



Installation, Operation, and Maintenance

Model TVP(VS1) Series

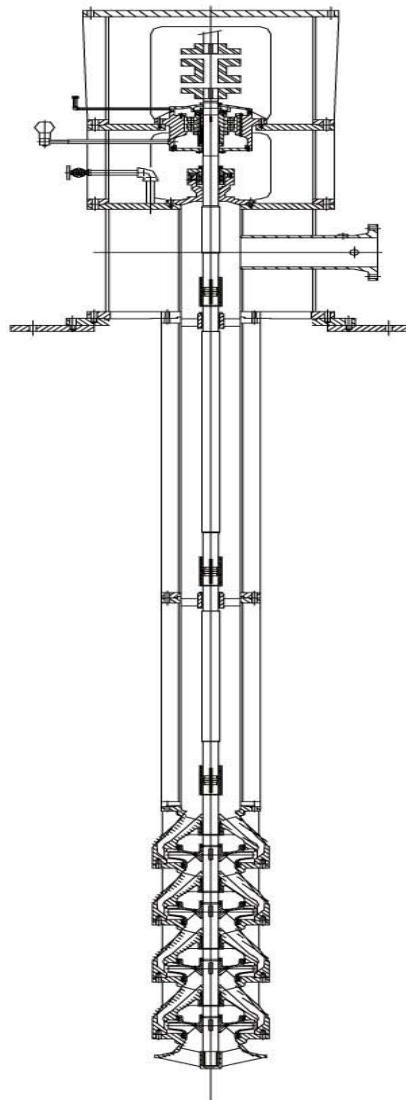


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Introduction and Safety

Safety







WARNING:

- The operator must be aware of safety precautions to prevent physical injury.
 - Any pressure-containing device can explode, rupture, or discharge its contents if it is over-pressurized.
Take all necessary measures to avoid over-pressurization.
 - Operating, installing, or maintaining the unit in any way that is not covered in this manual could cause death, serious personal injury, or damage to the equipment. This includes any modification to the equipment or use of parts not provided by TRUFLO. If there is a question regarding the intended use of the equipment, please contact TRUFLO representative before proceeding.
 - Installation, Operation, and Maintenance manuals clearly identify accepted methods for disassembling units. These methods must be adhered to. Trapped liquid can rapidly expand and result in a violent explosion and injury. Never apply heat to impellers, propellers, or their retaining devices to aid in their removal.
 - Do not change the service application without the approval of an authorized TRUFLO representative.
 - Never operate the pump below the minimum rated flow, when dry, or without adequate submergence.
 - Never operate the pump without safety devices installed.
 - Never operate the pump with the discharge valve closed.
 - Never operate the pump with the suction valve closed.
 - Never operate the pump when the strainer is clogged.
-

Safety message levels

Definitions

Safety message level	Indication
 DANGER	A hazardous situation which, if not avoid, will result in death or serious injury.
 WARNING	A hazardous situation which, if not avoided, could result in death or serious injury
 CAUTION	A hazardous situation which, if not avoided, could result in minor or moderate injury
 Electrical Hazard	The possibility of electrical risks if instructions are not followed in a proper manner
NOTICE	<ul style="list-style-type: none">• A potential situation which, if not avoided, could result in an undesirable result or state• A practice not related to personal injury

Environmental safety

The work area

Always keep the pump station clean to avoid and/or discover emissions.

Recycling guidelines

Always recycle according to these guidelines:

1. If the unit or parts are accepted by an authorized recycling company, then follow local recycling laws and regulations.
2. If the unit or parts are not accepted by an authorized recycling company, then return them to the nearest TRUFLO representative.

Waste and emissions regulations

Observe these safety regulations regarding waste and emissions:

- Dispose appropriately of all waste.
- Handle and dispose of the pumped fluid in compliance with applicable environmental regulations.
- Clean up all spills in accordance with safety and environmental procedures.
- Report all environmental emissions to the appropriate authorities.

Reference for electrical installation

For electrical installation requirements, consult your local electric utility.

User health and safety

Safety equipment

Use safety equipment according to the company regulations. Use this safety equipment within the work area:

- Helmet
- Safety goggles (with side shields)
- Protective shoes
- Protective gloves
- Gas mask
- Hearing protection

The work area

Observe these regulations and warnings in the work area:

- Always keep the work area clean.
- Pay attention to the risks presented by gas and vapors in the work area.
- Avoid all electrical dangers. Pay attention to the risks of electric shock or arc flash hazards.

Product and product positioning requirements

Observe these requirements for the product and the product positioning:

- Never operate a pump unless safety devices are installed.
- Never operate a pump unless a coupling guard is installed.
- Never force the piping in order to make a connection with a pump.
- Never start a pump without the proper submergence.
- Never run a pump below the minimum rated flow or with any suction or discharge valve closed.

Electrical connections regulations

Electrical connections must be made by certified electricians in compliance with all international, national, state, and local regulations.

Observe these guidelines and warnings for electrical connections:

- Make sure that the product is isolated from the power supply and cannot be energized by mistake.
This guideline also applies to the control circuit.
- Make sure that the thermal contacts are connected to a protection circuit

according to the product approvals, and that they are in use.

Earthing (grounding)

All electric equipment must be earthed (grounded). This rule applies to pumps and mixers as well as monitoring equipment.

Precautions before work

Observe these safety precautions before you work with the product or in connection with the product:

- Provide a suitable barrier around the work area, for example, a guard rail.
- Make sure that all safety guards are in place and secure.
- Make sure that the equipment is properly insulated when it operates at extreme temperatures.
- Allow all system and pump components to cool before you handle them.
- Make sure that you have a clear path of retreat.
- Make sure that the product cannot roll or fall over and injure people or damage property.
- Make sure that the lifting equipment is in good condition.
- Use a lifting harness, a safety line, and a breathing device as required.
- Make sure that the product is thoroughly clean.
- Make sure that there are no poisonous gases within the work area.
- Make sure that you have quick access to a first-aid kit.
- Disconnect and lock out power before servicing.
- Check the explosion risk before you weld or use electric hand tools.

Precautions during work

Observe these safety precautions when you work with the product or in connection with the product:

- Never work alone.
- Always wear protective clothing and hand protection.
- Stay clear of suspended loads.
- Always lift the product by its lifting device.
- Beware of the risk of a sudden start if the product is used with an automatic level control.
- Beware of the starting jerk, which can be powerful.
- Rinse the components in water after you disassemble the pump.
- Do not exceed the maximum working pressure of the pump.
- Do not open any vent or drain valve or remove any plugs while the system is pressurized. Make sure that the pump is isolated from the system and that pressure is relieved before you disassemble the pump, remove plugs, or disconnect piping.
- Never operate a pump without a properly installed coupling guard.

Clean chemicals from the eyes

1. Hold your eyelids apart forcibly with your fingers.
2. Rinse the eyes for at least 15 minutes.
Use an eyewash or running water.
3. Seek medical attention.

Clean chemicals from the body

1. Remove contaminated clothing.
2. Wash the skin with soap and water for at least one minute.
3. Seek medical attention, if required.

Safety regulations for Ex-approved products in potentially explosive atmospheres

Description of ATEX

The ATEX directives are a specification enforced in Europe for electrical and non-electrical equipment.

ATEX deals with the control of potentially explosive atmospheres and the standards of equipment and protective systems used within these atmospheres. The relevance of the ATEX requirements is not limited to Europe. You can apply these guidelines to equipment installed in any potentially explosive atmosphere.

General guidelines



WARNING:

Installation, Operation, and Maintenance manuals clearly identify accepted methods for disassembling units. These methods must be adhered to. Trapped liquid can rapidly expand and result in a violent explosion and injury. Never apply heat to impellers, propellers, or their retaining devices to aid in their removal.

If there are any questions regarding these requirements, the intended use, or if the equipment requires modification, contact a TRUFLO representative before you proceed.

Personnel requirements

TRUFLO disclaims all responsibility for work done by untrained and unauthorized personnel.

