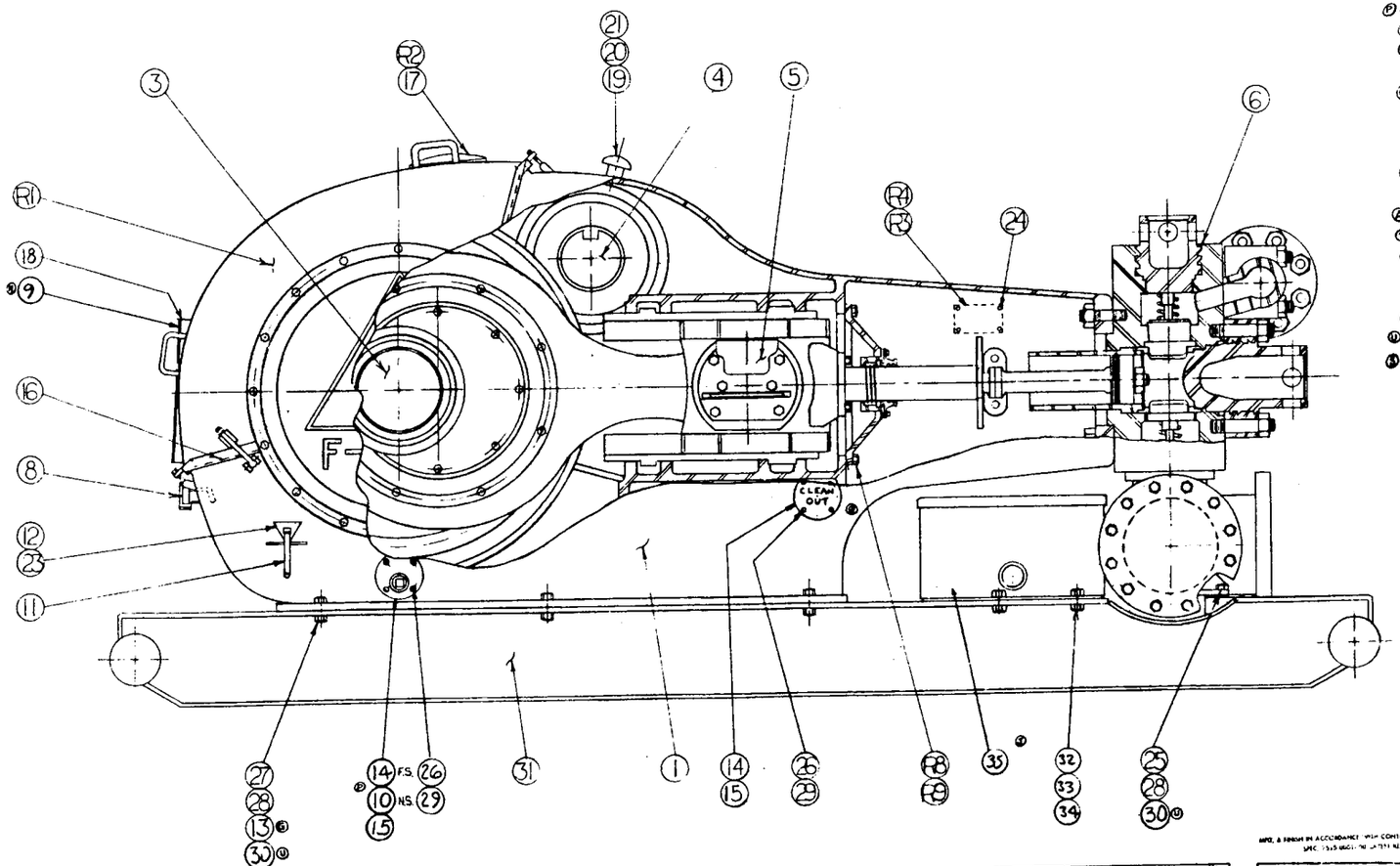
PARTS LIST

F-1000
TRIPLEX MUD PUMP

INSPECTION PER:
7511-0110-02 PUMP TEST REPORT
7511-0110-11 HYDROSTATIC TEST
7511-0110-16 CROSSHEAD CLEARANCE
7511-0110-20 ALIGNMENT

R1	1	6319-0074-00	GEAR CASE COVER	
R2	2	7510-0201-00	C-E INSPECTION DR	
R3	2	7506-0419-35	NAME PL C-E	
R4	2		" " MID CONT	
R5				
R6				
R7				
R8	24	7601-033052	1/2"-13 X 1 3/4" HEX HD CAP SCREW	
R9	24	7601-132016	1/2" LOCKWASHER	
R10				

ITEM NO.	NO. REQ'D	PART NO.	DESCRIPTION
1	1	6319-0154-01	FRAME ASSY
2			
3	1	6319-0032-00	CRANKSHAFT ASSY
4	1	6319-0028-00	PINION SHAFT ASSY
5	1	6319-0139-00	CROSSHEAD ASSY
6	1	6999-0088-00	FLUID END ASSY
7			
8	1	6319-0141-00	LUBRICATION ASSY
9	1	6319-0106-00	COVER PLATE
10	1	6316-0349-00	CLEAN OUT COVER 7 1/2" CPLG.
11	2	6397-0668-00	OIL LEVEL INDICATOR ASSY
12	2	7506-0032-00	OIL LEVEL NAME PLATE
13	6	6316-0259-00	SHIM SET (AS REQ'D)
14	3	6397-0264-00	CLEAN OUT COVER
15	4	7502-0581-00	CLEAN OUT CVR GASKET
16	1	7602-059010	GEAR CASE CVR GASKET
17	2	7502-0103-00	INSPECT. DR. GASKET
18	1	6319-0105-00	GASKET
19	1	6397-0186-00	BREATHER CAP
20	1	7507-0200000	BREATHER CAP STUD
21	1	7602-107013	COPPER WOOL (2 OZ)
22	1	7602-5940-07	GEAR CASE COVER GASKET
23	6	7601-106006	#6 X 3/8" P.K. DRIVE SCREW
24	8	7601-106009	#8 X 5/8" PK DR SCR
25	2	7601-033140	1"-8 X 5 1/2" HEX CAPSCREW
26	16	7601-033050	1/2" X 1 1/4" HEX HD CAP SCREW
27	6	7601-033133	1" X 3" HEX HD CAP SCREW
28	8	7601-063020	1"-8 NC HVY NUT
29	16	7601-133004	1/2" PLAIN WASHER SM. OD
30	8	7601-132033	1" LOCKWASHER
31	1	6319-0184-00	SKID
32	4	7601-033077	3/4"-11 X 1 3/4" HEX CAPSCREW
33	4	7601-061012	3/4"-11 HEX NUT
34	4	7601-132030	3/4" LOCKWASHER
35	1	6317-0164-00	90 GAL TANK
36			



6319-0093-03 DIMENSIONAL DWG. (UP TO S.N. 102)
6319-0093-10 DIMENSIONAL DWG. (S.N. 103 & UP)

T	63430	ITEM 25, QTY. WAS 4	
S	61890	Rev. R WAS INCORRECTLY	
R	61817	SKID(31) WAS 6319-0013-00	
Q	—	RELOCATE CLEAN OUT	
P	62356	ADDED 3/4"-4 CPLG. WAS 4	
N	60092	ADDED PER 6319-0105-00	
M	58959	(6) WAS 6319-0081-00	
L	57247	ADDED INSPECTION PLATE	
K	57077	ADDED PER 6319-0157-00	
J	56609	ADD TANK (31)(32)(33)(34)	

H	55935	FRAME WAS 6319-0083-00	
G	55920	ADD SHIM SET	
F	55509	(8) WAS 6319-0084-00	
E	55000	ADDED ITEMS 28 & 29	
D	54921	ADDED PER 6319-0138-00	
C	54867	ADD 6319-0105-00	
B	54796	ADDED PER 6319-0081-00	
A	53868	ADD ITEMS 26 & 27	

CONTINENTAL-EMSCO COMPANY
DALLAS, TEXAS

F1000 POWER PUMP
GENERAL ASSEMBLY

SIZE D | 6319-0085-00

| | | | |

THD.	TORQUE BOLTS TO:	LB FEET
1 1/4-8	DISCH. MANIF. TO CYL. BLOCK	950-1000
1 3/8-8	THD. RING TO CYL. BLOCK	1310-1360
1/2-8	CYL. BLOCK TO FRAME	1375-1425
3/8-9	SUCTION MANIF. TO CYL. BLOCK	220-250

ITEM NO.	NO. REQ'D.	PART NO.	DESCRIPTION
		REF. OPTIONAL PARTS	
R34	3	7601-136120	LINER
R37	2	7601-206187	COMPANION FLANGE
R38			
R39			
R40			

ITEM NO.	NO. REQ'D.	PART NO.	DESCRIPTION
		MISC. REF. PARTS	
R21			
R22	12	7597-2108-00	STUD (1")
R28	18	7601-2305-00	STUD (1 1/2")
R29	30	7601-2150-00	STUD (1 1/8")
R30			
R32	6	7601-033360	1/4"-8NC-2A x 4 1/4" LG. HEX. HD. CAP SCR.
R33	18	7601-06[illegible]17	1/2"-8 HVY. HEX. NUT
R35	12	7601-[illegible]3[illegible]24	1/4"-8 "
R39	6	7601-[illegible]3015	3/8" LK. WASHER
R40	30	7601-063028	1 1/8" HVY. HEX. NUT
R31			
G R32	3	6999-0087-02	FLUID END
R33			
K R34	1	6319-0070-00	FLUID BAFFLE DISC
R35			

