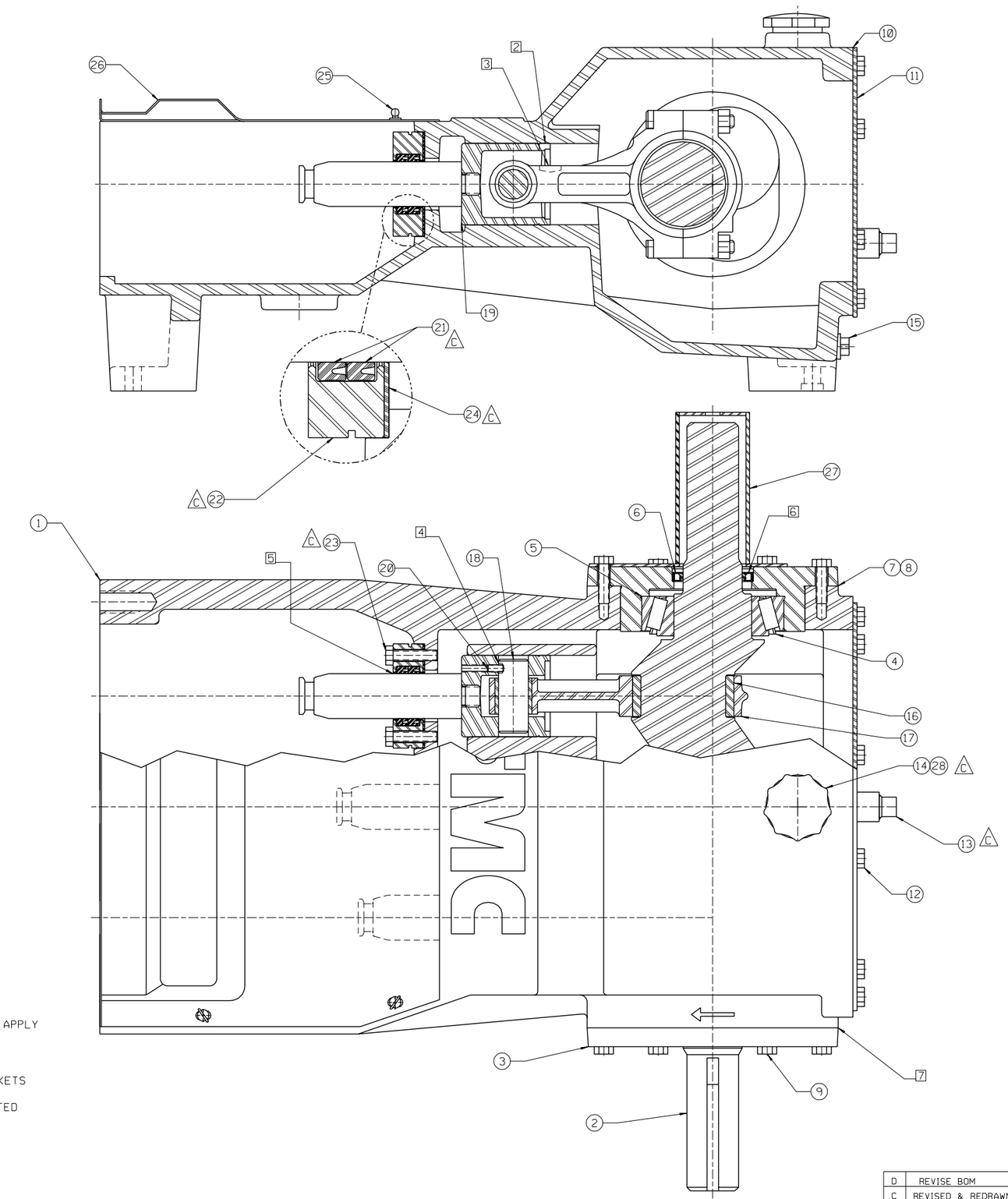
BOLT TORQUE SPECS

1 BEARING HOUSING HHCS	25 FT-LBS
2 OIL SEAL HOLDER HHCS	15 FT-LBS
3 BACK COVER HHCS	15-20 FT-LBS
4 CONNECTING ROD HEX NUTS	40-45 FT-LBS