These are the personnel requirements for Ex-approved products in potentially explosive atmospheres:

- All work on the product must be carried out by certified electricians and TRUFLO-authorized mechanics.
- Special rules apply to installations in explosive atmospheres.
- All users must know about the risks of electric current and the chemical and physical characteristics of the gas and/or vapor present in hazardous areas.
 - The maintenance operation for Ex-approved products must be made in conformity to the international or national standards (IEC/EN 60079-17).

Product and product handling requirements

These are the product and product handling requirements for Ex-approved products in potentially explosive atmospheres:

- Only use the product in accordance with the approved motor data stated on the nameplates.
- The Ex-approved product must never run dry during normal operation. Dry running during service and inspection is only permitted outside the classified area.
- Never start a pump with a closed suction valve or blocked suction line.
- Before you start working with the product, make sure that the product and

the control panel are isolated from the power supply and the control circuit, so they cannot be energized.

- Do not open the product while it is energized or in an explosive gas atmosphere.
- Make sure that thermal contacts are connected to a protection circuit according to the approval classification of the product.
- Intrinsically safe circuits are normally required for the automatic level-control system by the level regulator if mounted in zone 0.
- The yield stress of fasteners must be in accordance with the approval drawing and the product specification.
- Make sure that the equipment is properly maintained:
- Monitor the pump components and the end temperature of the liquid.
- Maintain proper bearing lubrication.
- Do not modify the equipment without approval from an authorized TRUFLO representative.
- Only use parts that have been provided by an authorized TRUFLO representative.

Equipment for monitoring

For additional safety, use condition-monitoring devices. Condition-monitoring devices include but are not limited to these devices:

- Pressure gauges
- Flow meters
- Level indicators
- Motor load readings
- Temperature detectors
- Bearing monitors
- Leak detectors
- Pump Smart control system

Product warranty

Coverage

TRUFLO undertakes to remedy faults in products from TRUFLO under these conditions:

- The faults are due to defects in design, materials, or workmanship.
- The faults are reported to TRUFLO representative within the warranty period.
- The product is used only under the conditions described in this manual.
- The monitoring equipment incorporated in the product is correctly connected and in use.
- All service and repair work is done by TRUFLO-authorized personnel.
- Genuine TRUFLO parts are used.
- Only Ex-approved spare parts and accessories authorized by TRUFLO are used in Ex-approved products.

Limitations

The warranty does not cover faults caused by these situations:

- Deficient maintenance
- Improper installation
- Modifications or changes to the product and installation made without consulting TRUFLO
- Incorrectly executed repair work
- Normal wear and tear

TRUFLO assumes no liability for these situations:

- Bodily injuries
- Material damages
- Economic losses

Warranty claim

TRUFLO products are high-quality products with expected reliable operation and long life. However, should the need arise for a warranty claim, then contact your TRUFLO representative.

Transportation and Storage

Receive the unit

1. Inspect the package for damaged or missing items upon delivery.
2. Note any damaged or missing items on the receipt and freight bill.
3. File a claim with the shipping company if anything is out of order.

Unpack the unit

1. Remove packing materials from the unit.
Dispose of all packing materials in accordance with local regulations.
2. Inspect the unit to determine if any parts have been damaged or are missing.
3. Contact your TRUFLO representative if anything is out of order.

Pump handling



WARNING:

Installation, Operation, and Maintenance manuals clearly identify accepted methods for disassembling units. These methods must be adhered to. Trapped liquid can rapidly expand and result in a violent explosion and injury. Never apply heat to impellers, propellers, or their retaining devices to aid in their removal.

NOTICE: Use a forklift truck or an overhead crane with sufficient capacity to move the pallet with the pump unit on top. Failure to do so can result in equipment damage.

Lifting methods



WARNING :

- Assembled units and their components are heavy. Failure to properly lift and support this equipment can result in serious physical injury and/or equipment damage. Lift equipment only at the specifically identified lifting points. Lifting devices such as eyebolts, slings, and spreaders must be rated, selected, and used for the entire load being lifted.
 - Crush hazard. The unit and the components can be heavy. Use proper lifting methods and wear steel-toed shoes at all times.
 - Do not attach sling ropes to shaft ends
-

Table 1 : Methods

Pump type	Lifting method
A fully-assembled pump	Use suitable lifting devices attached to the lifting lugs on the discharge head or suitable eyebolts through the barrel flange or the discharge head base flange.
A partially-assembled pump	Use suitable lifting devices attached to the component or sub-assembly lifting lugs or suitable eyebolts through the component flanges.
A disassembled pump	Use suitable lifting devices attached to the component lifting lugs or suitable eyebolts through the component flanges.

Pump storage requirements

Requirements

Vertical pumps require proper preparation for storage and regular maintenance during storage. The pump is considered in storage when it has been delivered to the job site and is awaiting installation.

For specific requirements for storing motors, gearheads, and engines, contact the equipment manufacturer.

Storage preparation

Condition	Proper preparation
Indoor storage area (preferred)	<ul style="list-style-type: none"> • Pave the area. • Clean the area. • Drain the area and keep it free from flooding.
Outdoor storage area (when indoor storage is not available)	<ul style="list-style-type: none"> • Observe all indoor storage requirements. • Use weather-proof coverings such as flame-resistant sheeting or tarpaulins. • Place coverings in a manner that maximizes drainage and air circulation. • Tie coverings down in order to protect the pump from wind damage.
Placement of pumps and component Parts	<ul style="list-style-type: none"> • Place the pump on skids, pallets, or shoring higher than 6in.(15cm) from the ground for good air circulation. • Sort the parts in order to permit easy access for inspection and/or maintenance without excessive handling.
Stacking of pumps or component parts	<ul style="list-style-type: none"> • Make sure that racks, containers, or crates bear the full weight of pumps or parts in order to prevent distortion. • Keep identification markings readily visible. • Immediately replace any cover you remove for internal access.
Controlled storage facilities	<ul style="list-style-type: none"> • Maintain an even temperature of 10°F (6°C) or higher above the dew point. • Keep the relative humidity to less than 50%. • Make sure that there is little or no dust.
Uncontrolled storage facilities that have uneven temperatures, higher humidity, and/or dusty conditions	<ul style="list-style-type: none"> • Inspect the pump periodically to make sure that all preservative are intact. • Seal all pipe threads and flanged pipe covers with tape.

When pump is not in regular operation

If a pump has been installed, but is not in regular operation for an extended period of time, such as during a seasonal shutdown, then operate it for at least 15 minutes every two weeks, if possible.

Prepare the pump for long-term storage

For storage periods over six months, you must follow the pump storage requirements and this procedure:

1. Inspect the lube-oil and seal-flush piping and either fill the piping with rust-preventative oil, or recoat the piping periodically in order to prevent corrosion.
2. Place 10 lbs (4.5 kg) of moisture-absorbing desiccant or 5.0 lbs (2.3 kg) of vapor-phase inhibitor crystals near the center of the pump.
3. If the pump is assembled, place an additional one pound (0.5 kg) in the discharge nozzle and securely fasten the nozzle to the discharge elbow.
4. Install a moisture indicator near the perimeter of the pump.
5. Cover the pump with black polyethylene with a minimum thickness of 6.0mil(.15mm), and seal it with tape.
6. Provide a small ventilation hole approximately 0.5in. (12.0 mm) in diameter.
7. Provide a roof or shed shelter in order to protect the pump from direct exposure to the elements.

Product Description

General description

The Model TVP is a vertical, industrial, turbine-type pump designed to meet a wide range of applications.

This pump has these capabilities:

- Capacities up to 70,000 gpm (15,900 m³/h)
- Heads up to 4,500 ft. (1,372 m)
- Power up to 5,000 hp (3,730 kW)

Bowl assembly

The bowl construction is flanged for accurate alignment and ease of assembly and disassembly. Impellers are either open or enclosed, depending on the design requirements. For temperatures over 180°F (82°C) and in the larger size bowls, impellers are keyed to the shaft. Low NPSH first-stage impellers are available for special applications.

Column

Flanged column construction provides positive shaft and bearing alignment, and also eases assembly and disassembly. The lineshaft is supported within the column with the use of bearing retainers that are spaced in order to provide vibration-free operation and ensure long bearing and shaft wear.

Discharge head

The discharge head is designed to support the pump and to align the driver to the pump. Driver support windows provide access to seal piping and allow for easy adjustment of seals and couplings.