ITEM NO.	NO. REQ'D.	PART NO.	DESCRIPTION
1	1	6319-0085-00	DISCHARGE MANIFOLD
2	3	-0026-00	LINER CAGE
3	3	-0027-00	VALVE POT COVER
4	3	6999-0089-00	THREAD RING
5	3	6319-0031-00	CYLINDER HEAD PLUG
6	1	6319-0067-00	SUCTION MANIFOLD
A 7	2	6319-0079-01	SHIM SET
B 8	3	6999-0086-02	FLUID END (STUDDED)
9	3	6297-0575-00	VALVE GUIDE - UPPER
10	1	6316-0105-00	SUCTION FLANGE
D 11	1	6317-0074-00	BLIND SUCTION FLANGE
E 12	2	6319-0132-00	SPACER
13	3	6319-0070-00	CYLINDER HEAD
14			
15	3	7503-CE10-18	HOSE ASS'Y.
16			
17			
F 18	3	7601-253042	1" TO 1/4" PIPE BUSHING - GALV
19	3	-237027	1/4" 90° STREET ELL - GALV
20	3	6297-0603-00	RETAINER: UPPER VLV. GUIDE
21			
22	36	7601-033139	1"-8NC x 5" LG. HEX. HD. CAP SCR.
23	18	7601-033600	1/4"-8NC x 2" HEX. HD. CAP SCR.
24	36	7601-063020	1"-8NC HVY HEX. NUT
25	3	7602-160052	SUCTION PLG. GSKT.
26	3	7602-160061	" MANF. "O"-RING
27	3	7602-161046	"O"-RING TYPE AN 6230-18
A 28	12	7501-0051-00	RETAINER SCREW - VLV. GUIDE
29	1	7602-528072	1/16" DIA. SOFT IRON WIRE x 6'-0"
30	1	7601-133015	1/8 PLAIN WASHER
31	2	7601-209056	90° ELL ADAPTER
32			
33			
34			
35			
36			
37			
38			
39			
40			
41			
42			
43			
44			
45			

ITEM NO.	NO. REQ'D.	PART NO.	DESCRIPTION
R20			
S R19	3	6319-0121-00	LINER END COVER
R18	3	6316-0098-00	BUSHING - LOWER VLV. GUIDE
P R17	3	6319-0087-00	VALVE GUIDE - LOWER
P R16	1	7602-301049	"PROTO" HVY. DUTY SOCKET N. 5770
R15	1	7602-301022	"PROTO" HVY. DUTY SOCKET N. 5776
R14	1	7602-301009	" " " "
R13	1	7602-321007	8" EXTENSION VA 5861
R12	1	7602-301095	SLIDING BAR VA 5984
F R11	6	7602-220332	LINER SEAL
R10	3		
R9	2	7602-066111	RING JOINT GSKT.
R8	16	7601-126217	STUDS "T" NUTS - 1 1/2-6 x 10" LG
R7	3	7601-072058	1 1/2"-8 HVY. LK. NUT
R6	1	7602-2031-01	VALVE COVER BAR
R5	3	6319-0089-01	LOCKING CLIP (LOWER VALVE)
R4		7601-258111	1/4 PIPE NIPPLE 2" GALV
R3	3	6319-0075-00	VALVE COVER SEAL
P R2	3	6319-0075-00	PISTON ROD
R1	3	6319-0071-00	" " CLAMP

REF. LOOSE PARTS

P	3/31	100935	CHG 216 - R17
N	8/14	68553	CHG QTY WAS 3
M	6/26	68256	CHG QTY WAS 2 - 6319-042
L	6/8	68087	REVISED R38 & R39-R40
K	6-15	67067	ADD R34
J	5/10	63902	(23) WAS 7601-034066

H	8/19	63430	ITEM 7, 12, QTY. WAS 4
G	7/3	61805	(8) WAS 6999-0086-02
F	5/2		ADDED TORQUE NOTE
E	2/11	58113	(18) WAS 7601-253042 (23) WAS 7601-034[illegible]
D	9/24	57156	(11) WAS [illegible] - ADD'D
C	7/24	54[illegible]	[illegible]
B	3/1	54766	ADDED R19 ITEM 23 WAS 7601-033114
A	7-28 71	54-16	ADDED R19

MACHINING DIMENSIONS ± .010"
STRUCTURAL DIMENSIONS ± 1/16"
CONCENTRICITY .010" TIR
ANGLES ± 1/2 DEG.

CONTINENTAL-EMSCO COMPANY
DALLAS, TEXAS
F-1000 PUMP
FLUID END ASS'Y.
WIDE
SIZE D
6999-0088-00

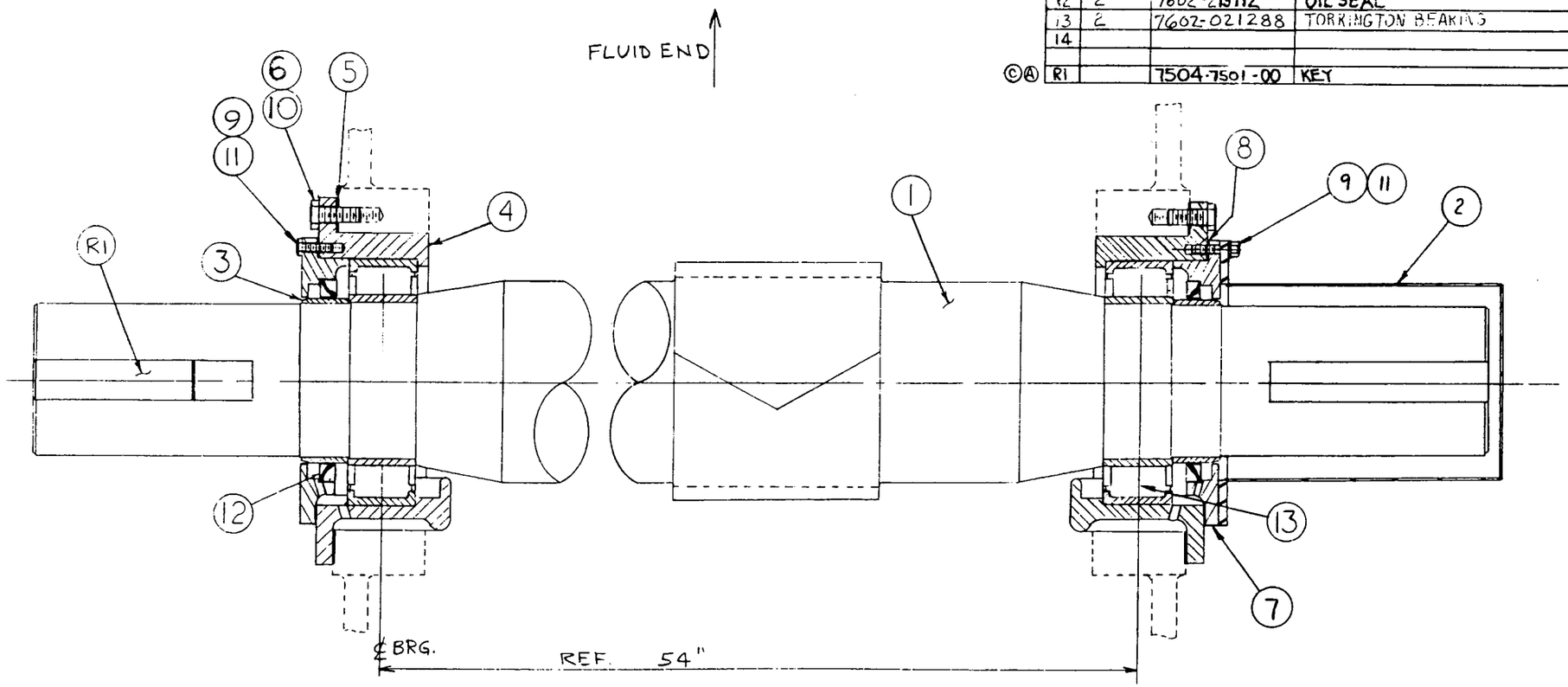
VIEW A-A

ASSM. 47 SLOT DOWNWARD

ITEM 30 USED ON MIDDLE CYLINDER ONLY

LOCKTITE 609

	1	1'	6319-0012-00	PINION SHAFT
B A	2	1	6319-0143-00	COVER
	3	2	6319-0022-00	OIL SEAL WEAR RING
	4	2	6319-0024-00	PINION BEARING CARRIER
	5	2	7502-0884-00	PINION BEARING CARRIER GASKET
	6	16	7601-033600	7/8"-9UNCx2" HEX.HD CAP SC-GR5
	7	2	6319-0023-00	OIL SEAL CARRIER
	8	2	7502-0883-00	OIL SEAL CARRIER GASKET
	9	12	7601-033220	1/2"-13UNC x 1 1/2" HEX HD CAP SC-GR5
	10	16	7601-132019	7/8" LOCKWASHER
	11	12	7601-132016	1/2" LOCKWASHER
	12	2	7602-213112	OIL SEAL
	13	2	7602-021288	TORRINGTON BEARING
	14			
C A	R1		7504-7501-00	KEY



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LTR	DATE	E.O. NO.	REVISION	BY
C	10-8	68554	(R1) Was 7504-9301-00	CM
B	1-25	66655	ADD ITEM #2	JMP
A	11-18	54958	REM. ITEM #2, ADD ITEM #R1	PJD

