, dry well-ventilated place free from vibrations, moisture, and temperature variation.
2. Wipe clean all exposed machined surfaces and coat with a heavy layer of grease or other equivalent rust preventative material.
3. Cover the suction and discharge of the pump with cardboard or wood to prevent entry of foreign material or varmits. This also applies to column sections.
4. The enclosing tube, bearings, shaft, and couplings should be stored as components, i.e. shaft with couplings installed on lower ends inserted into enclosing tubes with bearings installed in upper ends. The ends should then be wrapped with heavy plastic or protective material and secured tightly to prevent entry of foreign matter and varmits.

Assembled Pumps:

1. Remove the gland halves, packing and seal water rings from the stuffing box if the pump is so equipped. If the pump is equipped with an inside mechanical seal, remove the pipe plug in the stuffing box cover, and coat the seal with light oil. This may be done by using an oil can, squirting the seal through the tapped opening while rotating the pump shaft. If equipped with outside seal, oil and cover for protection.
2. When pumps with rubber bearings are stored assembled in horizontal position, it is necessary to rotate the entire pump and column assembly 90 degrees once per month. This practice will help prevent the weight of the shafts from deforming the rubber bearings.

Pumps with metal bearings stored in horizontal positions are to have shafts rotated once per month to prevent lineshafts from deforming or bowing under their own weight.

3. Pumps stored fully assembled and installed are to be rotated once per week to prevent brinelling of motor thrust bearings. Packing or mechanical seals are to be serviced as noted above.

GENERAL DESCRIPTION

This manual covers the Figure 8000 series of propeller pumps which consist of two basic types, the Figure 8211 and the Figure 8312. The mechanical construction of these two types are very similar and for this reason are grouped together. However, there are some basic differences that should be noted.

The Figure 8211 series pumps are defined as axial flow pumps, and typically are high capacity, low head units. The term axial flow is derived from the basically straight flow pattern parallel to the axis of the pump shaft. The propellers in this pump run with a close clearance between the propeller outside diameter and a cylindrical seat machined into the pump bowl.

The Figure 8312 series pumps are defined as mixed flow pumps and typically produced higher heads than the Figure 8211. The flow path in these units is partially radial: that is, perpendicular to the shaft axis. The outside diameter of the propellers for these pumps is machined to a conical shape. These propellers run very close to a conical mating surface machined into the pump bowl.

The Figure 8211 and Figure 8312 pumps are available as one or two stage units. Figure 8211 pumps usually have a straight column while Figure 8312 pumps have a tapered column section immediately above the discharge bowl.

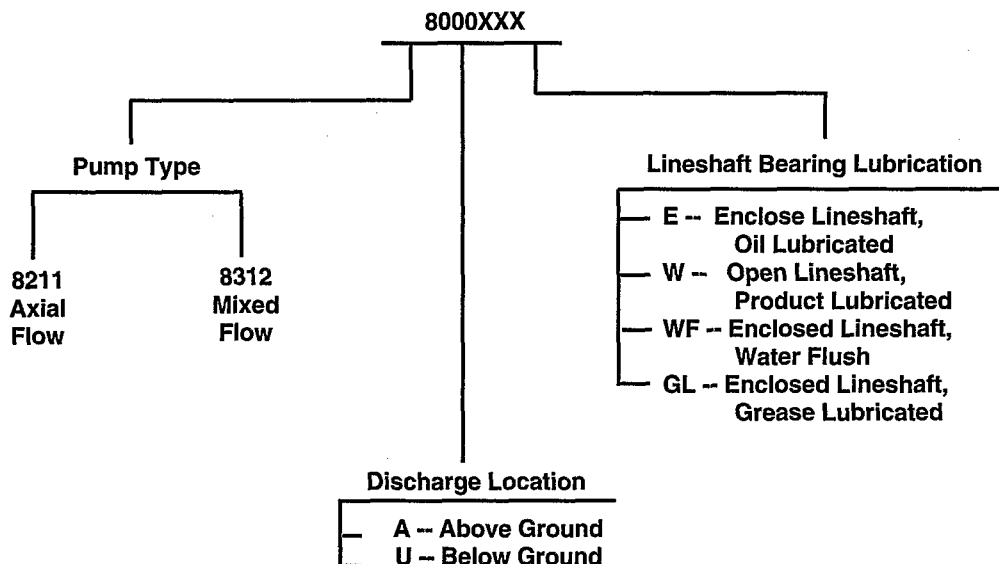
Both of the above pumps are offered with either open or enclosed lineshafts. Bearings for the open lineshaft design are lubricated by the liquid being pumped. Enclosed lineshaft design has a tube surrounding the lineshaft. This tube protects the lineshaft and bearings from the liquid being pumped and channels the lubricant to the lineshaft bearings.

The chart on the following page indicates the pump Model Number description.

Refer to the Technical Data section for general arrangement drawings.

Bowl Assembly

The 8000 series single stage bowl assembly is made up of a suction bell, propeller (impeller), discharge bowl and pump shaft. For two-stage bowl assemblies, an intermediate bowl is added.



Column Pipe

Column pipe for the pumps covered in this manual can be either threaded or flanged.

Threaded column features straight threads on both column ends and butt solidly together within the coupling. Standard nominal column lengths for threaded column are 5 foot, 10 foot or 20 foot (enclosed lineshaft only).

Flanged column includes registered fits for accurate column alignment and are bolted together. Flanged column is available in standard lengths of 10 foot or 5 foot; or can be provided in any special length up to 10 foot.

Lineshafting

The lineshaft transmits torque from the pump driver to the pump bowl assembly and rotates inside the column pipe. Both ends of the shaft are precision machined, and are secured together with couplings. This shafting is supported by bearings at specific intervals; the types of bearings used and how they are lubricated are described as follows:

A. Open Lineshaft -- Product Lubricated

This design is such that the lineshaft and bearings are exposed to and lubricated by the liquid being pumped. The lineshaft is supported at intervals of not more than ten feet by bearings that run on shaft sleeves. Support for these bearings is supplied by bearing retainers. The outer hub of the retainer is seated between the two column ends. (See the Technical Data Section).

B. Enclosed Lineshaft

In the enclosed lineshaft design the shafting is surrounded by tubing. This tubing protects both the shaft and bearings from the pumped liquid and provides a channel for lubricating the shaft bearings. The bearings have machined grooves on their inside diameter to allow lubrication to flow from one bearing to the next. These bearings are also

threaded on the outside diameter and are used to connect the five foot enclosing tube sections. Lubrication is normally oil or water from a separate source. The enclosing tube may be supported by spiders unequally spaced to reduce the risk of vibration. (See the Technical Data Section).

Discharge Heads

Discharge heads perform multiple functions: direct the pump flow from the pump column to the discharge piping system, provide a method for sealing the lineshaft or enclosing tube, provide a base from which the pump is suspended, and provides a mounting surface for the driver.

Surface discharge heads incorporate both the discharge elbow and driver pedestal in one piece. Underground discharge elbows can also be provided in which case a separate driver pedestal is provided. Either design can be supplied with a flanged or plain end discharge connection. The bottom surface of the discharge head or pedestal is machined when furnished with a sole plate.

Drivers

Drivers may be either vertical hollow or vertical solid shaft motors, or right angle gears coupled to horizontal shaft drivers.

When a vertical hollow shaft driver is used, the lineshaft passes through the driver, positioned with an adjusting nut to accommodate impeller adjustment and is connected to the top of the driver by a keyed drive hub or coupling.

Solid shaft drivers require adjustable couplings in order to attach to the pump shaft and to accommodate impeller adjustment. Refer to your submittal package for your specific pump driver configuration.

INSTALLATION

General

Prior to assembly and/or installation, the pump and loose parts are to be inspected for completeness, correctness and cleanliness. During this inspection, all parts are to be thoroughly cleaned and any burrs removed by filing. The pump bowl assembly, including the lineshaft coupling, is normally shipped completely assembled. Both the suction and discharge openings should be inspected for damage and for foreign materials. Rotate the shaft by hand, and move in and out to check for end play. Place all parts in an orderly arrangement for convenient assembly.

WARNING

- **Extreme caution is to be exercised when hoisting components with open lifting lugs. Precautions should be taken to prevent hoisting slings from coming out of the lugs.**
- **Never attempt to mount the driver on the discharge head prior to installation of the pump.**
- **Never attempt to hoist the entire pump by the driver lifting lugs or eyes. These lifting points are designed only to hoist the weight of the driver, not other attached components.**

IMPORTANT

- **All shafting has been pre-straightened to a tolerance of 0.005" in 10 feet prior to leaving the factory or assembly plant. Care in handling must be taken to insure that the shafting is not bent prior to and during installation. We suggest shafts be checked to meet straightness requirements.**

Foundation

A foundation must be supplied consisting of any material that will provide a permanent, rigid support. This support is to be of sufficient size and depth to fully carry the weight of the pump (full of water) and rigid enough to prevent vibration.

Anchor bolts are to be supplied and set in place by the installing contractor. Anchor bolts of appropriate size, length and configuration are required to adequately secure the discharge head/pedestal to the foundation.

When the pump is to be mounted over a pit on structural steel framing, it should be located as close to the main structure or wall as possible. Cross members are to be used to prevent distortion and vibration of structural mounting frame.

Well and Pit Inspection

Prior to installation and start-up, the well or pit must be cleaned of all loose material and debris.

CAUTION

- **Reduced performance and possible equipment damage may result from ingestion of foreign material by the pump.**

Bowl Assembly

- **NOTE: Before proceeding, measure and record the pump bowl assembly end play. This information will be needed later.**

Shaft projection can be defined as the distance from the discharge bowl mounting surface (flange seat for flanged column, thread seat for threaded column) to the end of the pump shaft. Nominal standard shaft projection is 17-1/2".

Shaft end play is the amount of axial movement available in the pump bowl assembly. Measure and record the pump bowl end play. This can most easily be accomplished with the bowl assembly in a horizontal position. Grasp the pump shaft and move the shaft through its maximum axial travel. Consult Table #1 in the Technical Data Section to assure that the distance measured complies with the specifications for your pump model.

Suction Strainer

If a suction strainer is used, it is clipped onto the suction bell as required.

Hoisting, Leveling, Grouting & Piping

Normally your pump is shipped completely assembled, it is now ready to install.

WARNING

- **The pump is to always be lifted using adequate crane and sling capacity. All applicable safe hoisting practices should be employed.**

The pump is to be hoisted by the discharge head. Pumps thirty feet or more in overall length should also be supported at the column midpoint to avoid column/shaft distortion and possible pump damage.

The pump is to be lowered onto the anchor bolts and leveled. This can be achieved by applying a good quality machinists spirit level to the machined motor mounting surface or to the below-grade pump column, if accessible.

After leveling, the base plate is to be grouted in place with a good quality non-shrinking grout. After the grout is fully dry, the base plate is to be nutted solidly in place against the grout bed.

Leveling devices are to be removed or backed off and the pump base plate tightened solidly against the grout bed. All pockets and/or holes left by removal of leveling devices are to be filled with grout.

IMPORTANT

- **Damaging vibration may result if the base plate is not solidly in contact with the grout bed. Even the highest quality non-shrink grouts contract slightly during drying. All leveling wedges, nuts or jackscrews are to be removed or backed off prior to final torquing of the base plate fasteners. Failure to do so will result in the pump base plate resting on the leveling devices rather than the grout bed.**

Piping is to be brought in direct axial alignment with the pump discharge. Flange faces are to fit closely and squarely. The pump discharge is to have no strain imposed upon it by piping misalignment.

Pump Assembly

If the pump has been shipped disassembled, the following instructions are to be employed to assemble the unit vertically in the well.

Determine if the pump to be assembled is Product Lubricated Open Lineshaft, Oil Lube Enclosed Lineshaft or Water Flush Enclosed Lineshaft. Prior to assembly, all components are to be identified and laid out in order of assembly. Standard length (5' or 10') intermediate column, enclosing tube and shaft are interchangeable and can be assembled in any order. However, shorter non-standard column, enclosing tube and shaft sections are provided to accomplish the required overall pump length, and must be installed at the top of the pump directly under the discharge head. The top enclosing tube also has longer threads to engage the top tube tension nut.

On threaded column, all column couplings are to be installed on the upper end of the column prior to lifting. This will provide a stop for pipe clamps during the hoisting process.

Using an appropriate hoisting system, lift the bowl assembly into position over the sump. Lower the bowl partially into the sump. Attach a pipe clamp (see Figure #1) to the upper most bowl directly below the bowl discharge flange (or below threads if threaded column is to be used). Lower the assembly, allowing it to be supported on the foundation via the pipe clamp.

Column, Tube, Shaft Assembly

On larger size units and/or if there is sufficient crane capacity and headroom, the shaft, enclosing tube (if used) and column may be installed individually rather than as a preassembled section.

Follow detailed instructions in the following sections relative to threading shafts and enclosing tubes in place as well as bolting or threading on sections of column.

Product Lubricated Open Lineshaft, Flanged Column

1. Lift the first section of shaft into position over the suspended bowl assembly. Care is to be taken not to damage the threads on the pump shaft or lineshafts. Clean the threads and lubricate with appropriate thread lubricant.

A lineshaft coupling should already be in place on the pump shaft. Thread the lineshaft into the coupling.

IMPORTANT

- **Lineshaft threads are left hand. Tighten shafts and couplings securely with pipe wrenches.**

Assure that no burrs or foreign matter exist on the coupling or on the shaft threads. The threaded shafts are to butt together solidly and squarely in the center of the coupling. Both shafts are to be equally engaged in the coupling threads. Threads should be exposed on both ends of the coupling.

NOTE: Shafts with replaceable wear sleeves must be positioned to engage lineshaft bearings. The presence of any foreign material between the shaft ends will cause shaft misalignment and will result in vibration or accelerated bearing wear.

2. Hoist the first section of column into position over the assembled lineshaft. Lower the column onto the bowl discharge flange. All column joints should be coated with non-hardening gasket sealant such as Loctite P.S.T. #567, Permatex No. 2 or equal. Silicon sealants are also permissible. Install bolts and nuts and tighten.

IMPORTANT

- **Measure the shaft projection. It should conform to the shaft projection measurement taken and recorded previously on the bowl assembly.**
3. The lineshaft is to project out beyond the end of the installed column. Install the bearing retainer assembly over the shaft projection. Seat the retainer OD in the column flange counterbore.

NOTE: Coat the column counterbore with sealant prior to a retainer installation.

NOTE: Bronze lineshaft bearings are to be lubricated with grease prior to installation. Rubber lineshaft bearings should NOT be lubricated. Lubrication of rubber bearings may cause distortion or swelling.

4. Lift the column/bowl assembly slightly and remove the pipe clamp from the bowl. Lower the assembly and reinstall the pipe clamp below the upper column flange. Lower the assembly so the pipe clamp suspends the assembly on the foundation.
5. Install the next shaft/column segment as previously instructed assuring that its lower flange counterbore engages the top of the bearing retainer OD. Coat the column counterbores with sealant prior to installation.

Install bolts and nuts and tighten. A slight gap will remain between the two column flanges. The condition allows the flanges to clamp the bearing retainer securely between them.

6. Continue subsequent shaft and column assembly until complete. Continue to measure the shaft projection after assembly of each shaft/column section.

NOTE: Standard shaft and column lengths are 10 feet. Nonstandard lengths of shafts and column may be used to accomplish the required overall pump length. Nonstandard shaft/column sections will always be assembled at the top of the pump, directly under the discharge head. The shaft segment which protrudes through the packing box will always have a replaceable wear sleeve unless otherwise specified and submitted.

Assembly procedure for underground discharge (U.G.D.) units closely parallels that of standard pumps with above ground discharge heads. Always refer to the Fairbanks Morse submittal drawings and setting plan to determine the proper location of discharge elbow centerline.

If the packing box of the U.G.D. pump is lubricated by the pumped media, it is recommended that an air release valve be provided in the top column. This will prevent air from becoming trapped in the column above the discharge elbow, and will allow the media to lubricate the packing box bushing and packing. If the pump's total dynamic head is not sufficient to raise the media to the altitude of the packing box, an alternate method of lubrication must be provided (i.e., grease lube).

7. For ease of installation, remove the packing box if shipped assembled to the discharge head.
8. Install column flange gasket (when used) and secure the discharge head to the last column flange. When attaching the column to the discharge head, make sure the register fit is fully engaging the head.
9. After attaching the column to the discharge head and removing the column clamp, lower the unit to the foundation and tighten mounting bolts. Check the shaft to see if it is centered in the packing box opening in the head. If the shaft is not centered, it could be an indication of a bent shaft, column not seated properly, or the unit is not properly plumbed. Any or all of these problems must be corrected before proceeding with the installation of the unit.
10. Apply lubricant to the packing box bushing and install the packing box on the discharge head.
11. Install the packing and glands into the packing box. Install gland bolts and nuts. Allow the gland nuts to remain loose. Packing adjustment will be performed later with the pump operating. If a mechanical seal is employed, refer to the Mechanical Seal section of this manual.

Product Lubricated Open Lineshaft, Threaded Column

1. Lift the first section of shaft into position over the suspended bowl assembly. Care is to be taken not to damage threads on the pump shaft or lineshafts. Clean the threads and lubricate with appropriate thread lubricant.

A lineshaft coupling should already be in place on the pump shaft. Thread the lineshaft into the coupling and tighten.

IMPORTANT

- Lineshaft threads are left hand. Tighten shafts and couplings securely with pipe wrenches.

Assure that no burrs or foreign matter exist on the coupling or on the shaft threads. The threaded shafts are to butt together solidly and squarely in the center of the coupling. Both shafts are to be equally engaged in the coupling threads. Threads should be exposed on both ends of the coupling.

NOTE: Shafts with replaceable wear sleeves must be positioned to engage lineshaft bearings. The presence of any foreign material between the shaft ends will cause shaft misalignment and will result in vibration or accelerated bearing wear.

IMPORTANT

- Assure that no burrs or foreign matter exist on the column coupling threads or on the column threads prior to assembly. All joints are to be coated with sealant prior to assembly. The column sections should butt together solidly and squarely in the middle of the column coupling. Secure each joint firmly with appropriate wrenches. **ALL COLUMN THREADS ARE RIGHT HAND.**

2. Lower the column and thread it into the bowl assembly until it solidly and squarely butts together with the bowl, tightening it firmly with appropriate wrenches.
3. Lift the column/bowl assembly slightly and remove the pipe clamp from the bowl. Lower the assembly and reinstall the pipe clamp below the upper column threads. Lower the assembly so the pipe clamp suspends the assembly on the foundation.

The lineshaft is to project out beyond the end of the installed column.

IMPORTANT

- Measure the shaft projection. It should conform to the shaft projection measurement taken and recorded previously on the bowl assembly.
4. Slide the bearing retainer with bearing over the shaft projection and lower into the column coupling. Install the shaft coupling and next section of shaft/column assembly as previously outlined.
 5. Continue subsequent shaft and column assembly until complete. Continue to measure the shaft projection after assembly of each shaft/column section.

NOTE: Standard shaft and column lengths are 10 feet. Nonstandard lengths of shafts and column may be used to accomplish the required overall pump length. Nonstandard shaft/column sections will always be assembled at the top of the pump, directly under the discharge head. The shaft segment which protrudes through the packing box will always have a replaceable wear sleeve unless otherwise specified and submitted.

Assembly procedure for underground discharge (U.G.D.) units closely parallels that of standard pumps with above ground discharge heads. Always refer to the Fairbanks Morse submittal drawings and setting plan to determine the proper location of discharge elbow centerline.

If the packing box of the U.G.D. pump is lubed by the pumped media, it will be necessary to provide an air release valve in the top column. This will prevent air from becoming trapped in the column above the discharge elbow, and will allow the media to lubricate the packing box bushing and packing. If the pump's total dynamic head is not sufficient to raise the media to the altitude of the packing box, an alternate method of lubrication must be provided (i.e., grease lube).

6. For ease of installation, remove the packing box if shipped assembled to the discharge head.
7. Thread the top column adapter flange onto the top column and tighten with appropriate wrenches. Install column flange gasket and secure the discharge head to the column adapter flange. When attaching the column to the discharge head, make sure the register fit is fully engaging the head and the flange is timed with the pipe tapped hole of the discharge head.
8. After attaching the column to the discharge head and removing column clamp, lower the unit to the foundation and tighten mounting bolts. Check the shaft to see if it is centered in the packing box opening in the head. If the shaft is not centered, it could be an indication of a bent shaft, column not seated properly, or the unit is not properly plumbed. Any or all of these problems must be corrected before proceeding with the installation of the unit.
9. Apply lubricant to the packing box bushing and install the packing box on the discharge head.
10. Install the packing and glands into the packing box. Install gland bolts and nuts. Allow the gland nuts to remain loose. Packing adjustment will be performed later with the pump operating. If a mechanical seal is employed, refer to the Mechanical Seal section of this manual.

Oil Lube Enclosed Lineshaft, Flanged Column

1. Before proceeding with assembly, lay out all lineshaft, enclosing tube, column and connectors. Inspect and identify all items and arrange them in the order in which they will be assembled. Oversized diameter enclosing tube sections (if used) must be installed at the bottom of the assembly, directly above the pump discharge bowl. When oversized tube sections are used, special stepped connector bearings are provided in order to adapt them to the remaining standard diameter enclosing tube sections.

Preassemble matching sets of shaft, enclosing tube and column by sliding them inside each other and attaching connectors and couplings. This will allow each set of column/enclosing tube/shaft to be hoisted into place.

Non-standard lengths of column, enclosing tube and line shafting must be assembled at the top of the pump as previously outlined.

Using an appropriate hoisting system, lift the shaft/tube/column assembly and position it above the suspended bowl. Slide the lower end of the shaft out of the enclosing tube about one foot. Refer to Figure #2 for lifting of this assembly.

2. Lower the shaft/tube/column assembly into position. A lineshaft coupling is to already be in place on the pump shaft. Assure that the threaded shafts and coupling are clean and free of burrs. Lubricate threads with light oil. Thread the shafts into the coupling so that both shafts engage the coupling equally. The shafts should butt together solidly in the center of the coupling. Threads should be exposed on both ends of the coupling. Assure that no foreign matter exists between the shaft ends. Such a condition will cause shaft misalignment and will result in vibration and accelerated bearing wear.

IMPORTANT

- **Lineshaft threads and enclosing tube threads are left hand rotation. Tighten shafts, enclosing tubes and couplings securely with pipe wrenches.**
3. Assure that all enclosing tube threads and connector bearing threads are clean and free of burrs. Coat all connector bearing threads with a sealant such as Loctite P.S.T. #567; Permatex No. 2 Non-hardening Gasket Sealant prior to assembly. Silicone sealants are also permissible. This step is very important in preventing entry of the pressurized pumped media into the enclosing tube. Thread the enclosing tube onto the connector bearing and secure with chain wrenches.
 4. Clean all coating or foreign materials from the column flange faces prior to assembly. Lower the shaft/tube/column assembly into position and coat the flange faces with sealant. Assure that the flange faces engage squarely and that all bolt holes align. Install bolts and nuts and tighten.
 5. Lift the column and bowl assembly slightly. Remove the pipe clamp from the bowl and lower the assembly into the well. Reinstall the pipe clamp on the upper end of the column directly below the upper flange. Lower the assembly until the pipe clamp supports the assembly on the foundation.

IMPORTANT

- **Measure the shaft projection. It should conform to the shaft projection measurement taken and recorded previously on the bowl assembly.**

6. Repeat the above steps until complete. Continue to measure the shaft projection after assembly of each shaft/tube/column section.

Before installing the discharge head, prelubricate the connector bearings by pouring oil down the enclosing tube. Approximately one pint of oil should be added for every 20 feet of pump length.

NOTE: Standard column length is 10 feet, some non-standard lengths of column, enclosing tube and shaft may be required to accomplish the specified overall length of the pump. These nonstandard lengths should be installed directly under the discharge head.

Assembly procedure for underground discharge units closely parallels that of standard pumps with above ground discharge heads. Always refer to the Fairbanks Morse submittal drawings and setting plan to determine the proper location of discharge elbow centerline.

7. Install column flange gasket (when used) to the upper column flange and secure to the discharge head being sure it is timed with the pipe tapped hole of the discharge head.
8. Coat both sides of the copper gasket and the tension nut threads with sealant prior to installation. Install the bronze top tube tension nut gasket onto the top tube tension nut.
9. Install the top tube tension nut over the projecting lineshaft and slide into position in the discharge head. Remembering that the tension nut threads are left hand, thread it into the top enclosing tube. The threads should engage the tube smoothly and allow the washer and nut to seat squarely in the counterbore of the discharge head. Torque the top tube tension nut (refer to Table #2).

Water Flush Enclosed Lineshaft, Flanged Column

1. Before proceeding with assembly, lay out all lineshaft, enclosing tube, column and connectors. Inspect and identify all items and arrange them in the order in which they will be assembled. Oversized diameter enclosing tube sections (if used) must be installed at the bottom of the assembly, directly above the pump discharge bowl. When oversized tube sections are used, special stepped connector bearings are provided in order to adapt them to the remaining standard diameter enclosing tube sections.

Preassemble matching sets of shaft, enclosing tube and column by sliding them inside each other and attaching connectors and couplings. This will allow each set of column/enclosing tube/shaft to be hoisted into place.

Non-standard lengths of column, enclosing tube and line shafting must be assembled at the top of the pump as previously outlined.

Using an appropriate hoisting system, lift the shaft/ tube/ column assembly and position it above the suspended bowl. Slide the lower end of the shaft out of the enclosing tube about one foot. Refer to Figure #2 for lifting of this assembly.

2. Lower the shaft/tube/column assembly into position. A lineshaft coupling is to already be in place on the pump shaft. Assure that the threaded shafts and coupling are clean and free of burrs. Lubricate threads with light oil. Thread the shafts into the coupling so that both shafts engage the coupling equally. Threads should be exposed on both ends of the coupling. The shafts should butt together solidly in the center of the coupling. Assure that no foreign matter exists between the shaft ends. Such a condition will cause shaft misalignment and will result in vibration and accelerated bearing wear.

IMPORTANT

- **Lineshaft threads and enclosing tube threads are left hand rotation. Tighten shafts, enclosing tubes and couplings securely with pipe wrenches.**
3. Assure that all enclosing tube threads and connector bearing threads are clean and free of burrs. Coat all connector bearing threads with a sealant such as Loctite P.S.T. #567, or Permatex No. 2 Non-hardening Gasket Sealant prior to assembly. Silicone sealants are also permissible. This step is very important in preventing entry of the pressurized pumped media into the enclosing tube. Thread the enclosing tube onto the connector bearing and secure with chain wrenches.
 4. Lower the column and thread it into the bowl assembly until it solidly and squarely butts together with the bowl, tightening it firmly with appropriate wrenches. The lineshaft and enclosing tube is to project out beyond the end of the installed column.
 5. Lift the column and bowl assembly slightly. Remove the pipe clamp from the bowl and lower the assembly into the well. Reinstall the pipe clamp on the upper end of the column directly below the upper flange. Lower the assembly until the pipe clamp supports the assembly on the foundation.

IMPORTANT

- **Measure the shaft projection. It should conform to the shaft projection measurement taken and recorded previously on the bowl assembly.**
6. Repeat the above steps until complete. Continue to measure the shaft projection after assembly of each shaft/tube/column section.

NOTE: Standard column length is 10 feet, some non-standard lengths of column, enclosing tube and shaft may be required to accomplish the specified overall length of the pump. These non-standard lengths will always be installed at the top of the column, directly under the discharge head.

NOTE: The segment of the lineshaft which protrudes through the combination top tube tension nut/packing box will always have a replaceable wear sleeve. This shaft must be installed so that the sleeve engages the top tube tension nut bushing.

Assembly procedure for underground discharge units closely parallels that of standard pumps with above ground discharge heads. Always refer to the Fairbanks Morse submittal drawings and setting plan to determine the proper location of discharge elbow centerline.