Thrust pot

A thrust pot is an option that is used when the driver is not designed to carry the axial pump thrust.

Drivers

Solid shaft drivers are used with most industrial applications. The rigidity of the rotor enhances vibration free operation when mechanical seals are used.

You can use hollow shaft drivers in applications that specify packing.

Barrel

The barrel is flanged to support the weight of the pump and driver when it is full of liquid. You can install the barrel in a sleeve or open steel structure. The suction flange is located on the side of the barrel in the TVP model.

Nameplate information

Important information for ordering

Every pump has a nameplate that provides information about the pump. The nameplate is located on the discharge head.

When you order spare parts, identify this pump information:

- Model
 - Size
 - Serial number
 - Item numbers of the required parts
- Item numbers can be found in the spare parts list.

Nameplate types

Pump : Provides information about the hydraulic characteristics of the pump.

Discharge head nameplate

TRUFLO CONDENSATE TRANSFER PUMP

ITEM NO.		MODEL	
CAPACITY	m ³ /h	BRG. NO.RAD	
HEAD	m	BRG. NO.THR	
BHP	kW	HYDRO TEST	kg/cm ² G
MOTOR POWER	kW	MAWP	kg/cm ² G
RPM		TEMP. MAWP	°C
WEIGHT	Kg	DATE	
M/C SEAL TYPE			
SERIAL NO.			

Figure 1 : Name plate

Table 2 : Explanation of discharge head nameplate

Nameplate field	Explanation
ITEM NO.	Pump item number of the customer
CAPACITY	Rated pump flow, gpm (m ³ /h)
HEAD	Rated pump head, ft(m)
BHP	Brake horse power
MOTOR POWER	The power of motor
RPM	Rate pump speed, revolutions per minute
WEIGHT	Weight of the pump
M/C SEAL TYPE	The type of mechanical seal
SERIAL NO.	Serial number of the pump
MODEL	Pump model
BRG. NO.RAD	The number of radial bearing
BRG. NO.THR	The number of thrust bearing
HYDRO TEST	The result of hydro test
MAWP	Max allowable working pressure
TEMP. MAWP	Temperature at max allowable working pressure
DATE	Day the pump was built

Installation

Pre installation

Inspect the barrel flange or sub-base

1. If an optional sub-base is furnished, remove it from the barrel when it is shipped assembled.
2. Completely clean the underside of the barrel flange or sub-base.
You might need to coat the underside of the barrel flange or sub-base with an epoxy primer which you can purchase as an option.
3. Remove the rust-preventative solution from the machined topside of the barrel flange with an appropriate solution.

Concrete foundation requirements

Requirements

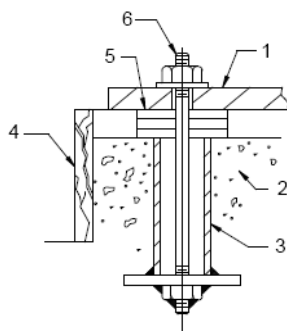
Make sure that you meet these requirements when you prepare the pump foundation:

- The foundation must be able to absorb any vibration.
- The foundation must be able to form a permanent and rigid support for the pumping unit.
- The foundation must be of adequate strength in order to support the complete weight of the pump and driver, plus the weight of the liquid that passes through it.

Typical installation

A typical installation has these characteristics:

- Bolts with a pipe sleeve that is two and a half times the size of the bolt diameter embedded in the concrete
- Properly sized
- Located in accordance with the dimensions given in the example drawing
- Enough space inside the pipe sleeves to allow the final position of the foundation bolts to align with the holes in the sub-base flange.



1. Barrel flange or sub-base
2. Foundation
3. Sleeve
4. Dam
5. Shims
6. Anchor bolt

Figure 2: Example of a typical installation

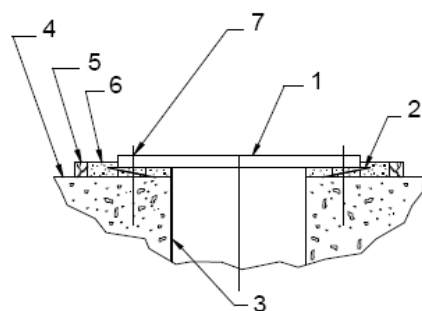
Install the barrel or sub-base on a concrete foundation



CAUTION:

You must earth (ground) all electrical equipment. This applies to the pump equipment, the driver, and any monitoring equipment. Test the earth (ground) lead to verify that it is connected correctly.

1. Remove water and debris from the anchor bolt holes and sleeves before you start the grout.
2. For sleeve-type bolts, fill the sleeves with packing or rags in order to prevent grout from entering the sleeves.
3. Carefully lower the barrel or sub-base onto the foundation bolts and hand-tighten the bolt nuts.
4. Use a machinist's level in order to level the barrel or sub-base or a machine surface of the discharge head using leveling wedges.
In order to ensure an accurate reading, check that the surface being leveled is free from all contaminants, such as dust.



1. Barrel flange or sub-base
2. Levelling wedges
3. Floor sleeve (optional)
4. Foundation
5. Dam
6. Grout
7. Centerline anchor bolt.

Figure 3: Install the sub-base on a concrete foundation

5. Level the barrel or sub-base in two directions at 90° on the machined surface.

Table 3: Levelness tolerances

Commercial	API
0.005 inches per foot (0.127 mm per meter)	0.001 inches per foot (0.025 mm per meter)

Grout the barrel or sub-base

Non-shrink grout is recommended for this procedure.

1. Inspect the foundation for dust, dirt, oil, chips, and water.
2. Remove any contaminants.

Do not use oil-based cleaners since they do not bond well with grout. Refer to the instructions from the grout manufacturer.

3. Build a dam around the foundation.

4. Thoroughly wet the foundation.
5. Pour grout to a minimum thickness of 0.375in. (9.520 mm) between the barrel or sub-base and concrete foundation, up to the level of the dam.
6. Remove any air bubbles from the grout as it is poured by either puddling, using a vibrator, or pumping the grout into place.
7. Allow the grout to set at least 48 hours.
8. Tighten the foundation bolts.

Install the pump on a structural-steel foundation

1. Locate the barrel and pump directly over – or as near as possible to the main building members, beams, or walls.
2. Bolt the barrel or sub-base to the support in order to avoid distortion, prevent vibration, and retain proper alignment.
3. Level the barrel or sub-base using shims.

Piping checklists

General piping checklist

Precautions



CAUTION:

- Never draw piping into place by using force at the flanged connections of the pump. This can impose dangerous strains on the unit and cause misalignment between the pump and driver. Pipe strain adversely affects the operation of the pump, which results in physical injury and damage to the equipment.
- Vary the capacity with the regulating valve in the discharge line. Never throttle the flow from the suction side. This action can result in decreased performance, unexpected heat generation, and equipment damage.

NOTICE :

Flange loads from the piping system, including those from the thermal expansion of the piping, must not exceed the limits of the pump. Discharge head deformation can result in contact with rotating parts, which can result in excess heat generation, sparks, and premature failure.

Piping guidelines

Guidelines for piping are given in the Hydraulic Institute Standards available from the Hydraulic Institute at 9 Sylvan Way, Parsippany, NJ 07054-3802. You must review this document before you install the pump.

Checklist

Check	Explanation/comment	Checked
Check that all piping is supported independently of, and lined up naturally with, the pump flange.	This helps to prevent: <ul style="list-style-type: none"> • Strain on the pump • Misalignment between the pump and the drive unit • Wear on the pump bearings, seal, and shafting 	

Check	Explanation/comment	Checked
Do not connect the piping to the pump until: <ul style="list-style-type: none"> • The grout for the barrel or subbase has hardened. • The hold-down bolts for the pump are tightened. 	—	
Make sure that all the piping joints and fittings are airtight.	This prevents air from entering the piping system or leaks that occur during operation.	
If the pump handles corrosive fluids, make sure that the piping allows you to flush out the liquid before you remove the pump.	—	
If the pump handles liquids at elevated temperatures, make sure that the expansion loops and joints are properly installed.	This helps to prevent misalignment due to thermal expansion of the piping.	
Make sure that all piping components, valves and fittings, and pump branches are clean prior to assembly.	—	

Suction and discharge piping checklist

Check	Explanation/comment	Checked
Check that isolation valves are installed in the suction and discharge line.	Isolation valves are required for: <ul style="list-style-type: none"> • Priming • Regulation of flow • Inspection and maintenance of the pump 	
Check that check valves are installed in the suction and discharge lines, between the isolation valve and the pump discharge head.	The location between the isolation valve and the pump allows inspection of the check valve. The check valve prevents damage to the pump and seal due to the back flow through the pump, when the drive unit is shut off. It is also used to restrain the liquid flow.	
If quick-closing valves are installed in the system, check that cushioning devices are used.	This protects the pump from surges and water hammer.	
If increasers are used, they must be of the eccentric type.	This prevents air from collecting at the top of the discharge pipe.	