MATERIAL: —

UNLESS SPECIFIED OTHERWISE:
STRUCTURAL DIMENSIONS ± 1/16"
CONCENTRICITY .010" TIR
ANGLES ± 1/2 DEG

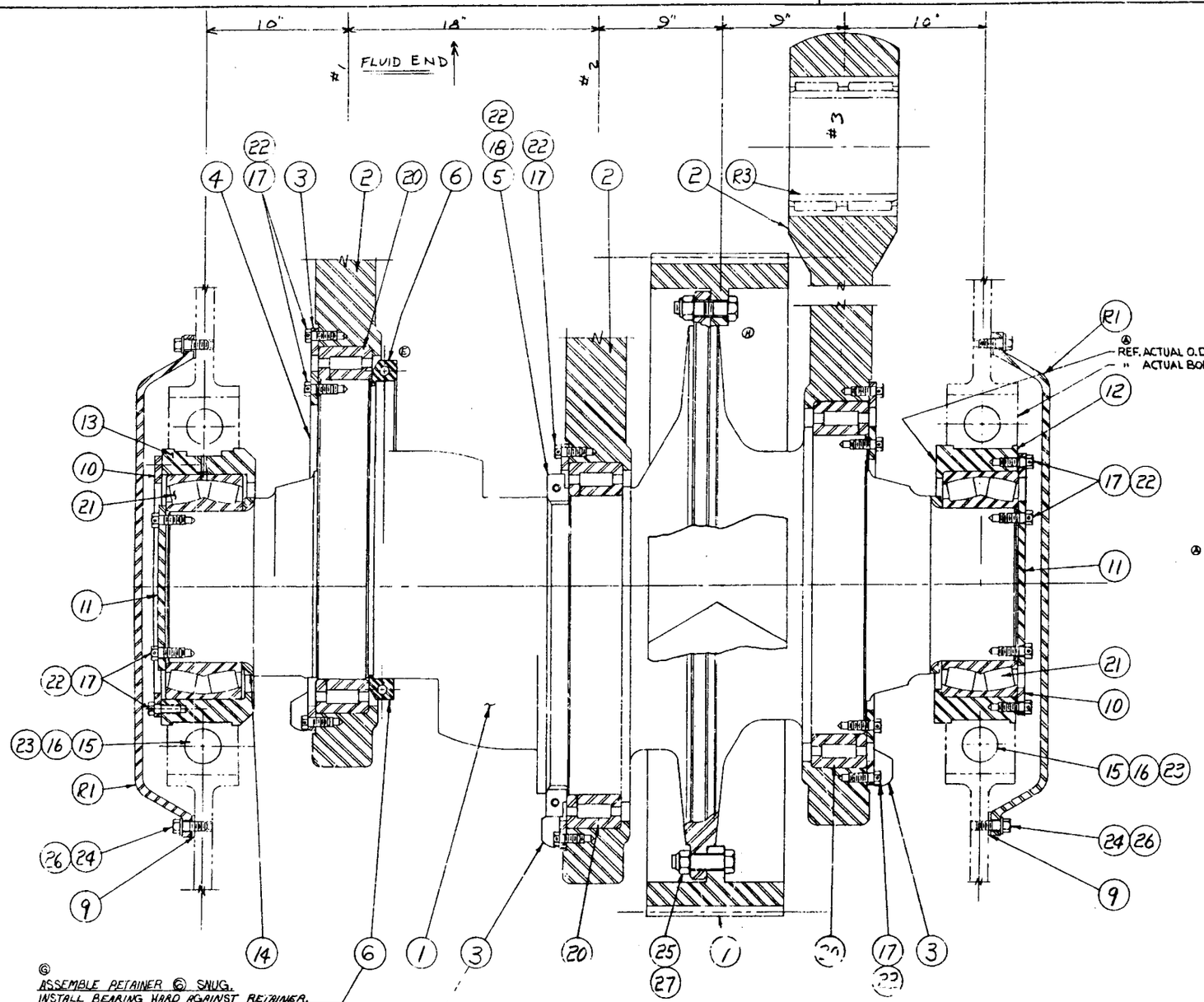
SUPERSEDES
SUPERSEDED BY

DR BY CEC | CH BY | APPR.
SCALE 3" = 1 FT. | DATE 10-13-69

CONTINENTAL-EMSCO COMPANY
A DIVISION OF THE CONTINENTAL OIL AND TUBE COMPANY
DALLAS, TEXAS

F1000
TRIPLEX PUMP
PINION SHAFT ASSY.

SIZE B | 6319-0028-00



ITEM NO.	NO. REQ'D	PART NO.	DESCRIPTION
1	4	6319-0033-01	CRANKSHAFT
2	3	6319-0035-00	ECCENTRIC STRAP
3	3	6319-0036-00	OUTER RACE RETAINER
4	2	6319-0037-00	INNER RACE RETAINER
5	1	6319-0038-00	INNER RACE RET. (CENTER)
© 6	1	6319-0125-00	CRANKSHAFT BRG. INNER RET.
7	1	6319-0011-00	ECCENTRIC RING GEAR
8			
9	2	6319-0040-00	MAIN BRG. COVER GASKET
10	2	6319-0041-00	OUTER RACE RET. MAIN BRG.
11	2	6319-0096-00	INNER RACE RET. MAIN BRG.
12	1	6319-0093-00	BEARING CARRIER LEFT
Ⓕ 13	1	6319-0174-00	BEARING CARRIER RIGHT
14	2	6319-0095-00	MAIN BEARING SPACER
15	4	6319-0034-00	MAIN BEARING HSG. BOLT
16	4	6319-0382-00	MAIN BEARING HSG. SHIM SET
17	70	7501-0004-00	5/8"-11 x 1 1/2" DRILL HD CAPSCREW
Ⓓ 18	2	7501-1251-00	5/8-11 x 4" DRILL SOCKET HD CAPSCREW
19			
20	3	6319-0078-00	ECCENTRIC BRG.
21	2	7602-020147	MAIN BRG.
22	1	7602-528960	16 GA SOFT IRON WIRE x 80'-0"
23	1	7602-520060	11 GA SOFT IRON WIRE x 5'-0"
24	24	7601-033077	5/8"-11 x 1 3/4" HX. HD. CAPSCREW
25	12	7601-033235	1/4-7 x 5" HX. HD. CPS. GR. 5
26	24	7601-133005	5/8" REGULAR WASHER - SMALL OD.
27	12	7601-072019	1 1/4-7 HEAVY HEX LOCKNUT
28			
R1	2	6319-0042-00	MAIN BRG. COVER, C-E CO.
Ⓙ R2			
23	3	6397-0267-00	CROSSHEAD BEARING
24	1	7602-301051	MAIN BRG. BOLT WRENCH

Ⓐ NOTE:
Ⓑ1.

Ⓑ2. SHIM TO OBTAIN NET FIT OF .004" TIGHT BETWEEN CARRIERS AND FRAME. REFER TO 6399-0066-00 FOR DETAILS.

©Ⓑ3. TORQUE MAIN BEARING BOLTS TO 8,800 FT. LBS. CHECK ROLLERS TO BE SURE NO MORE THAN 4 ARE TIGHT. (EXCEPT AT BOTTOM DUE TO WEIGHT). ZERO TIGHT ROLLERS IS OK.

Ⓑ4.

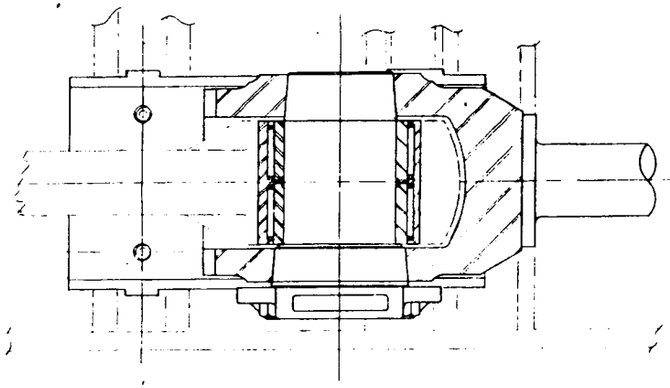
© ASSEMBLE RETAINER © SNUG.
INSTALL BEARING HARD AGAINST RETAINER.
LET BEARING COOL TO ROOM TEMP.
TIGHTEN & SAFETY WIRE RETAINER BOLTS.

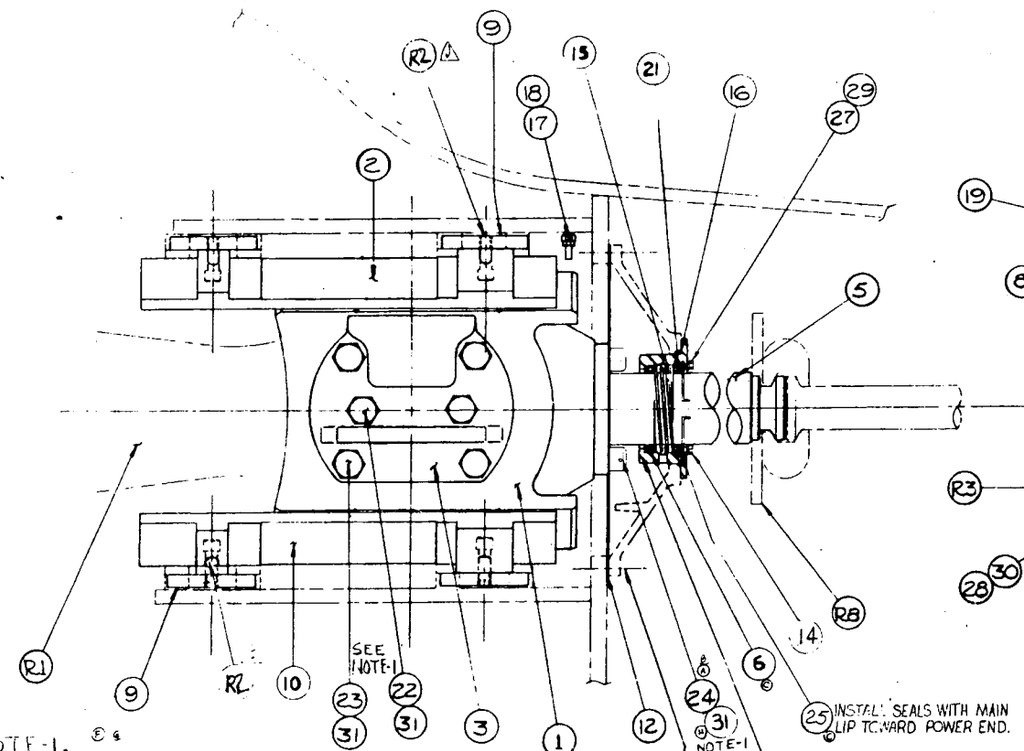
J	68086	REVISED PER		
H	65045	REVISED CRANKSHAFT & BELT WAS UNKNOWN PREVIOUSLY		
G	57174	ADDED NOTE		
F	57070	ITEM 13 WAS 6319-0094-00		
E	57002	(6) WAS 6319-0039-00		
D	56394	(18) WAS 4" 7501-1256-00		
C	55290	WAS 7000 FT-LBS		
B	50055	REVISED NOTES		
A	54706	REVISED NOTE		

CONTINENTAL-EMSCO COMPANY
DALLAS, TEXAS

F-1000 POWER PUMP
CRANKSHAFT ASSEMBLY

MATERIAL —
UNLESS SPECIFIED OTHERWISE: MACHINING DIMENSIONS ± .010", STRUCTURAL DIMENSIONS ± 1/16", CC INCENTRICITY .010" TIR, ANGLES ± 1/2 DEG.
INTERPRET
SUPERSEDES
SUPERSEDED BY
APPR. 10-8-68
SIZE D
6319-0032-00





NOTE-1. LOCTITE 2 TORQUE PIN RETAINER BOLT PER 6319-0066-02.

