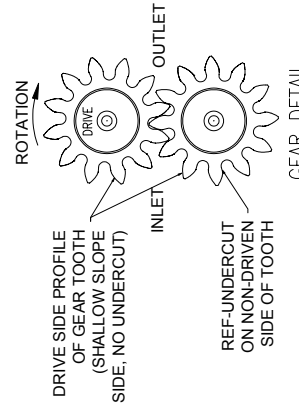


**NOTES:**

1. ASSEMBLE WITH INLET SIDE OF BEARING CASE AND INLET SIDE OF SIDE PLATE ADJACENT TO INLET SIDE OF BODY. SIDE PLATE MUST HAVE IT'S STEEL SIDE AGAINST THE BEARING CASE AND IT'S BRONZE SIDE AGAINST THE LATERAL FACE OF THE GEAR.
2. ROTATION DIRECTION IS DETERMINED BY VIEWING THE PUMP FROM THE DRIVE SHAFT END. TO INSURE CORRECT PARTS/ORIENTATION OF PARTS, OBSERVE THE FOLLOWING WHEN ROTATING THE DRIVE GEAR IN THE DESIRED DIRECTION:
  - A) THE 23° PRESSURE ANGLE SIDE OF THE DRIVE GEAR AND IDLER GEAR ARE IN CONTACT. (THE LIKE PROFILES ARE TOUCHING)
  - B) THE TEETH ARE COMING OUT OF MESH ON THE INLET SIDE OF THE PUMP.
3. FRONT AND BACK PLATES MUST ALSO BE ORIENTATED SO THAT THE INLET SIDE IS ADJACENT TO THE INLET SIDE OF THE PUMP BODY.
4. FRONT FACE OF BODY INDICATED BY THE MILLED RELIEFS ON SIDE OF BODY.
5. BOLT TORQUE (LUBRICATED THREADS) 24 FT-LBS #2 FT-LBS.
6. PUMP PERFORMANCE STANDARDS SAME AS SP25A SERIES.