Install a partially-assembled pump

Pumps 20 feet (6 meters) or less in length are usually shipped partially assembled, with the exception of these parts:

- Driver
- Packing
- Mechanical seal with piping
- Coupling assembly, spacer or non-spacer type

Refer to the Certified Pump Outline Drawing for the location of the anchor-bolt holes.

1. Clean the barrel flange and the bottom of the discharge head.
2. Check that all pump fasteners are tight since transportation and handling can result in bolt relaxation.
3. Install the barrel-to-discharge head O-ring.
4. Attach shackles to the discharge head lifting lugs or thread two eyebolts through the bolt holes in the mounting flange.
5. Hoist the unit into position over the foundation. Make sure that the shackles, eyebolts, and sling are rated to handle in excess of the pump weight. See the outline drawing.
6. Carefully guide the unit so that it does not strike the sides of the sub-base or foundation.
7. Lower the unit until the discharge-head flange engages and rests firmly on the barrel flange, then secure it with the cap screws provided.
8. When a line shaft is shipped separately, complete these steps:
 - a) Check that the average total run out does not exceed 0.005in. TIR(0.127 mm) for every 10 ft.(3 m).
The shaft must be within tolerance prior to installation.
 - b) Remove the stuffing box, if it is installed.
 - c) Carefully slide the shaft through the top column bearing retainer.
 - d) Thread the shaft into the coupling after you replace the stuffing box or seal housing.

Install the bowl assembly



WARNING:

Do not work under a heavy and suspended object unless there is a positive support and safeguards that will protect you if a hoist or sling fails.



CAUTION:

- Do not attempt to lift the bowl assembly by the pump shaft. This can result in damage to the pump shaft.
 - Do not drop any foreign object into the bowl assembly. This can cause serious damage to the pump and any downstream components. Any foreign object
-

1. Check that all cap screws are tight and turn the pump shaft by hand to make sure it turns freely.
2. Remove all accumulated dust, oil, or other foreign material from the external surfaces.
3. Place two I-beam supports across the barrel opening that are strong enough to safely support the weight of the entire pump assembly.
Connect these I-beams with threaded rods and nuts so you can clamp them

firmly together for the portion to be supported.

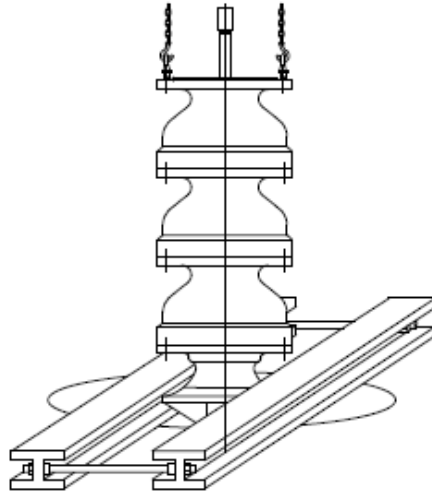


Figure 4: Install the bowl assembly

4. Place a suitable hoist or derrick over the barrel opening with the hook in the center.
5. Install two threaded eyebolts through the discharge bowl bolt holes 180° apart.
6. Attach a sling to the eyebolts and hoist it into position over the foundation opening.
7. Carefully lower the bowl assembly, guiding the unit so it does not strike the sides of the opening, until the discharge bowl flange rests firmly on the I-beam supports.
8. Place a cover over the discharge bowl opening to prevent the entrance of dirt or other foreign matter until you are ready to install the column assembly.

Install the threaded coupling

If you have a keyed coupling, see the Install the column section of this manual.



CAUTION:

Use Molykote Dow-Corning or an equivalent for all galling material such as 316 stainless steel.

Shaft threads are left hand.

1. Coat the threads with a light coat of oil for a non-galling material, or Molykote for galling material.
2. Install the threaded coupling onto the pump shaft by threading it on for one-half of its length.

You can insert a fine wire in the drill hole at the center of the coupling that serves as a gauge in order to determine when the coupling is correctly positioned on the pump shaft.

3. Remove the wire.

Install the column

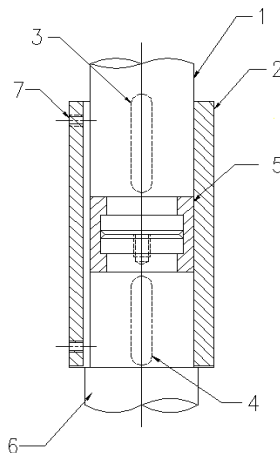


CAUTION:

Use Molykote Dow-Corning or an equivalent for all galling material such as 316 stainless steel.

The bearing retainer is integral with the column. The top flange of the column has a male register and the bottom flange of the column has a female register.

1. Check the head-shaft and line-shaft for straightness.
The average TIR should be less than 0.0005in. (0.013mm) per ft.(0.305m) and not exceed 0.005in.(0.127mm) for every 10 ft. (3m).
2. Apply a thin film of oil to the line-shaft.
3. Install the coupling :
 1. Insert the key into the pump shaft.
 2. Lower the sleeve over the pump shaft, to approximately 1.0in. (25.4 mm) below the top of the shaft.
 3. Lower the lineshaft until it touches the pump shaft.
 4. Insert the split ring into the grooves of the pump shaft and lineshaft.
 5. Raise the sleeve until it covers the split ring.
 6. Insert the key into the lineshaft.
 7. Raise the sleeve to the top of the key.
 8. Secure the sleeve to the split ring with a lock screw and lock wire.



1. Lineshaft
 2. Inter coupling
 3. Key
 4. Key
 5. Split ring
 6. Pump shaft
 7. Lock screw/lock wire
- Figure 3: Key coupling type**

4. Attach the column to the bowl assembly:
 - a) Lower the column over the lineshaft, taking care as the shaft passes through the lineshaft bearing, until the column flange engages the top-bowl flange register.

-
- b) Attach a sling to the eyebolts and to the hoist hook.
 - c) Hoist the column section over the bowl assembly.
 - d) Lower the column over the lineshaft until the column flange engages the discharge-bowl flange register.
 - e) Insert as many capscrews through both flanges as possible and gradually tighten them in diametrically-opposite pairs.
5. Lift the bowl and column assembly high enough to allow for the removal of the I-beam supports.
 6. Install and tighten the remaining capscrews.
 7. Place the bowl and column assembly on the barrel flange:
 - a) Lift the entire assembly by the column pipe eyebolts and remove the supports.
 - b) Slowly lower the bowl and column assembly.
 - c) Place the supports on the barrel flange and continue to lower the assembly until the upper column flange comes to rest on the supports.
 8. If required, install the coupling and lineshaft to the protruding end of the lineshaft.
 9. Assemble the next column section, or top column:
 - a) Make sure that the bottom-column register engages the top-column register.
 - b) Secure the columns with capscrews and hex nuts until all column and lineshaft sections required for the proper pump setting are assembled.
 - c) Tighten the capscrews into the hex nuts gradually and uniformly.

Install the discharge head



CAUTION:

- Do not bump or scrape the shaft protruding above the column. This could result in a bent or damaged shaft.
 - Packed stuffing boxes are not allowed in an ATEX-classified environment.
 - The mechanical seal used in an Ex-classified environment must be properly certified. Prior to startup, make sure that all areas that could leak pumped fluid to the work environment are closed.
-

NOTICE:

Make sure that the eyebolts or slings are rated to handle more than the pump weight.