TORQUE TOLERANCE --- ± 5%



NOTES:

△C 1 ITEMS 13 AND 28 TO BE INSTALLED AFTER TESTING, AND BEFORE CLEANING AND PAINTING.
2 CROSSHEAD SLOT MUST BE FACING UPWARD.
3 LUBRICATING OIL WELL MUST BE FACING UPWARD.
4 WRIST PIN LOCK HOLE MUST BE ALIGNED WITH SET SCREW. APPLY LOCTITE 271 TO SET SCREWS BEFORE ASSEMBLING.
5 LUBRICATE OIL SEAL WITH LUBRIPLATE.
6 LUBRICATE CRANKSHAFT OIL SEALS WITH LIGHT OIL ONLY.
7 BEARING END PLAY TO BE .005 LOOSE TO .002 TIGHT. GASKETS (ITEM 6) ARE AGAINST PUMP CASE.
8 ALL MOVING PARTS IN THE DRIVE END SHOULD BE LUBRICATED WITH SAE 30 WT OIL AT ASSEMBLY.

ITEM	NO. REQD	PART NO.	PART NAME
1	1	5263701	PUMP CASE
2	1	5263694	CRANKSHAFT:
3	2	5263699	BEARING HOUSING:
4	2	320339	BEARING CONE: 2.625 ID, TIM#HM212049
5	2	320340	BEARING CUP: 4.8125 OD, TIM#HM212010
6	2	5263902	OIL SEAL: CRANKSHAFT
7	2	5263898	GASKET: BEARING HOUSING
8	10	5263899	SHIM:
9	12	1100043	HEX HD. CAP SCREW: 3/8-16 X 1 1/4" LG.
10	1	5263895	GASKET: BACKCOVER
11	1	5263897	BACKCOVER:
12	12	1100068	HEX HD. CAP SCREW: 3/8-16 X 3/4" LG.
△C 13	1	3266520	PLUG: PIPE, 1/2" NPT, POLY
14	1	A5054	OIL CAP:
15	1	1187048	PLUG: MAGNETIC DRAIN
△D 16	6	P506697	ROD BEARING
17	3	18710	CONNECTING ROD:
18	3	A5006	WRIST PIN:
19	3	5263705	CROSSHEAD ASSEMBLY:
20	3	1103444	SET SCREW: 1/4-20 X 1/2" LG. CUP PT.
△C 21	6	P501999	OIL SEAL: PLUNGER ROD
△C 22	3	P502045	SEAL HOLDER:
23	6	P502390	HEX HD. CAP SCREW:
24	3	5264602	GASKET: OIL SEAL HOLDER
25	4	320319	THUMB SCREW: 1/4-20 X 1/2" LG.
26	1	5264004	ACCESS COVER:
27	1	5263905	SHAFT GUARD:
28	1	3269461	PLUG: PIPE, 1-1/4" NPT, POLY, (NS)
29	1	5277980	NAME PLATE (NOT SHOWN)
30	4	1187413	SELF TAPPING SCREW: #4-3/16" (NS)
31	1	1104350	KEY: 3/8" SQ X 3" PLAIN (NS)

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Unless Otherwise Specified:
Remove all burrs & sharp corners .015 R.
All diameters concentric within .010 T.I.R.
Angles ±1/2°
.X ±.015
.XX ±.005
.XXX ±.005
Finish 125 RMS
All dimensions are in inches

FMC Corporation
Fluid Control Division
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Stephenville, Texas 76401

DRIVE END ASSEMBLY
F/M08 PUMP

REV		ECN	BY	DATE
D	REVISE BOM	500562	ORG	05-15-00
C	REVISED & REDRAWN	500143	BKM	10-08-97

RELEASED FOR PRODUCTION

ECN	DATE
✓	✓

DRAWN	BKM	10-08-97
CKD.	RMC	10-10-97
APPD.	GG	10-10-97

SCALE: HALF
SIZE D
DRAWING NO. 5267537

5267537