7. Install column flange gasket (when used) to the upper column flange and secure to the discharge head being sure it is timed with the pipe tapped hole of the discharge head.
8. Install the bronze top tube tension nut washer onto the top tube tension nut. Coat both sides of the washer and the tension nut threads with sealant prior to installation.
9. Install the combination top tube tension nut/packing box over the projecting lineshaft and slide into position in the discharge head. Remembering that the tension nut threads are left handed, thread it into the top enclosing tube. The threads should engage the tube smoothly and allow the washer and nut to seat squarely in the counter bore of the discharge head. Torque the combination top tube tension nut/packing box (refer to Table #3).
10. Install the packing and glands into the packing box. Install gland bolts and nuts. Allow the gland nuts to remain loose. Packing adjustment will be performed later with the pump operating. If a mechanical seal is employed, refer to the Mechanical Seal section of this manual.

Oil Lube Enclosed Lineshaft, Threaded Column

1. Before proceeding with assembly, lay out all lineshaft, enclosing tube, column and connectors. Inspect and identify all items and arrange them in the order in which they will be assembled. Oversized diameter enclosing tube sections (if used) must be installed at the bottom of the assembly, directly above the pump discharge bowl. When oversized tube sections are used, special stepped connector bearings are provided in order to adapt them to the remaining standard diameter enclosing tube sections.

Preassemble matching sets of shaft, enclosing tube and column by sliding them inside each other and attaching connectors and couplings. This will allow each set of column/enclosing tube/shaft to be hoisted into place.

Non-standard lengths of column, enclosing tube and line shafting must be assembled at the top of the pump as previously outlined.

Using appropriate hoisting system, lift the shaft/tube/column assembly and position it above the suspended bowl. Refer to Figure #2 for lifting of this assembly. Slide the lower end of the shaft out of the enclosing tube.

2. Lower the shaft/tube/column assembly into position. A lineshaft coupling is to already be in place on the pump shaft. Assure that the threaded shafts and coupling are clean and free of burrs. Lubricate threads with light oil. Thread the shafts into the coupling so that both shafts engage the coupling equally. The shafts should butt together solidly in the center of the coupling. Threads should be exposed on both ends of the coupling. Assure that no foreign matter exists between the shaft ends. Such a

condition will cause shaft misalignment and will result in vibration and accelerated bearing wear.

IMPORTANT

- **Lineshaft threads and enclosing tube threads are left hand rotation. Tighten shafts, enclosing tubes and couplings securely with pipe wrenches.**
3. Assure that all enclosing tube threads and connector bearing threads are clean and free of burrs. Coat all connector bearing threads with a sealant such as Loctite P.S.T. #567, Permatex No. 2 Non-hardening Gasket Sealant prior to assembly. Silicone sealants are also permissible. This step is very important in preventing entry of the pressurized pumped media into the enclosing tube. Thread the enclosing tube onto the connector bearing and secure with chain wrenches.

IMPORTANT

- **Assure that no burrs or foreign matter exist on the column coupling threads or on the column threads prior to assembly. All joints are to be coated with sealant prior to assembly. The column sections should butt together solidly and squarely in the middle of the column coupling. Secure each joint firmly with appropriate wrenches. ALL COLUMN THREADS ARE RIGHT HAND.**
4. Lower the column and thread it into the bowl assembly until it solidly and squarely butts together with the bowl, tightening it firmly with appropriate wrenches.

The lineshaft and enclosing tube is to project out beyond the end of the installed column.

5. Lift the column/bowl assembly slightly and remove the pipe clamp from the bowl. Lower the assembly and reinstall the pipe clamp below the upper column threads. Lower the assembly so the pipe clamp suspends the assembly on the foundation.

IMPORTANT

- **Measure the shaft projection. It should conform to the shaft projection measurement taken and recorded previously on the bowl assembly.**
6. Repeat the above steps until complete. Continue to measure the shaft projection after assembly of each shaft/tube/column section. Before installing the discharge head, prelubricate the connector bearings by pouring oil down the enclosing tube approximately one pint of oil should be added for every 20 feet of pump length.

NOTE: Standard shaft and column lengths are 10 feet. Nonstandard lengths of shafts and column may be used to accomplish the required overall pump length. Nonstandard shaft/column sections will always be assembled at the top of the pump, directly under the discharge head.

Assembly procedure for underground discharge units closely parallels that of standard pumps with above ground discharge heads. Always refer to the Fairbanks Morse submittal drawings and setting plan to determine the proper location of discharge elbow centerline.

7. Thread the top column adapter flange onto the top column and tighten with appropriate wrenches. Install column flange gasket and secure the discharge head to the column adapter flange. When attaching the column to the discharge head, make sure the flange is timed with the pipe tapped hole of the discharge head.
8. Install the bronze top tube tension nut washer onto the top tube tension nut. Coat both sides of the washer and the tension nut threads with sealant prior to installation.
9. Install the top tube tension nut over the projecting lineshaft and slide into position in the discharge head. Remembering that the tension nut threads are left handed, thread it into the top enclosing tube. The threads should engage the tube smoothly and allow the washer and nut to seat squarely in the counter bore of the discharge head. Torque the top tube tension nut (refer to Table #2).

Water Flush Enclosed Lineshaft, Threaded Column

1. Before proceeding with assembly, lay out all lineshaft, enclosing tube, column and connectors. Inspect and identify all items and arrange them in the order in which they will be assembled. Oversized diameter enclosing tube sections (if used) must be installed at the bottom of the assembly, directly above the pump discharge bowl. When oversized tube sections are used, special stepped connector bearings are provided in order to adapt them to the remaining standard diameter enclosing tube sections.

Preassemble matching sets of shaft, enclosing tube and column by sliding them inside each other and attaching connectors and couplings. This will allow each set of column/enclosing tube/shaft to be hoisted into place.

Non-standard lengths of column, enclosing tube and line shafting must be assembled at the top of the pump as previously outlined.

Using an appropriate hoisting system, lift the shaft/tube/column assembly and position it above the suspended bowl. Slide the lower end of the shaft out of the enclosing tube. Refer to Figure #2 for lifting of this assembly.

2. Lower the shaft/tube/column assembly into position. A lineshaft coupling is to already be in place on the pump shaft. Assure that the threaded shafts and coupling are clean and free of burrs. Lubricate threads with light oil. Thread the shafts into the coupling so that both shafts engage the coupling equally. The shafts should butt together solidly in the center of the coupling. Threads should be exposed on both ends of the coupling. Assure that no foreign matter exists between the shaft ends. Such a condition will cause shaft misalignment and will result in vibration and accelerated bearing wear.

IMPORTANT

- **Lineshaft threads and enclosing tube threads are left hand rotation. Tighten shafts, enclosing tubes and couplings securely with pipe wrenches.**
3. Assure that all enclosing tube threads and connector bearing threads are clean and free of burrs. Coat all connector bearing threads with a sealant such as Loctite P.S.T. #567, or Permatex No. 2 Non-hardening Gasket Sealant prior to assembly. Silicone sealants are also permissible. This step is very important in preventing entry of the pressurized pumped media into the enclosing tube. Thread the enclosing tube onto the connector bearing and secure with chain wrenches.

IMPORTANT

- **Assure that no burrs or foreign matter exist on the column coupling threads or on the column threads prior to assembly. All joints are to be coated with sealant prior to assembly. The column sections should butt together solidly and squarely in the middle of the column coupling. Secure each joint firmly with appropriate wrenches. ALL COLUMN THREADS ARE RIGHT HAND.**
4. Lower the column and thread it into the bowl assembly until it solidly and squarely butts together with the bowl, tightening it firmly with appropriate wrenches. The lineshaft and enclosing tube is to project out beyond the end of the installed column.
 5. Lift the column/bowl assembly slightly and remove the pipe clamp from the bowl. Lower the assembly and reinstall the pipe clamp below the upper column threads. Lower the assembly so the pipe clamp suspends the assembly on the foundation.

IMPORTANT

- **Measure the shaft projection. It should conform to the shaft projection measurement taken and recorded previously on the bowl assembly.**
6. Repeat the above steps until complete. Continue to measure the shaft projection after assembly of each shaft/tube/column section.

NOTE: Standard shaft and column lengths are 10 feet. Nonstandard lengths of shafts and column may be used to accomplish the required overall pump length. Nonstandard shaft/column sections will always be assembled at the top of the pump, directly under the discharge head.

NOTE: The segment of lineshaft which protrudes through the top tube tension nut will always have a replaceable wear sleeve. This shaft must be installed so that the sleeve engages the top tube tension nut bushing.

Assembly procedure for underground discharge units closely parallels that of standard pumps with above ground

discharge heads. Always refer to the Fairbanks Morse submittal drawings and setting plan to determine the proper location of discharge elbow centerline.

7. Thread the top column adapter flange onto the top column and tighten with appropriate wrenches. Install column flange gasket and secure the discharge head to the column adapter flange. When attaching the column to the discharge head, make sure the flange is timed with the pipe tapped hole of the discharge head.
8. Install the bronze top tube tension nut washer onto the top tube tension nut. Coat both sides of the washer and the tension nut threads with sealant prior to installation.
9. Install the top tube tension nut over the projecting lineshaft and slide into position in the discharge head. Remembering that the tension nut threads are left handed, thread it into the top enclosing tube. The thread should engage the tube smoothly and allow the washer and nut to seat squarely in the counter bore of the discharge head. Torque the combination top tube tension nut/packing box (refer to Table #3).
10. Install the packing and glands into the packing box. Install gland bolts and nuts. Allow the gland nuts to remain loose. Packing adjustment will be performed later with the pump operating. If a mechanical seal is employed, refer to the Mechanical Seal section of this manual.

Driver Installation

IMPORTANT

- Read and understand the driver manufacturer's manual before proceeding. Determine if the driver to be installed is a vertical hollow shaft electric motor, a solid shaft motor or a right angle gear. Refer to the appropriate instructions.

Hollow Shaft Drivers; General

Hollow shaft drivers provide a hollow quill tube through the rotor. The pump shaft passes through the quill tube and attaches at the top of the driver. Most propeller pump designs provide a shaft coupling above the packing box or tube tension nut. This allows the motor to be set in place and the top section of shaft installed later, through the driver. Other shaft/head designs have no such coupling and require that the motor be lowered over the projecting top shaft.

CAUTION

- Care should be taken to avoid motor/shaft contact during this process as a bent top shaft could result.

Register fits on the bottom of the driver base and on the top of the discharge head (motor pedestal) will facilitate approximate driver positioning. The fits are generally loose enough to accommodate the additional movement required for precision alignment. After precision alignment is achieved, the driver is permanently held in position by the clamping force of the

mounting bolts. Doweling or pinning of the driver is not required, but may be implemented at the owner's option.

Installation, Hollow Shaft Drivers

1. Before installation, remove the driver top cover. Remove the driver clutch coupling (or non-reverse ratchet if so equipped). This will facilitate top shaft installation and rotation check.
2. Using an appropriate hoisting system, lift the driver over the discharge head mounting surface and carefully lower into position. Be sure the drive shaft is centered within the hollow shaft. Engage the driver base over the register fit of the mounting surface.
3. Bolt the driver down. If an electric motor is used, now is the time to connect it to the electrical source and to verify correct rotation. If a right angle gear is used proceed to step 4.

⚠ DANGER

- Electrical motors must be installed and operated only by qualified, trained electrical technicians. Consult the motor manufacturer or the motor manual to assure that all installation and operation safety procedures are fully understood and implemented. Always lock out all controls and/or power supplies and verify driver can not be started before installing or servicing electrical apparatus.
- Oil lubricated drivers and right angle gears are shipped dry and require an initial fill of the manufacturer's recommended lubricant prior to bump-start or startup. See driver manufacturer's manual for lube specifications. Lubricants are not supplied by the manufacturer.

With non-reverse ratchets (if so equipped) removed or disabled, "bump" the motor for rotation. This is generally accomplished on three-phase motors by engaging and immediately disengaging the power switch. It is seldom necessary to engage the power source for more than one second to determine motor rotation.

Note the direction of motor rotation. If the motor rotates counter clockwise as viewed from the top, the rotation is correct and installation may proceed. If the motor rotates clockwise as viewed from the top, reverse any two of the three power leads and motor rotation will be reversed. Lineshaft threads are left hand.

CAUTION

- Lineshaft thread are left hand.
- Operation of the pump in a clockwise (as viewed from the top) direction will cause the lineshaft couplings to unthread, causing serious damage to the pump.
- Assure that no burrs or foreign matter exists on the shaft threads.

4. Install the pump's driver top shaft through the top of the driver and tighten into the lineshaft coupling. Make sure that the top shaft is centered in the quill tube.
5. Install the driver coupling and/or non-reverse ratchet. Install the gib key (supplied with the driver) into the driver/shaft keyway. The key should be a close slip fit in the keyway. It may be necessary to deburr or file the key to achieve the proper fit. Never drive or wedge the key into an overly tight keyway.
6. Install the top shaft adjusting nut. The adjusting nut will be used to lift the shaft/propeller assembly in order to achieve proper propeller clearance. Adjusting nut threads are right hand.

NOTE: Before installation of the nut, the weight of the shaft/propeller assembly rests on the bottom of the pump bowls. This condition makes the shaft almost impossible to rotate until the nut is installed and the shaft/propellers are raised off the bottom of the bowls. In running position, the shaft, propellers and hydraulic downthrust are supported by the driver thrust bearing.

7. Tighten the nut on the shaft until the propellers are raised very slightly off the bowl bottoms. This will be evident when resistance to shaft rotation disappears as the propellers are lifted off the bottom.
8. 8211 Propeller Adjustment:

8211 propeller pumps employ a cylindrical bowl section. The propeller vane tips are machined to provide a pre-determined clearance between the bowl and propeller. It is, however necessary to set the propeller position so that it operates at the midpoint of its available axial travel.

Begin propeller adjustment with the propeller resting in its lower most position. Using the adjusting nut or coupling, raise the propeller/shaft assembly until it contacts the upper most stop. This will be evident when the shaft becomes resistant to further upward movement. Refer to Table #1 for total axial movement available.

Lower the shaft/propeller assembly approximately one-half of the total axial movement observed. This will effectively center the adjusting nut or coupling in place as required.

CAUTION

- Do not run pumps dry.
 - Momentarily engage the pump drive to check for free rotation prior to full speed operation
9. 8312 Propeller Adjustment:
- 8312 Propeller pumps employ a conical (tapered) bowl seat. The tips of the propeller vanes are machined to a similar conical profile to provide a congruent relationship between the propeller and bowl. Maximum pump efficiency is achieved when the propeller is run closest to the bowl seat, without touching.

Begin propeller adjustment with the propeller resting on the bowl seat. Using the adjusting nut or coupling, raise the propeller and shaft assembly until it first rotates freely. This is the starting point for clearance adjustment. Raise the shaft/propeller assembly until the proper running clearance is achieved. Refer to Table #1 for proper running clearance. Lock the adjusting nut or coupling in place as required.

CAUTION

- Do not run pumps dry.
 - Momentarily engage the pump drive system to check for propeller contact prior to full speed operation. Propeller/bowl seat contact can damage the pump.
10. After propeller adjustment, place the adjusting nut lock screw through the nut and thread into the driver clutch coupling and secure. If the nut must be rotated to align with the clutch coupling hole, always move to the next higher adjustment position.
 11. Replace the driver cover.
 12. Refer to the driver manual to assure that all lubrication instructions have been followed completely.
 13. Consult the driver manufacturer's manual to assure that all safety procedures are completely understood and implemented prior to operation.

IMPORTANT

- Grease lubricated drivers are shipped prelubricated. Oil lubricated drivers and right angle gears are shipped dry and require an initial fill of the manufacturer's recommended lubricant prior to bump-start or startup. See driver manufacturer's manual for lube specifications. Lubricants are not supplied by the manufacturer.

Solid Shaft Drivers; General

Solid shaft drivers have a vertical main shaft projecting from the bottom of the driver base. The shaft projection has a vertical keyway to transmit torque and an annular groove to suspend the pump shaft/propeller assembly. Solid shaft drivers require the use of adjustable couplings to facilitate pump propeller adjustment.

Register fits on the bottom of the driver base and on the top of the discharge head (motor pedestal) will facilitate approximate driver positioning. The fits are designed to accommodate the additional movement required for precision alignment. After precision alignment is achieved, the driver is permanently held in position by the clamping force of the mounting bolts. Doweling or pinning of the driver is not required, but may be implemented at the owner's option.

Installation, Solid Shaft Drivers

CAUTION

- Before installing the driver, read and understand the driver manufacturer's instruction manual.
- Electric motors must be installed and operated only by qualified, trained electrical technicians. Consult the motor manufacturer or the motor manual to assure that all installation and operation safety procedures are fully understood and implemented. Always lock out all controls and/or power supplies before installing or servicing.

1. Check both driver and pump shafts for burrs or dirt, cleaning as necessary. Also check the coupling parts for burrs and dirt, cleaning as required. If force is required to position the couplings on the shafts, non-metallic dead blow hammers should be used to prevent damage to the machined surfaces.
2. Install the coupling hubs on the driver shaft and top shaft prior to installing the driver according to the following procedure:

NOTE: It is generally most convenient to install the driver coupling hub on the driver shaft before hoisting the driver into position.

- A. Insert the square key into the driver shaft keyway and slide the driver coupling hub onto the driver shaft until the annular shaft groove is exposed. Install the thrust rings. Pull the coupling down over the rings to hold them in place. When a spacer is used, pilot the spacer into the driver hub and secure with the short bolts (see drawing #7000A091).
- B. Install a dowel pin into the hole provided in the pump coupling hub. Drive the pin through the coupling hub until it protrudes slightly into the coupling keyway. The purpose of this pin is to prevent the key from falling out of the hub until the setscrew has been secured. Slide pump coupling half hub over top shaft threads.
- C. Align the keyway in the shaft with the keyway in the coupling hub and insert the key.
- D. Thread the coupling adjusting nut onto the top lineshaft.
- E. Using an appropriate hoisting system, lift the driver over the discharge head mounting surface and carefully lower into position. Engage the driver base over the register fit of the mounting surface. Temporarily bolt the driver down. Check for driver to lineshaft alignment. If an electric motor is used, now is the time to connect to the electrical source per manufacturer's instructions and verify correct rotation. If a right angle gear is used proceed to step 4.

DANGER

- Make sure the main power source is locked off before any electrical connections are made and verify driver can not be started. After the start has been performed, again lock off the main power source to guard against accidental starting and electrical shock.
 - Oil lubricated drivers and right angle gears are shipped dry and require an initial fill of the manufacturer's recommended lubricant prior to bump-start or startup. See driver manufacturer's manual for lube specifications. Lubricants are not supplied by the manufacturer.
 - Make sure all loose coupling parts are off the motor half coupling, and that no part of one coupling half will contact the other half during the bump start, otherwise personal injury could occur.
 - Make sure the protective guard is in place on the discharge head before the bump start is done. Do not operate this machine, even to check rotation, without protective guards in place.
3. With non-reverse ratchets (if so equipped) removed or disabled, "bump" the motor for rotation. Bump Start is generally accomplished on three-phase motors by engaging and immediately disengaging the power switch. It is seldom necessary to engage the power source for more than one second to determine motor rotation.
 4. Note the direction of motor rotation. If the motor rotates counter clockwise as viewed from the top, the rotation is correct and installation may proceed. If the motor rotates clockwise as viewed from the top, reverse any two of the three power leads and motor rotation will be reversed.

CAUTION

- Operation of the pump in a clockwise (as viewed from the top) direction will cause the lineshaft couplings to unthread, causing serious damage to the pump.

After correct rotation has been obtained, complete the coupling connection and proper adjustment as follows:

5. 8211 Propeller Adjustment:

8211 propeller pumps employ a cylindrical bowl section. The propeller vane tips are machined to provide a predetermined clearance between the bowl and propeller. It is, however, necessary to set the propeller position so that it operates at the midpoint of its available axial travel.

The propeller should be adjusted upward half of the total end play measured.

- a. Thread the adjusting nut onto the shaft until it is flush with the top of the shaft.
- b. Measure the gap between the motor shaft and adjusting nut.

- b. Measure the gap between the motor shaft and adjusting nut.
- c. Thread the nut upwards until the gap is decreased by half.
- d. Refer to step #7 below.

⚠ CAUTION

- Do not run pumps dry.
- Momentarily engage the pump drive system to check for free rotation prior to full speed operation.

6: 8312 Propeller Adjustment:

8312 propeller pumps employ a conical (tapered) bowl seat. The tips of the propeller vanes are machined to a similar conical profile to provide a congruent relationship between the propeller and bowl. Maximum pump efficiency is achieved when the propeller is run closest to the bowl seat, without contact.

The propeller should be adjusted upwards until it just clears the bowl seat. This is easily determined as the shaft assembly will turn freely.

- a. Thread adjusting nut onto the shaft until it is flush with the top of the shaft.
- b. Measure the gap between the motor shaft and the adjusting nut.
- c. Thread the nut upwards until the gap is decreased to about 1/16".
- d. Refer to step #7 below.

⚠ CAUTION

- Do not run pumps dry.
- Momentarily engage the pump drive system to check for propeller contact prior to full speed operation. Propeller/bowl seat contact can damage the pump.

7. Align the bolt holes and insert coupling bolts. Torque to the values as shown in Table #6. Install the set screw in the pump coupling hub and secure.

8. Install protective guards.

⚠ WARNING

- Make sure the protective guard is in place on the discharge head before operating the pump.
- 9. Refer to the driver manual to assure that all lubrication instructions have been followed completely.
- 10. Consult the driver manufacturer's manual to assure that all safety procedures are completely understood and implemented prior to operation.

⚠ CAUTION

- Grease lubricated drivers are shipped prelubricated. Oil lubricated drivers and right angle gears are shipped dry and require an initial fill of the manufacturer's recommended lubricant prior to start-up. See driver manufacturer's manual for lube specifications. Initial start-up lubricants are not supplied by the manufacturer.

OPERATION

General

Because variations may exist in both the equipment used with these pumps, and in the particular installation of the pump and driver, specific operating instructions are not within the scope of this manual. However, there are general rules and practices that apply to all pump installations and operation.

⚠ CAUTION

- Before starting or operating the pump, read this entire manual, especially the following instructions.

Before starting the pump:

1. Rotate the unit or assembly by hand to assure all moving parts are free.
2. Install coupling guards around all exposed rotating parts. Guards are mandatory on discharge head (motor pedestal) openings if the pump is equipped with an adjustable coupling.
3. Install packing (or mechanical seal).
4. Install oiler and fill with oil (if pump is oil lubricated) and ensure oil lines are properly installed.

Open the lubrication valve and allow oil to feed into the enclosing tube for 15 minutes before initial start-up. During the first five (5) hours of operation lubrication rate should be 10 - 15 drops per minute. After this initial operating time, the flow rate may be reduced to 5 - 6 drops per minute.

NOTE: The amount of oil flow above is a recommended minimum. Greater flows are not detrimental, and are even encouraged.

NOTE: Cold weather will cause the oil to thicken and reduce the flow rate. Feed adjustment should be checked and reset as a result of changing ambient temperatures.

5. Install water line to packing box (for water flush or mechanical seals).
6. Observe all danger, warning and caution tags attached to this equipment.
7. Ensure water in sump is at the specified level for adequate submergence.
8. If pump has a packed box, adjust the packing gland finger tight. Refer to PACKING ADJUSTMENT in the maintenance section to properly adjust packing.

If excessive vibration or noise occurs during operation, shut the pump down and review the **TROUBLE SHOOTING** section. If the problem cannot be corrected, consult a Fairbanks Morse representative.

Operating at Reduced Capacity

In a typical application covering a wide range of flow rates, a variable speed driver is often used to adjust pump capacity, and this is taken into consideration by Fairbanks Morse when selecting the pump and propeller trim. Although these pumps are applicable over a wide range of operating conditions, care should be exercised when doing so, especially when the actual conditions differ from the sold conditions. You should always contact your nearest Fairbanks Morse distributor or factory before operating the pumps at any condition other than sold conditions.

Initial Startup

Inspect the complete installation to ensure that the installation instructions of this manual, and the manuals of all the related equipment, have been followed and that the installation is complete. Use the "Prestart-up and Start-Up Check List" found in this manual as a guide.

Ensure that the driver is properly serviced, and that the proper pump rotation is obtained.

Rotate the pump shaft by hand. It should rotate freely on all motor driven installations.

Ensure the discharge valve is open. Start the pump according to the following procedure:

- A. Start driver according to driver manufacturer's instructions.
- B. Immediately after the pump has been started, check lubrication system, stuffing box lubrication and operation, and pump noise level. Continue to monitor these for the first several hours of operation.
- C. Check the driver and other necessary equipment for satisfactory operation following their manuals.
- D. Check the foundation for integrity.
- E. After the first shutdown, repeat the propeller adjustment. Running may have tightened up some of the shaft joints, changing the original setting.

Normal Operation

Check the following before normal startup:

- A. Driver lubrication levels and flow.
- B. General condition of all equipment.

Monitor the following during running cycles:

- A. Unit vibration or noise.
- B. Driver lubrication levels and flow.
- C. Packing box leakage.

Shutdown

Pump stations are usually designed to have the pumps started and stopped automatically. Since this is a function of station design, the operators should be familiar with the systems operating parameters. The general procedure to shut down the pump is as follows:

- A. Disconnect the electrical power source.
- B. If the pump is to be removed for repair, close all valves.

WARNING

- After removal of pump, ensure pump opening is adequately covered and secured.

Seasonal Operating Instructions

If the pump is located in an area that is subject to below freezing temperatures and will not be operated enough to prevent freezing, it should be drained to prevent damage to the casing caused by freezing.

Emergency Procedures

Many installations are equipped with emergency shut off switches near the pump location. These locations should be plainly marked and readily accessible at all times.

The control panel (if used) may be equipped with an emergency start/stop button or switch.

IMPORTANT

- The operator or persons working around the equipment should be familiar with locations of emergency start-up & shut off points.

TROUBLESHOOTING

If you have followed the installation and start up procedures outlined in this manual, your pump should provide reliable service and long life. However, if operating problems occur, significant time and expense can be saved if you use the following checklist to eliminate the most common causes of those problems.

Insufficient Pressure or Flow	
Symptom	Remedy
1. Wrong direction of rotation.	Reverse any two motor lead connections. Check driver O & M.
2. Discharge head too high.	Change system. Raise wet well level. Install larger propeller & driver.
3. Propeller running clearance too great.	Reset propeller clearance per O & M manual.
4. Insufficient suction bell submergence.	Raise wet well level.
5. Speed too low.	Check driver speed and voltage.
6. Bowl passage partially plugged.	Clean bowl passages.
7. Clogged suction.	Clean suction passages.
8. Low water level.	Raise wet well level.
9. Air in liquid.	Deaerate liquid. Increase submergence to prevent vortexing.
10. Improper sump design.	Change sump design. Increase submergence to prevent vortexing.
11. Propeller damaged.	Check and repair or replace.
12. Propeller too small.	Replace propeller. Check driver HP.

Loss of Suction Operation	
Symptom	Remedy
1. Low water level.	Raise wet well level.
2. Insufficient suction bell submergence.	Raise wet well level.
3. Wrong direction of rotation.	Reverse any two motor lead connections. Check driver O & M.
4. Air or gases in liquid.	Deaerate liquid. Increase submergence to prevent vortexing.

Excessive Power Consumption	
Symptom	Remedy
1. Improper propeller adjustment causing rubbing.	Readjust propeller clearance setting as outlined in this manual.
2. Head higher than rating, pumps operating under capacity.	Change system. Increase pump speed. Change propeller & check drive HP.
3. Speed too high.	Check driver speed and voltage.
4. Improper voltage to driver.	Check driver voltage. Change power source or driver.
5. Misalignment.	Check motor/pump to base connections. Realign coupling.
6. Packing box gland too tight.	Readjust packing gland.
7. Incorrect propeller.	Determine correct propeller and replace.
8. Shaft bent.	Replace shaft.
9. Specific gravity or viscosity of liquid pumped is too high.	Reduce pump capacity.
10. Pump partially plugged.	Backflow pump.

Excessive Packing Box Leakage	
Symptom	Remedy
1. Gland not properly tightened.	Adjust packing gland.
2. Worn packing or sleeve.	Replace packing and/or sleeve.
3. Ends of packing not staggered.	Repack to stagger packing ends.
4. Bypass is plugged or restricted.	Clean by-pass line.