ITEM NO.	NO. REQ'D	PART NO.	DESCRIPTION
1	3	6319-0014-00	CROSSHEAD
2	3	-0238-00	" GUIDE(UPPER) ASSY
3	3	-0016-00	" PIN RETAINER
4	3	-0017-00	" PIN
5	3	-0020-00	" EXTENSION
© 6	3	7602-213205	SINGLE LIP OIL SEAL
7	3	6397-0543-00	DIAPHRAM STUFFING BOX
8	3	6397-0267-00	TORRINGTON BRG. NEE-1716B
9	24	6319-0131-00	LOCKING PLATE
10	3	6319-0239-00	CROSSHEAD GUIDE-LOWER ASSY
11			
12	3	6319-0019-00	GASKET - DIAPHRAM
13	2	6319-0069-00	" - CROSSHEAD COVER
14	3	6397-0540-00	DIAP STUFF. BOX LOCKSPRING
15	3	6397-0539-00	DIAP. STUFF. B.X SPRING
16	3	7602-161021	O-RING TYPE U.S. G230-40
17	3	7601-273007	3/8" HOSE CONN. 5/8 x 3/8 MPT. (MYD 200-6-6)
18	3	7508-0014-31	3/8" COPPER TUBING ASS'Y.
19	4	7601-258008	3/8" x 2" LG. PIPE NIPPLE
20			
21	3	7602-160037	"O" RING-6227-60
(F) 22	6	7501-0141-00	1"-8UNC x 2 1/4" DR. HD. CAPSCR (GR. 5)
(F) 23	12	7501-0139-00	1"-8 x 2 1/2 "
(3A) 24	12	7501-1269-00	1"-8 x 2 1/2" SKT HD CAPSCR
© 25	3	7602-213275	DOUBLE LIP OIL SEAL
26			
27	12	7601-033029	3/4"-10UNC x 3" HEX. HD CAP SCREW
28	24	7601-033076	3/8"-11UNC x 1 1/2" LG. "
29	12	7601-132014	3/8" LK. WASHER
30	24	7601-133005	3/8" SMALL OD. PLAIN WASHER
(6) 31	1	7602-531340	X-ref STAINLESS STL. WIRE
32			
33			
34			
35			
R15			
R14			
R13			
R12			
R11			
R10	24	7601-132016	1/2 LK. WASHER
R9	24	7601-033052	1/2"-13UNC-2A x 1 1/4" LG. HEX. HD. CAP SCREW
R8	3	6319-0070-00	FLUID BAFFLE DISC
R7			
R6			
R5			
R4			
R3	2	6319-0068-00	CROSSHEAD DOOR
△ R2	24	7601-0342 35	SKT HD CAPSCR "ANKLOK" 3/8-16 X 2.25
R1	3	6319-0033-00	ECCENTRIC STRAP

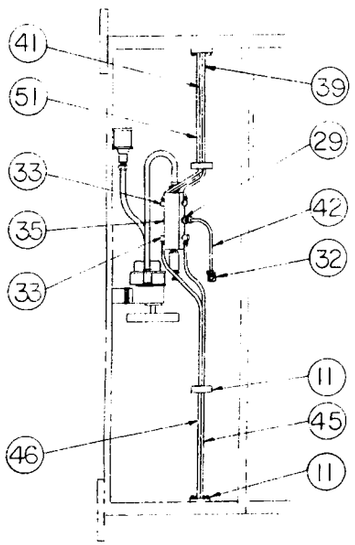
H	8/31/70	~	ADD (31) TO (24)	
G	5/11/70	62681	ADD 6397-0066-02 TO NOTE 1	
F	5/8/70	62385	WERE GRADE 5 ARE UNLESS	
E	4/29/70	~	ADDED ~ FOR SIZE	
D	4/7/70	60917	NOTE ADDED	
C	3/2/70	56498	(31) WAS 6304-0815-00 ADD 1260 SS	
B	2/18/70	55917	R SHAKEPROOF NYLOCK BOLT	
A	8/14/69	55840	WAS 7501-1269-00	