Mechanical seals are shipped separately. If the seal housing is assembled to the discharge head, remove the seal before you begin this procedure.

1. If the stuffing box is assembled to the head, remove it and all attached piping.
 2. Remove the coupling guard:
 - a) Attach shackles to the discharge head lifting lugs, or thread two eyebolts in the head driver support mounting holes diametrically opposite each other.
 - b) Hoist the discharge head over the protruding headshaft.
 3. Orient the discharge head in the required position:
 - a) Lower the head while you center the vertical hole with the headshaft that protrudes above the column.
Stop when the discharge head engages the column.
 - b) Install the capscrews and secure the discharge head to the column.
 - c) Tighten the capscrews gradually in diametrically-opposite pairs.
 4. Lift the pump assembly high enough to allow for the removal of the supports.
-

-
5. Install and tighten the remaining capscrews until all capscrews are uniformly tight.
 6. Hoist the bowl, column, and head assembly and remove the supports.
 7. Lower the bowl, column, and head assembly until the discharge-head mounting flange engages the barrel flange.
 8. Secure the discharge head to the barrel flange.

Stuffing box installation

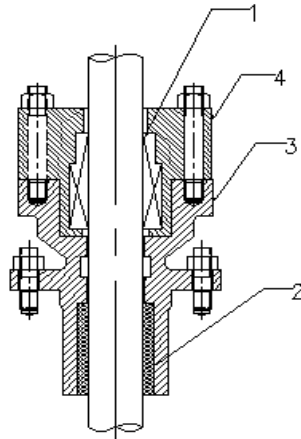


CAUTION:

- Make sure the split gland fits squarely in the stuffing box. A split gland that is not properly seated can cause uneven compression of the packing and damage to the shaft or sleeve.
 - Packed stuffing boxes are not allowed in an ATEX-classified environment.
-

Stuffing box types

- Solid type



1. Mechanical seal
2. Bearing
3. Stuffing box
4. Seal gland

Figure 4 : Solid type stuffing box

Install the solid type stuffing boxes

A stuffing box is the exception that it has a shaft sleeve with an O-ring.

1. Lubricate the O-ring and the shaft threads.
2. Slip the sleeve onto the shaft and carefully rotate it counterclockwise while you gently push down until the O-ring is clear of the shaft threads.
3. Locate the sleeve on the shaft and secure it with setscrews.
4. Position the gasket on the discharge head.
5. Slide the stuffing box down over the shaft and into position on the gasket.
6. Secure the stuffing box with capscrews.
7. If the packing washer is provided, insert it into the stuffing box.
The packing washer is not required on shaft sizes 2.19in. (55.63 mm) and larger.
8. Grease the packing rings for easier installation.

-
9. Install the packing rings:
 - a) Twist each of the five packing rings sideways in order to easily get them around the shaft. You can set the sixth ring aside until the packing is adjusted for leakage after the first startup.
 - b) Start the first ring into the stuffing box.
 - c) Use your fingers to position the entire ring in the stuffing box.
 - d) Tap each ring down using a split wooden bushing and push the packing ring down firmly until it seals on the shaft and bore of the stuffing box.
 - e) Stagger the ring joints 90° apart.
You can use the split gland as a tamper for the top ring.
 10. Install the split gland and thread the nuts on the split gland studs.
 11. Hand-tighten the nuts.
 12. If an optional bypass line is furnished, attach it to the tube fitting in the stuffing box. Final adjustment of the stuffing box must be made at pump start up. This final adjustment applies to all stuffing box styles. A properly packed stuffing box needs to be loose enough to allow you to manually turn the shaft.

Mechanical seal options



CAUTION:

The mechanical seal piping must always stay connected. Failure to do so will result in excess heat generation and seal failure.

Pumps are shipped without mechanical seals installed. If they are not, then refer to the mechanical seal manufacturer's installation instructions.

These are the mechanical seal options for this pump:

- Cartridge mechanical seal
 - Conventional inside component mechanical seal
 - High-pressure seal
 - Dual mechanical seal
-

Install the mechanical seal



CAUTION:

Sparingly lubricate the shaft and sleeve ID with the lubricant included with the mechanical seal or recommended by the mechanical seal manufacturer. You can use these lubricants for water service when no lubricant is supplied or recommended by the mechanical seal manufacturer:

- Light oil (SAE #10 or 20)
- Dow Corning #4 grease
- Silicone lubricant
- Wax or clay
- Soapy water

Oil-based lubricants will damage EPR / EPDM elastomer O-rings. Silicone lube and soapy water are safe for EPR / EPDM elastomer O-rings.

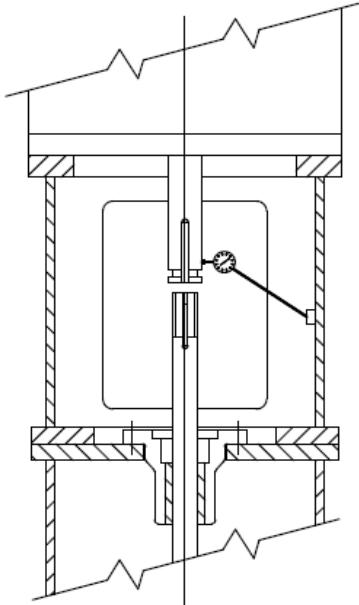
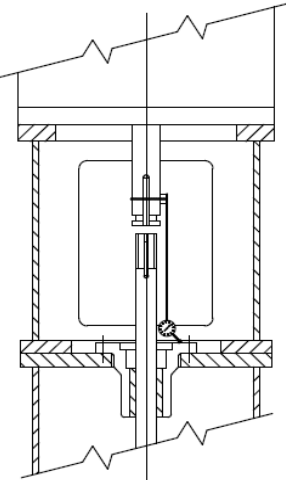
NOTICE:

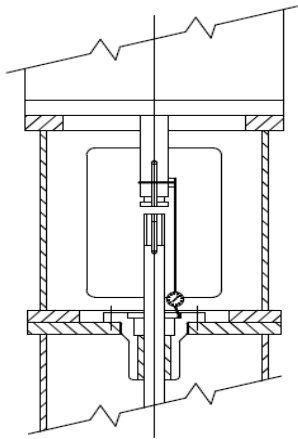
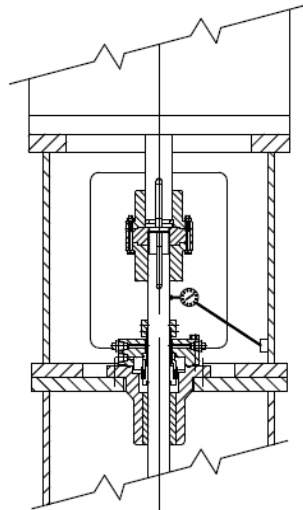
- Do not bump carbon inserts against the shaft as they can chip, crack, or break.
-

-
- Do not overtighten the capscrews on the gland. This can distort the seal seat and cause seal failure.
 - Do not remove the seal spacer or eccentric washer, adjust the seal, or tighten the setscrews until after you adjust the impellers.
 - Reset the seal after you adjust the impeller.
-

1. Install the O-ring or gasket between the seal housing and seal:
 - a) Install the seal over the shaft and ease it into position against the face of the seal box.
 - b) Take care when you pass the sleeve and O-ring over the keyways or threads in order to avoid damage to the O-ring.
2. Position the seal gland on the discharge-head seal housing and secure it with capscrews.
3. Tighten the capscrews gradually and uniformly in a criss-cross pattern, taking two or three passes.
4. Install all seal piping as required.
5. Before you make the final connections of the sealing-liquid pressurizing lines, make sure the seal housing and all sealing-liquid lines are flushed free of dirt, scale, and other particles.
6. Install the driver and coupling.
7. Take these flatness and concentricity measurements:

Runout of driver shaft	Procedure
Concentricity of driver shaft	<ol style="list-style-type: none"> 1. Install the dial indicator as shown, with the base attached to the motor support. 2. Rotate the driver shaft by hand while you read the dial. Make sure that the runout does not exceed NEMA standards, 0.002in. (0.05mm) maximum TIR. 3. If the indicator reads higher than 0.002in.(0.05mm) TIR, loosen the four driver hold-down bolts and relocate the driver on the motor base register. 4. Obtain the desired position. 5. Tighten the hold-down bolts and repeat the indicator reading.

