



SPD1B DOUBLE PUMP (COUNTER CLOCKWISE)

ITEM	QTY	PART NO.	DESCRIPTION
1	4	SEE CHART	HEX HEAD CAP SCREW
2	4	190100037	DOWEL PIN (5/16 X 1 1/8)
3	2	190100050	DOWEL PIN (5/16 X 1 3/4)
4	2	190100051	DOWEL PIN (5/16 X 1 3/4)
5*	SEE CHART	230001125	SNAP RING
6	1	230001133	O-RING
7	1	500501000	FRONT PLATE
8	1	500501501	BACK PLATE
9	1	SEE CHART	INNER COVER W/O RING GRV
10	1	SEE CHART	INNER COVER
11	4	500502004	BEARING CARRIER ASSY
12	1	SEE CHART	FRONT BODY
13	1	SEE CHART	FRONT DRIVE SHAFT
14	1	SEE CHART	FRONT REAR DRIVE SHAFT
15	1	SEE CHART	FRONT IDLER
16	1	SEE CHART	FRONT WASHER
17	1	SEE CHART	WASHER
18	4	500507754	COUPLER
19	1	SEE CHART	O-RING FOR KEY (NOT SHOWN)
20	4	500512000	SP-20 MOLDED SEAL
21*	4	500512101	BACK-UP STRIP
22*	SEE CHART	500512500	SHAFT SEAL
23*	SEE CHART	SEE CHART	KEY (NOT SHOWN)
24	*	SEE CHART	PMCK-SPD1 SEAL KIT (ITEMS INCLUDED)

- NOTES:**
- ASSEMBLE WITH INLET SIDE OF BEARING CASE ADJACENT TO INLET SIDE OF BODY.
 - ROTATION DIRECTION IS DETERMINED BY VIEWING THE PUMP FROM THE DRIVE SHAFT END. TO INSURE CORRECT PART ORIENTATION OF PARTS, OBSERVE THE FOLLOWING WHEN ROTATING THE DRIVE GEAR IN THE DESIRED DIRECTION:
 - THE 23° PRESSURE ANGLE SIDE OF THE DRIVE GEAR AND IDLER GEAR ARE IN CONTACT. (THE LIKE PROFILES ARE TOUCHING)
 - THE TEETH ARE COMING OUT OF MESH ON THE INLET SIDE OF THE PUMP.
 - FRONT, BACK AND INNER COVERS MUST ALSO BE ORIENTATED SO THAT THE INLET SIDE IS ADJACENT TO THE INLET SIDE OF THE PUMP BODY.
 - FRONT FACES OF THE BODIES ARE INDICATED BY DRILL POINT INDENTATION ON THE FACE.
 - BOLT TORQUE (LUBRICATED THREADS) 24 FT-LBS ±2 FT-LBS.
 - REAR PUMP SHAFT SEAL AND SNAP RING ARE ONLY REQUIRED IN PUMPS WITH SEPARATE INLETS AND WHEN REQUIRED ARE ALWAYS IN THE REARMOST COVER.

NOTE:
SEAL AND SNAP RING NOT
REQUIRED WITH COMMON
INLET DESIGN