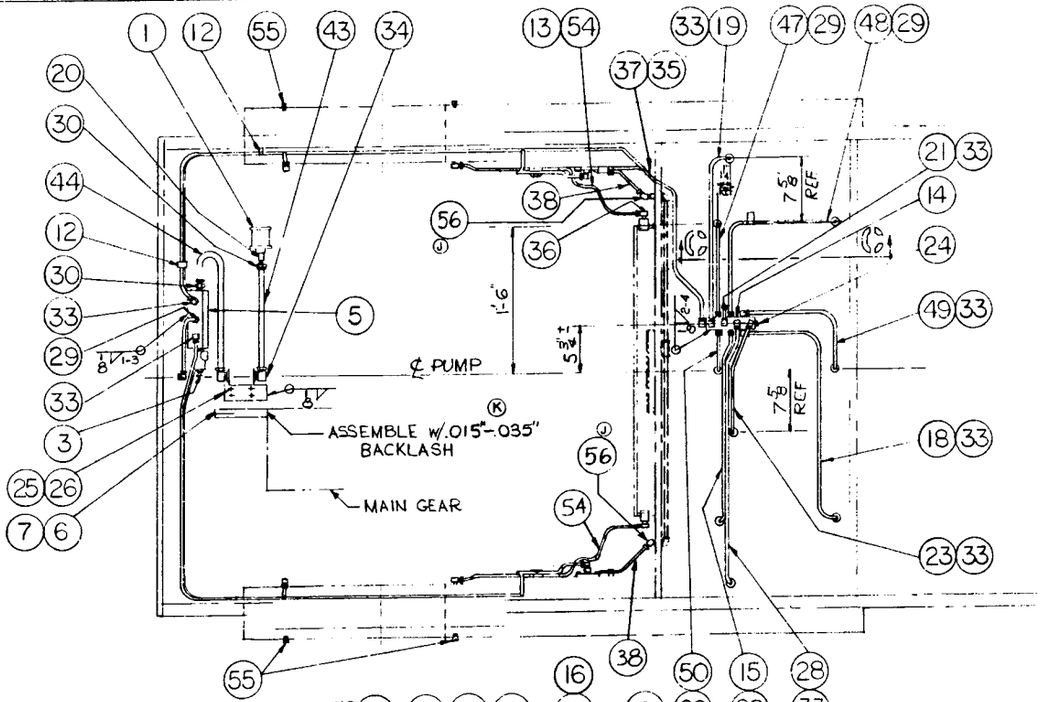
CONTINENTAL-EMSCO COMPANY

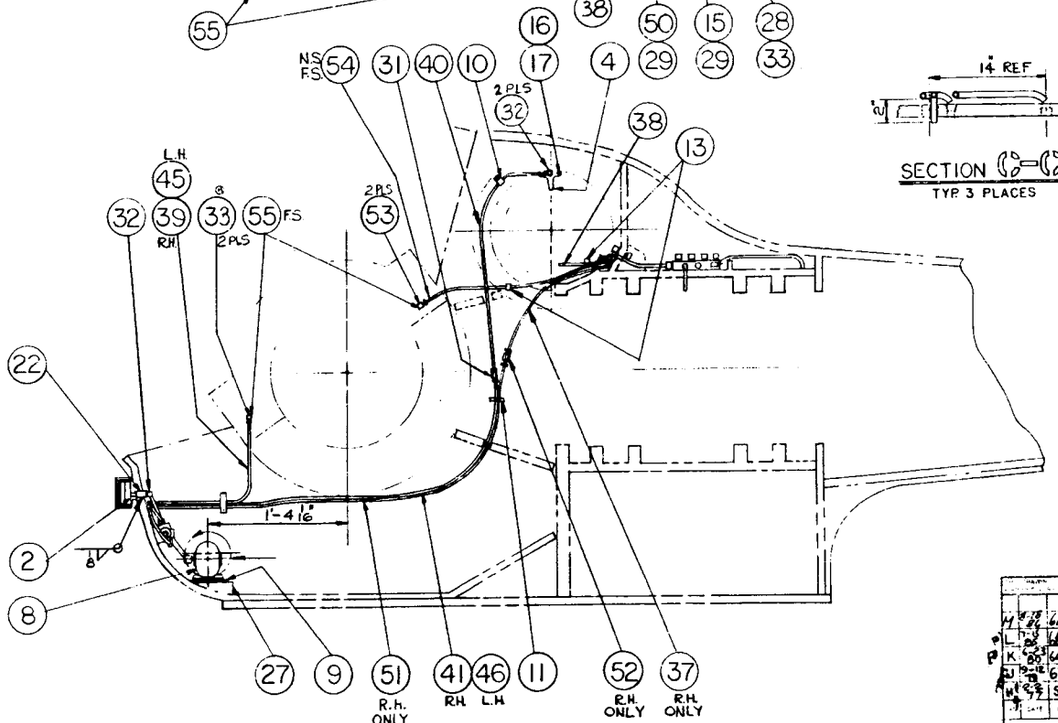
F-1000 PUMP

CROSSHEAD ASSY

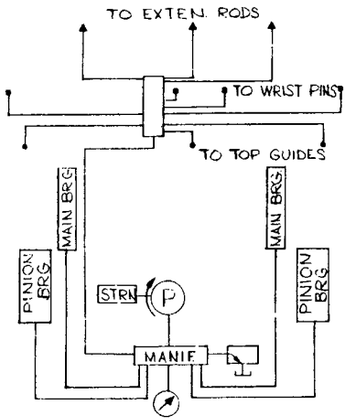
D 6318-0139-00







SECTION
TYP 3 PLACES



PRESSURE LUBE SCHEMATIC

			DESCRIPTION
1	1	7602-107003	AIR MAZE FILTER Nº OHN
2	1	7602-115098	MARSH GAUGE. 0 TO 160, N= PUDI818
3	1	7602-291478	LUNKENHEIMER 40# RELIEF VALVE
4	2	6296-0224-06	OIL JET
5	1	6920-0259-00	MANIFOLD
6	1	6319-0094-00	OIL PUMP GEAR
7	1	7504-0002-00	KEY 3/4 SQ x 1"
8	1	7602-183082	#2S B&S PUMP W/o RELIEF VALVE
9	1	6319-0095-00	SHIM SET
10	13	7514-0202-00	5/16 TBG CLAMP (SGL)
11	3	7514-0203-00	5/16 " " (DBL)
12	2	7514-0204-00	5/16 " " (TPL)
13	4	7514-0007-00	1/2" TBG CLAMP
14	1	6316-0169-00	MANIFOLD (X-HEAD)
15	1	7508-0330-22	5/16" LUBRICATOR TBG.
16	4	7601-033003	1/4"-3/4 LG HEX HD CAP SCREW
17	4	7601-132038	1/4" LOCK WASHER
18	1	7508-0400-22	5/16" LUBRICATOR TBG
19	1	7508-0260-22	5/16" " "
20	1	7601-255003	1/2" PIPE CLPG
21	1	7508-0060-22	5/16" LUBRICATOR TBG
22	1	7601-255024	1/8" PIPE CLPG
23	1	7508-0370-22	5/16" LUBRICATOR TBG
24	1	7601-259076	1/4" PIPE PLUG
25	4	7601-033032	3/8"-16 x 1 1/2" HEX HD. CAP SCREW
26	4	7601-132014	3/8" LOCKWASHER MED
27	1	6319-0096-00	OIL PUMP MTG PLATE
28	1	7508-0230-22	5/16" LUBRICATOR TBG ASS'Y
29	5	7601-273004	WTHD MALE CONN 1/2-20 TO 1/4 MPT
30	2	7601-273086	WEATHERHEAD 5/8 FT TO 1/2 MP STR CONN 302 x 10
31	2	-281002	300 x 5 5/16" T UNION
32	3	-275004	400 x 5 5/16 FT TO 1/8 MP 90° ELL
33	12	-275005	400 x 5 x 4 5/16 FT TO 1/4 MP "
34	2	-275200	WTHD ELBOW (4-02 x 10)
35	2	-275006	" " (400 x 6)
36	2	-275009	400 x 8 1/2 x 5/8 INV. MALE EL. TBG.
37	1	7508-0500-28	3/8" COPPER TBG ASS'Y
38	2	-0090-40	2" " " "
39	1	-0400-19	5/16" " " "
40	2	-0380-19	5/16" " " "
41	1	-0650-19	5/16" " " "
42	1	-0104-19	5/16" " " "
43	1	-0130-45	5/8" " " "
44	1	-0270-45	5/8" " " "
45	1	-0540-19	5/16" " " "
46	1	-0790-19	5/16" " " "
47	1	-0120-22	5/16" LUBRICATOR TBG ASS'Y
48	1	-0290-22	5/16" " " "
49	1	-0230-22	5/16" " " "
50	1	-0120-22	5/16" " " "
51	1	-0650-28	3/8" COPPER TBG ASS'Y
52	1	7601-281003	3/8" TB'G UNION (300 x 6)
53	2	7601-275035	WTHD MALE ELBOW 90°
54	2	7508-0240-37	1/2" COPPER TBG ASS'Y
55	4	7601-259094	1/4"-18 CTSK ALLEN HD PIPE PLUG
56	2	7601-275027	WTHD. MALE ELBOW 45°

F-1000 SER 12 & UP SIM 6319-0084-00

H	61574	33 WAS # 8 B&S	
L	60086	3 WAS -2 WAS 7602-113098	
K	64118	WAS .025-.030"	
J	63506	ADDED ITEM # 56	
H	59941	REDRAWN	

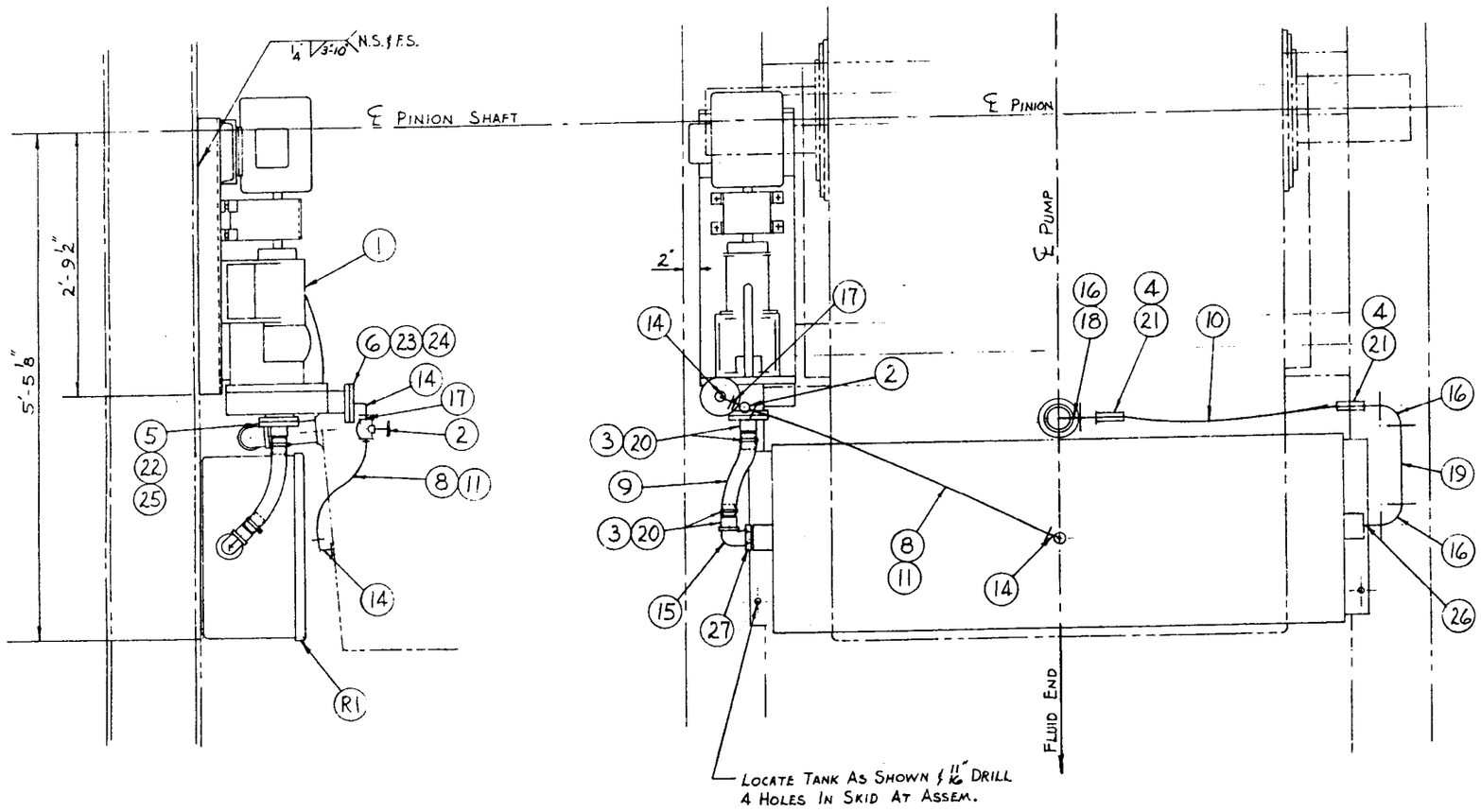
CONTINENTAL EMSCO COMPANY

F-1000 PUMP
POWER END
LUBRICATION ASS'Y

6319 OM1-00 7-22-77 MGT RHE

D 6319-0141-00

2-2-77



ITEM NO.	NO. REQ'D	PART NO.	DESCRIPTION
1	1	6316-0266-00	1"x1½" MISSION PUMP ASS'Y. (LESS MOTOR)
2	1	7602-291019	1" GLOBE VALVE
3	2	-072004	2" HOSE CLAMP (IDEAL #5256)
4	2	-072041	3" HOSE CLAMP
5	1	-066145	1½"-150# FLANGE GASKET
6	1	-066144	1"-150# FLANGE GASKET
7			
8	1	7503-0480-66	1" HOSE ASS'Y.
9	1	7601-324014	1½" I.D. HOSE (GATES 35W x 1'-2")
10	1	-431036	2½" I.D. HOSE (GATES 35W x 3'-0")
11	1	-209028	MALE PIPE ADAPTER (#1013-16-16B)
12			
13			
14	2	7601-257091	1" x 90° STREET ELL (GALV.)
15	1	-257093	1½" x 90° STREET ELL
16	3	-257047	2½" x 90° ELBOW
17	1	-258160	1" x CLOSE NIPPLE
18	1	-258238	2½" x 8" NIPPLE
19	1	-258824	2½" x 12" NIPPLE
20	2	-258394	1½" KING COMB. NIPPLE
21	2	-258352	2½" KING COMB. NIPPLE
22	1	-206013	1½"-150# THD. FLANGE
23	1	-206317	1"-150# THD. FLANGE
24	4	-126119	½"-13 x 2½" STUD BOLTS W/NUTS
25	4	-126120	½"-13 x 2¾" STUD BOLTS W/NUTS
26	1	-258234	2½" x 4" NIPPLE (GALV.)
27	1	-253098	2½" x 1½" BUSHING
28			
29			
R1	1	6317-0164-00	90 GALLON TANK

NOTE:

1. LEFT HAND INSTALLATION SHOWN; RIGHT HAND SAME EXCEPT OPP. HAND.
2. MISSION PUMP ROTATION SHOULD BE COUNTER-CLOCKWISE LOOKING INTO END OF PUMP SHAFT.

SIM. 6319-0162-00

CONTINENTAL-EMSCO COMPANY
A DIVISION OF YOUNGSTOWN SHEET AND TUBE COMPANY
DALLAS, TEXAS

F-1000 POWER PUMP
PISTON & LINER WASH ASS'Y.
W/MISSION CENT. PUMP, LESS TANK

6319-0181-00 (L.H.)
6319-0181-01 (R.H.)

SIZE D

SCALE 1" = 1 FT.

UNLESS SPECIFIED OTHERWISE:
MACHINING DIMENSIONS ± .010"
STRUCTURAL DIMENSIONS ± 1/16"
CONCENTRICITY .010" TIR
ANGLES ± 1/2 DEG.