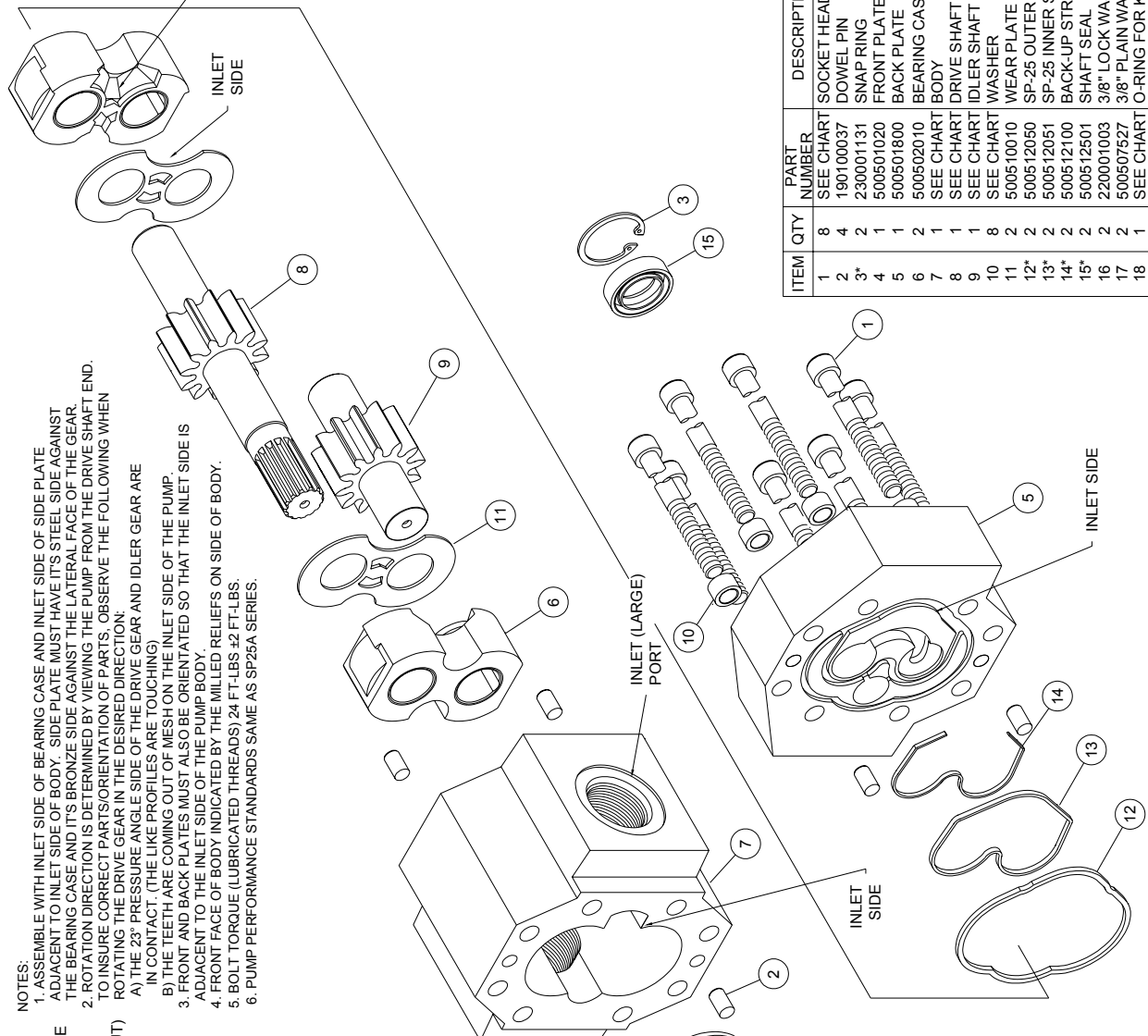


ITEM	QTY	PART NUMBER	DESCRIPTION
1	8	SEE CHART	SOCKET HEAD CAP SCREW
2	4	190100037	DOWEL PIN
3*	2	230001131	SNAP RING
4	1	500501030	FRONT PLATE
5	1	500501801	BACK PLATE
6	2	500502010	BEARING CASE ASSY
7	1	SEE CHART	BODY
8	1	SEE CHART	DRIVE SHAFT
9	1	SEE CHART	IDLER SHAFT
10	8	SEE CHART	WASHER
11	2	500510010	WEAR PLATE
12*	2	500512050	SP-25 OUTER SEAL
13*	2	500512051	SP-25 INNER SEAL
14*	2	500512100	BACK-UP STRIP
15*	2	500512501	SHAFT SEAL
16	2	220001003	3/8" LOCK WASHER (NOT SHOWN)
17	2	500507527	3/8" PLAIN WASHER (NOT SHOWN)
18	1	SEE CHART	O-RING FOR KEY (NOT SHOWN)
19	1	SEE CHART	.250 SQ. KEY (NOT SHOWN)

**SPD2 PLUG IN DOUBLE PUMP  
(CLOCKWISE)**

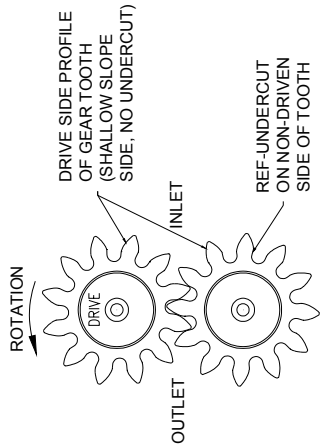
KEY (NOT SHOWN)  
PMCK-SPD1 SEAL KIT  
(\*ITEMS INCLUDED)