Over-Heating	
Symptom	Remedy
1. Packing gland too tight.	Adjust packing gland.
2. Water flush line plugged.	Clean water flush line. (Use clean water.)
3. Shaft bent.	Replace shaft. Check alignment.

Vibration or Noise	
Symptom	Remedy
1. Foundation bolts loose or defect in grouting.	Tighten foundation bolts and/or regrout.
2. Worn pump bearings.	Replace pump bearings.
3. Pipe strain- improperly supported or aligned.	Improperly supported or aligned. Check pipe supports and adjust or realign.
4. Pumps operating excessively far from BEP.	Change system head. Change pump speed. Change propeller. Raise or lower water level.
5. Misalignment between driver and pump.	Realign driver and pump.
6. Shaft bent.	Replace shaft. Realign pump.
7. Pump running at shut-off condition.	Open discharge valve. Check for obstructions. Backflow pump.
8. Insufficient suction bell submergence.	Increase submergence.
9. Low water level.	Increase wet well level.
10. Air in liquid.	Increase submergence to prevent vortexing.
11. Foreign object in pump.	Remove foreign object. Check for damage.
12. Bad driver bearing.	Replace driver bearing.
13. Improper sump design.	Change sump design. Increase submergence to prevent vortexing.

MAINTENANCE

Preventive Maintenance

To assure satisfactory operation of the pump, scheduled inspection and periodic maintenance are required. We suggest an inspection and maintenance log be kept and the inspector immediately report any problems.

Open Lineshaft

This Fairbanks Morse model 8000 vertical propeller pump is supplied with product lubricated column and bowl bearings. The suction bell bearing is grease packed at the factory. It is not necessary to relubricate this bearing except when the pump is to be torn down for maintenance and the bowl assembly is to be disassembled.

A guide for preventive maintenance for normal applications is given below. Unusual applications with abnormal heat, moisture, dust, etc., may require more frequent inspection and service.

Item	Action Required
1. Packing box	a
2. Alignment	b
3. Vibration	b
4. Noise level	b
5. Driver bearings	c

Action Code

a. Should be checked on a weekly basis.

b. Should be monitored for changes on a yearly basis.

c. Follow driver manufacturer's instructions for driver bearing lubrication.

Grease Recommendation

Refer to the Technical Data section of this manual (Table #6) for grease recommendations.

Packing Adjustment

Generally, packed box pumps should be checked every 150 hours of operation and the glands should be readjusted if necessary.

Initial adjustment is accomplished by tightening the gland nuts finger tight.



- **Excessive tightening of the glands may cause shaft sleeve damage.**

Packing Replacement

For general service application with pump temperature 0° C to 93° C, use a good grade of soft, square, long fiber packing thoroughly lubricated and graphited.

For best results use only genuine Fairbanks Morse replacement packing. The replacement procedure should be as follows:

A. Stop the pump.

⚠ DANGER

- **Lock out electrical power to prevent accidental starting and causing possible personal injury.**

B. Unbolt and remove the gland.

C. Use a flexible packing tool * with a hook attachment for removal of the packing.

*The packing tool can be purchased from the factory or local supply house.

D. Clean the packing box and shaft sleeve.

E. Inspect the shaft sleeve for wear or rough finish and replace the sleeve with a Fairbanks Morse sleeve if necessary.

F. Install the new packing.

IMPORTANT

- **Stagger the packing end joints 180° and firmly seat each ring of packing as you install it.**

Refer to the technical data section for pertinent stuffing box and packing dimensions.

G. Reinstall the gland and tighten the gland nuts finger tight. After the pump has been started, adjust the glands so that there is a steady stream, approximately 1/8" diameter, from the packing box.

Oil Lubricated Enclosed Lineshaft

This Fairbanks Morse model 8000 vertical propeller pump is supplied with oil lubricated lineshaft bearings and product lubricated bowl bearings. The suction bearing is grease packed at the factory and only requires repacking when the unit is torn down for maintenance.

A guide for preventive maintenance for normal applications is given below. Unusual applications with abnormal heat, moisture, dust, etc., may require more frequent inspection and service.

Item	Action Required
Lubricator	a
Pump alignment	b
Vibration	b
Bearings	c
Driver Bearings	d

Action Code

- a. Check for adequate lubricant on a daily basis.
- b. Check for changes on an annual basis.
- c. Check to see that bearings are lubricated on a continuous basis.

- d. Follow driver manufacturer's instructions for driver bearing lubrication.

Oil Recommendation

Refer to the Technical Data section of this manual (Table #6) for oil recommendations.

Grease Recommendation

Refer to the Technical Data section of this manual (Table #6) for grease recommendations.

Water Flush Enclosed Lineshaft

This Fairbanks Morse model 8000 pump is supplied with water flush lubricated column and bowl bearings. The suction bearing is grease packed at the factory and only requires repacking when the unit is torn down for maintenance.

A guide for preventive maintenance for normal applications is given below. Unusual applications with abnormal heat, moisture, dust, etc., may require more frequent inspection and service.

Item	Action Required
Packing box	a
Pump alignment	b
Vibration	b
Lube System	c
Driver Bearings	d

Action Code

- a. Check for proper operation and excess leakage every 150 hours. Adjust packing gland or replace packing as required.
- b. Check for changes on an annual basis.
- c. Check lubrication system for proper operation on a daily basis.
- d. Follow driver manufacturer's instructions for driver bearing lubrication

Packing Box

All packing is subject to wear and should be given regular inspections. Generally, packed box pumps should be checked every 150 hours of operation and the glands should be readjusted if necessary.

Initial adjustment is accomplished by tightening the gland nuts finger tight.

⚠ CAUTION

- **Excessive tightening of the glands may cause shaft sleeve damage.**

Packing Replacement

For general service application with pump temperature 32° F to 200° F (0°C- 93°C) use a good grade of soft, square, long fiber packing thoroughly lubricated and graphited.

For best results use only Fairbanks Morse replacement packing. The replacement procedure should be as follows:

- A. Stop the pump.

DANGER

- **Lock out electrical power to prevent accidental starting and causing possible personal injury.**
- B. Unbolt and remove the gland.
- C. Use a flexible packing tool* with a hook attachment for removal of the packing.
- *The packing tool can be purchased from the factory or local supply house.
- D. Clean the packing box and shaft sleeve.
- E. Inspect the shaft sleeve for wear or rough finish and replace the sleeve with a Fairbanks Morse sleeve if necessary.
- F. Install the new packing.

IMPORTANT

- **Stagger the packing end joints 180° and firmly seat each ring of packing as you install it.**

Refer to the technical data page for pertinent stuffing box, and packing dimensions.

- G. Reinstall the gland and tighten the gland nuts finger tight. After the pump has been started, adjust the glands so that there is a steady stream, approximately 1/8" diameter, from the packing box. Refer to Figure #7 for flush water requirements.

Grease Recommendation

Refer to the Technical Data section of this manual (Table #6) for grease recommendations.

Pump Disassembly

WARNING

- **Read this entire disassembly procedure and refer to the sectional drawings in this manual before starting.**

Major maintenance beyond lubrication, adjustment of wear ring clearance, and replacement or adjustment of the packing will require disassembly of the pump. The following are step-by-step instructions and are essentially the reverse of the installation procedure.

Vertical Hollow Shaft (VHS) Driver

- A. Stop the pump and lock out the power to the driver. Close the discharge valve. Disconnect the electrical cables from the driver. Disconnect and remove gauges and all other auxiliary piping. (Stuffing box lubrication, oil, or grease lines, etc.)

DANGER

- **Check with proper electrical testing equipment to be certain all electrical power to the driver and accessories associated with the pump is disconnected.**
- B. Remove the driver cover, adjusting nut lockscrew, and gib key. Lower the shaft until the propeller rests on the bowl seat. Remove the adjusting nut and driver coupling.
- C. Disconnect the shaft coupling under the driver (if used) and remove the top shaft. Remove the capscrews holding driver to discharge head or pedestal.
- D. Lift the driver from the head and set aside.

Vertical Solid Shaft (VSS) Driver

- A. Stop the pump and lock out the power to the driver. Close the discharge valve. Disconnect the electrical cables from the driver. Disconnect and remove gauges and all other auxiliary piping. (Stuffing box lubrication, oil, or grease lines, etc.)

DANGER

- **Check with proper electrical testing equipment to be certain all electrical power to the driver and accessories associated with the pump is disconnected.**
- B. Remove the bolts holding the coupling halves together slowly so that the propeller does not drop.
- C. Remove the capscrews holding driver to discharge head or pedestal.
- D. Lift the driver from the head and set aside.

Open Lineshaft (Refer to Drawing #7000A041)

- A. Remove and disassemble the pump head, the column, packing box and shafting according to the following procedure which is essentially the reverse of the installation procedure.
- B. Remove the packing gland bolts (8, 8A), glands (9), water slinger (6) and packing (15).
- C. Loosen and remove all the discharge piping flange bolts.

⚠ WARNING

- Use a guide rope to go from the sling joint, above the head and attach to the discharge flange. This will keep the head from tipping over, possibly causing personal injury.

- D. Remove the packing box bolts and remove the packing box from the head and shaft to a work area for inspection & cleaning.

The packing box bearing (17A) is an interference fit in the packing box. The removal of this bearing will require the use of a mechanical press or the bearing may be removed by machining or other similar methods. Use care when removing bearings to not damage bores or hubs.

⚠ CAUTION

- Always use protective eyewear.
- E. Lift entire unit with the lifting lugs and install a column clamp just below the upper column flange leaving room to remove the flange bolting. Lower unit so that the column clamp rests on adequate supports.

⚠ DANGER

- Use a crane or hoist of adequate capacity to prevent serious personal injury.
- F. Remove the bolts holding the column to the discharge head. Lift the discharge head off the unit and set aside.

Flanged Column

- A. Install eyebolts of sufficient size in the column flange holes, lift the unit and reposition the clamp below the next column flange.
- B. Use column and shaft clamps (or other acceptable method) to safely support and lift this assembly.
- C. Unbolt column flange and lift column enough to loosen the shaft coupling. When all components are loose, carefully lift this assembly from the pump unit. With soft skid boards under the column to protect the flange, slowly lower the column and shaft assembly onto the floor and move to a convenient work area.

IMPORTANT

- Shaft threads are left-hand.
- D. Repeat above steps A, B, and C until all column and shaft sections have been removed from the unit.
- E. Remove the bearing retainer assembly for inspection and cleaning. (Sizes 16" and larger bearing retainers are welded in place.)
- F. Remove shaft section from column pipe. Remove couplings from shafts and inspect for wear or damage.

- G. Inspect bearings and retainers for damage.

- H. If the top and intermediate drive shaft sleeves (13 & 29) show wear or damage remove the sleeve by heating it to 350° F - 400° F to break the Loctite® bond.

IMPORTANT

- Measure and record the position of the sleeves (13 & 29) on the shafts before removal. They must be put back in exactly the same place.

⚠ CAUTION

- To prevent possible serious personal injury always wear heat resistant gloves when handling heated parts.
- I. Refer to Pump Bowl Disassembly for detailed bowl disassembly procedures.

Threaded Column

- A. Install eyebolts of sufficient size in the column flange holes, lift the unit and reposition the clamp below the next column coupling.
- B. Use column and shaft clamps (or other acceptable method) to safely support and lift this assembly.
- C. Unscrew the column coupling and lift column enough to loosen the shaft coupling. When all components are loose, carefully lift this assembly from the pump unit. With soft skid boards under the column to protect the threads, slowly lower the column and shaft assembly onto the floor and move to a convenient work area.

IMPORTANT

- Shaft threads are left-hand.
 - Column threads are right-hand.
- D. Repeat above steps A, B, and C until all column and shaft sections have been removed from the unit.
- E. Remove the bearing retainer assembly for inspection and cleaning.
- F. Remove shaft section from column pipe. Remove couplings from shafts and inspect for wear or damage.
- G. Inspect bearings and retainers for damage.
- H. If the top and intermediate drive shaft sleeves (13 & 29) show wear or damage remove the sleeve by heating it to 350° F - 400° F to break the Loctite® bond.

⚠ CAUTION

- To prevent possible serious personal injury always wear heat resistant gloves when handling heated parts.

⚠ CAUTION

- Measure and record the position of the sleeves (13 & 29) on the shafts before removal. They must be put back in exactly the same place.

I. Refer to **Pump Bowl Disassembly** for detailed bowl disassembly procedures.

Enclosed Lineshaft

Oil Lubricated (Refer to Drawing #7000A043).

Remove and disassemble the pump head, the column, tension nut and shafting according to the following procedure which is essentially the reverse of the installation procedure.

- A. Loosen and remove the tube tension nut (63) and set aside for inspection.
- B. Loosen and remove all the discharge piping flange bolts.

⚠ DANGER

- Use a guide rope to go from the sling joint, above the head and attach to the discharge flange. This will keep the head from tipping over, possibly causing personal injury.
- C. Lift entire unit with the lifting lugs and install a column clamp just below the upper column flange leaving room to remove the flange bolting. Lower unit so that the column clamp rests on adequate supports.

⚠ DANGER

- Use a crane or hoist of adequate capacity to prevent serious personal injury.
- D. Remove the bolts holding the column to the discharge head. Lift the discharge head off the unit and set aside.
- E. Refer to **Pump Bowl Disassembly** for detailed bowl disassembly procedures.

Enclosed Lineshaft

Water Flush (Refer to Drawing #7000A045)

- A. Remove the packing gland bolts (8, 8A), glands (9), water slinger (6) and packing (15).
- B. Disconnect the water flush supply line.
- C. Loosen and remove the packing box (17) and connector bearing (50). Set aside for inspection.
- D. Loosen and remove all the discharge piping flange bolts.

⚠ DANGER

- Use a guide rope to go from the sling joint, above the head and attach to the discharge flange. This will keep the head from tipping over, possibly causing personal injury.

- E. Lift entire unit with the lifting lugs and install a column clamp just below the upper column flange, leaving room to remove the flange bolting. Lower unit so that the column clamp rests on adequate supports.

⚠ DANGER

- Use a crane or hoist of adequate capacity to prevent serious personal injury.
- F. Remove the bolts holding the column to the discharge head. Lift the discharge head off the unit and set aside.
- G. Refer to **Pump Bowl Disassembly** for detailed bowl disassembly procedure.

Flanged Column

- A. Install eyebolts of sufficient size in the column flange holes, lift the unit and reposition the clamp below the next column flange.
- B. Use column and shaft clamps (or other acceptable method) to safely support and lift this assembly.
- C. Unbolt column flange and lift column enough to loosen the enclosing tube. Continue to lift the assembly until the shaft coupling can be loosened. When all components are loose, carefully lift this assembly from the pump unit. With soft skid boards under the column to protect the flange, slowly lower the column, tube and shaft assembly onto the floor and move to a convenient work area.

IMPORTANT

- Shaft threads are left-hand.
- Enclosing tube threads are left-hand.
- D. Repeat above steps A, B, and C until all column and shaft sections have been removed from the unit.
- E. Remove shaft and tube section from column pipe. Remove the shaft from the tube section. Remove couplings from shafts and inspect for wear or damage.
- F. Inspect connector bearings (50) for wear or damage.
- G. Refer to **Pump Bowl Disassembly** for detailed bowl disassembly procedures.

Threaded Column

- A. Install eyebolts of sufficient size in the column flange holes. Lift the unit and reposition the clamp below the next column coupling.
- B. Use column and shaft clamps (or other acceptable method) to safely support and lift this assembly.
- C. Unscrew the column coupling and lift column enough to loosen the enclosing tube. Continue to lift the assembly until the shaft coupling can be loosened. When all components are loose, carefully lift this assembly from the

pump unit. With soft skid boards under the column to protect the threads, slowly lower the column, tube and shaft assembly onto the floor and move to a convenient work area.

IMPORTANT

- **Shaft threads are left-hand.**
 - **Enclosing tube threads are left-hand.**
 - **Column threads are right-hand.**
- D. Repeat above steps A, B, and C until all column and shaft sections have been removed from the unit.
- E. Remove shaft and tube section from column pipe. Remove the shaft from the tube section. Remove couplings from shafts and inspect for wear or damage.
- F. Inspect connector bearings (50) for wear or damage.
- G. Refer to **Pump Bowl Disassembly** for detailed bowl disassembly procedures.

8211 Bowl Disassembly

- **Read this entire procedure before starting disassembly.**

Select a clean area for work. Refer to assembly drawing and parts list for part identification. Measure and record the shaft end play.

For disassembly of the pump bowls, proceed according to the steps listed below:

- A. Remove the Shaft Coupling (31).
- B. Remove the capscrews and nuts holding the discharge bowl (33) to the suction bowl (40), or intermediate bowl (36) if multi-stage.
- C. Lift the discharge bowl off the pump shaft (32) and set aside for inspection.
- D. Remove the upper snap ring from the pump shaft.
- E. Remove the propeller (38) from the pump shaft and key (97).
- F. Remove the lower snap ring (27) from the pump shaft.
 1. Bowl sizes 24", 30" & 36" use thrust rings (27A) secured by a snap ring.
- G. Remove the capscrews and nuts holding the intermediate bowl, multi-stage bowls only, to the suction bowl.
 1. Remove the intermediate bowl.
- H. Repeat steps E & F to remove the next propeller.
 1. Remove the shaft from the suction bowl.
- J. Measure and record the location of the sand collar (58).

1. Remove the sand collar only if it is damaged and replacement is required.
- K. The pump bowl assembly is now disassembled and ready for inspection.
- L. Refer to **Inspection for Replacement** section of this manual and inspect all components prior to reassembly.

8211 Bowl Assembly

- A. Prior to starting to reassemble the pump bowl the following should be done.
 1. Clean all components before starting the assembly.
 2. Remove the pipe plug (59) from the suction bowl and remove the old grease. Repack with a good grade of multi-purpose grease. Refer to the Technical Data section of this manual (Table #6) for grease recommendations. Replace the pipe plug.
 3. Apply grease to the bowl registers to improve assembly alignment.
 4. Install bearings in their respective bowls if they have been removed. If they have not been replaced, they should be cleaned and lubricated with a thin film of grease.
 5. Install new liner(s) if it is to be added or replaced. Refer to **Liner Replacement** for retrofitting a liner or if liner replacement is indicated.
 6. Layout the parts in the order in which they will be assembled.
 7. Proceed with assembly of the pump bowls.
- B. Put the suction bowl (40) in a vertical position.



- **Block the bowl assembly from rolling.**
- C. Install the sand collar (58), if it has been removed, in the exact position as previously measured in J. Secure with set-screws.
 1. Insert the pump shaft (32) into the bearing as far as it will go.
 - D. Install the lower snap ring (27) on the pump shaft.
 1. For bowl sizes 24", 30" & 36" insert the thrust rings (27A) secured by snap ring.
 - E. Install the propeller key (97) in the pump shaft keyway.
 1. Check the key for fit prior to starting to assemble the propeller. It may be necessary to dress the key to ensure a proper fit in the keyways.
 - F. Install the propeller over the pump shaft and position over the key and against the snap ring (thrust rings on 24", 30" & 36" bowl sizes).
 - G. Install the upper snap ring in the pump shaft against the propeller hub.

- H. Install the intermediate bowl (36) and tighten capscrews & nuts. (Multi-Stage Bowl Assemblies only).
- I. Repeat steps D, E, F & G to install second stage propeller. (Multi-Stage Bowl Assemblies only).
- J. Install the discharge bowl (33) and tighten capscrews & nuts.
 - 1. Check the shaft end play.
 - 2. It should be the same as previously recorded (or very close). If it is not, the bowl assembly should be disassembled to determine the reason.
- K. Install the coupling (31) on the pump shaft.
- L. The bowl assembly is now complete.
- M. Refer to the **INSTALLATION SECTION** of this manual to complete pump assembly and reinstallation.

8312 Bowl Disassembly

- **Read this entire procedure before starting disassembly.**

Select a clean area for work. Refer to assembly drawing and parts list for part identification. Measure and record the shaft end play. For disassembly of the pump bowls, proceed according to the steps listed below.

NOTE: 24-inch bowls are equipped with a bowl seat section (99) which is connected to the suction bowl (40) or intermediate bowl (36). It is unnecessary to disconnect the bowl seat section unless replacement of either it or the bowl is required.

- A. Remove the shaft coupling (31).
- B. Remove the capscrews and nuts holding the discharge bowl (33) to the suction bowl (40), or intermediate bowl (36) if multi-staged.
- C. Lift the discharge bowl off of the pump shaft (32) and set aside for inspection.
- D. Remove the locknut (37), collet (39) and propeller (38) from the pump shaft according to the following procedure.
 - 1. Drive the collet from the propeller.
 - 2. Remove the propeller from the pump shaft. Set aside for inspection.
 - 3. To remove the collet from the pump shaft, insert a screwdriver in the collet slit and wedge apart; the collet will slide easily off of the shaft.
 - 4. Remove the propeller key (24" & 30" bowls only).
- E. Remove the capscrews and nuts holding the intermediate bowl (36) to the suction bowl. (Multi-Stage Assemblies only).
- F. Remove the locknut, collet and propeller from the pump shaft as in D above.

- G. Remove the intermediate bowl capscrews and remove the intermediate bowl. (Multi-Stage Bowl Assemblies only).
- H. Remove the pump shaft from the suction bowl.
 - I. Remove the sand collar (58).
- J. The pump bowl assembly is now disassembled and ready for inspection.
- K. Refer to **Inspection For Replacement** section of this manual and inspect all components prior to reassembly.

8312 Bowl Assembly

- A. Prior to starting to reassemble the pump bowl, the following should be done:
 - 1. Clean all components before starting the assembly.
 - 2. Remove the pipe plug (59) and remove the old grease.
 - 3. Apply grease to the bowl registers to improve assembly alignments.
 - 4. Install bearings in their respective bowls if they have been removed. If they have not been replaced, they should be cleaned and lubricated with a thin film of grease.
 - 5. Install new liner(s) if it is to be added or replaced. Refer to **Liner Replacement** for retrofitting a liner or if liner replacement is indicated.
 - 6. Layout the parts in the order in which they will be assembled.
 - 7. Proceed with assembly of the pump bowl.
- B. Put the suction bowl (40) in a horizontal position and block from rolling.
 - 1. Insert the pump shaft (32) into the bearing.
 - 2. Insert a shaft locating tool (See assembly tools in the technical data section of this manual) through the pipe tap in the suction bowl and secure to the pump shaft.
- C. Install the sand collar (58) tight against the bearing and secure with setscrews.
 - 1. Put the suction bowl and shaft in a vertical position for the balance of the assembly procedures.



- **Block the bowl from rolling.**
- D. Open a lock collet (39) slightly and slide over the pump shaft into approximate propeller location.
 - 1. 24" & 36" bowls use a key (97) in addition to the collet. Install the key in the pump shaft keyway and position a collet over the key.
 - 2. Check the key for fit prior to starting to assemble the propeller. It may be necessary to dress the key to ensure a proper fit in the keyways.

E. Install the propeller (38) over the pump shaft and position on the lock collet.

1. The bushing does not slip on the shaft, but rather the propeller will slip "in" over the bushing when the lock nut is drawn up tight. Allowance must be made for this before starting to tighten the locknut.
2. Screw on the lock nut by hand. Move the propeller and bushing toward the bowl seat until there is 3/32" to 1/8" clearance between the propeller vanes and the bowl seat.
3. Tighten the lock nut until the vanes contact the bowl seat. When the propeller is getting very close to the bowl seat, test it by tapping very lightly with a small hammer or metal object. When it is tight against the bowl seat it will sound dull. If it is not in contact, the sound will ring clear.

NOTE: A spanner wrench with a handle length of 20 times the pump shaft diameter is recommended.

IMPORTANT

- **The propeller should not be forced against the bowl seat by the locknut. The locknut must tighten on the bushing just as the propeller contacts the bowl seat area. If this does not happen, reposition the propeller and repeat the procedure.**
 - **Failure to properly tighten the propeller lock collet may result in damage to the pump.**
4. After the locknut is tight, use a center punch to punch a burr on the propeller hub into a notch in the lock nut to prevent it from working loose.
- F. Install the intermediate bowl (36) and tighten capscrews & nuts (Multi-Stage Bowl Assemblies only).
- G. Repeat steps D, E, & F to install the second stage propeller. (Multi-Stage Bowl Assemblies Only).
- H. Install the discharge bowl (33) and tighten capscrews & nuts.
- I. Remove the bolt holding the pump shaft locating tool in place.
1. Check the shaft end play.
 2. It should be the same as previously recorded (or very close). If it is not, the bowl assembly should be disassembled to determine the reason.
 3. Repack with a good grade of multi-purpose grease. See the list of recommendations in the technical data section of this manual.
 4. Replace the pipe plug.
- J. Install the coupling (31) on the pump shaft.
- K. The bowl assembly is now complete.
- L. Refer to the **INSTALLATION SECTION** of this manual to complete pump assembly and reinstallation.

Inspection For Replacement

After the components are disassembled, each part should be thoroughly cleaned and inspected for wear and physical damage.

It is not necessary to remove bearings unless inspection indicates replacement is necessary. If it is necessary to remove bearings, they should be pressed from their seats and discarded.

IMPORTANT

- **Use care not to damage bores or hubs during bearing removal.**

Any parts showing signs of excessive wear or damage should be replaced with Fairbanks Morse parts.

- A. Inspect the shafting (23) at each bearing location for damage or excessive wear and replace shaft if not salvageable.
 1. Open lineshaft construction requires the use of shaft sleeves (13, 29). These sleeves should be inspected for wear and replaced as necessary.
- B. Inspect all lineshaft bearings (50) and tension nut (63) bores for damage and wear. If the diametral bearing clearance exceeds the limits shown in Table #7, the bearings must be replaced.
 1. Open lineshaft pumps use a rubber bearing (26) and a packing box bushing (17A).
- C. Inspect all bowl bearings, (34, 35, 41 & 50) for wear & excessive clearance. If the diametral bearing clearance exceeds the limits shown in Table #7, the bearings must be replaced.
- D. Inspect the propeller/bowl contact area for wear and excessive clearance. If the clearance exceeds the limits shown in Table #7, the propeller/bowl must be replaced or retrofitted with liners. Refer to the **Liner Replacement** section of this manual.

Bowl Seat (or Liner) and Propeller Wear Limits

The Model 8312 propeller has a conical outside diameter and operates in a conical bowl seat (or liner), it is always possible to lower the propeller and achieve the prescribed clearance between the propeller and the bowl seat. The propeller/bowl seat wearout limits are therefore not directly measurable. Rather, the general condition of the bowl seat (or liner) and the condition of the propeller tips should be the criteria for replacement. If either the propeller tips or the bowl seat are worn in an extremely convoluted or uneven manner, they should be replaced. At the lower most position, all propeller tips should contact the bowl seat evenly and completely across the entire face of the propeller tip. Propellers which are bent or obviously damaged should be replaced. Bowl liners which fit loosely in the bowl should be resecured or replaced.

Any noticeable change in operating conditions, i.e., loss in capacity, drop in head or lower amp draw at driver could be an

indicator of a worn propeller and/or liner and may or may not be totally recoverable by propeller adjustment.

It is noteworthy that any significant degree of wear on the propeller tips will allow it to be lowered further down into the bowl seat before contact. In some cases, the sand collar located below the propeller may settle on the suction bell bearing before the propeller contacts the bowl seat. If such a condition exists, it will be necessary to a) loosen the sand collar, b) lower and reset the propeller and, c) reset the sand collar about 1/8" above the suction bell bearing.

Fairbanks Morse Field Service should be consulted prior to any attempts to weld or remachine propellers, bowl seats or liners.

Bowl Liner

If the pump is equipped with a bowl liner and replacement is required, refer to **Liner Removal** below.

If this bowl assembly is to be fitted with a bowl liner, and was not equipped with a bowl liner at the factory, contact the factory for correct dimensions.

IMPORTANT

- Machine work should be done by a qualified machinist experienced in similar machining work.