	
Runout of driver shaft	Procedure
Flatness of the seal housing	<p>For this measurement, remove the mechanical seal if the dial indicator stylus cannot rotate 360° on the top surface of the seal gland.</p> <ol style="list-style-type: none"> 1. Remove the lower coupling components and attach the base of the dial indicator to the driver shaft. 2. Place the stylus at the top surface of the seal gland, or at the top surface of the seal housing. 3. Slowly rotate the driver shaft 360°. 4. Check that the face of the seal housing is square with the shaft to within 0.002in.(0.05 mm) TIR. 
Concentricity of the seal housing	<p>This measurement requires that you remove the mechanical seal.</p> <ol style="list-style-type: none"> 1. Install the dial indicator as shown. 2. Rotate the driver shaft by hand and run the indicator in the inside-machined surface of the seal housing in order to determine the concentricity.

	<p>3. If the indicator reads higher than 0.004in.(0.10mm) TIR, loosen the four driver hold-down bolts and relocate the driver on the motor base register.</p> <p>4. Obtain the desired position.</p> <p>5. Tighten the hold-down bolts and repeat the indicator reading.</p> 
Runout of driver shaft	Procedure
Concentricity of the head shaft	<p>1. Reinstall the mechanical seal if it was removed for the flatness or concentricity measurement.</p> <p>2. Install the coupling assembly and adjust the impeller.</p> <p>3. Attach the base of the dial indicator on the discharge head or driver support.</p> <p>4. Place the stylus on the shaft between the top of the seal and the bottom of the pump coupling.</p> <p>5. Slowly rotate the driver shaft 360°.</p> <p>6. Check that the shaft run out is within 0.004in.(0.10mm) TIR, or as required by specification.</p> <p>7. Drill and dowel the pin in three places in order to secure the driver to the motor base after you obtain the required run outs.</p> 

-
8. Position and install the drive collar of the seal by tightening the setscrews using the instructions from the mechanical seal manufacturer.
 9. Save the seal spacer or eccentric washer.
You can use these in order to hold the correct seal spacing in the event that you have to remove the seal. You must loosen the seal setscrews in order to re-adjust the impellers.
 10. Seals that use half-dog-point setscrews might require that the shaft be spot faced or drilled in order to provide a secure placement:
 - a) Cover the seal and seal housing.
 - b) Remove the setscrews one at a time from the collar and spot face or drill the shaft and then tighten the setscrews into position.
 - c) Remove any metal chips in order to avoid damage to the seal.

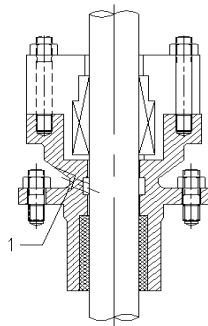
Assemble a single inside-mounted mechanical seal

Single inside-mounted mechanical seals have these characteristics:

- They are cartridge seals.
- They have glands and sleeves.
- They are assembled as a unit by the seal manufacturer.

Follow the special instructions from the seal manufacturer in the event that non-cartridge seals are installed.

If the seal is...	Then...
An O-ring type	Assemble the complete unit over the shaft. Use care when you pass the sleeve and O-ring over the keyways or threads to avoid damaging the O-ring.
A Teflon wedgering type	<ol style="list-style-type: none"> 1. Remove the sleeve collar and Teflon wedge ring. 2. Assemble them separately after the sleeve is in position. 3. Tighten the collar on the threads to seal the Teflon wedge around the shaft.



1. Bypass to suction (If suction pressure is high)

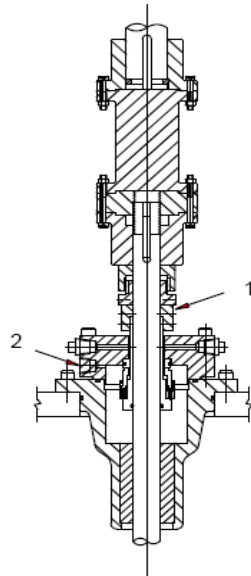
Install the high-pressure seal

High-pressure seals have these characteristics:

- Usually cartridge seals
- Shipped assembled and ready for installation
- Are either single or dual seals

Mechanical seals on pumps with over 1200 psi (85 kg/cm²) gauge discharge pressure, or a pressure level specified by the seal manufacturer, are normally fitted with backup rings. These rings are installed after the seal installation, between the drive collar of the seal and the bottom of the flanged-pump coupling.

1. Install the backup ring:
 - a) Thread the bottom backup ring into the top backup ring until it bottoms out.
 - b) Slide the backup ring assembly over the shaft and position it on the seal.
2. Install the spacer coupling and the driver.
3. Set the seal into position.
4. Check the TIR on the headshaft above the mechanical seal.
5. Adjust the backup ring assembly.



1. Back-up rings
2. Bypass to suction

Figure 5 : Mechanical seal

Install the dual mechanical seals

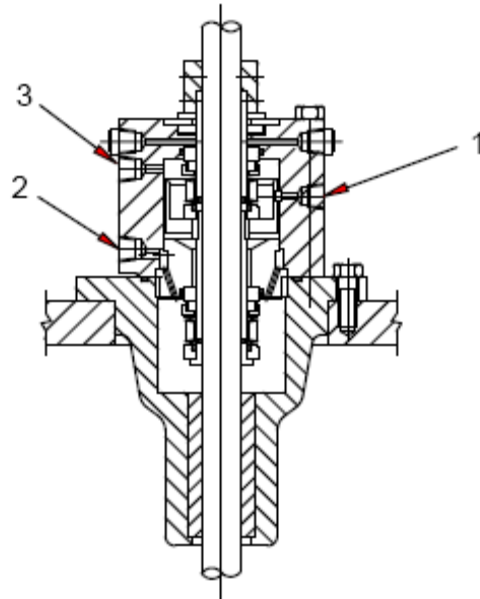
Dual seals are cartridge seals that are shipped assembled. This procedure only applies if a non-cartridge type seal is furnished, and there are no instructions provided by the seal manufacturer.

1. Scribe a mark on the shaft or sleeve that is flush with the face of the seal housing.

Use this reference mark to set the seal to the seal assembly.

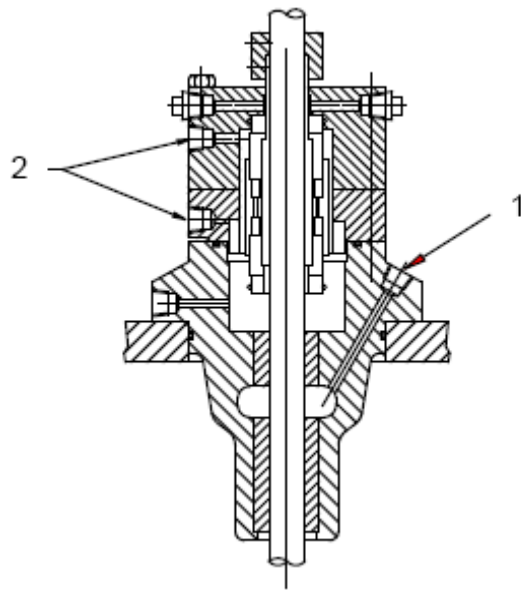
2. Install the inner insert face:

-
- a) Lubricate the stuffing-box bore and OD of the inner (or lower) stationary insert.
 - b) Protect the inner insert face with a soft and clean material, such as gasketing or sheet rubber.
 - c) Install the inner insert face into the bottom of the seal housing with hand pressure only.
 - d) If the insert includes a holding pin, make sure that the pin is aligned with the slot or hole in the bottom of the seal housing.
3. Carefully place the gland ring and outer stationary insert over the shaft.
 4. Lubricate the shaft or sleeve before you install any of the rotary unit parts.
 5. Install the seal collar, or collars, on the shaft or sleeve:
 - a) Locate the collar so that it aligns with the reference mark you created in step 1 and to the setting dimension given on the seal assembly drawing.
 - b) Tighten the setscrews to lock the collar to the shaft or sleeve.
 6. Install the remaining rotary unit parts on the shaft or sleeve in the proper sequence and complete the assembly of equipment.
 7. If it is provided, install the shaft packing on the shaft or sleeve individually.
Use care to avoid nicks or damage that can cause the seal to leak.
 8. Seat the gland ring and gland gasket against the face of the seal housing:
 - a) Tighten the nuts or bolts evenly and firmly.
 - b) Make sure that the gland ring is not cocked.
 - c) Tighten the nuts or bolts just enough to seal at the gland ring gasket.