INLET SIDE CAVITY  
INLET SIDE



**NOTES:**

1. ASSEMBLE WITH INLET SIDE OF BEARING CASE AND INLET SIDE OF SIDE PLATE ADJACENT TO INLET SIDE OF BODY. SIDE PLATE MUST HAVE ITS STEEL SIDE AGAINST THE BEARING CASE AND ITS BRONZE SIDE AGAINST THE LATERAL FACE OF THE GEAR.
2. ROTATION DIRECTION IS DETERMINED BY VIEWING THE PUMP FROM THE DRIVE SHAFT END. TO INSURE CORRECT PARTS/ORIENTATION OF PARTS, OBSERVE THE FOLLOWING WHEN ROTATING THE DRIVE GEAR IN THE DESIRED DIRECTION:
  - A) THE 23° PRESSURE ANGLE SIDE OF THE DRIVE GEAR AND IDLER GEAR ARE IN CONTACT. (THE LIKE PROFILES ARE TOUCHING)
  - B) THE TEETH ARE COMING OUT OF MESH ON THE INLET SIDE OF THE PUMP.
3. FRONT AND BACK PLATES MUST ALSO BE ORIENTATED SO THAT THE INLET SIDE IS ADJACENT TO THE INLET SIDE OF THE PUMP BODY.
4. FRONT FACE OF BODY INDICATED BY THE MILLED RELIEFS ON SIDE OF BODY.
5. BOLT TORQUE (LUBRICATED THREADS) 24 FT.-LBS ±2 FT.-LBS.
6. PUMP PERFORMANCE STANDARDS SAME AS SP25A SERIES.



**GEAR DETAIL**

ARROW ON BACKSIDE

ITEM	QTY	PART NUMBER	DESCRIPTION
1	8	SEE CHART	SOCKET HEAD CAP SCREW
2	4	190100037	DOWEL PIN
3*	2	230001131	SNAP RING
4	1	500501020	FRONT PLATE
5	1	500501800	BACK PLATE
6	2	500502010	BEARING CASE ASSY
7	1	SEE CHART	BODY
8	1	SEE CHART	DRIVE SHAFT
9	1	SEE CHART	IDLER SHAFT
10	8	SEE CHART	WASHER
11	2	500510010	WEAR PLATE
12*	2	500512050	SP-25 OUTER SEAL
13*	2	500512051	SP-25 INNER SEAL
14*	2	500512100	BACK-UP STRIP
15*	2	500512501	SHAFT SEAL
16	2	220001003	3/8" LOCK WASHER (NOT SHOWN)
17	2	500507527	3/8" PLAIN WASHER (NOT SHOWN)
18	1	SEE CHART	O-RING FOR KEY (NOT SHOWN)
19	1	SEE CHART	.250 SQ. KEY (NOT SHOWN)
			KEY (NOT SHOWN)
			PMCK-SPD1 SEAL KIT (*ITEMS INCLUDED)

**SPD2 PLUG IN DOUBLE PUMP  
(COUNTER CLOCKWISE)**

	ITEM #18	ITEM #19
	O-RING	KEY
SHAFT CODE 1 (SPLINED)	NOT USED	NOT USED
SHAFT CODE 2 (KEYED)	240000910	500507505

PUMP MODEL/ DISPLACEMENT	DRIVE GEAR (ITEM #8)						IDLER GEAR (ITEM #9)	BODY (ITEM #7) SIDE PORT CODE A	SOCKET HEAD CAP SCREW (ITEM #1)	MACHINED WASHER (ITEM #10)
	LEFT HAND ROTATION		RIGHT HAND ROTATION		SPLINED SHAFT CODE 1	SPLINED SHAFT CODE 2				
	SPLINED SHAFT CODE 1	KEYED SHAFT CODE 1	SPLINED SHAFT CODE 1	KEYED SHAFT CODE 2						
SPD2 19	500505240	500505250	500504240	500504250	500506200	500503300	170003045 (4.50")	500507519		
SPD2 22	500505241	500505251	500504241	500504251	500506201	500503301	170003045 (4.50")	500507518		
SPD2 27	500505242	500505252	500504242	500504252	500506202	500503302	170003045 (4.50")	500507516		
SPD2 32	500505243	500505253	500504243	500504253	500506203	500503303	170003040 (5.00")	500507519		
SPD2 38	500505244	500505254	500504244	500504254	500506204	500503304	170003040 (5.00")	500507518		
SPD2 44	500505245	500505255	500504245	500504255	500506205	500503305	170003046 (5.50")	500507521		
SPD2 52	500505246	500505256	500504246	500504256	500506206	500503306	170003046 (5.50")	500507518		
SPD2 63	500505247	500505257	500504247	500504257	500506207	500503307	170003042 (6.00")	500507519		