Liner Removal

Remove the bowl liner according to the following procedure:

1. Remove the setscrews (if supplied) holding the liner in place.
2. Remove the liner by tapping several places around the liner until it is loose.
3. Split the liner with a chisel or other similar means and remove from the bowl seat.
4. As an option, the liner can be machined until it is loose and can be removed from the bowl seat.

IMPORTANT

- Care should be used to avoid damage to the bowl seat.



- To prevent possible serious personal injury, extreme care should be exercised to select the proper grinding equipment. Approved safety glasses must be worn when grinding or machining.

Liner Installation

If the liner is to be replaced, it should be replaced with a Fairbanks Morse bowl liner. Install the liner as follows:

- A. Thoroughly clean the area where the liner will be installed.

- B. Liners are installed and secured with Loctite®. Setscrews may also be used on some sizes of Model 8312 bowl assemblies.

- C. Install the liner in the bowl according to the following procedure.

NOTE: To ensure proper bonding, thoroughly clean all mating parts with solvent to remove all grease, oil, dirt, etc.

1. Apply two beads of Loctite® No. 609 completely around the liner.
2. Install the liner in the bowl and rotate it to spread the Loctite®. Check to see that the liner is properly seated.

- D. If set screws were supplied, drill and tap the same size and quantity of holes as were originally supplied. Install the set screws.

IMPORTANT

- Care should be used to avoid damage to the bowl liner seat.

- E. Proceed with reassembly.

Shaft Straightness

Prior to installation or reassembly, bowl shafts and lineshafts should be checked for straightness. The maximum allowable total indicated runout must be less than .005".

The drawing below outlines the proper positions at which dial indicator readings should be taken. The shaft should be supported in V-blocks or on rollers as shown. Position the dial indicator and zero the dial face. Slowly rotate the shaft and observe the maximum runout.

If the shafts exceed the .005" maximum limit, straightening will be required. Consult the Fairbanks Morse factory for straightening recommendations, or a local qualified machine shop.

Keyed Lineshaft Couplings

On some large pumps or specified applications, Fairbanks Morse employs keyed lineshaft couplings Type 1 or Type 2 rather than threaded couplings, see Drawing #8000-M093. On these configurations, the end of the lineshafts are keyed and a precision bored coupling with an internal keyway is installed over the shaft ends.

Shafts also have annular grooves at the ends of the keyways to accommodate the installation of split thrust rings.

Type 1:

Prior to assembly, it is beneficial to position coupling parts and shafts in orderly series to assure that assembly is in proper sequence. For the Type 1 coupling, assembly is accomplished by sliding the coupling and coupling caps onto the respective shaft ends. Butt the two shaft ends together and install the key so that it engages the keyways of both shafts. Slide the coupling over the keyed shaft ends. Install the split thrust rings into the

annular shaft grooves on each shaft. Slide the coupling caps over the thrust rings and bolt in place. Assembly is complete. Disassemble in reverse order.

Type 2:

Prior to assembly, it is beneficial to position coupling parts and shafts in orderly series to assure that assembly is in proper sequence. For the Type 2 couplings, setscrews are used over the keys and the split thrust rings are held in position by the coupling. It should also be noted that the shaft ends which are intended to be positioned in the lower half of the coupling joint are shouldered to limit vertical movement of the coupling should any unexpected failure occur. The shaft ends which are to be positioned in the upper half of the coupling joint are undercut to

allow for the coupling to be positioned on the upper shaft for installation of the split thrust ring and keys. Slide the coupling on the upper shaft. Install the vertical key in this shaft and slide the coupling over the key, install the thrust ring. Continue to lower the coupling over the thrust ring. Install the lower key and continue to lower the coupling over the key, with the couplings final position to be just above the shoulder. Firmly tighten the setscrews. Assembly is now complete. Disassemble in reverse order.

It should be noted that as previously stated, both of these coupling types are precision machined and the normal hand fitting by removal of burrs and small imperfections are required and should be expected.

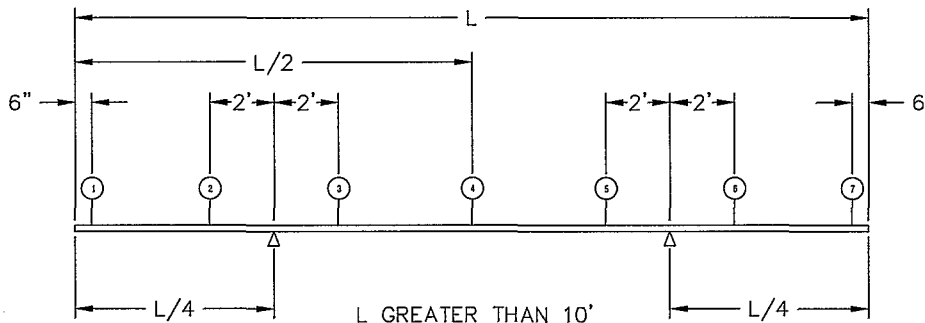
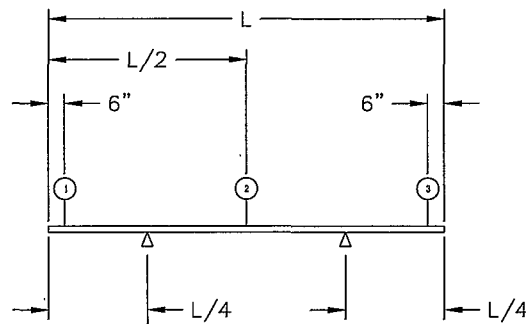


FIGURE 1



$L = 10'$ OR LESS

FIGURE 2

Mechanical Seals

(Refer to Drawing #7000A081)

The mechanical seal covered by these instructions, when properly installed, will give satisfactory performance. To ensure the proper installation these instructions should be read carefully.

Description

Several types of mechanical seals are used. The most common types are the single inside seal, single outside seal and a cartridge type seal. Since seals supplied by different vendors may vary slightly these instructions are general in nature. Refer to any specific seal installation instructions that may be supplied with your pump or contact the factory.

General Application

The seals described in these instructions are acceptable for use in pumps handling water. It is not recommended for handling fluids which are highly acidic, highly alkaline, or contain gritty or dissolved substances that tend to crystallize.

Installation

Prior to installation inspect the seal, seal housing and sleeve to make sure they are clean and free from burrs, nicks, dirt, rust, or any foreign material. Apply a light coat of liquid soap or liquid detergent to the shaft sleeve (13).

IMPORTANT

- **Seal faces are lapped and polished to a mirror finish. It is imperative that sealing faces be handled with care and kept perfectly clean. DO NOT touch the sealing faces.**

Inside Single Seal

Use the following general procedure to install this type of seal prior to installing the motor.

- Remove the packing box capscrews (431A) which hold the seal housing (17B) to the discharge head (or the driver pedestal).
- Install the seal box gasket (11) onto the seal housing.
- Adjust the impellers per instructions in this manual.
- With scribe or marker, place a mark on the sleeve that is level with the seal housing (17B) face.
- Position the end of the rotating seal (456) flush with the mark on the sleeve and tighten the locking screw.
- Install the stationary seat (456A) into the seal gland (431) using an o-ring lubricant or liquid soap on the o-ring.
- Pull the seal gland (431) down and secure with capscrews (431A).
- If used, connect piping to seal gland (431).

IMPORTANT

- **The seal gland must be piped to purge all air out of the seal housing cavity.**

Outside Single Seal

Use the following general procedure to install this type of seal prior to installing the motor:

- Remove the packing box capscrews (431A) which hold the seal housing (17B) to the discharge head (or driver pedestal).
- Install the seal box gasket (11) onto the seal housing.
- Install the seal gland (431) containing the stationary seat (456A) on the seal housing face and secure with packing box capscrews.
- Install the rotating seat (456) and retainer (456B) over the sleeve. Do not fasten the retainer to the sleeve until impellers have been properly adjusted.
- Refer to Table #4 and Table #5 and adjust the impellers.
- Compress the retainer and rotating assembly until the correct spring gap is attained. The gap is stamped on the seal retainer or may be included with the seal manufacturers printed instructions.
- Secure the retainer ring with setscrews.

Cartridge Seal

Use the following general procedure to install this type of seal prior to installing the motor:

- Remove the packing box capscrews (431A) which hold the seal housing (17B) to the discharge head (or driver pedestal).
- Install the seal box gasket (11) onto the seal housing.
- Install the seal (456), gland (431) and retainer (456B) over the sleeve and into position on the seal housing and secure with packing box capscrews.
- Refer to Table #4 and Table #5 and adjust the impellers.
- After the impellers have been adjusted, fasten the seal lock ring to the sleeve using setscrews provided.
- Loosen the retainer clips and rotate 90° and retighten the clip setscrews. These clips will be used if the seal is removed for any reason.

Operation

Special operating techniques are involved when using pumps equipped with mechanical seals. Certain precautions should be taken as follows:

- The seal should never be operated dry, even to check for rotation. A water source must be provided to cool and lubricate the seal faces during pump operation. The lube water can be either the pumped media or an external water source (refer to Figure #8 and Figure #9).
- If the pumped media is used for seal cooling and lubrication, a vent line must be provided to prevent air entrapment in the seal cavity (refer to the Technical Data Section). If an outside water source is used, a solenoid valve should be set to introduce seal water at or slightly before each motor start.
- Some seals may leak slightly at initial start-up. This condition should cease after a short period as the seal faces lap together. Operate and monitor the seal until leakage subsides.

Routine Maintenance

Routine maintenance is minimal and is as follows:

- Periodically (150 hours of operation) check to see that pumped liquid is going through stuffing box and out to wet well or drain.
- Check that the gland bolts have not loosened.

Seal Removal

General

Stop the driver and lock out the power so that the driver can not accidentally start.

⚠ DANGER

Check with proper electrical testing equipment to be certain all electrical power to the driver and accessories associated with the pump is disconnected.

Single Inside Seal

- A. Loosen the packing box capscrews (431A).
- B. Raise the gland (431) and loosen the setscrews securing the retaining ring to the sleeve.
- C. Use the adjusting nut and lower the impellers until they rest on the bowl seats.
- D. Loosen the shaft coupling. Remove the driver shaft (19), (or the VSS motor, or the coupling spacer).
- E. Remove the seal gland (431).
- F. Remove the seal rotating seat and retainer.
- G. *Inspect all parts of the seal. If any parts show signs of wear, the complete seal should be replaced.*

Single Outside Seal

- A. Loosen the retainer ring setscrews.
- B. Use the adjusting nut and lower the impellers until they rest on the bowl seats.

- C. Loosen the shaft coupling. Remove the driver shaft (19), (or the VSS motor or the coupling spacer, or VHS motor if one-piece headshaft).
- D. Loosen the capscrews securing the gland (431) to the seal housing. Remove the seal rotating assembly and the gland which contains the stationary seat.
- E. *Inspect all parts of the seal. If any parts show signs of wear, the complete seal should be replaced.*

Cartridge Seal

- A. Loosen the retainer clips and rotate 90° to secure the seal lock ring. Retighten the setscrews.
- B. Loosen the setscrews securing the lock ring to the sleeve.
- C. Use the adjusting nut and lower the impellers until they rest on the bowl seats.
- D. Loosen the shaft coupling. Remove the driver shaft (19), (or the VSS motor, or the coupling spacer.)
- E. Loosen the capscrews securing the gland (431) to the seal housing. Remove the seal assembly.
- F. *Inspect all parts of the seal. If any parts show signs of wear, the complete seal should be replaced.*

The O-rings may be replaced if necessary. Refer to the manufacturer's printed instructions shipped with the seal.

Maintenance History

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REPAIR PARTS

Ordering Parts

When ordering parts, give pump serial number, size, model number, a complete description, and item number of each part. Refer to the drawing and parts list in the back of this manual. You may order parts from your local Fairbanks Morse distributor. Consult your local telephone yellow pages under "Pumps" for the office nearest you.

You may also contact Fairbanks Morse directly as follows.

Kansas City, Kansas
Fairbanks Morse Pump Corporation
3601 Fairbanks Ave.
P.O. Box 6999
Kansas City, KS 66106-0999
(913) 371-5000
Fax (913) 371-2272

Fresno, California
Fairbanks Morse Pump Corporation
2790 South Railroad
Fresno, CA 93725
(209) 266-0828
Fax: (209) 266-5341

Returning Parts

All materials or parts returned to the factory must have prior approval and a "Returned Goods Tag", listing the material to be returned and the reasons for the return. All material to be returned should be carefully packed to avoid damage in route from rough handling or exposure to weather. Contact the factory for shipping instructions. All material is to be returned freight prepaid.

Fairbanks Morse makes improvements on its products from time to time and reserves the right to furnish improved parts for repairs. A part that is received and is not identical in appearance, or has a different symbol from the original part, may be interchangeable. Examine the part carefully before contacting your Fairbanks Morse representative. The parts should never be returned to the factory without first obtaining proper authorization from your Fairbanks Morse representative.

SERVICE

Warranty Service

For Warranty Service contact the facility from which your pump was shipped.

Shipping facilities addresses:

Kansas City, Kansas
Fairbanks Morse Pump Corporation
P. O. Box 6999
3601 Fairbanks Ave.
Kansas City, Ks. 66106-0999
(913) 371-5000
Fax: (913) 371-2272

Fresno, California
Fairbanks Morse Pump Corporation
2790 South Railroad
Fresno, Ca. 93725
(209) 266-0516
Fax: (209) 266-5341

Service After Warranty

For service after warranty on this pump or any other pumping equipment contact your local Fairbanks Morse distributor or call the factory repair group:

Pump Services Group, 1-800-648-PUMP (7867)

Or Write:

Pump Services Group
Fairbanks Morse Pump Corporation
P.O.Box 6999
3601 Fairbanks Ave.
Kansas City, Ks. 66106-0999
(913) 371-5000
Fax: (913) 371-2272

TECHNICAL DATA

Table #1

Bowl Size	Shaft End Play (inches)	Propeller Position
8211		
8"	0.81	Measure end play. Values given are nominal $\pm .045"$. Center propeller between measured end play.
10"	0.63	
12"	0.82	
20"	0.62	
24"	1.62	
30"	0.75	
36"	0.99	
8312		
10"	0.430	Raise propeller .062" vertically off the bottom.
12"	0.385	
14"	0.425	
16"	0.720	
20"	0.750	
24"	0.460	
30"	0.910	

Table #2

Tube Tension Torque Values For Oil Lube Tension Nut	
Enclosing Tube Size	Required Torque (Ft/Lbs)
2"	400 ft. lbs.
2-1/2"	400 ft. lbs.
3"	800 ft. lbs.
3-1/2"	800 ft. lbs.
4"	1200 ft. lbs.
5"	1200 ft. lbs.

Table #3

Tube Tension Torque Values For Water Flush Packing Box		
Enclosing Tube Size	Installation and Removal Tool	Required Torque (Foot-Pounds)
2"	MS1380A	400 ft. lbs.
2-1/2"	MS1380A	400 ft. lbs.
3"	MS1380B	800 ft. lbs.
3-1/2"	MS1380B	800 ft. lbs.
4"	MS1380C	1200 ft. lbs.
5"	MS1380C	1200 ft. lbs.

Table #4

Shaft Movement

The table below gives the amount of vertical movement of the shaft according to the number of turns of the adjusting nut.

Number Turns	Shaft Diameter							
	1	1 1/4	1 1/2	1 11/16	1 15/16	2 3/16	2 11/16	2 15/16
1	.07	.10	.10	.10	.10	.10	.10	.10
2	.14	.20	.20	.20	.20	.20	.20	.20
3	.21	.30	.30	.30	.30	.30	.30	.30
4	.28	.40	.40	.40	.40	.40	.40	.40
5	.35	.50	.50	.50	.50	.50	.50	.50

Table #5

Coupling Size	Torque (Ft. Lbs.)
1125	13
1625	26
2125	115
2625	115
2875	115
3125	115
3875	400
4000	550
6000	835
7200	835

TECHNICAL DATA

Table #6 Typical Lubricants

System Type	Grease	Oil
Non-Potable	N.L.G.I. #2 Lithium base multi-purpose grease with a mineral-based oil, viscosity of 750-1050 SSU at 100° F and 75-82 SSU at 210° F.	High quality grade of non-detergent oil with an API/SAE 10W Rating
	Suggested Manufacturer's: Atlantic RichfieldARCO MP#2 GulfGulfcrown #2 SinclairLitholine MP#2 Texaco Marfak #958, MP12	Suggested Manufacturer: Mobil Sinclair Texaco
Potable	N.L.G.I. #2 meeting FDA Regulation.178.3570 and has USDA Type H-1 and FDA approvals for lubricants with incidental food contact.	USDA and FDA approved.
	Suggested Manufacturer's: Chevron..... FM Grade 2 Ideal FG #2 Keystone Nevastone HT/AW2 Lubriplate FGL-2 Mobil FM Grade 2	Suggested Manufacturer's: AMOCOWhite Mineral Oil No. 5 NF

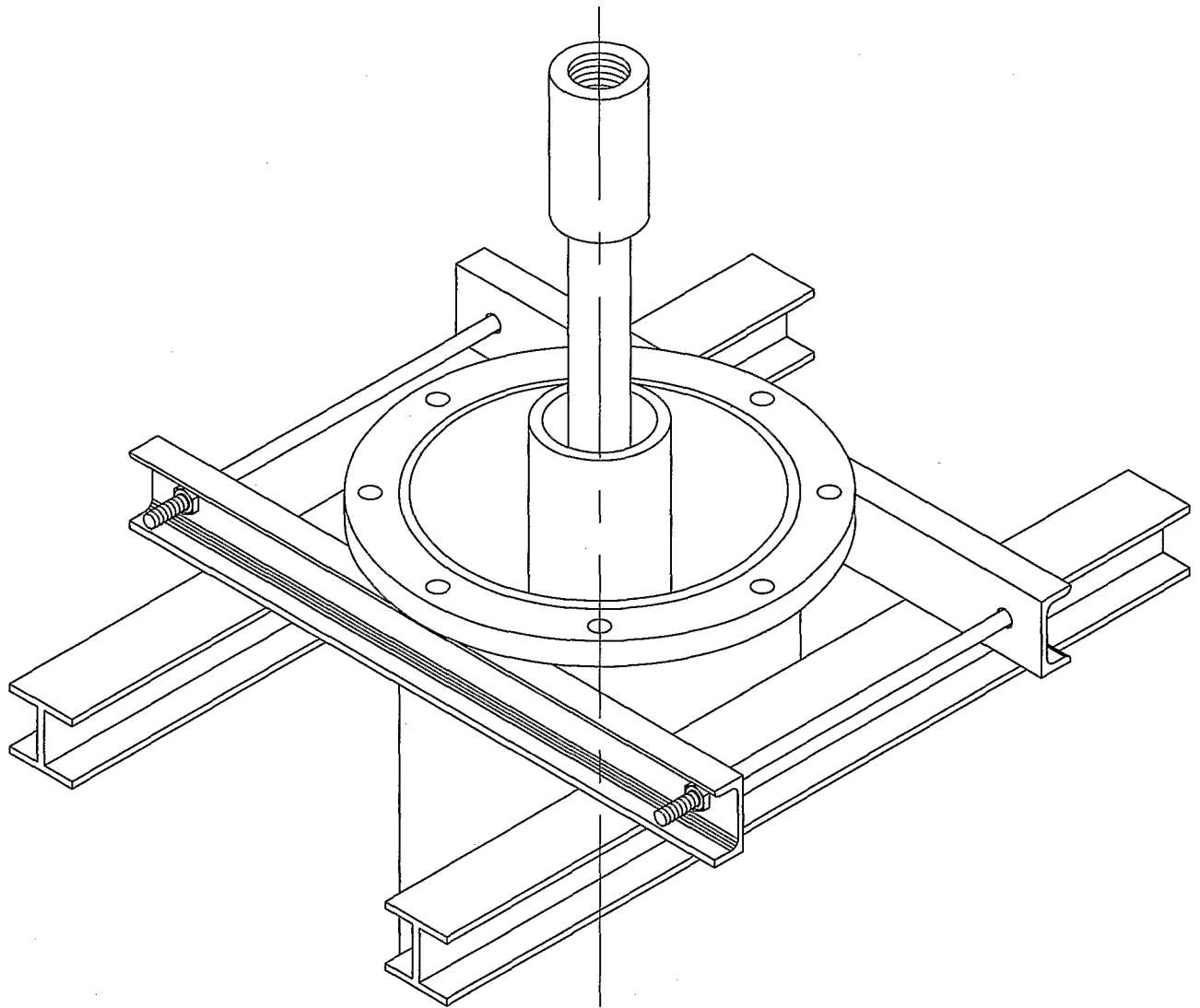
Table #7

Bowl Size	Propeller-To-Bowl Clearance (Diametral) (inches)		Lineshaft and Bowl Bearing Clearance (Diametral) (inches)	
	Nominal	Excessive	Nominal	Excessive
8211				
8"	.016	.046	.014	.018
10"	.020	.046	.014	.018
12"	.023	.046	.014	.018
20"	.040	.080	.014	.018
24"	.046	.092	.014	.018
30"	.055	.110	.014	.018
36"	.058	.116	.015	.019
8312				
10"	Propeller-to-Bowl Clearance is not measurable on the model 8312 pumps.		.014	.018
12"			.014	.018
14"			.014	.018
16"			.014	.018
20"			.014	.018
24"			.014	.018
30"			.015	.019

TECHNICAL DATA

Table #8

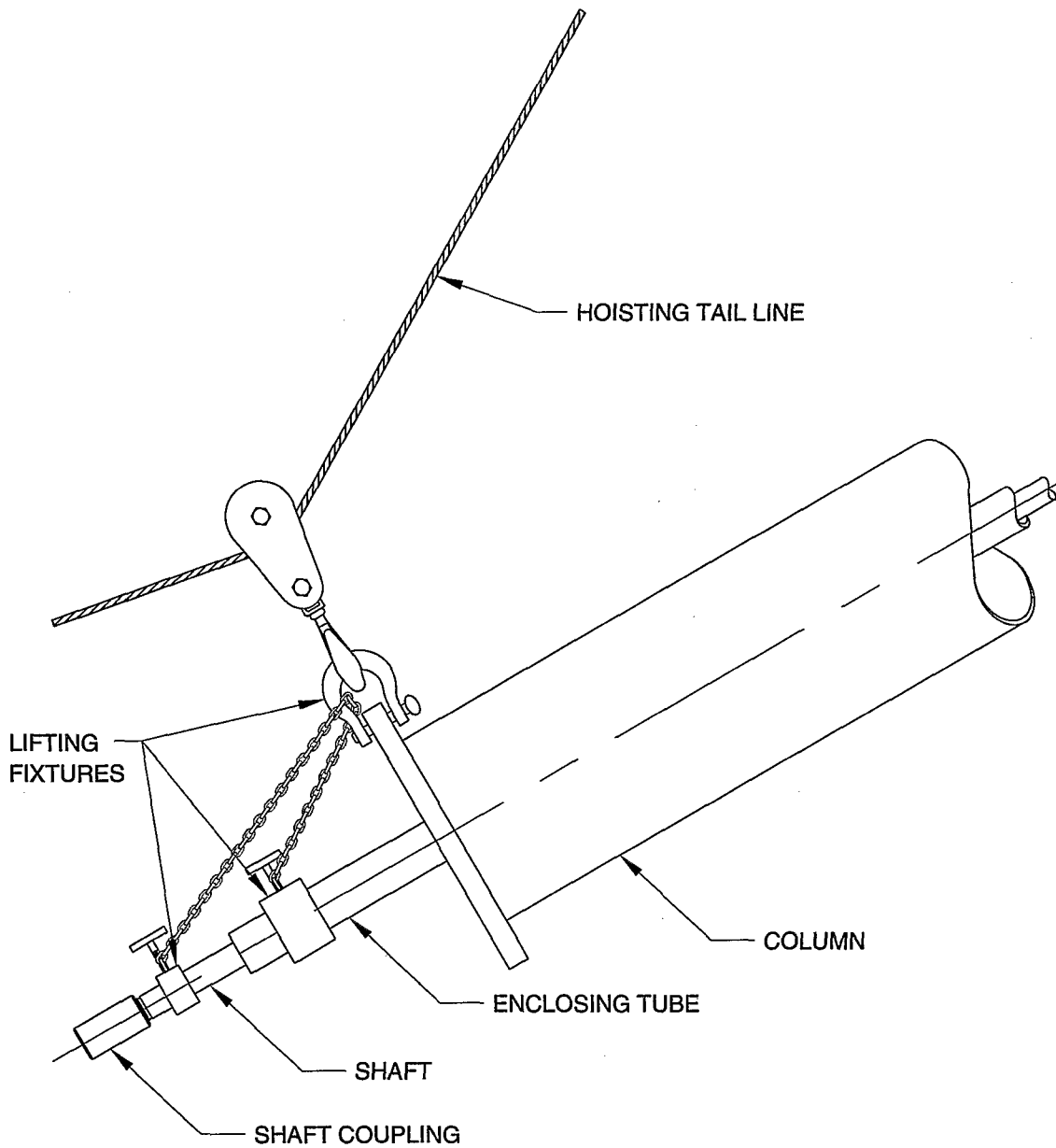
Product Lubricated (Rubber Bearings)						
Lineshaft Diameter	1	1 1/4	1 1/2	1 11/16	1 15/16	2 3/16
Sleeve OD	1 3/16	1 7/16	1 11/16	1 7/8	2 1/8	2 3/8
Box ID	1 15/16	2 3/16	2 7/16	2 5/8	2 7/8	3 1/8
Box Depth	1 5/8	1 5/8	1 5/8	1 5/8	1 5/8	1 5/8
No. Rings Packing	4	4	4	4	4	4
Size Packing	3/8	3/8	3/8	3/8	3/8	3/8
Enclosed Lineshaft-Oil Lubricated						
Lineshaft Diameter	1	1 1/4	1 1/2	1 11/16	1 15/16	2 3/16
Tube Size	1 1/2	2	2 1/2	2 1/2	3	3
Enclosed Lineshaft Water - Flush Lubricated (Bronze Bearings)						
Lineshaft Diameter	1	1 1/4	1 1/2	1 11/16	1 15/16	2 3/16
Sleeve OD	1 3/16	1 7/16	1 11/16	1 7/8	2 1/8	2 3/8
Box ID	1 15/16	2 3/16	2 7/16	2 5/8	2 7/8	3 1/8
Box Depth	1 5/8	1 5/8	1 5/8	1 5/8	1 5/8	1 5/8
No. Rings Packing	4	4	4	4	4	4
Size Packing	3/8	3/8	3/8	3/8	3/8	3/8