1. Connection to external seal lubrication
2. Bypass to suction
3. Connection to external seal lubrication

Figure 7: Tandem-mounted seal (dual unpressurized)



1. Bypass to suction
2. Connection to external seal lubrication

Figure 8: Double-mounted seal (dual pressurized)

Install a solid-shaft driver



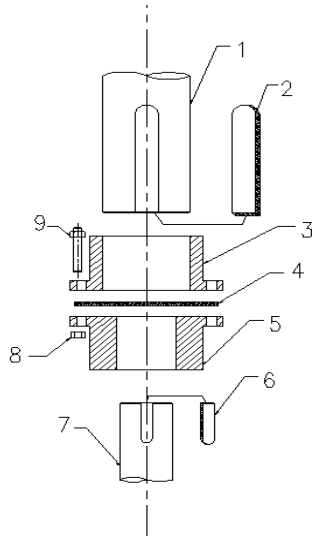
WARNING:

- When installing in a potentially explosive environment, make sure that the motor is properly certified.
- Do not test the motor for direction of rotation when it is coupled to the pump. If the pump rotates in the wrong direction, serious damage to the pump, motor, and personnel will result.
- Do not work under a heavy and suspended object unless there is a positive support and safeguards that will protect you if a hoist or sling fails.

NOTICE:

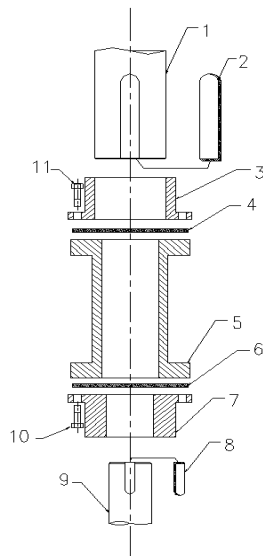
- When the pump is supplied with a thrust pot, do not secure the driver to the discharge head until after the thrust pot and flexible coupling are installed. A separate supplement for thrust pots will be furnished as required.
 - Read and follow the motor manufacturer's instructions before lubricating the motor bearings. Excessive lubrication can cause the bearings to overheat and fail prematurely.
-

The coupling between the driveshaft and the discharge-head shaft can either be a non-spacer type or a spacer type. The spacer type is used on pumps furnished with a mechanical seal to permit servicing of the seal without the removal of the driver.



- 1. Driveshaft
- 2. Driver key, supplied by motor vendor
- 3. Driver hub
- 4. Disk
- 5. Pump hub
- 6. Pump key
- 7. Headshaft
- 8. Capscrew
- 9. Hex nut

Figure 9: Non-spacer type coupling



- 1. Driveshaft
- 2. Driver key, supplied by motor vendor
- 3. Driver hub

-
- 4. Driver disk
 - 5. Spacer
 - 6. Pump disk
 - 7. Pump hub
 - 8. Pump key
 - 9. Headshaft
 - 10. Capscrew
 - 11. Capscrew

Figure 10: Spacer-type coupling

1. If a driver support is furnished and not installed, perform these steps:
 - a) Hoist the driver support and inspect the mounting surfaces and register.
 - b) Clean these surfaces thoroughly.
 - c) Install the driver support on the discharge head and secure it with cap-screws.
2. Attach a sling to the lifting lugs of the driver and hoist the motor.
3. Inspect the mounting surface, register, and shaft extension, and then clean these surfaces thoroughly.

If any burrs are found, remove them with a smooth mill file.
4. Orient the motor-conduit box in the required position:
 - a) Align the motor-mounting holes with the mating-tapped holes on the discharge head.
 - b) Lower the motor until the registers engage and the motor rests on the discharge head.
 - c) Secure the motor with cap-screws.
5. On drivers with a non-reverse ratchet or pins, manually turn the driver shaft clockwise when viewed from the top, until the non-reverse ratchet or pins fully engage.
6. Lubricate the motor bearings according to the instructions on the lubrication plate attached to the motor frame.
7. Make temporary electrical connections according to the tagged leads or the diagram attached to the motor.

The motor must rotate counterclockwise when viewed from the top. See the arrow on the pump nameplate. If the motor does not rotate counterclockwise, change the rotation by interchanging any two leads (for three phase only). For single-phase motors, see the instructions from the motor manufacturer.

If motor shaft-end-play adjustment is required, check it using a dial indicator before you connect the pump coupling to the solid-shaft motor. Consult the applicable motor manufacturer instruction manual for detailed information on motor shaft end play.

Install the coupling hub

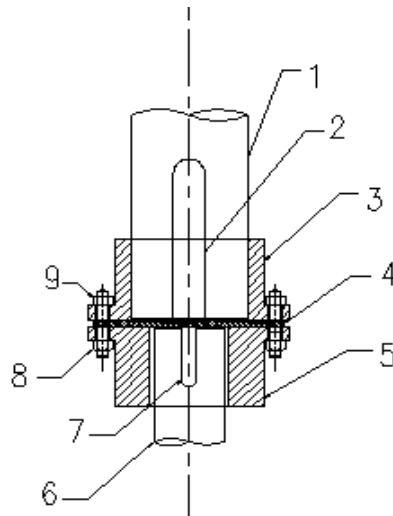
1. Apply a thin film of oil on the pump key and insert the key into the headshaft keyway seat.
2. Gently lower the pump half of the coupling hub onto the headshaft.
3. Thread the adjusting plate onto the headshaft until it is flush with the top of the headshaft.
4. Apply a thin film of oil to the driver key and insert the key into the drive-shaft keyway seat.
5. Place the driver half of the coupling hub onto the drive shaft with the key and slide it up the drive shaft until the annular groove is exposed.
6. Install the split ring in the groove and slide the driver half of the coupling hub

-
- down over the split ring to capture it.
7. If the pump is supplied with an adjustable spacer coupling, install the spacer between the headshaft and the drive shaft hubs.
 8. Secure with capscrews and hex nuts.

Impeller adjustment

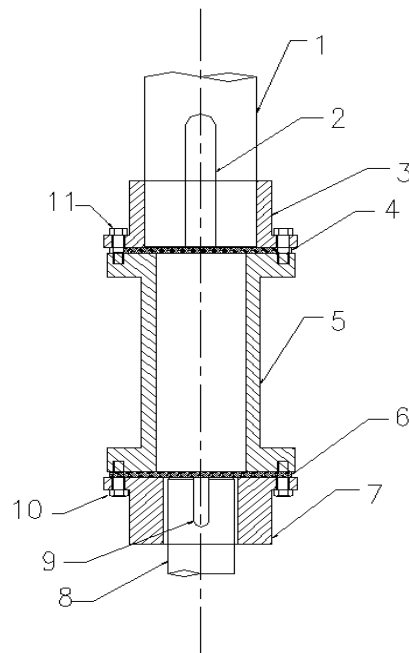
NOTICE:

- When a mechanical seal is provided, make sure it is not secured to the shaft during impeller adjustment. The shaft must move up or down within the seal assembly.
 - For pumps that handle liquids between -50°F to 200°F (-45°C to 93°C), you can make impeller adjustments under ambient conditions. For liquids in excess of this range, make any impeller adjustments after the pump reaches the temperature of the liquid. In situations where this is not feasible due to safety considerations, or impossible due to external ice buildup in cryogenic applications, refer to the factory for specific instructions.
 - Improper impeller adjustment can cause contact between the rotating and stationary parts. This results in sparks and heat generation.
-



1. Driveshaft
2. Driver key, supplied by the motor vendor
3. Driver hub
4. Disk
5. Pump hub
6. Headshaft
7. Pump key
7. Capscrew
9. Hex nut

Figure 11: Adjustable coupling (Non spacer type)



- 1. Driveshaft
- 2. Driver key, supplied by motor vendor
- 3. Drive hub
- 4. Drive disk
- 5. Spacer
- 6. Pump disk
- 7. Pump hub
- 8. Headshaft
- 9. Pump key
- 10. Hex nut
- 11. Hex nut

Figure 12: Spacer coupling (Spacer type)

Adjust the impeller for a solid-shaft driver

IMPORTANT : The determination of the driver-shaft end-play can be critical and should be added to the impeller setting noted in this topic. For larger pumps over 8.00in. (20.32 cm), this amount might not be sufficient. Refer to the pump outline drawing for details.