MATERIAL —

SUPERSEDES —

SUPERSEDED BY —

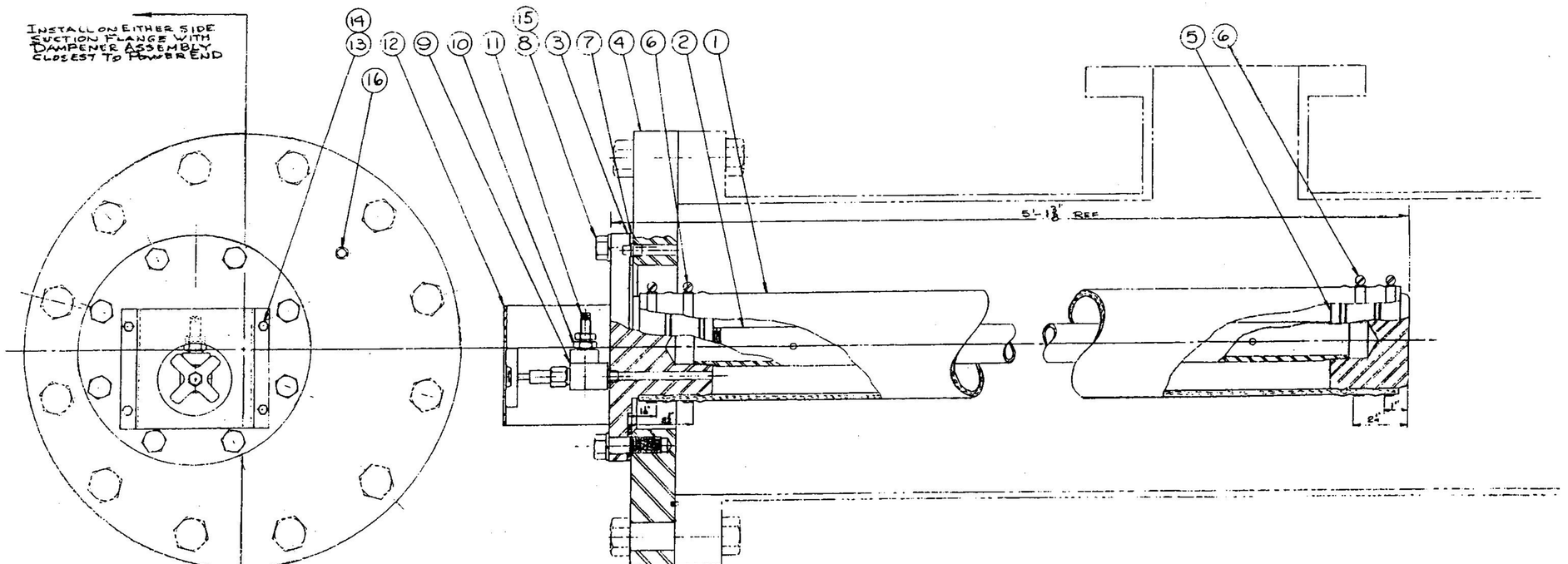
DRAWN RHG 9-12
TRACED TMB 9-12
CHECKED GGD 9-12
APPROVED

A 7A 9-12 HMS 8 SV 4-5-65 FS

DATE | DRAWN | E.C.O. No. | DESCRIPTION | BY

1" S.P.

BILL OF MATERIAL			
ITEM	REQ'D	PART NO.	DESCRIPTION
---	---	6922-0062-00	SD-8 SUCTION DESURGER ASSEMBLY (CONSISTS OF THE FOLLOWING)
1	1	6922-0054-00	BLADDER
2	1	6922-0066-00	ROD, SUPPORT
3	1	6922-0063-00	FLANGE, CHARGING
4	1	6922-0048-01	FLANGE, ADAPTER
5	1	6922-0065-00	PLUG, END
6	4	7602-072130	CLAMP, HOSE
7	1	6022-0053-00	GASKET
8	8	7601-033077	CAPSCREW, 5/8" X 1-3/4" LG. HEX HEAD
9	1	7602-291077	VALVE, 1/4" NEEDLE
10	1	7601-253001	BUSHING, 1/4" X 1/8" HEX HEAD PIPE
11	1	7602-291805	VALVE WITH VALVE STEM, 1/8" TANK
12	1	6922-0067-00	GUARD, VALVE
13	4	7601-033001	CAPSCREW, 1/4" - 20 X 1/2" LG. HEX HEAD
14	4	7601-132038	WASHER, 1/4" LOCK
15	8	7601-132030	WASHER, 5/8" LOCK
16	1	7601-259008	PLUG, 1/4" PIPE



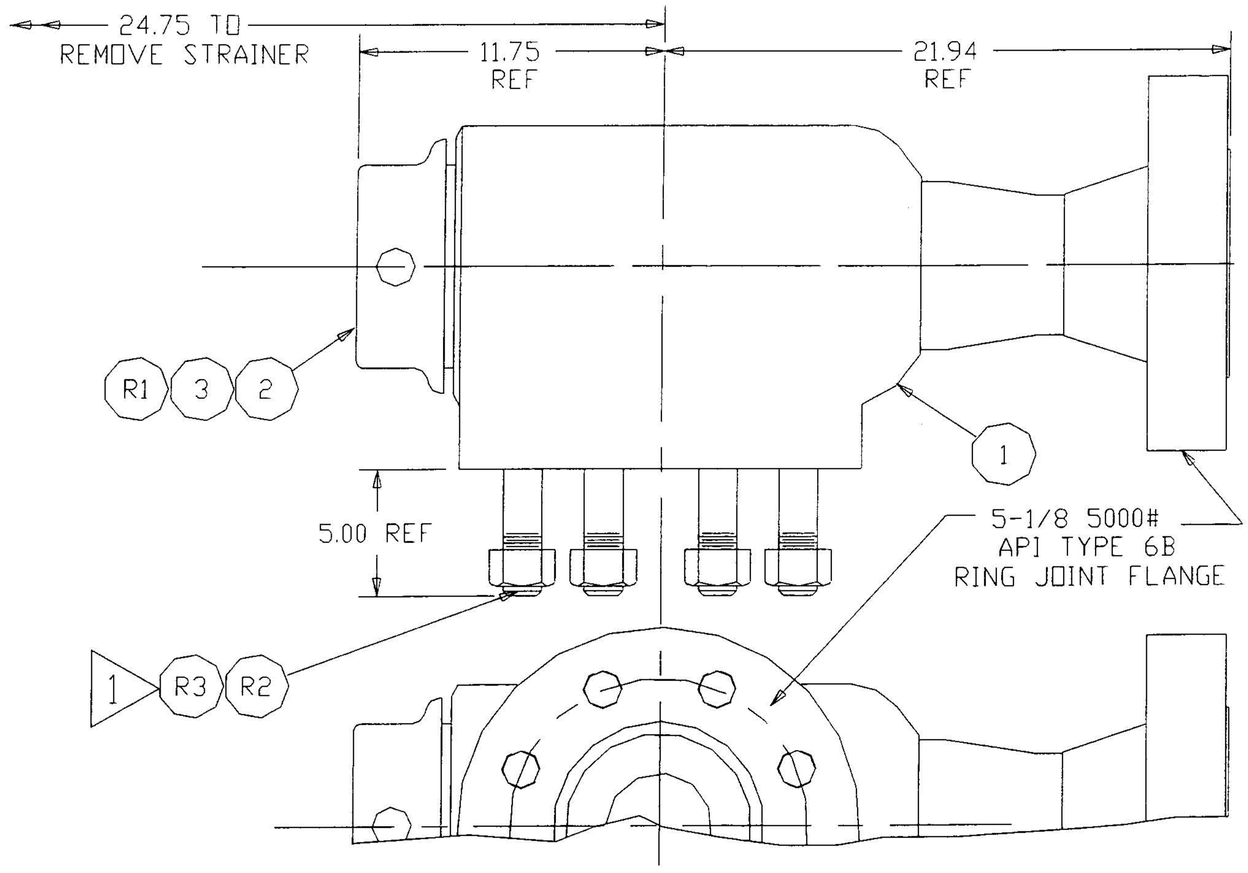
PRECHARGE RECOMMENDATION:
APPROX. 50% OF ANTICIPATED SUCTION PRESSURE WITH MAXIMUM PRECHARGE OF 10 PSIG.
ANY TYPE OF AUTO TIRE INFLATION EQUIPMENT MAY BE USED TO CHARGE DAMPENER. LIKEWISE, AN AUTO TIRE GAUGE MAY BE USED TO CHECK THE PRESSURE.
IF DESIRED PRESSURE IS EXCEEDED, BLEED OFF PRESSURE BY DEPRESSING PIN IN CENTER OF VALVE STEM (ITEM 11)

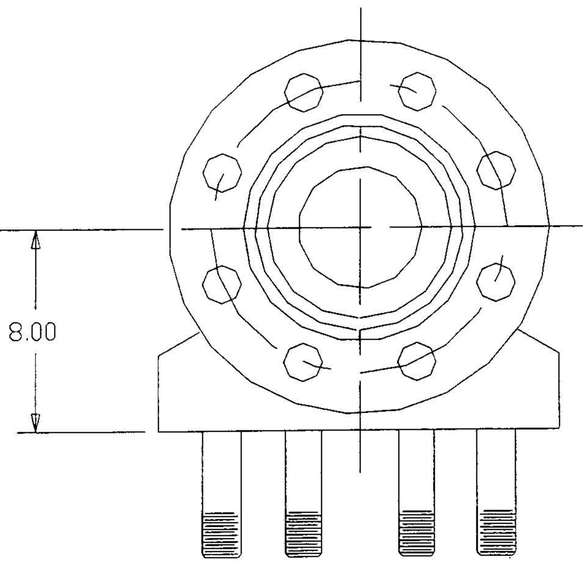
INSTALL CLAMPS (6) TO DIMENSIONS SHOWN AND TIGHTEN TO 35-40 IN. LB.

LEAK TEST ASSEMBLED DESURGER BY APPLYING 20 PSI AIR PRESSURE TO BLADDER FOR 30 MINUTES.

NOTE: OPTIONAL EQUIPMENT, PLEASE SPECIFY WHEN ORDERING.