BOWL / COLUMN CLAMP

 Fairbanks Morse

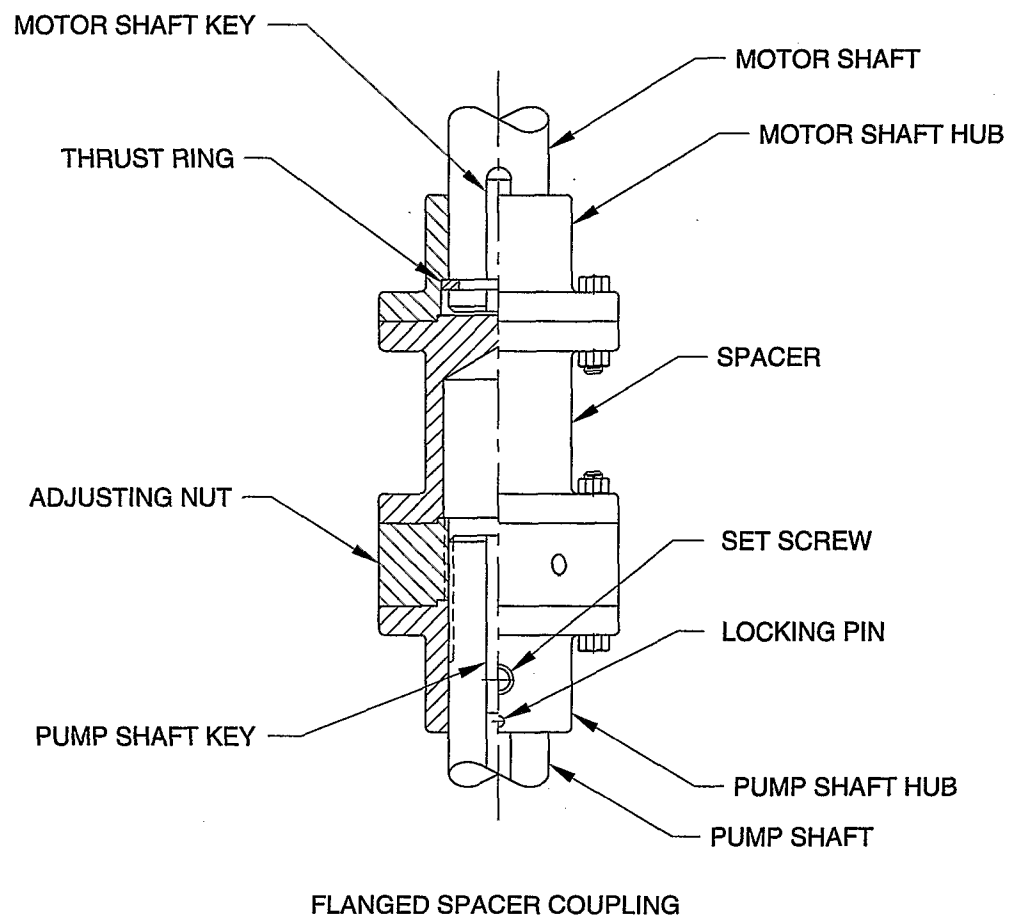
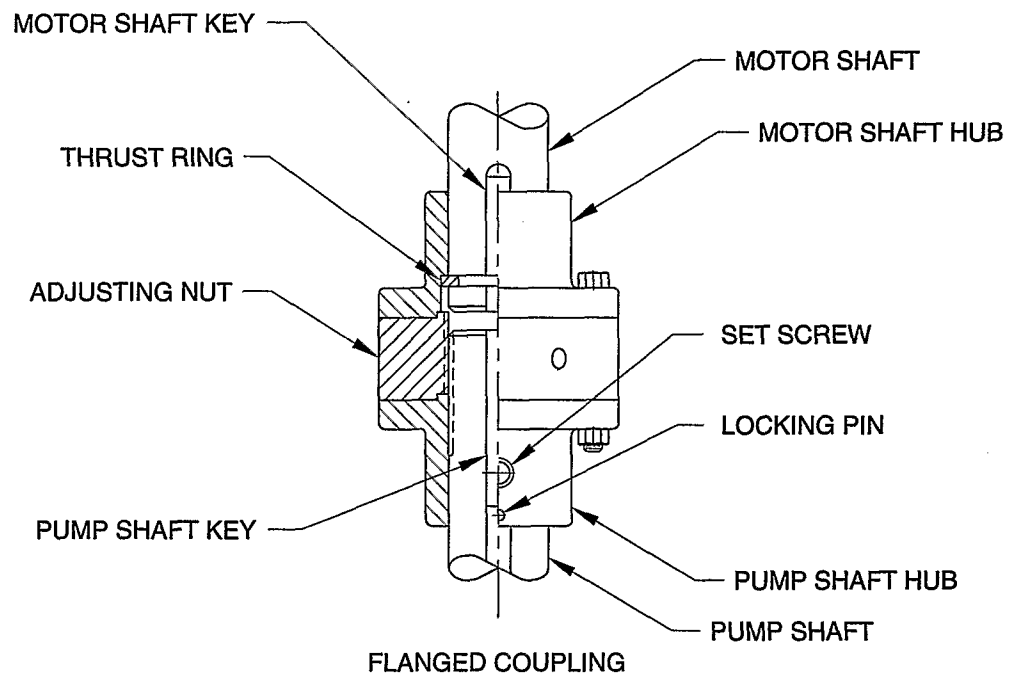
DWG NO	8000M096	REV NO	0
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COLUMN, TUBE & SHAFT
LIFTING DEVICE

 Fairbanks Morse

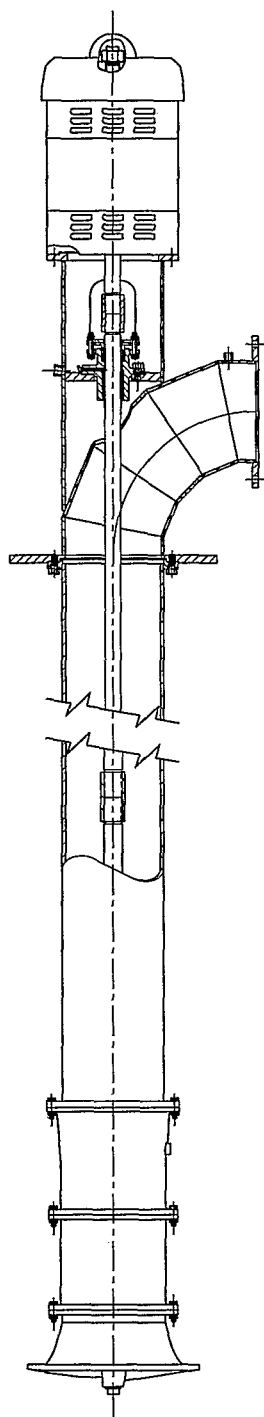
DWG NO	8000M095	REV NO	0
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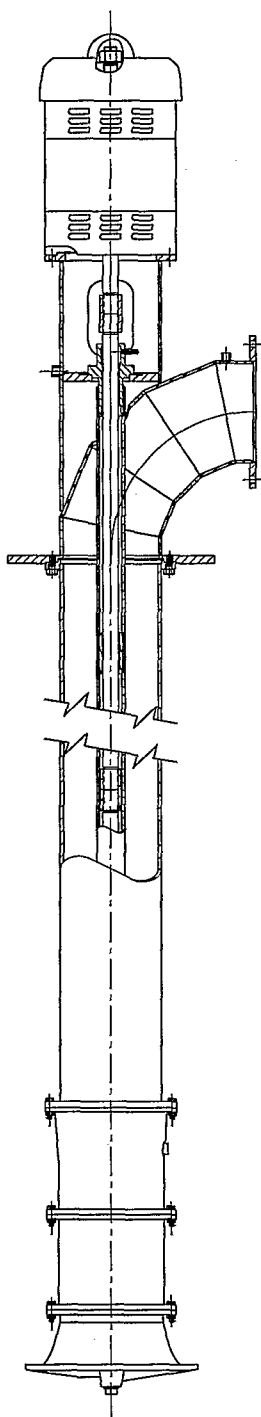
VSS MOTOR COUPLINGS



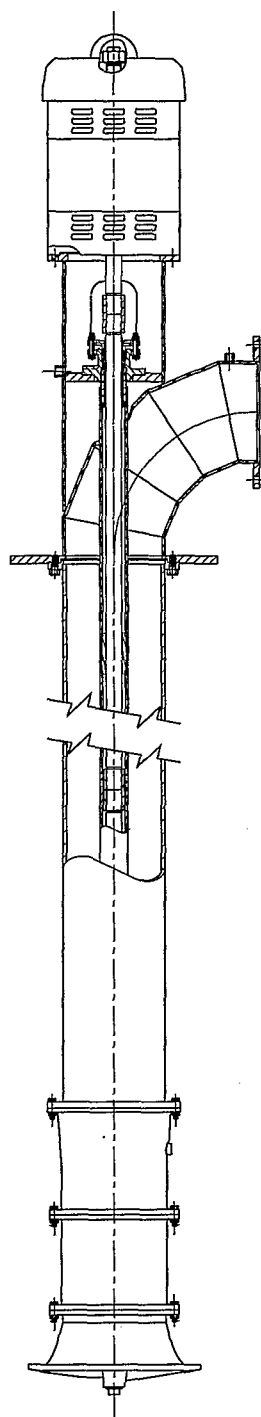
DWG NO	7000A091	REV NO	0
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OPEN LINESHAFT
MULTI-STAGE



OIL LUBE
ENCLOSED LINESHAFT
MULTI-STAGE



WATER FLUSH
ENCLOSED LINESHAFT
MULTI-STAGE

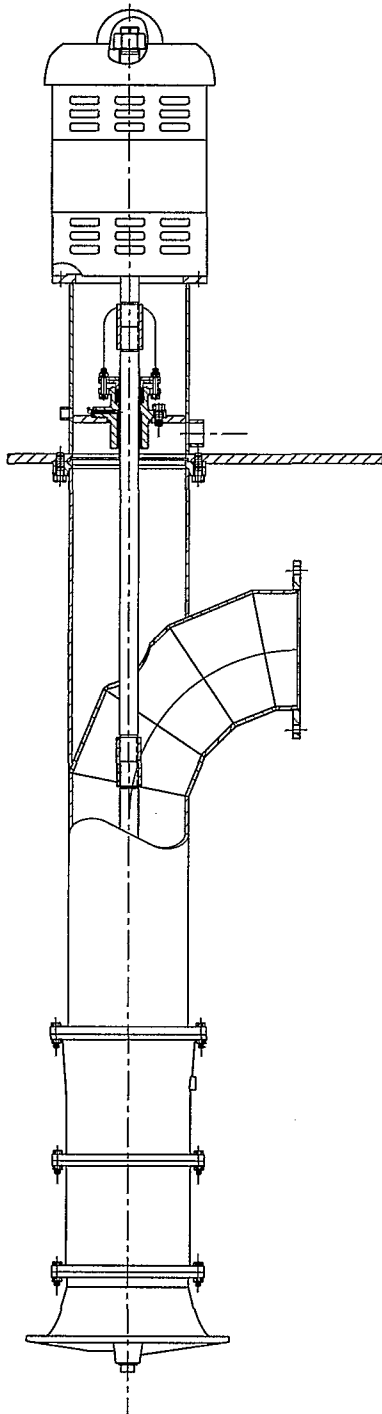
PROPELLER PUMP
ABOVEGROUND DISCHARGE

 Fairbanks Morse

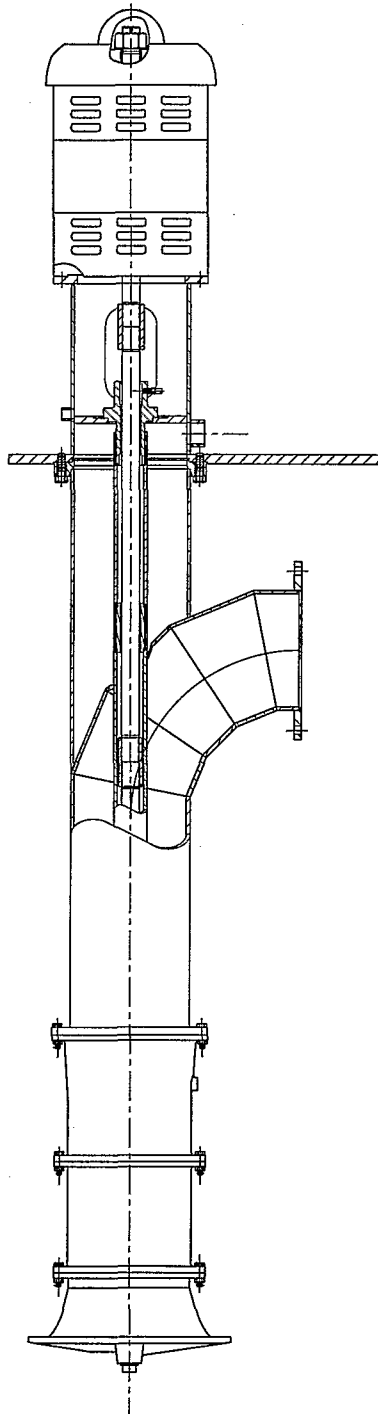
DWG
NO

8000M001

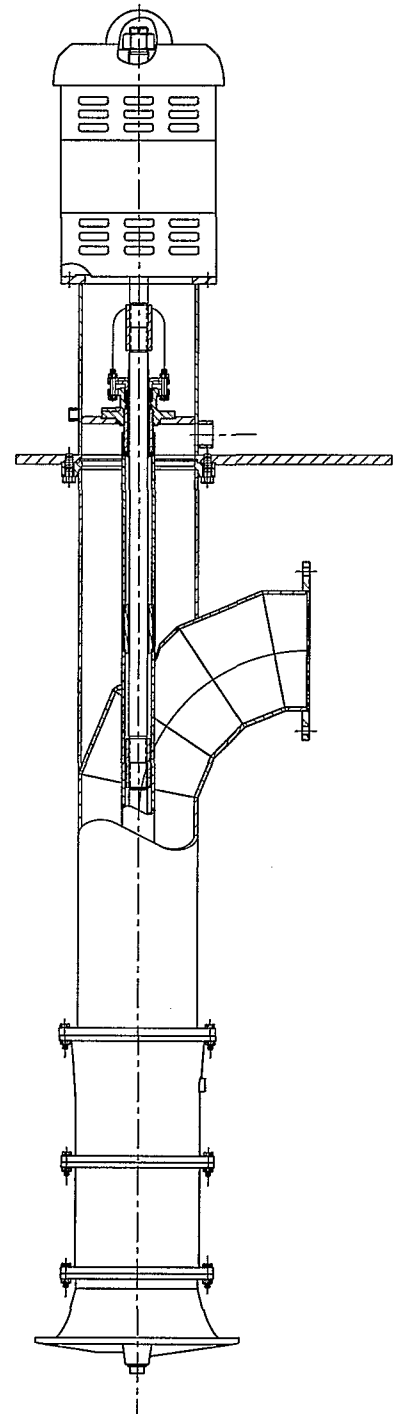
REV
NO 0



OPEN LINESHAFT
MULTI-STAGE



OIL LUBE
ENCLOSED LINESHAFT
MULTI-STAGE



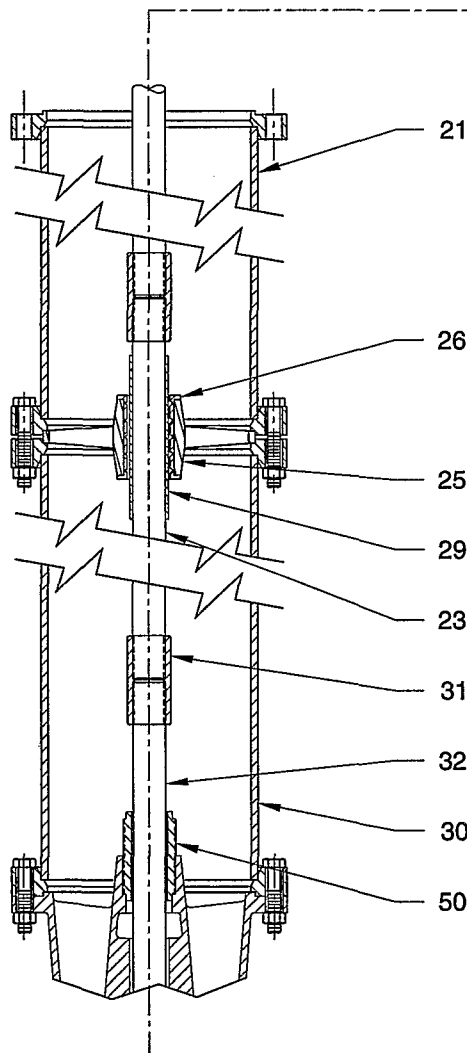
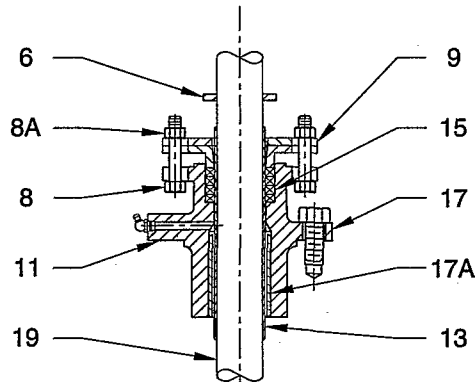
WATER FLUSH
ENCLOSED LINESHAFT
MULTI-STAGE

PROPELLER PUMP
BELOW GROUND DISCHARGE

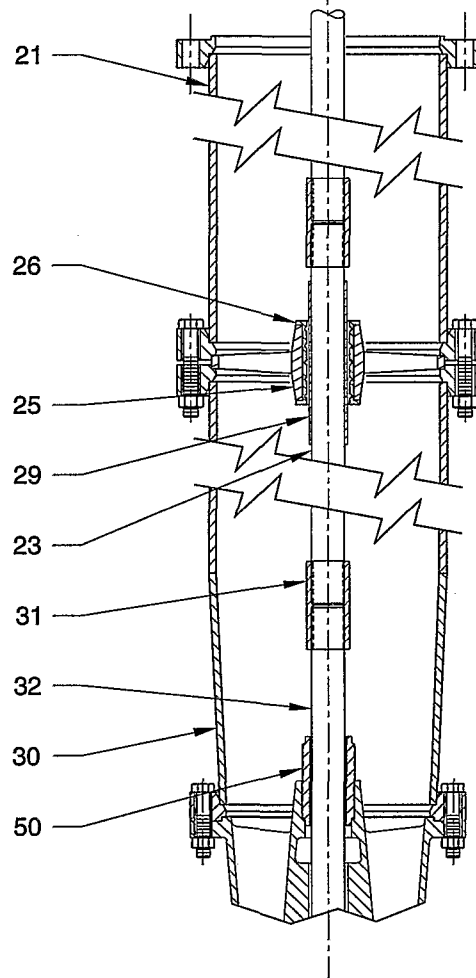
 **Fairbanks Morse**

DWG NO	8000M002	REV NO	0
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175# PACKING BOX



STRAIGHT COLUMN

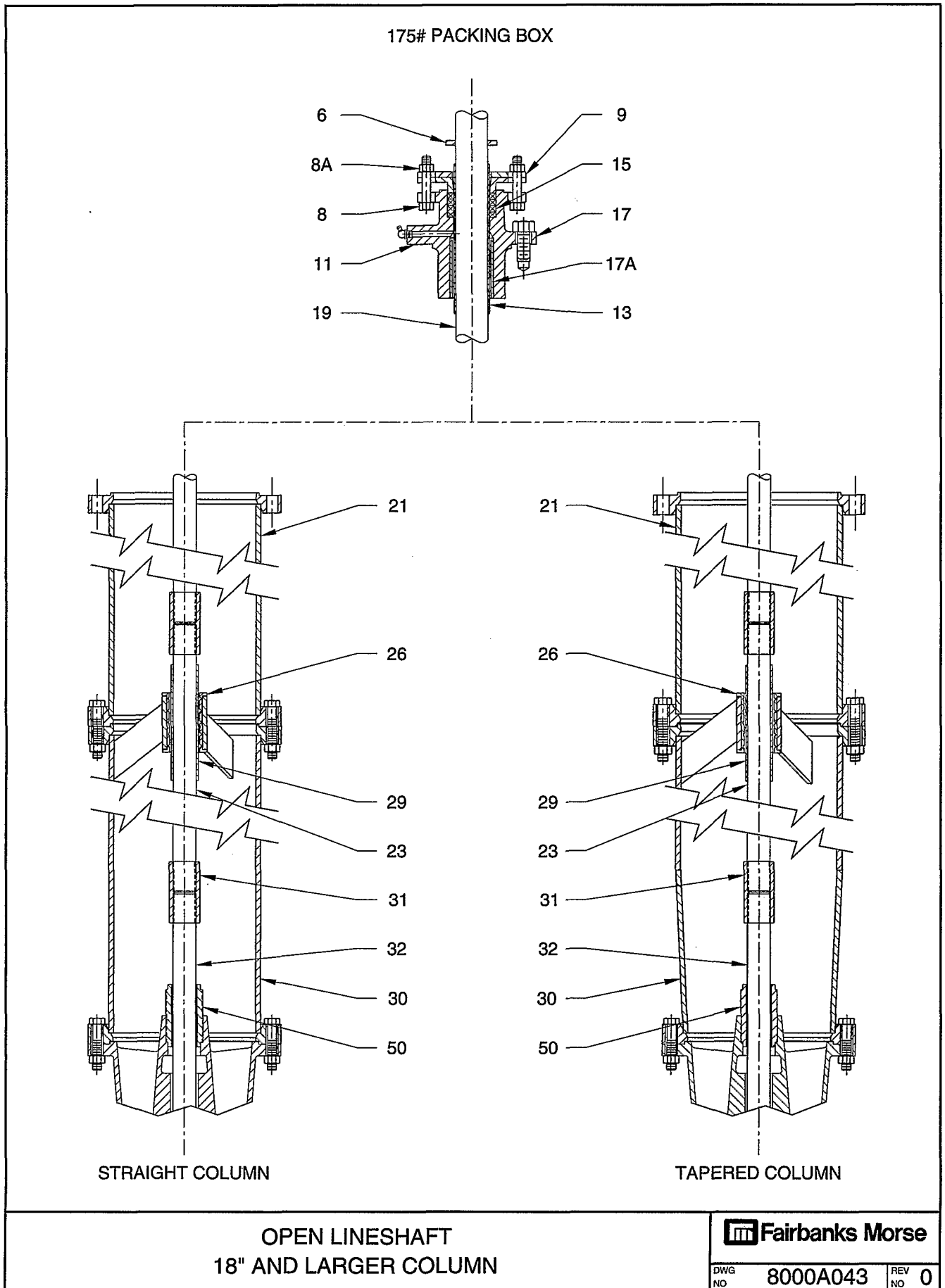


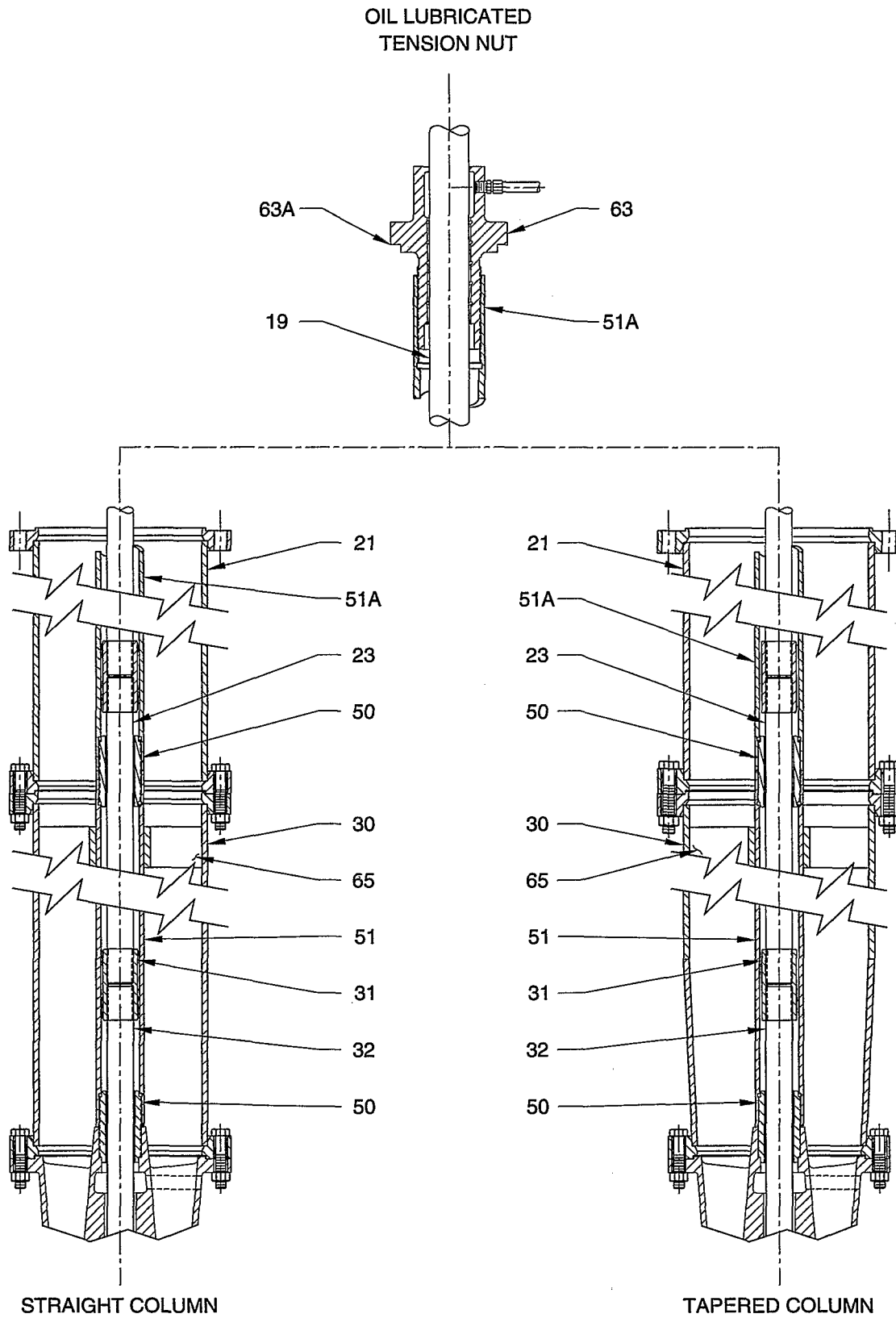
TAPERED COLUMN

OPEN LINESHAFT
8" THRU 16" COLUMN



DWG NO	8000A041	REV NO	0
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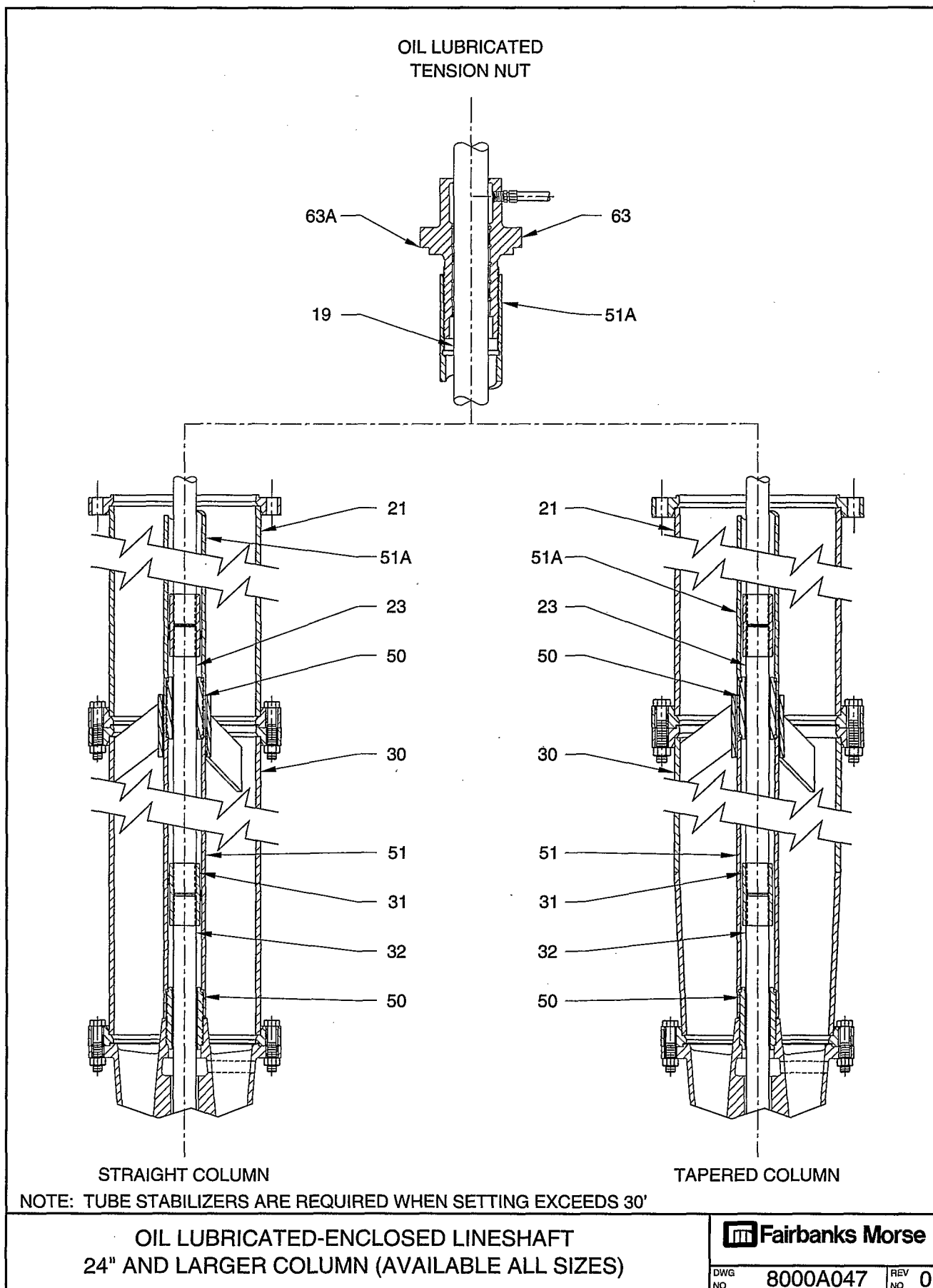


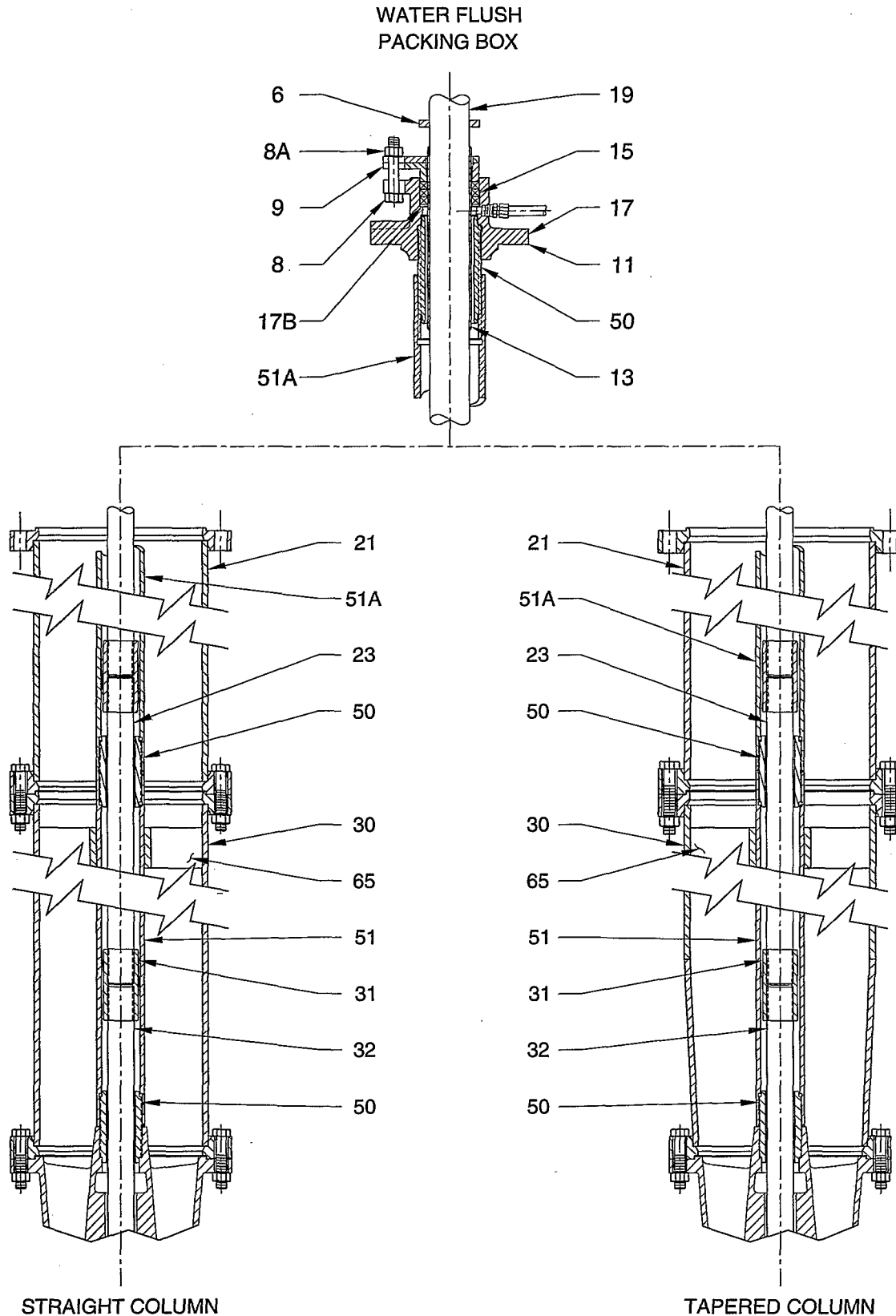
NOTE: TUBE STABILIZERS ARE REQUIRED WHEN SETTING EXCEEDS 30'

OIL LUBRICATED-ENCLOSED LINESHAFT
8" THRU 20" COLUMN

 **Fairbanks Morse**

DWG/ NO	8000A045	REV NO	0
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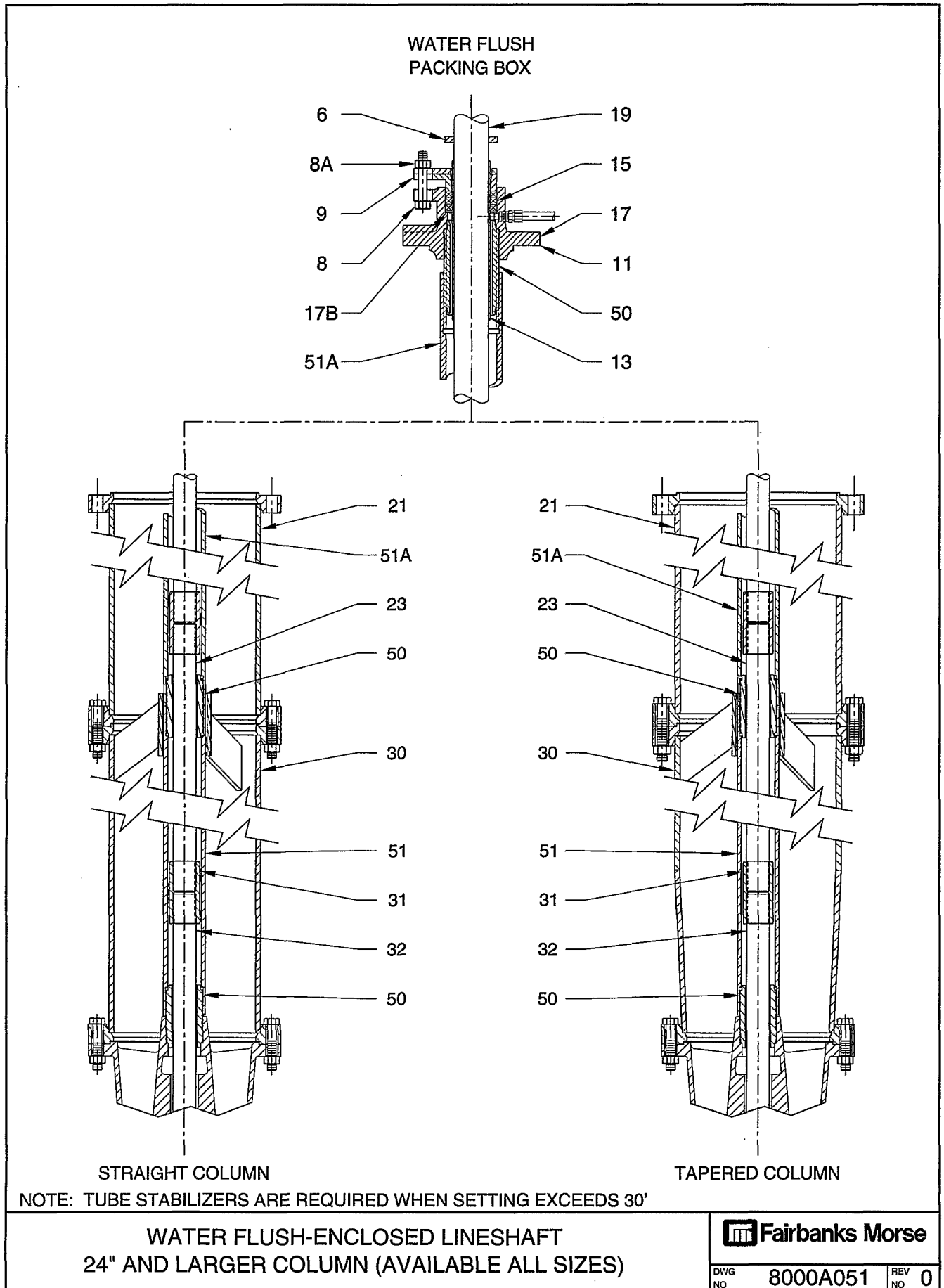


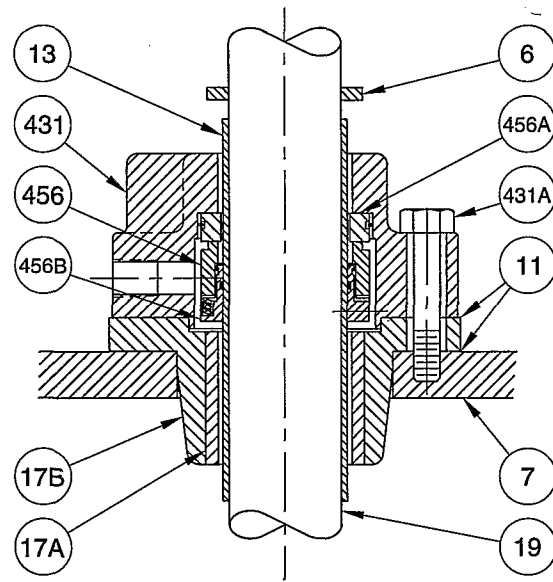
NOTE: TUBE STABILIZERS ARE REQUIRED WHEN SETTING EXCEEDS 30'

**WATER FLUSH-ENCLOSED LINESHAFT
8" THRU 20" COLUMN**

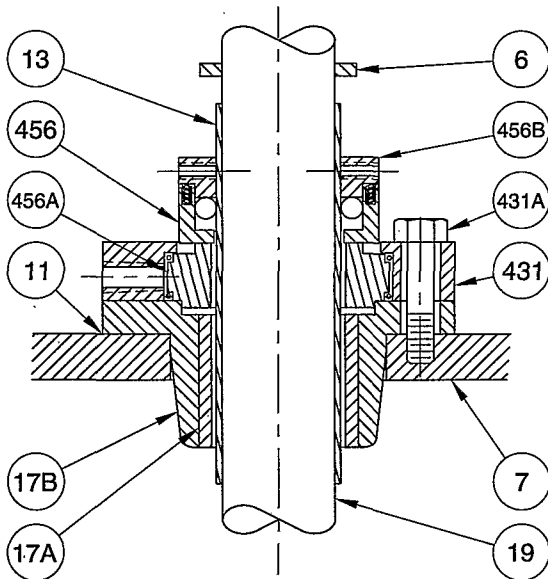
 **Fairbanks Morse**

DWG NO	8000A049	REV NO 0
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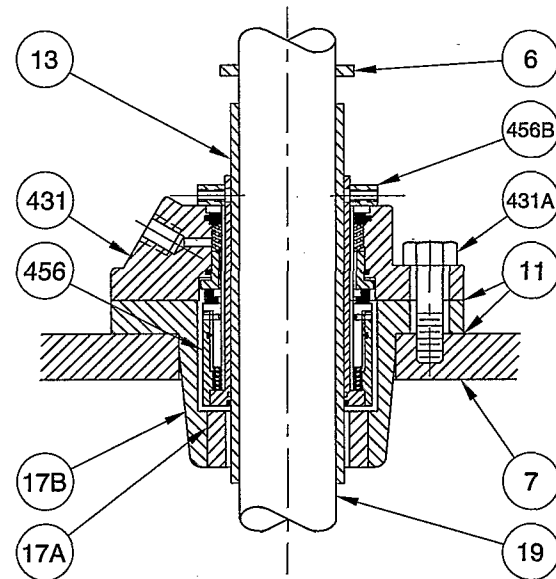




BASIC MECHANICAL SEAL ASSEMBLY



OUTSIDE MECHANICAL SEAL ASSEMBLY



CARTRIDGE MECHANICAL SEAL ASSEMBLY

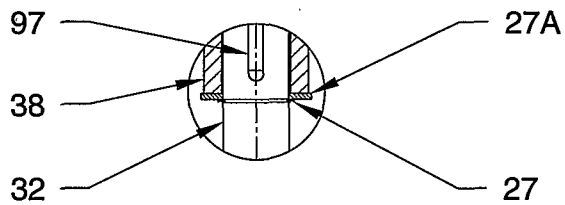
MECHANICAL SEALS

 **Fairbanks Morse**

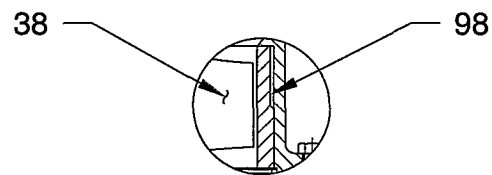
DWG NO	7000A081	REV NO	0
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Column\Lineshaft\Seal Box Parts List

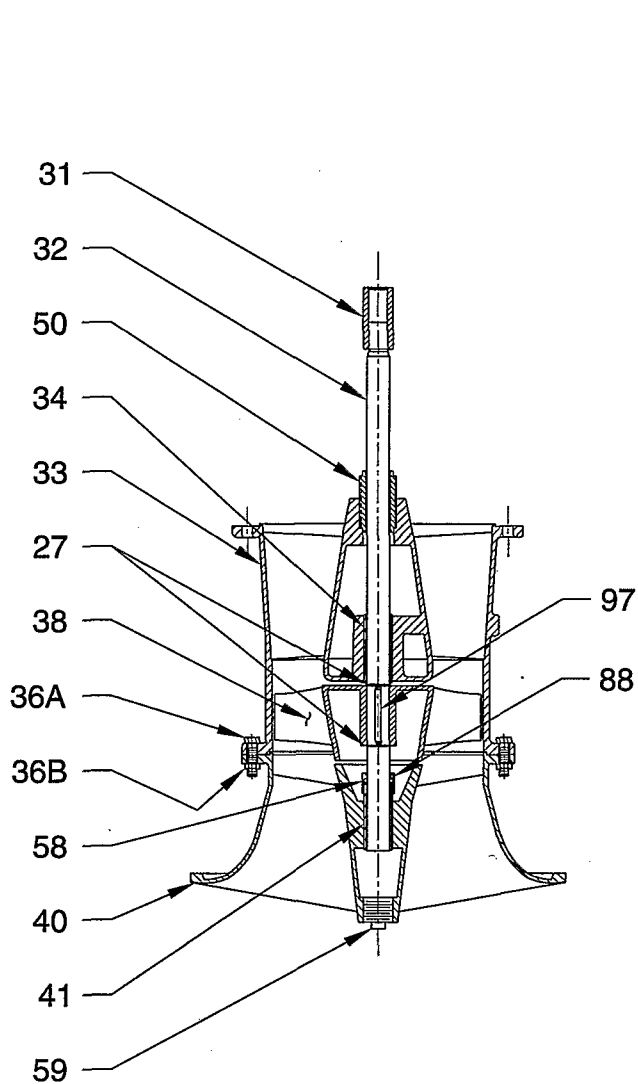
Part No.	Description
6	Slinger, Water
7	Discharge Head
8	Bolt, Gland
8A	Nut, Gland
9	Gland, Packing Box
11	Gasket, Packing Box
13	Sleeve, Top Shaft
15	Packing
17	Packing Box
17A	Bushing, Packing Box
17B	Seal Housing
19	Shaft, Top
21	Column, Top
23	Lineshaft
25	Retainer, Bearing
26	Bearing, Lineshaft
29	Sleeve, Lineshaft
30	Column, Bottom
31	Coupling, Shaft
32	Shaft, Bowl
50	Bearing, Connector
51	Enclosing Tube, Bottom
51A	Enclosing Tube
63	Tension Nut, Enclosing Tube
63A	Gasket, Tension Nut
65	Stabilizer, Enclosing Tube
431	Gland, Mechanical Seal
431A	Capscrews, Packing Box
456	Seat, Mechanical Seal Rotating
456A	Seat, Mechanical Seal Stationary
456B	Retainer, Mechanical Seal



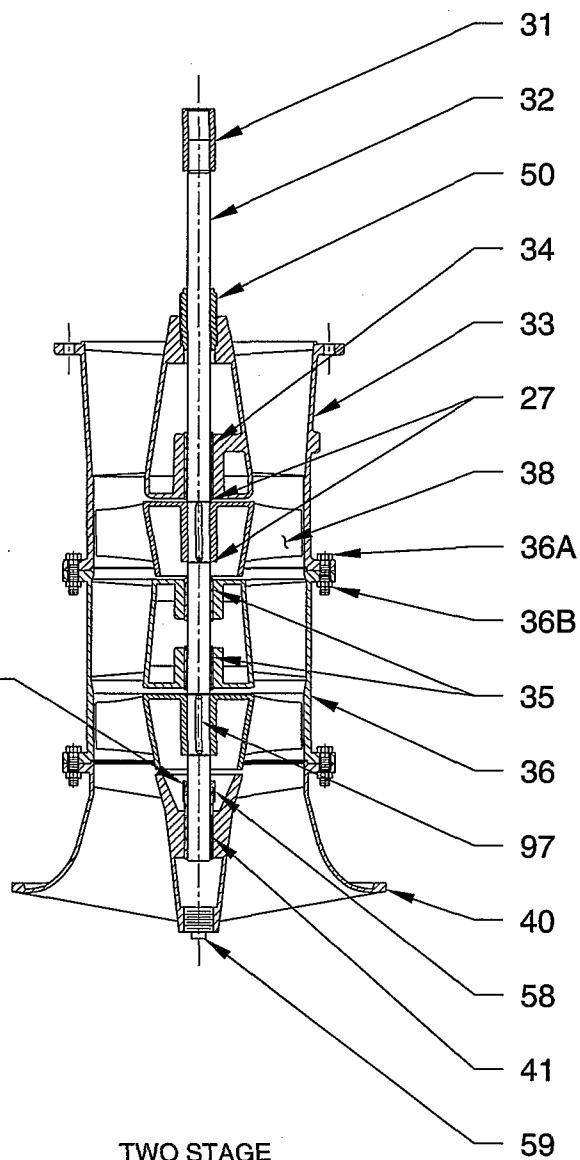
24", 30" AND 36" 8211W
IMPELLER THRUST RING CONSTRUCTION