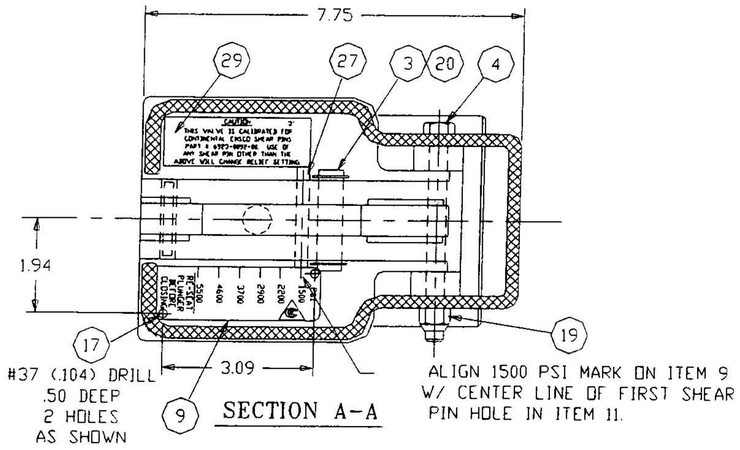
BILL OF MATERIAL			
ITEM	REQ'D	PART NO.	DESCRIPTION
---	---	6917-0039-00	DISCHARGE STRAINER ASSEMBLY (CONSISTS OF THE FOLLOWING)
1	1	6317-0049-00	HOUSING ASSEMBLY, STRAINER
2	1	6397-0290-00	STRAINER ASSEMBLY
3	1	7602-1600-40	GASKET, STRAINER
R1	1	6397-0293-01	STRAINER
R2	8	7507-2201-00	STUD, 1-1/2" - 8 X 6.88 LG.
R3	8	7601-0630-17	NUT, 1-1/2" - 8 HEAVY HEX

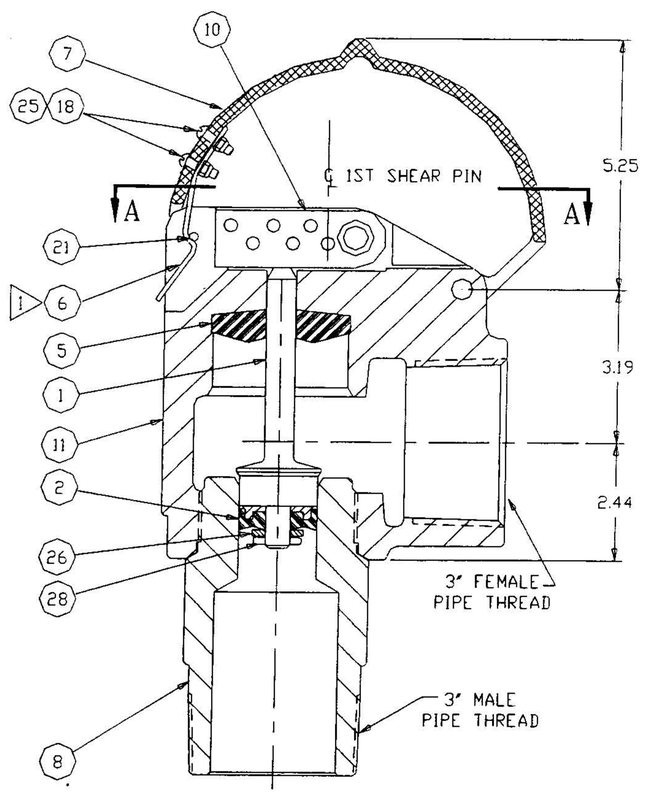


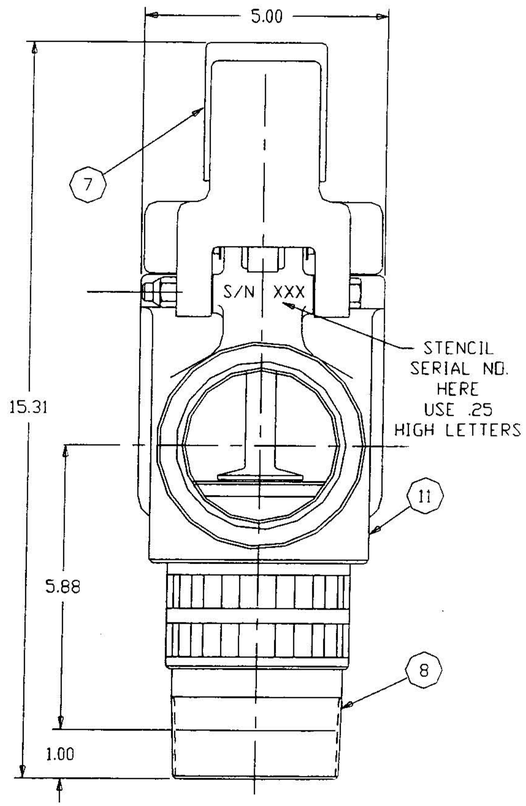


1 REF: STUD NUT TORQUE:
1575-1625 FT-LB

NOTE: **OPTIONAL EQUIPMENT, PLEASE SPECIFY WHEN ORDERING.**







BILL OF MATERIAL

ITEM	REQ'D	PART NO.	DESCRIPTION
---	---	6923-0016-00	3" TYPE B SHEAR RELIEF VALVE ASSEMBLY (CONSISTS OF THE FOLLOWING)
1	1	6923-0006-00	STEM, PLUNGER
2	1	6923-0007-00	SEAL, PLUNGER
3	1	6923-0011-00	PIN, SHEAR BAR
4	1	7601-0335-43	CAPSCREW, 3/8" - 16 X 4-1/2" LG. CAD PLTD. HEX HEAD
5	1	6923-0012-00	BUMPER
6	1	6923-0013-00	SPRING, COVER
7	1	6923-0014-00	COVER
8	1	6923-0015-00	ADAPTER, THREADED
9	1	7506-0087-00	PLATE, NAME
10	1	6923-0096-00	BAR, SHEAR
11	1	6923-0018-00	BODY
17	2	7601-1060-03	SCREW, NO. 4 X .31 LG. DRIVE
18	2	7601-0720-25	NUT, NO. 8 - 32 LIGHT THIN LOCK
19	1	7601-0720-26	NUT, 3/8" -16 LIGHT LOCK
20	2	7602-2040-78	RING, RETAINER
21	1	7601-0840-07	PIN, ROLL
25	2	7601-0010-35	SCREW, NO. 8 - 32 X .38 LG. CAD. PLTD. SKT. BUTTON HD.
26	1	7601-1330-10	WASHER, 1.06 O.D. X .53 I.D. X .13 THK. SPEC. FOR SKT. SCREW
27	12	6923-0092-00	PIN, SHEAR
28	1	7602-0810-62	PIN, .13 DIA. X 1" LG. CAD PLTD. COTTER
29	1	6923-0094-00	LABEL, WARNING

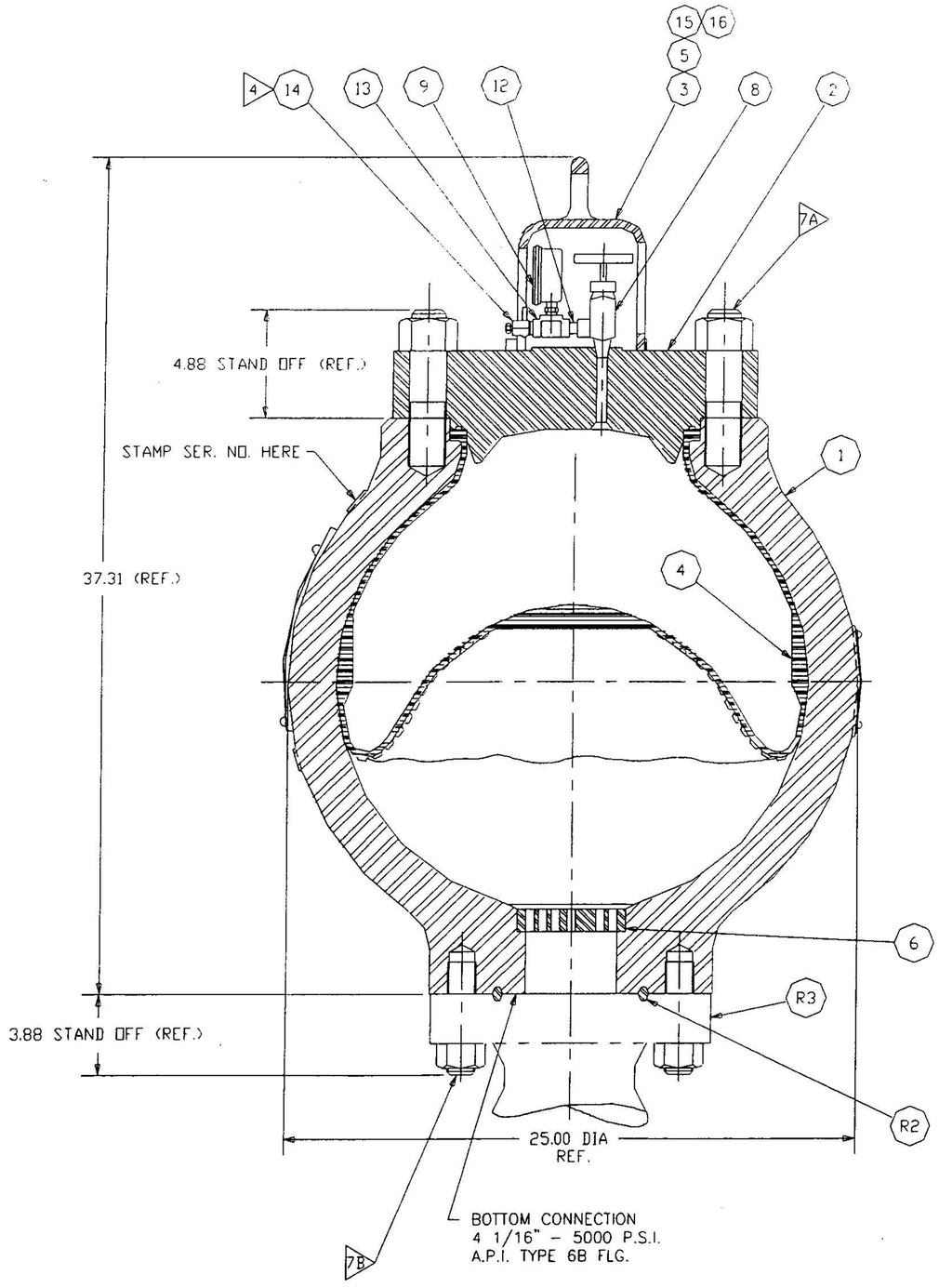
NOTES:

1. AFTER COMPLETE ASSEMBLY OF VALVE, ADJUST THE COVER SPRING, ITEM 6, IF REQUIRED TO HOLD COVER SECURELY IN PLACE. MAKE ADJUSTMENT BY BENDING BACK OR FORTH NEAR LOWER SCREW, ITEM 25.