OPTIONAL BOWL
LINER ASSEMBLY



ONE STAGE



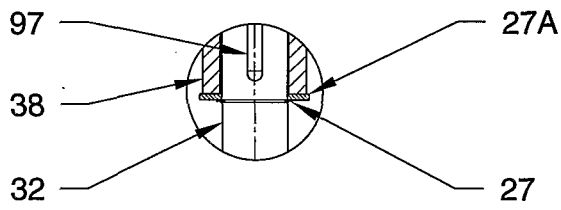
TWO STAGE

8" THRU 36" 8211W BOWL ASSEMBLY
OPEN LINESHAFT

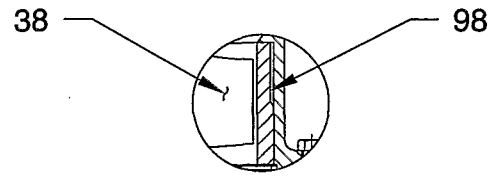
 Fairbanks Morse

DWG NO 8211M001

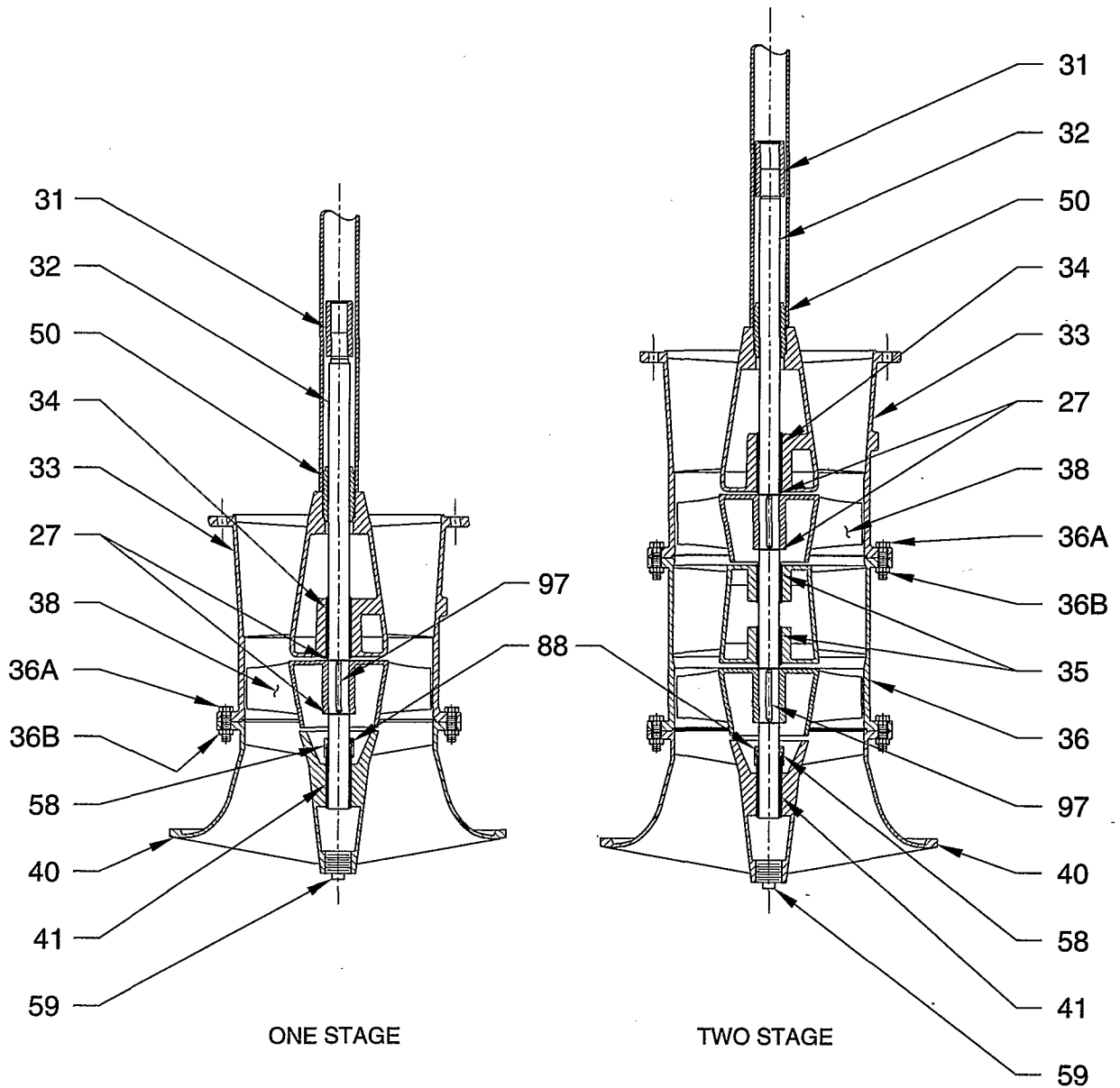
REV NO 0



24", 30" AND 36" 8211WF
IMPELLER THRUST RING CONSTRUCTION



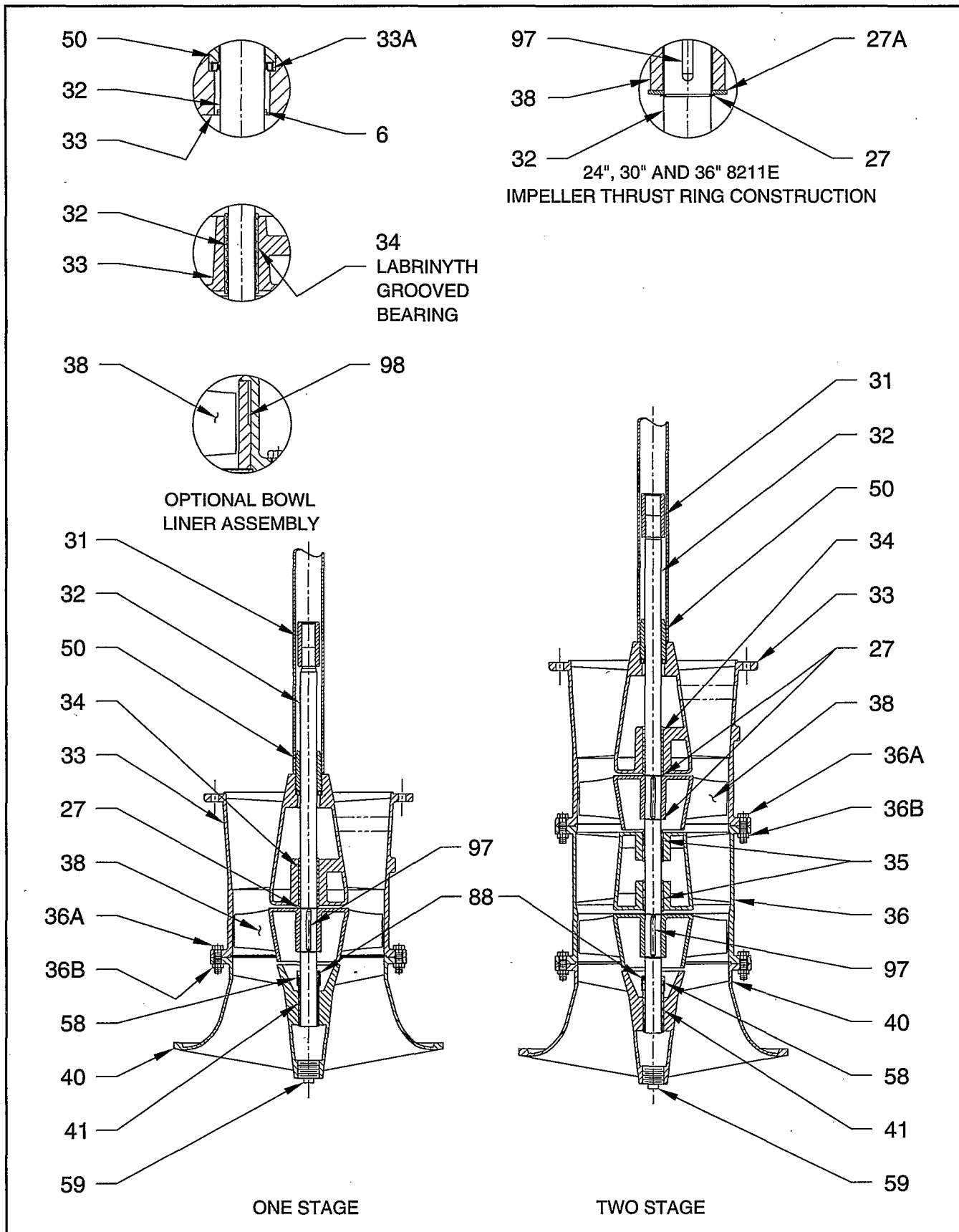
OPTIONAL BOWL
LINER ASSEMBLY



8" THRU 36" 8211WF BOWL ASSEMBLY
WATER FLUSH

 Fairbanks Morse

DWG NO 8211M003 REV NO 0

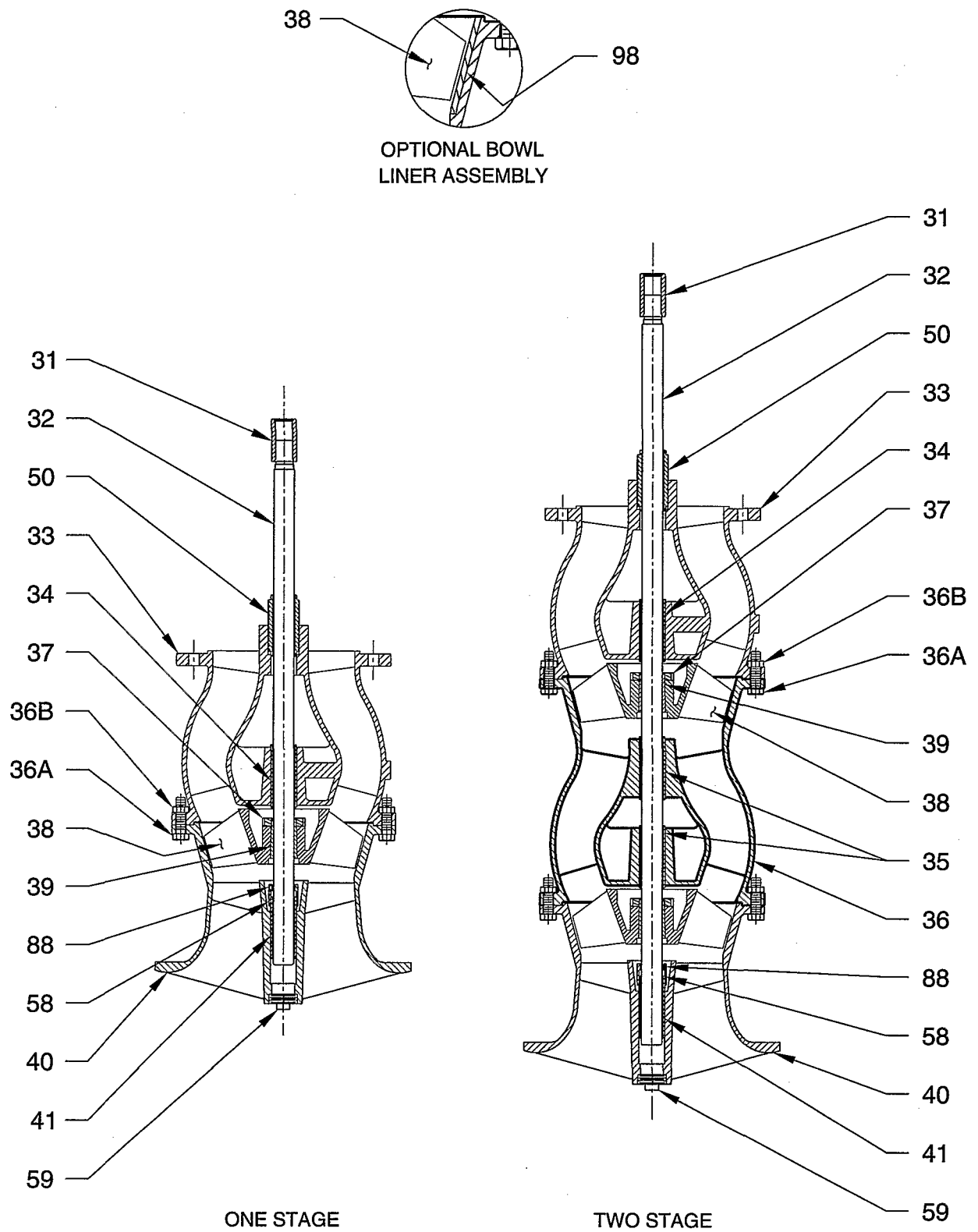


8" THRU 36" 8211E BOWL ASSEMBLY
OIL LUBRICATED

 **Fairbanks Morse**

DWG NO 8211M005

REV NO 0

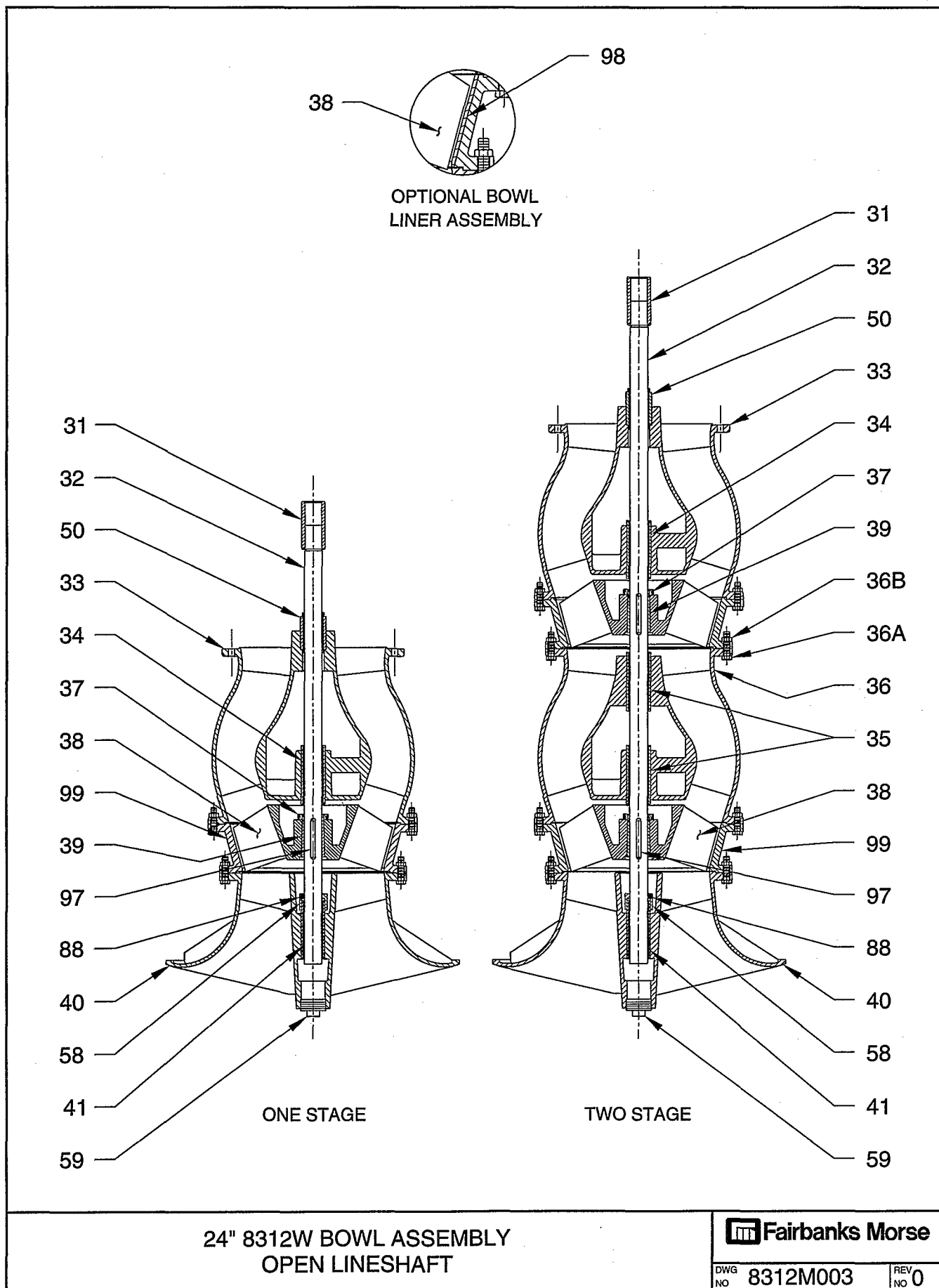


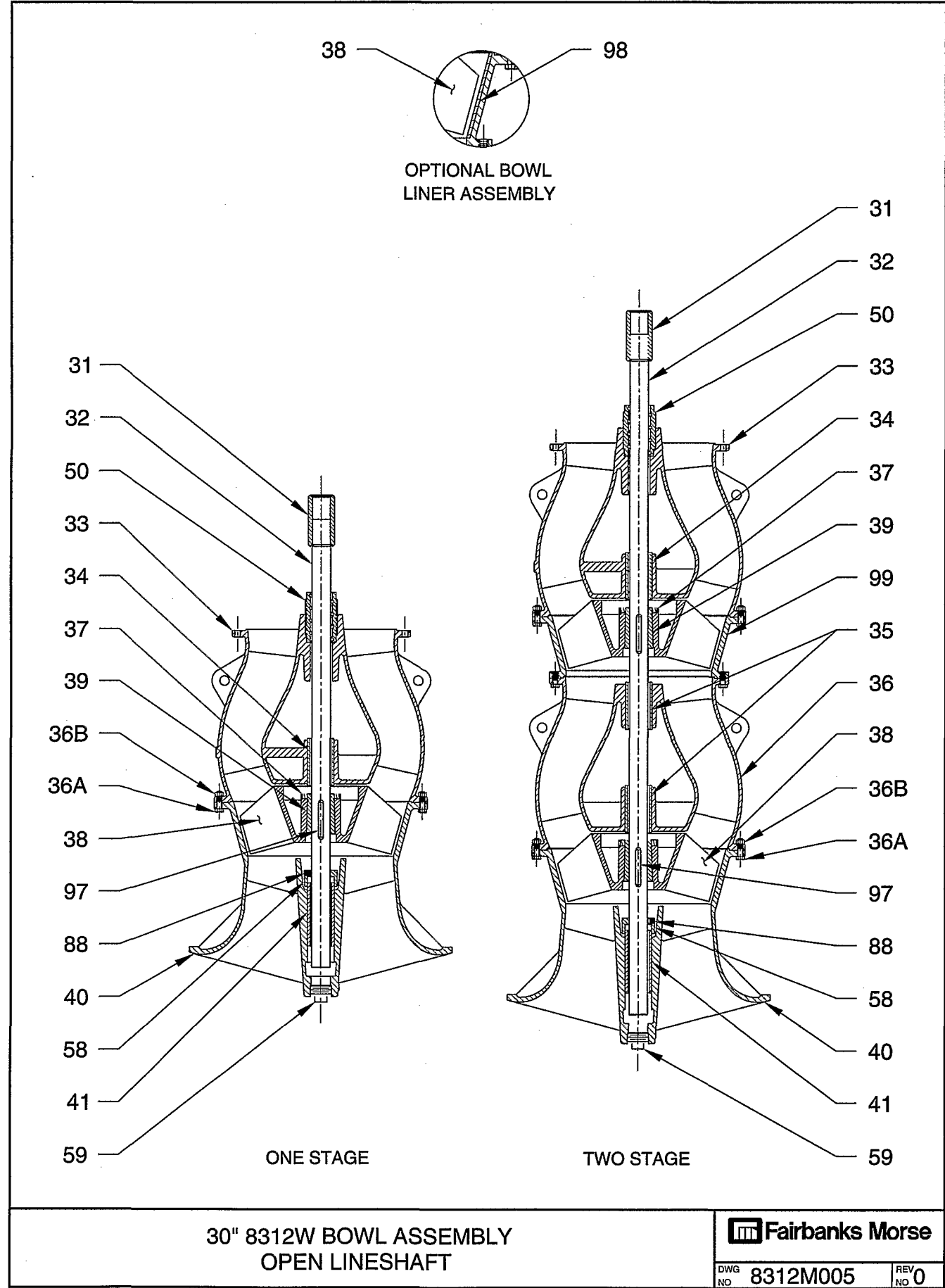
10" THRU 20" 8312W BOWL ASSEMBLY
OPEN LINESHAFT

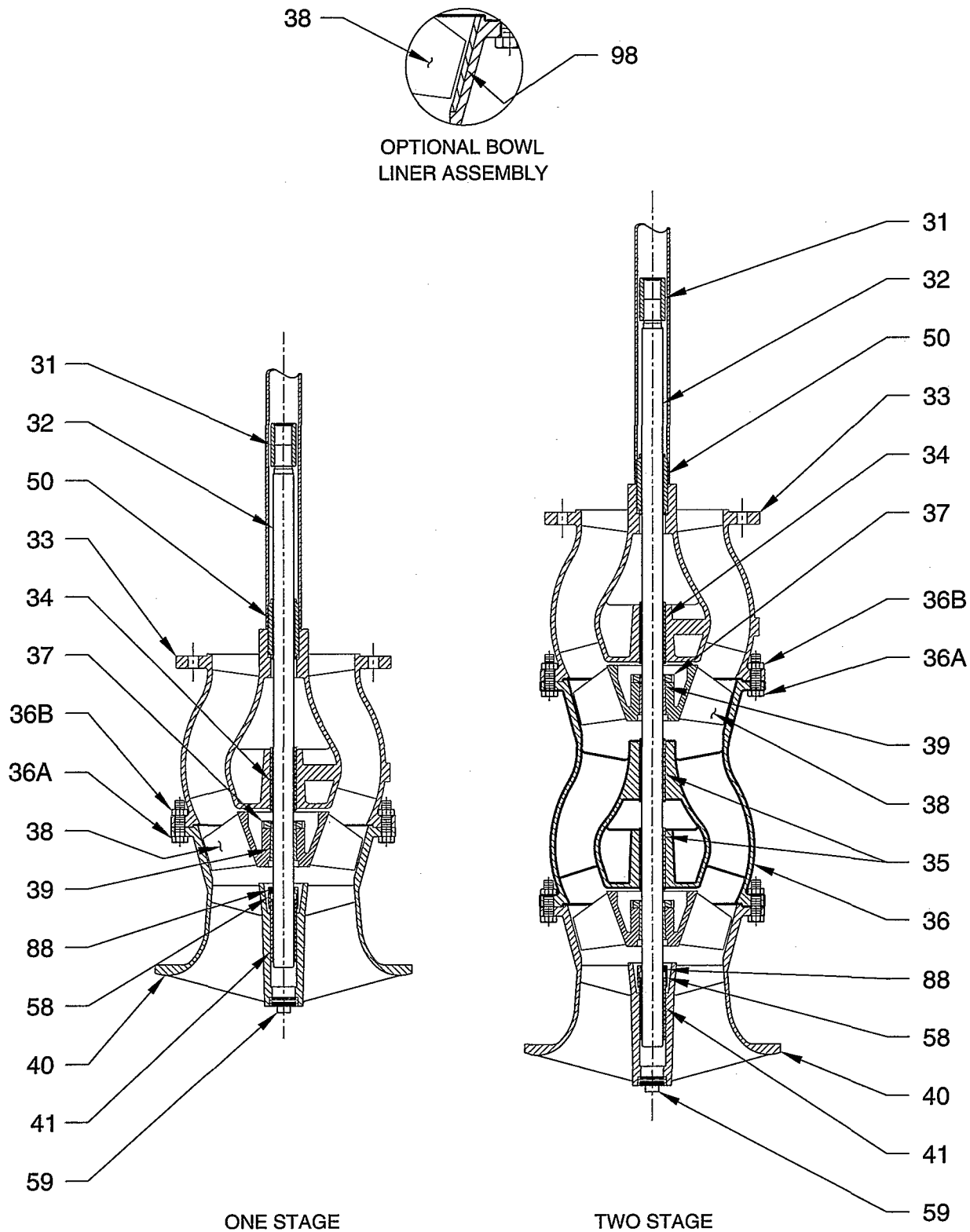
Fairbanks Morse

DWG NO 8312M001

REV NO 0





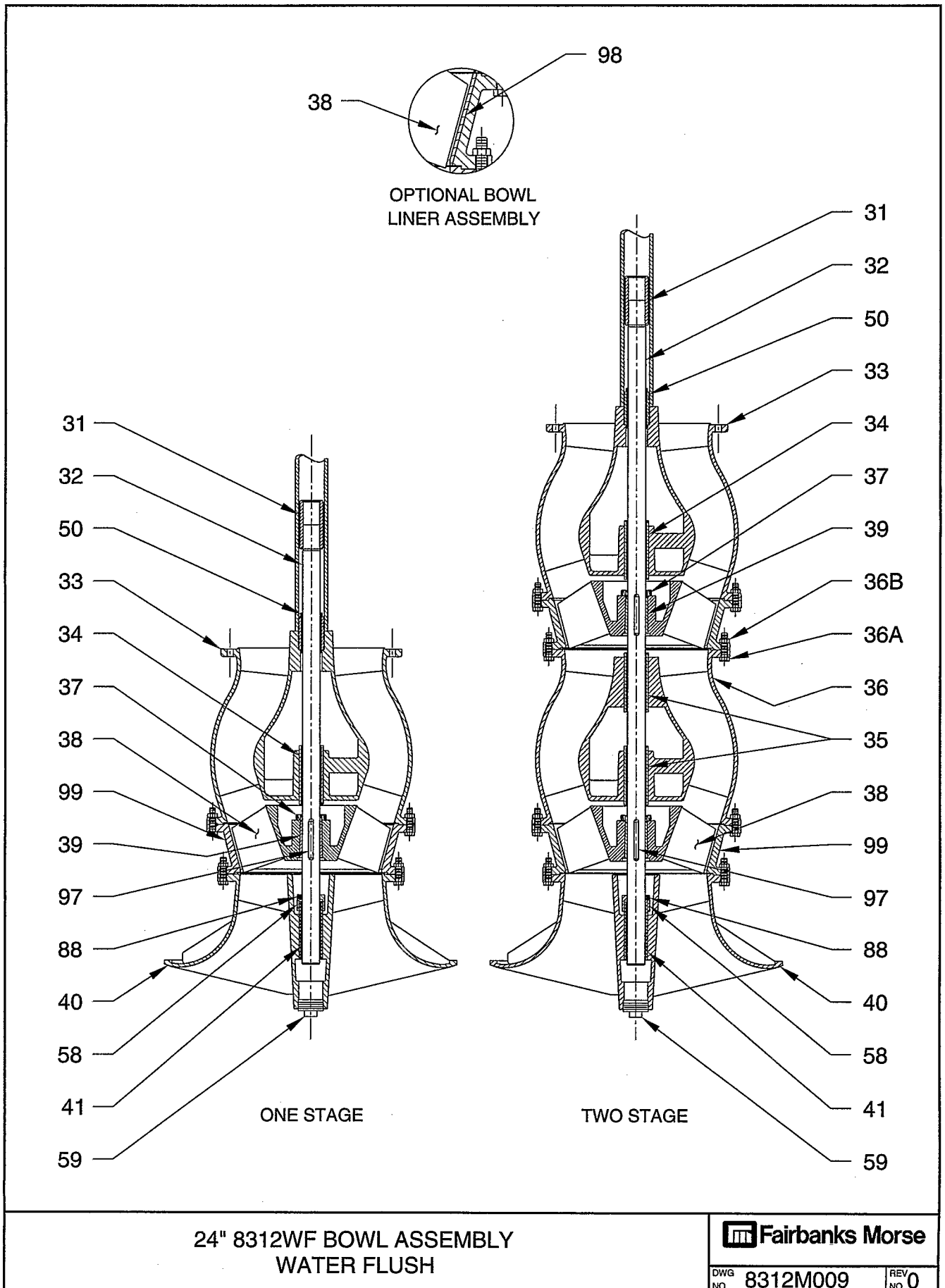


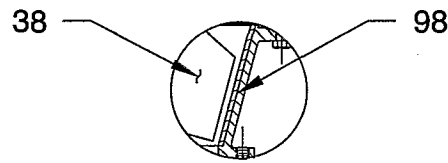
10" THRU 20" 8312WF BOWL ASSEMBLY
WATER FLUSH

Fairbanks Morse

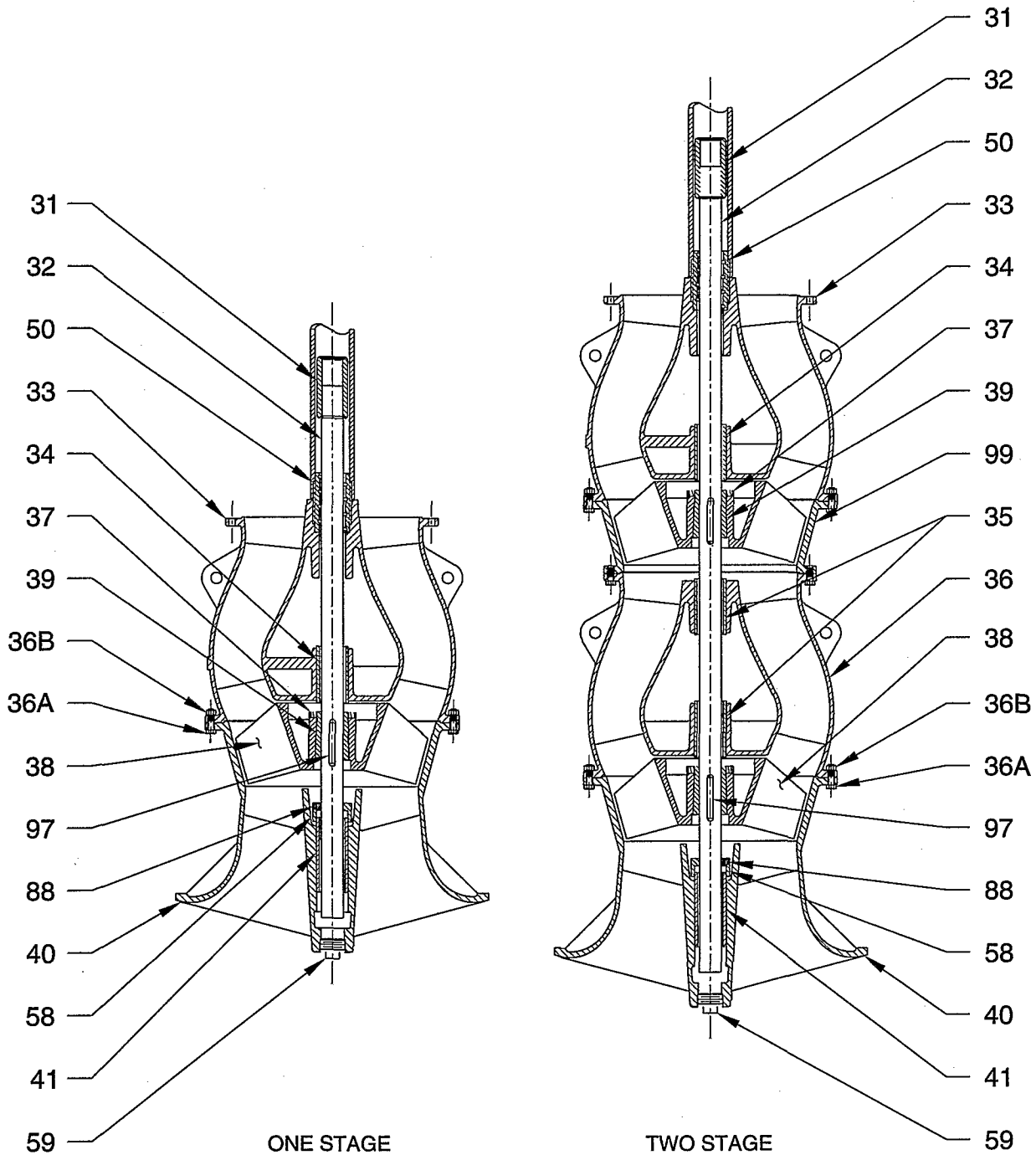
DWG NO 8312M007

REV NO 0





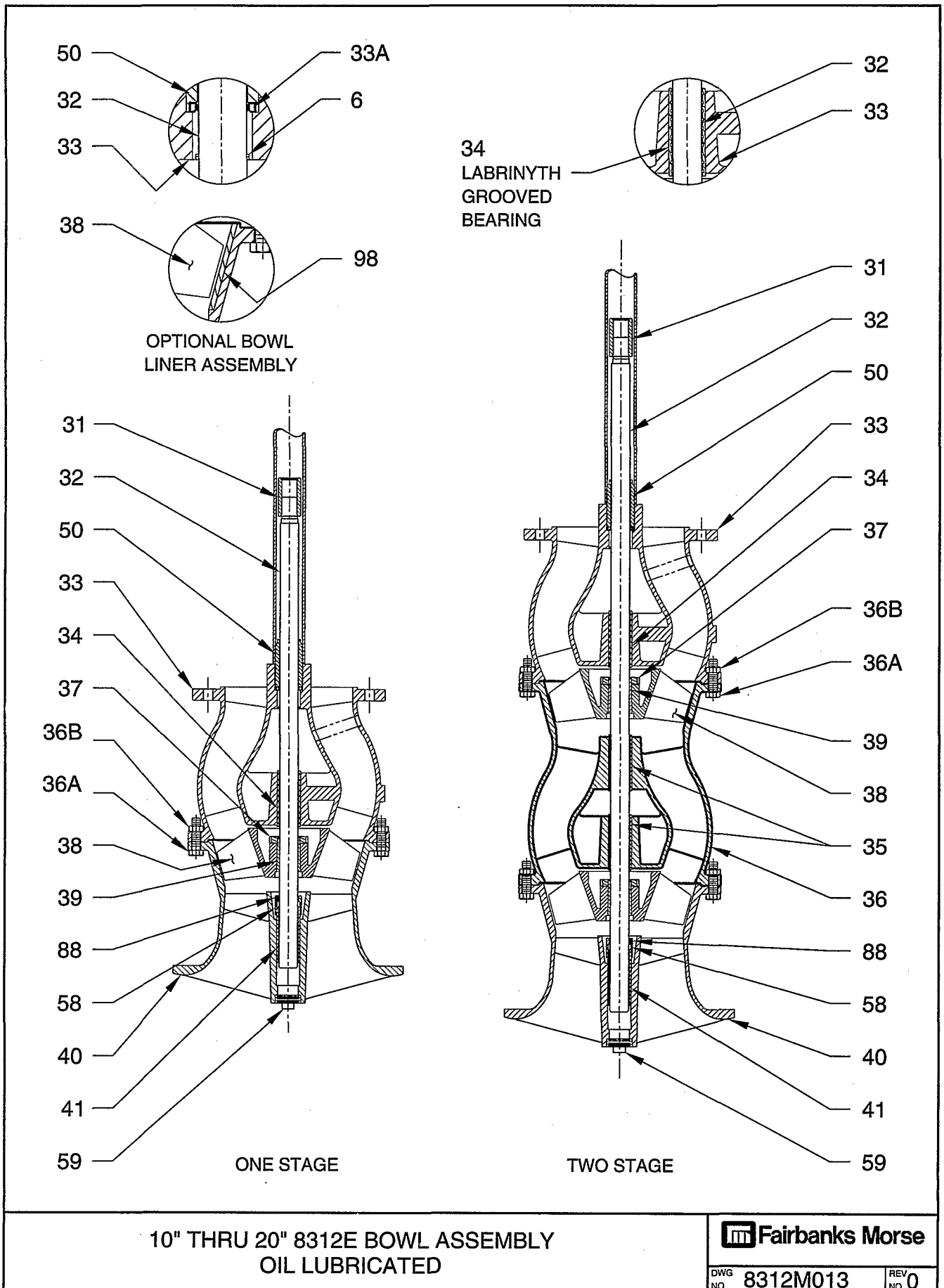
OPTIONAL BOWL
LINER ASSEMBLY

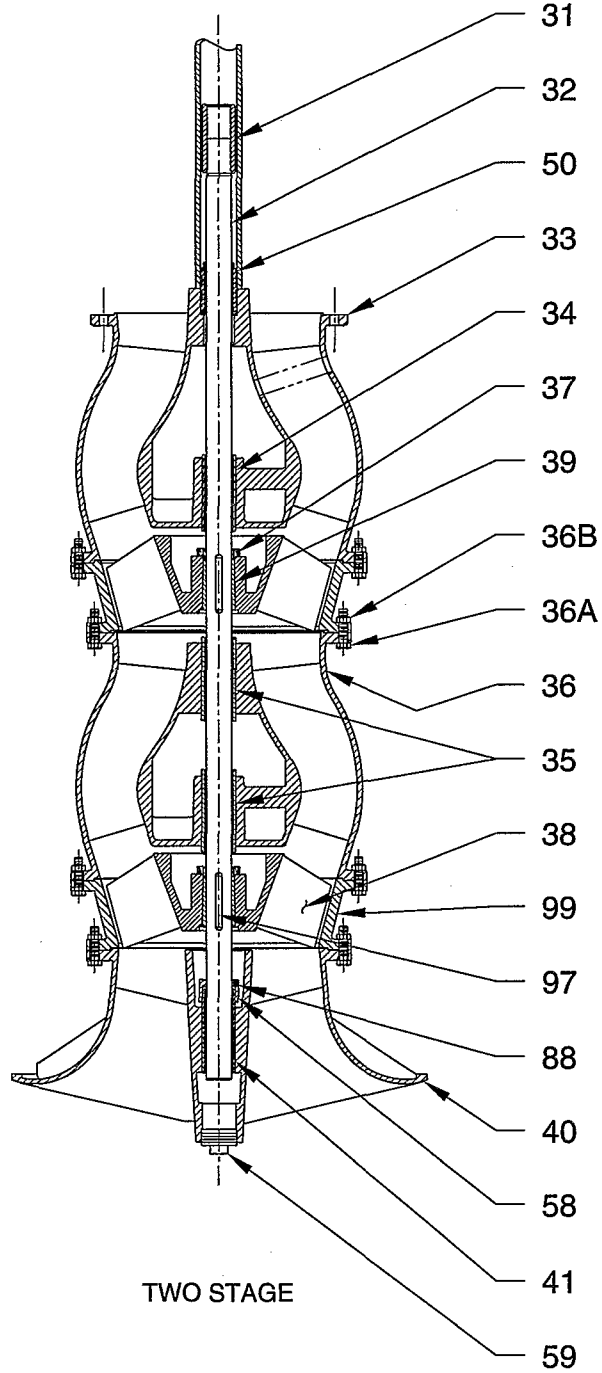
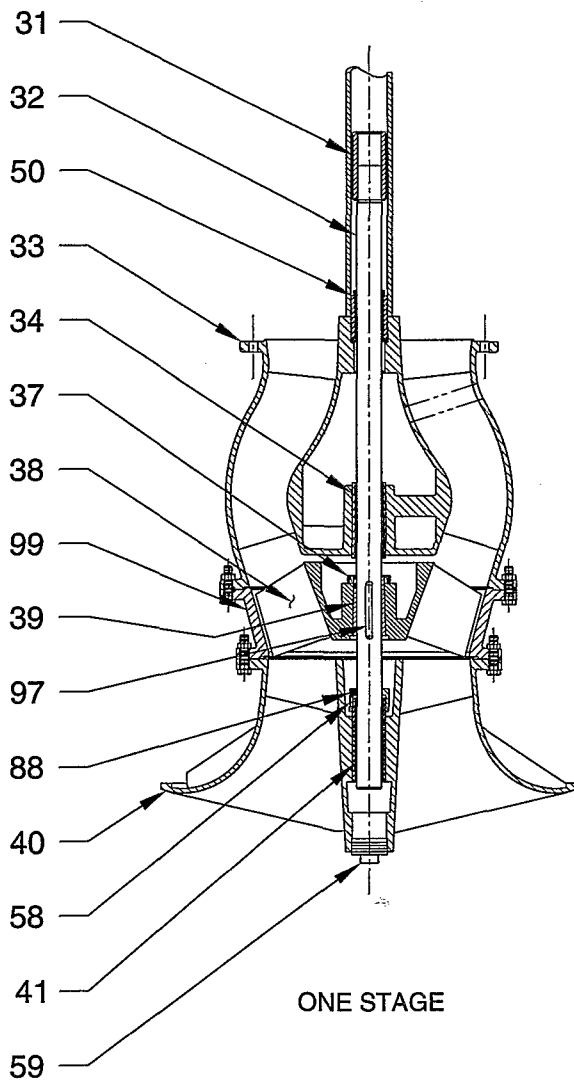
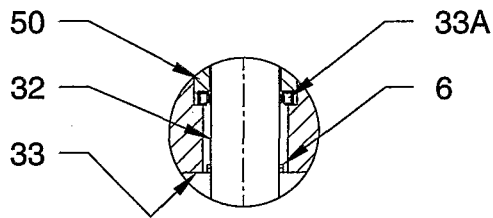
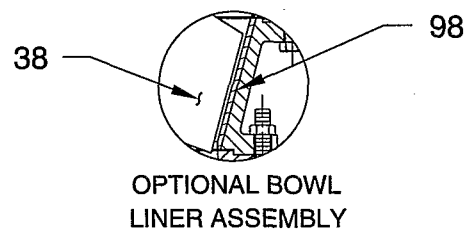
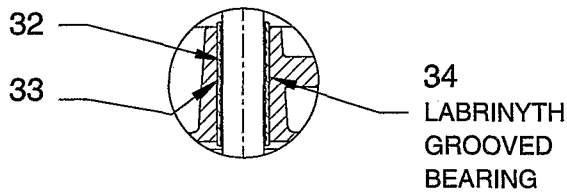


30" 8312WF BOWL ASSEMBLY
WATER FLUSH

 Fairbanks Morse

DWG NO	8312M011	REV NO	0
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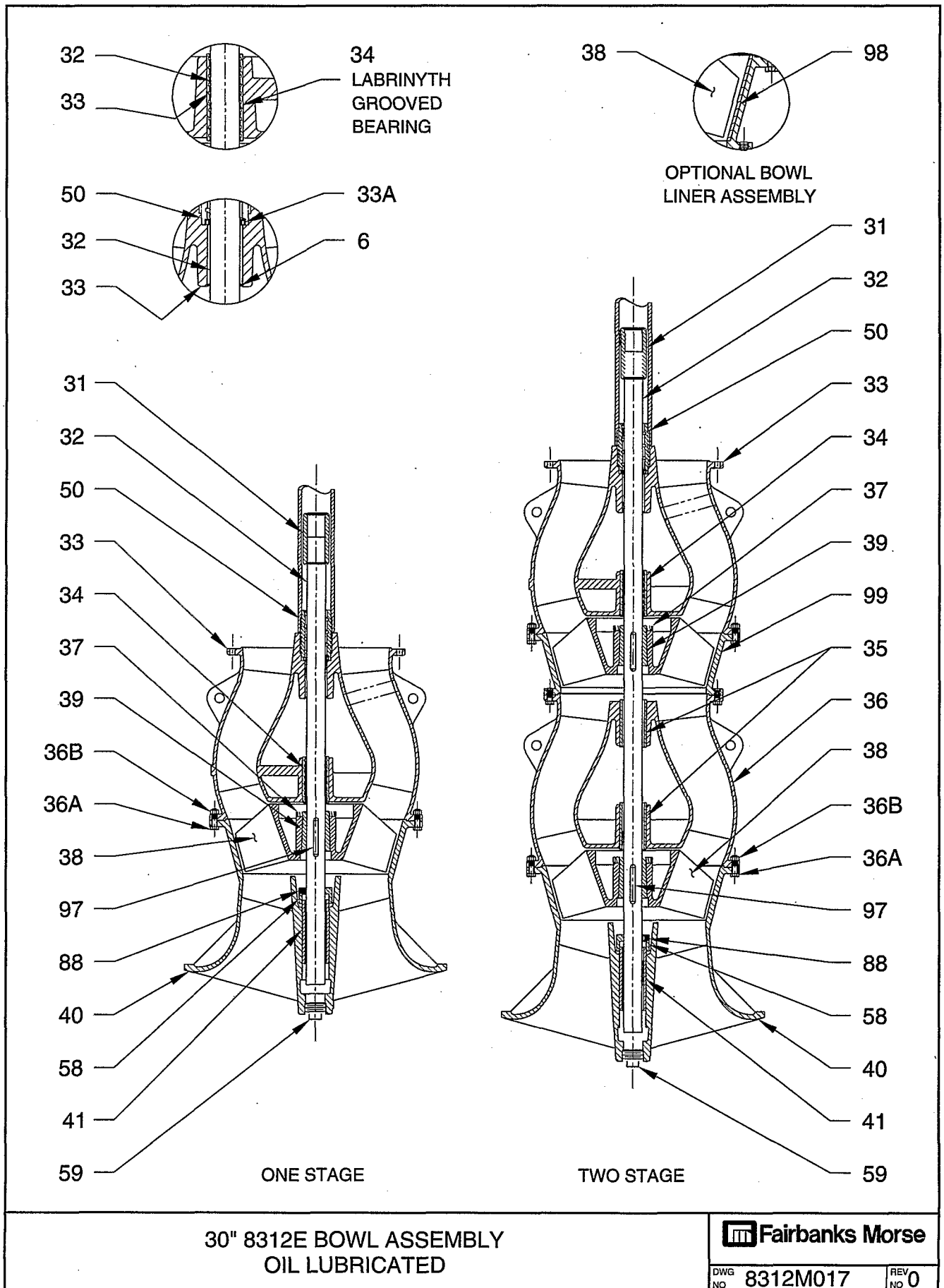


24" 8312E BOWL ASSEMBLY
OIL LUBRICATED

 Fairbanks Morse

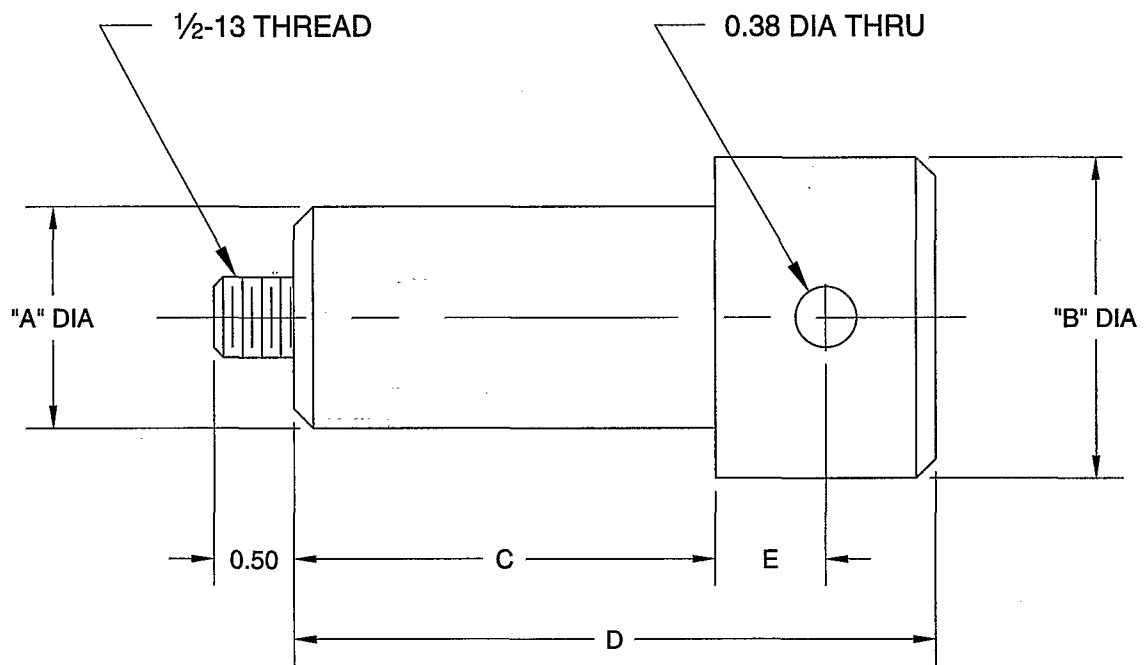
DWG NO 8312M015

REV NO 0



Bowl Assembly Parts List

Part No.	Description
6	Deflector
27	Snap Ring
27A	Washer
31	Coupling, Shaft
32	Shaft, Pump
33	Bowl, Discharge
33A	Lip Seal
34	Bearing, Discharge Bowl
35	Bearing, Intermediate Bowl
36	Bowl, Intermediate
36A	Capscrew
36B	Nut
37	Lock Nut, Propeller
38	Propeller
39	Lock Collet, Propeller
40	Suction Bell
41	Bearing, Suction Bell
50	Bearing, Connector
58	Sand Cap
59	Pipe Plug, Suction Bell
88	Set Screw, Sand Cap
97	Key, Propeller
98	Liner, Bowl
99	Bowl Seat Section

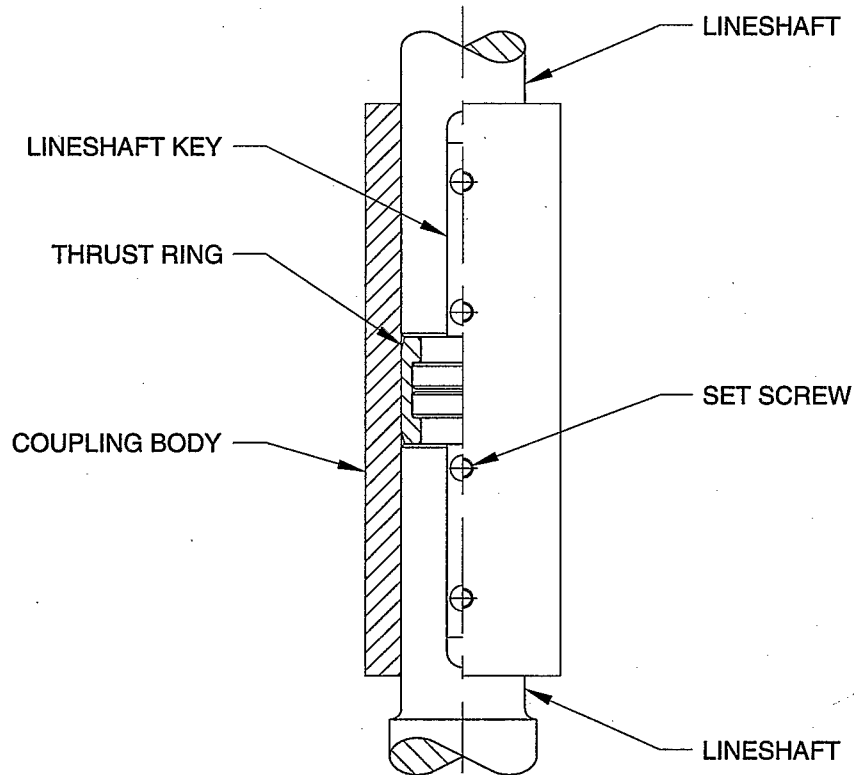


PUMP	A	B	C	D	E
10" 8312	1.38	2.00	2.63	4.00	0.69
12" 8312	1.50	2.25	2.50	3.88	0.69
14" 8312	2.06	2.75	2.88	4.25	0.69
16" 8312	2.06	2.75	2.88	4.25	0.69
20" 8312	2.50	3.25	8.00	10.00	1.00
24" 8312	3.13	4.00	6.50	7.88	0.69
30" 8312	3.00	4.50	4.50	5.88	0.69

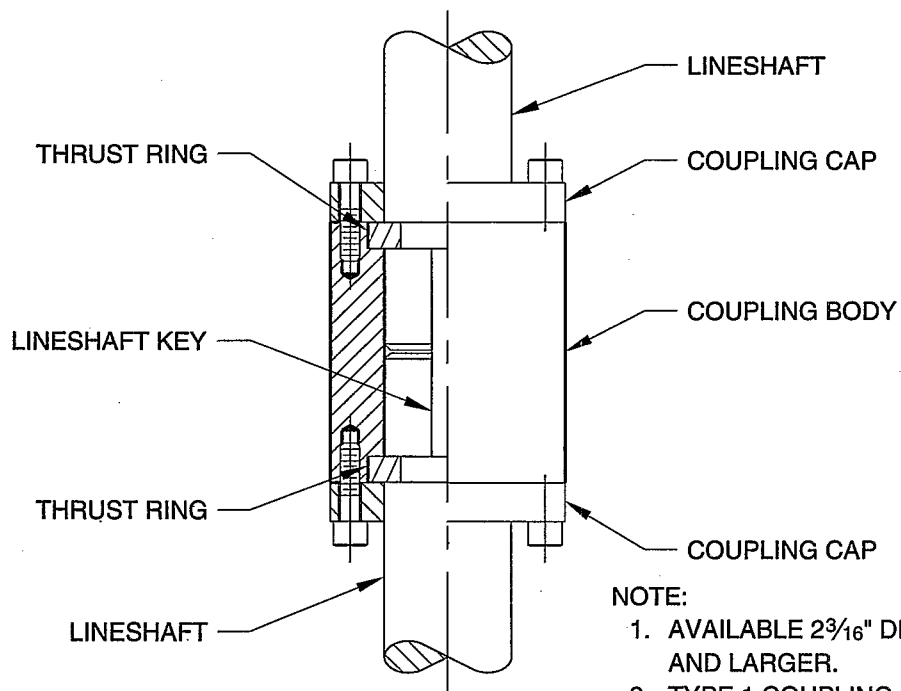
SHAFT LOCATING TOOL

 Fairbanks Morse

DWG NO 8000M091 REV NO 0



TYPE 2 COUPLING



TYPE 1 COUPLING

NOTE:

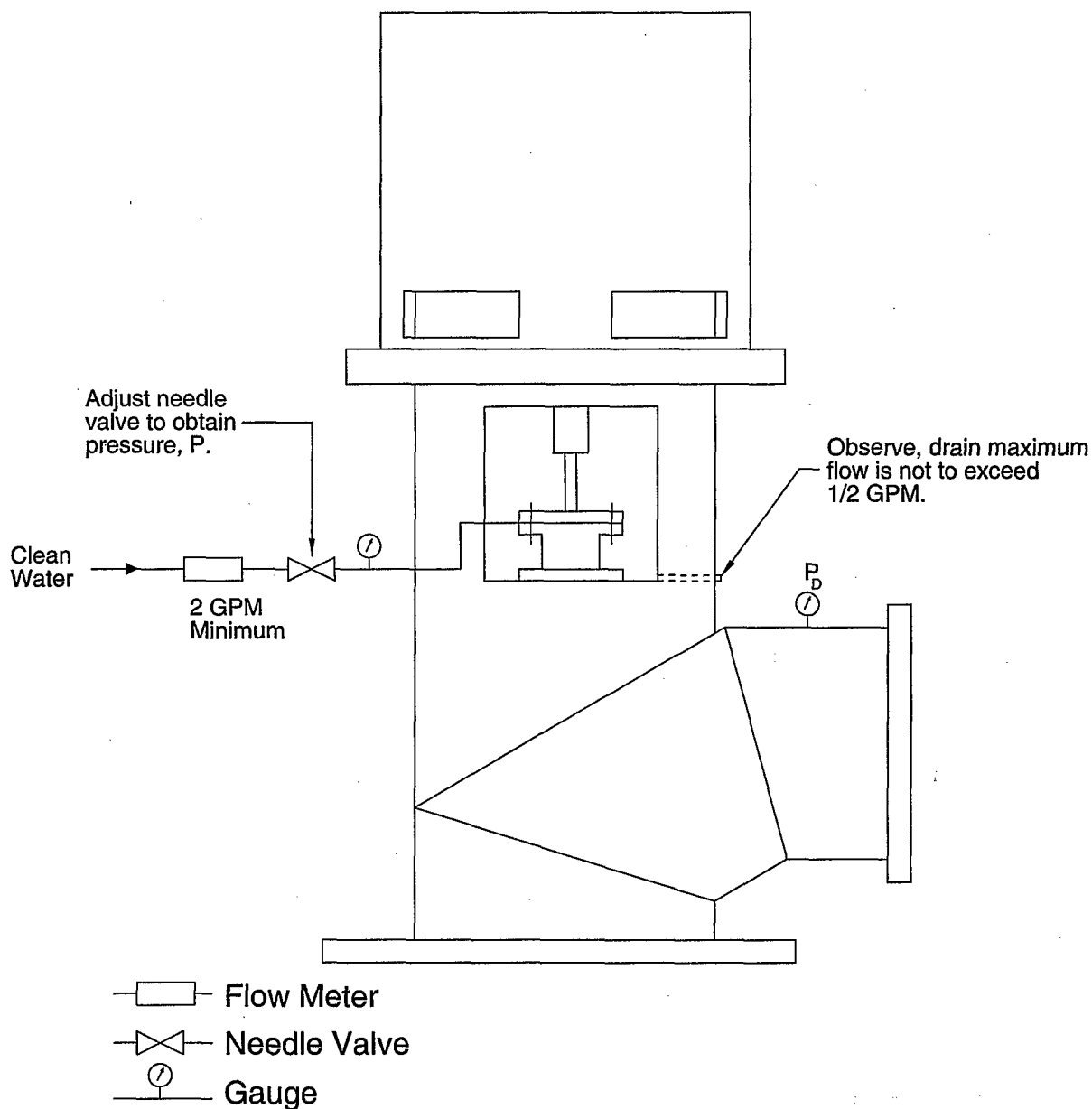
1. AVAILABLE $2\frac{3}{16}$ " DIA SHAFT AND LARGER.
2. TYPE 1 COUPLING MAY REQUIRE UPSIZING OF SHAFT AND ENCLOSING TUBE.

OPTIONAL KEYED LINESHAFT COUPLING

 **Fairbanks Morse**

DWG NO	7000A093	REV NO	0
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Water Flush System (Only for pump with packing)



PD = Pressure at discharge

$P = 3 \text{ psi for each 10 ft. of pump setting} + PD + 5 \text{ psi}$

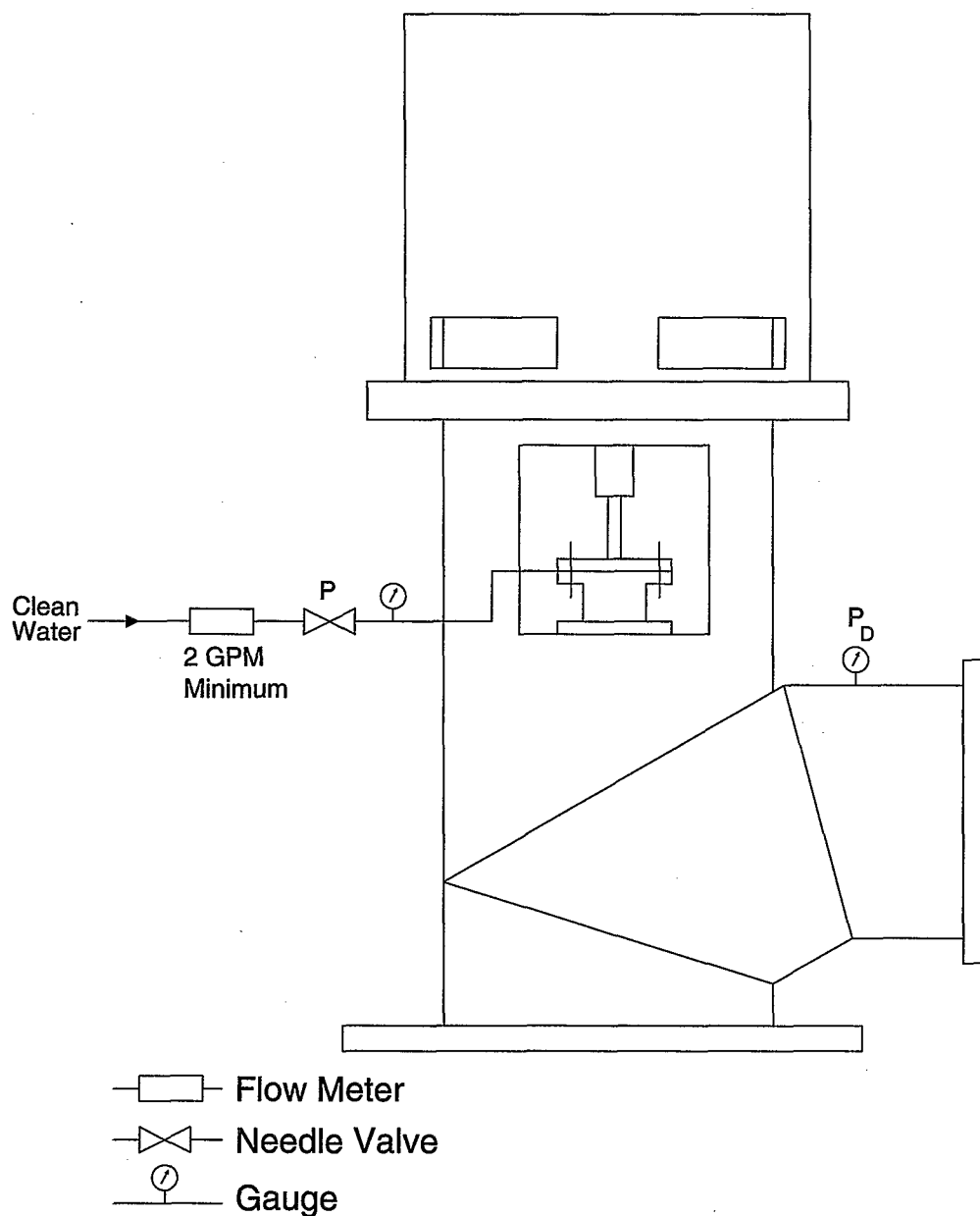
Example: 70 ft. setting
PD = 52 psi
$$P = 3 \times \frac{70}{10} + 52 + 5$$
$$= 78 \text{ psi}$$

- Note: (1) Flush water is recommended at pump at all times, whether pump is operating or not.
(2) Solenoid valves are not recommended.

Figure #7

Water Flush System

(Only for pump with mechanical seal)



PD = Pressure at discharge

$P = 3 \text{ psi for each 10 ft. of pump setting} + P_D + 5 \text{ psi}$

Example: 70 ft. setting

$$P = 3 \times \frac{70}{10} + 52 + 5$$

$$= 78 \text{ psi}$$

- Note: (1) Flush water is recommended at pump at all times, whether pump is operating or not.
 (2) Solenoid valves are not recommended.

Figure #8

Open Lineshaft Water Vent System

(Only for pump with mechanical seal)

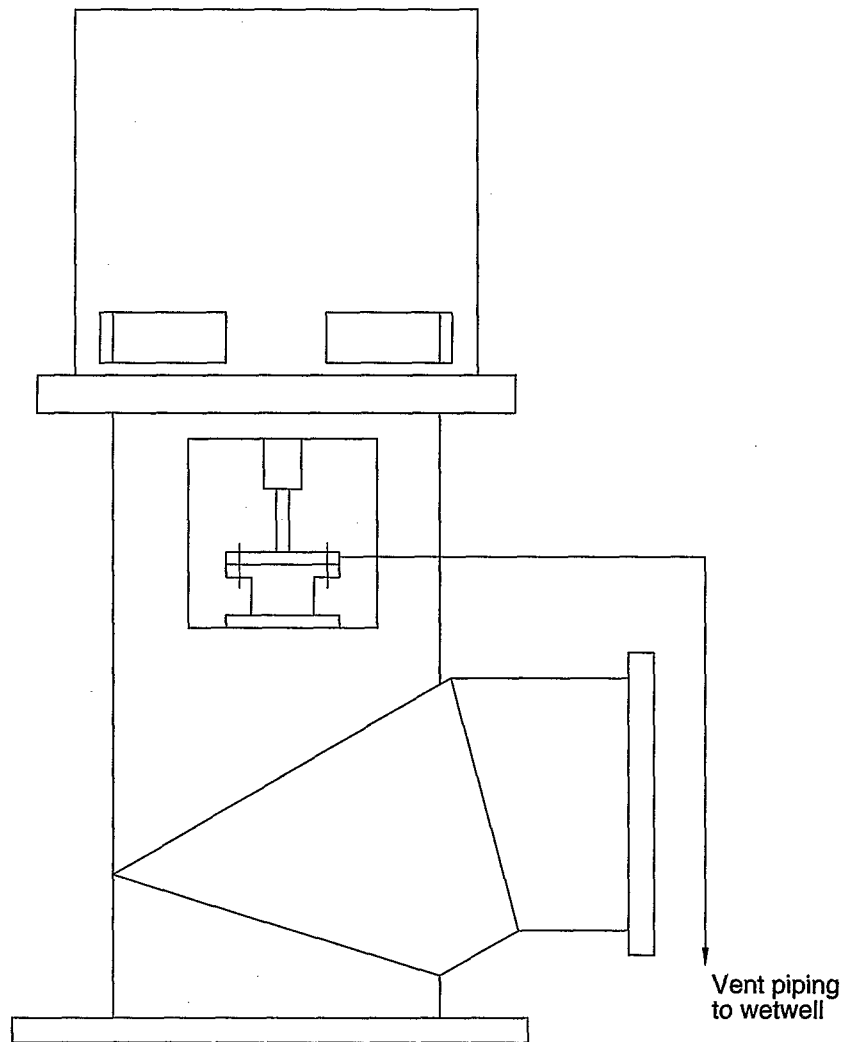


Figure #9



3601 Fairbanks Avenue
P.O. Box 6999
Kansas City, KS 66106-0999
(913) 371-5000
FAX: (913) 371-2272

2790 South Railroad
Fresno, CA 93725
(209) 266-0828
FAX: (209) 266-5341

FM217/0894

FM-03-513