2. AFTER ASSEMBLY, TEST VALVE BY SHEARING PIN AT 5500 PSI SHEAR HOLE. VALVE SHOULD BE WITHIN ±10 PERCENT PSI RATED

3. LUBRICATE PLUNGER AND SEAL FRICTION SURFACES WITH SUNVIS 911 OR EQUAL.

NOTE: **OPTIONAL EQUIPMENT, PLEASE SPECIFY WHEN ORDERING.**



BILL OF MATERIAL			
ITEM	REQ'D	PART NO.	DESCRIPTION
---	---	6922-0021-00	PD-55 PULSATION DAMPENER ASSY. (CONSISTS OF THE FOLLOWING)
1	1	6922-0022-00	STUDDED ASSEMBLY
2	1	6922-0017-00	HEAD
3	1	6922-0008-00	COVER, GUAGE
4	1	6922-0003-00	BLADDER
5	1	6922--0023-00	PLATE ASSEMBLY, NAME
6	1	6922-0019-00	PLUG, BOTTOM
8	1	7602-2910-00	VALVE, NEEDLE
9	1	7602-1153-03	GAUGE (0-6000 PSI), PRESSURE
12	1	7601-6582-79	NIPPLE, 1/4" X CLOSE S.S. PIPE
13	1	7601-2612-29	TEE, 1/4" STAINLESS STEEL PIPE
14	1	7602-2938-29	VALVE, 1/4" S.S. BLEED
15	4	7601-0340-29	CAPSCREW, SOCKET HEAD
16	4	7601-1320-16	WASHER, 1/2" LOCK
17	1	6399-0088-00	CHARGING INSTRUCTIONS
REFERENCE INFORMATION			
R2	1	7602-0660-03	GASKET, R-39 RING JOINT
R3	1	6397-0498-00	FLANGE, ADAPTER

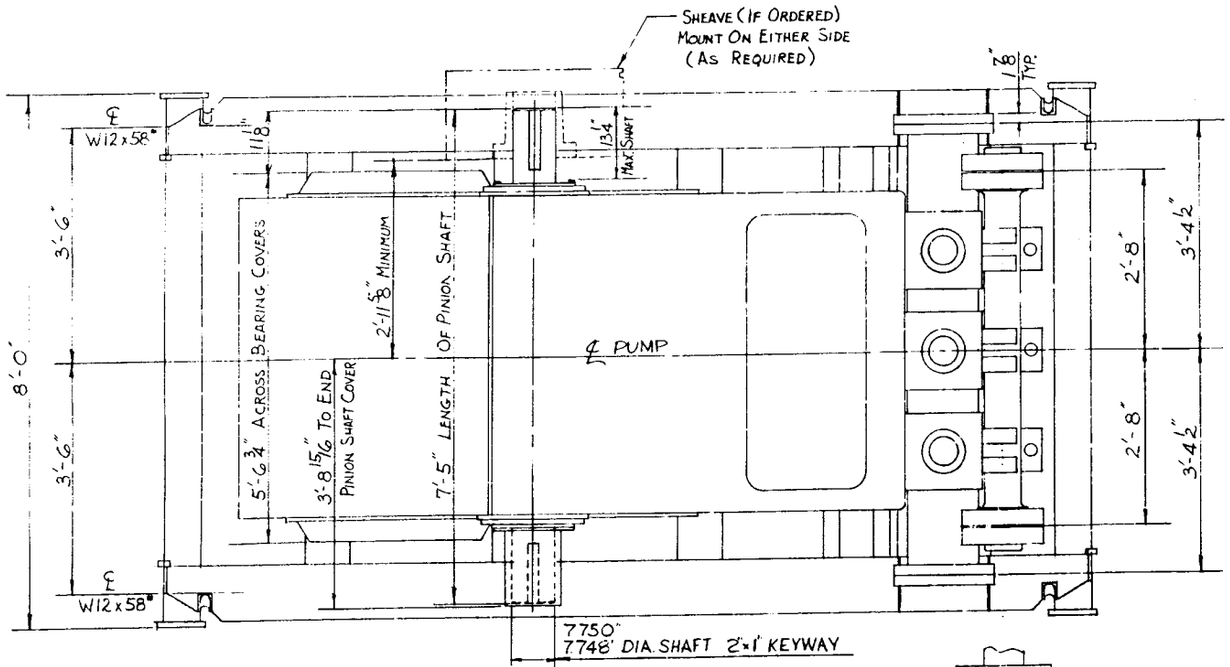
NOTES:
1. TEST WITH 100 PSI AIR PRESSURE AFTER ASSEMBLY, THEN VENT.
2. VENT
3. 7511-0110-12 TEST REPORT.
4. BEFORE CHARGING OR DISASSEMBLY, BLEED OFF ANY EXISTING PRESSURE IN GAUGE AREA BY TURNING APPROX. 1/4 TO 1/2 TURN, THEN REMOVE PURGE VALVE.
5. BLADDERS MUST BE STORED IN AN AREA PROTECTED FROM THE WEATHER. THE CONTAINER MUST BE CLOSED TO PREVENT AIR AND LIGHT EXPOSURE TO BLADDER.
6. APPROX. MUD VOL. 20 GALLONS.
7. A REF STUD NUT TORQUE 1575 – 1625 FT. LBS (1 1/2 -8 THREAD).
   B REF. STUD NUT TORQUE 950 – 1000 FT. LBS. (1 1/4 – 8 THREAD)
8. PRIOR TO USE, PRECHARGE WITH DRY NITROGEN GAS. REFER TO NAMEPLATE OR OPERATION AND MAINTENANCE MANUAL FOR INSTRUCTIONS.

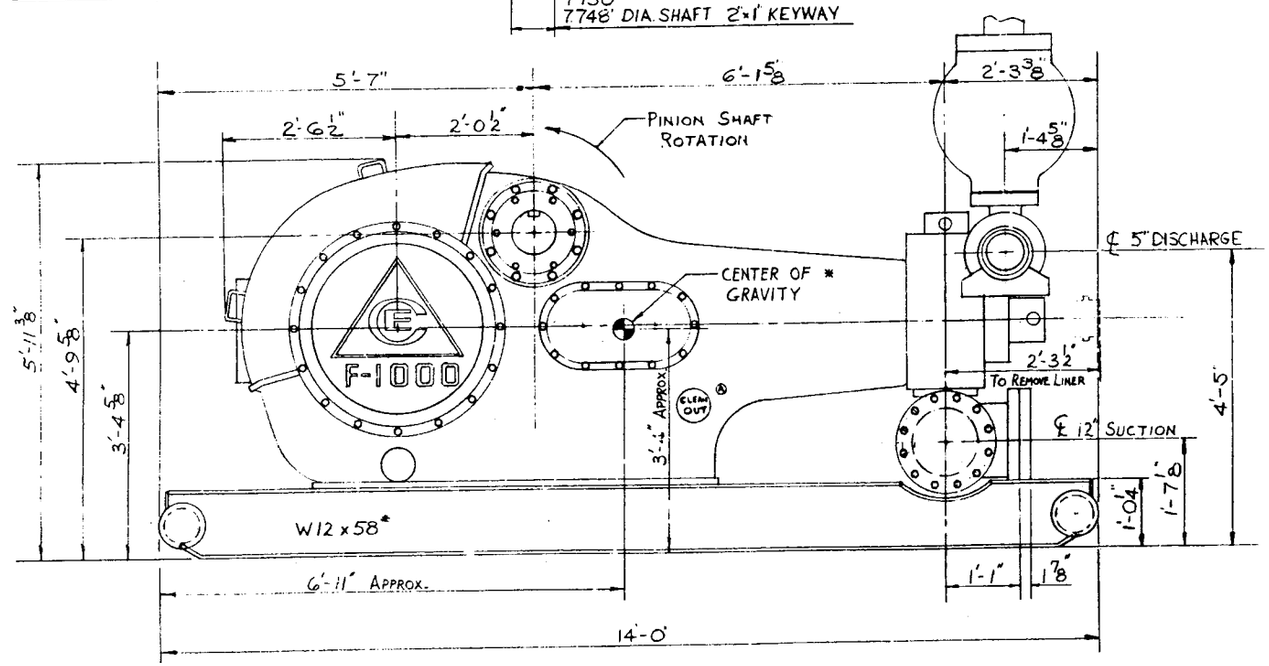
(17) NOT SHOWN

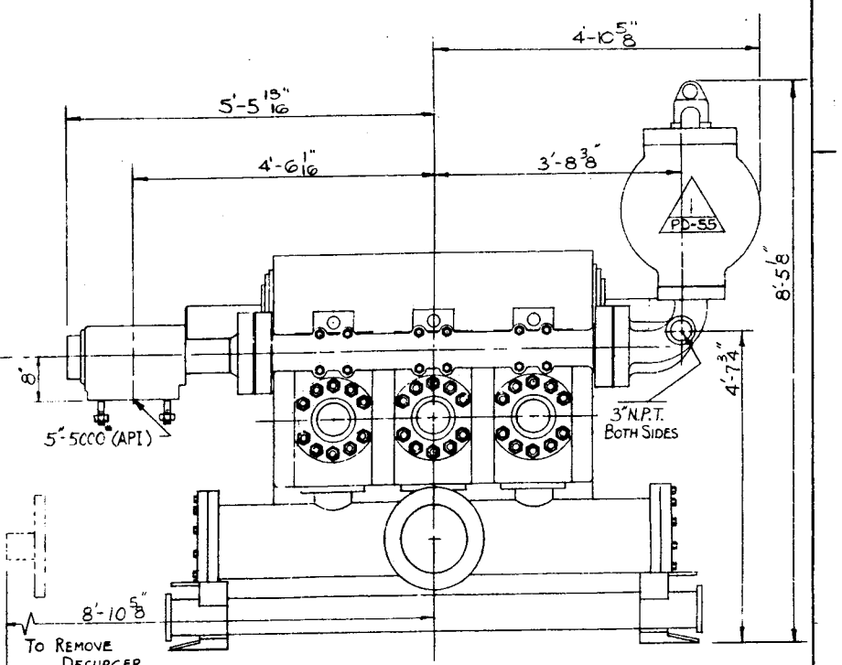
REF. DIMENSIONAL DWG. 6399-0091-00

NOTE: **OPTIONAL EQUIPMENT, PLEASE SPECIFY WHEN ORDERING.**

ITEM NO.	NO. REQ'D	PART NO.	DESCRIPTION







* CENTER OF GRAVITY FOR BASIC PUMP INCLUDES ACCESSORIES SHOWN

VERTICAL DIMENSIONS SUBJECT TO SKID BEAM TOLERANCES: +1/4", -1/8".

REVISION	BY	CHK	DATE
C REMOVE 1500# ANSI	PB		
B ADD 2'-6" & 11 3/8"	PB		
A ADD CLEAN OUT	PB		

MATERIAL —

UNLESS SPECIFIC OTHERWISE:
MACHINING DIMENSIONS ± .010"
STRUCTURAL DIMENSIONS ± 1/16"
CONCENTRICITY .010" TIR
ANGLES ± 1/2 DEG.

DR. BY PB 5-6-71
CH. BY WGT KING 5-6-71
APP'D. BY
SUPERSEDED
SUPERSEDED BY

CONTINENTAL-EMSCO COMPANY
DALLAS, TEXAS

F-1000 POWER PUMP
DIMENSIONAL DRWNG.
(HEAVY SKID)

SIZE D
6319-0093-10