When impellers are reset, you must also reset the seal.

Complete these steps based on your impeller type:

If your impeller is an...	Then...
Open impeller	<ol style="list-style-type: none"> 1. With the impellers touching the bottom of the bowls, turn the adjusting plate towards the driver hub or spacer to obtain a 0.015in. (0.381 mm) clearance between the adjusting plate and driver hub or spacer for the first 10 ft. (3 m) of column. 2. Add 0.010in. (0.254 mm) for each additional 10

	ft. (3 m) of column. For example, if the total pump length is 50 ft. (15 m), set the open impellers at 0.055in. (1.397 mm). 3. Align the adjusting plate with the pump hub, and tightly draw the coupling flanges together with capscrews and nuts. 4. Set the seal: a. Securely tighten all setscrews in the collar. b. Remove the spacer between the gland plate and the collar. c. Retain the spacer for future resetting of the seal.
Enclosed impeller	1. Obtain the impeller setting from the Certified Pump Outline Drawing. 2. Align the adjusting plate with the pump hub, and tightly draw the coupling flanges together with capscrews and nuts. 3. Set the seal: a. Securely tighten all setscrews in the collar. b. Remove the spacer between the gland plate and the collar. c. Retain the spacer for future resetting of the seal.

Installation and startup checklist

Use this checklist in conjunction with the standard instruction manual furnished with the equipment. Initial each completed item or write N/A if the item is not applicable. After you complete this checklist, forward a copy to the VPD field service for entry into the quality assurance records. Use a separate checklist for each individual pump.

Part 1: System and installation inspections

Check	Checked
Check that the pump foundation is level to within 0.005in. per ft. (0.0123 cm per m) of diameter. For API units, the level requirement is 0.001in. per ft. (0.003 cm per m) of diameter.	
Check that the foundation can handle the weight and loading of the pump.	
Check that the foundation is properly grouted using a high quality non-shrink grout.	
Check that all the anchor bolts are tight.	
Check that the suction and discharge piping is properly supported and that there is no excess nozzle loading on the discharge flange.	
On units with flexible or expansion joints attached to the pump suction or discharge, check that tie rods are in place and properly installed.	
Check that the suction valve is fully open.	
Check these items for all valves: <ul style="list-style-type: none"> • Operate freely • Properly installed for the direction of flow • Have the proper pressure 	
Check where the pumped fluid is going and that the system is properly lined up for the test.	

Check that the pumped fluid supply will be continuously available for the duration of the test. It is very important that the initial run is at least ten minutes in duration in order to completely flush the pump.	
If possible, check the cleanliness of the pumped fluid and piping. If you are present during the installation, check that the sump, barrel, and piping are clean.	

Part 2: Pump assembly pre-start inspections

Check	Checked
Verify that the drivers are properly lubricated before start-up. On drives with grease-lubricated motor bearings, insist that the motor vendor grease them on-site. Lubrication information is located on special motor tags or in the motor manuals.	
Before you couple the driver to the pump, verify the proper rotation of the driver by bumping it. The proper rotation for vertical pumps is counterclockwise when viewed from above. Run the pump uncoupled in order to check that the driver runs smooth and sounds normal. <ul style="list-style-type: none"> For VHS motors, remove the driveshaft if a coupling is provided. If a coupling is not provided, then remove the steady bushing and driver coupling. On drivers with NRRs, remove the ratchet pins, if possible. Otherwise, rotate the drive coupling clockwise until the pin stops tight against the ratchet plate. If a customer refuses to allow you to check the rotation, have the customer sign and date this checklist before you proceed. 	
Check	Checked
After you verify the proper rotation of the driver, you can couple the pump to the driver. <ul style="list-style-type: none"> On VSS units with a flanged coupling except for the AR type, set the impeller lift. On VHS units, set the impeller lift using the adjusting nut on top of the motor after you make up the threaded or AR coupling. See either the pump nameplate or the outline drawing for the specific impeller lift required for an individual pump.	
Check the alignment on pumps that are equipped with jacking bolts since they require that the motor be physically aligned to the pump. Special alignment of the pump to the motor is not usually required since all components are equipped with register fits.	
Use a dial indicator in order to check that the shaft runout above the sealing element is not excessive: <ul style="list-style-type: none"> Packing limit is a maximum of 0.008in. (0.020 cm) Mechanical seal limit is a maximum of 0.005in. (0.0123 cm) For API, the maximum is 0.002in. (0.005 cm) 	
On units with seals, check these items: <ul style="list-style-type: none"> Check that the seal rotates freely. Check that the seal spacers are removed. Check that the seal piping is properly installed. 	

Part 3: Unit startup

Check	Complete
After you complete all of the checks in Parts 1 and 2, conduct a start-up	

meeting with customer in order to discuss the actual procedures they might require during start-up and commissioning. Also, verify with the customer that their system is ready for pumped fluid.	
When the system is ready, push the start button and adjust the discharge valve in order to meet the design point, if required.	
Watch for signs of trouble. The unit must run at least ten minutes in order to flush out the pump and system.	
Verify that the unit runs smoothly with no unusual noise, vibration, or over heating.	
Run the unit for one hour in order to test the system.	

Measurements

Reading	Value
Impeller lift	
Shaft runout	
Megger	
Vibration	

Commissioning, Startup, Operation, and Shutdown

Preparation for startup



WARNING:

- Failure to follow these precautions before you start the pump will lead to serious personal injury and equipment failure.
- Do NOT operate the pump below the minimum rated flows or with the suction or discharge valves closed. These conditions can create an explosive hazard due to vaporization of pumped fluid and can quickly lead to pump failure and physical injury.
- Always disconnect and lock out power to the driver before you perform any installation or maintenance tasks. Failure to disconnect and lock out driver power will result in serious physical injury.
- Operating the pump in reverse rotation can result in the contact of metal parts, heat generation, and breach of containment.

Precautions

NOTICE:

- Verify the driver settings before you start the pump.
- Make sure that the warm-up rate does not exceed 2.5°F (1.4°C) per minute.

You must follow these precautions before you start the pump:

-
- Flush and clean the system thoroughly to remove dirt or debris in the pipe system in order to prevent premature failure at initial startup.
 - Bring variable-speed drivers to the rated speed as quickly as possible.
 - Run a new or rebuilt pump at a speed that provides enough flow to flush and cool the close-running surfaces of the stuffing-box or seal-housing bearing.
 - If temperatures of the pumped fluid will exceed 200°F (93°C), then warm up the pump prior to operation. Circulate a small amount of fluid through the pump until the casing temperature is within 100°F (38°C) of the fluid temperature.
 - Rubber bearings must be wet prior to startup if the non-submerged (dry column) length is greater than 50 ft (15 m). You can only use clean water or clean sea water

At initial startup, do not adjust the variable-speed drivers or check for speed governor or over-speed trip settings while the variable-speed driver is coupled to the pump. If the settings have not been verified, then uncouple the unit and refer to instructions supplied by the driver manufacturer.

Prepare for startup



WARNING:

- For the VSS motor, do not check the motor rotation unless the motor is bolted to the pump and the driver hub is disconnected from the pump hub.
- For a VHS motor, do not check the motor rotation unless the motor is bolted to the pump and the drive coupling is removed.
- Do not test the motor for direction of rotation when it is coupled to the pump. If the pump rotates in the wrong direction, serious damage to the pump, motor, and personnel will result.

Consult the applicable manufacturer instructions for detailed information for the prime mover (electric motor, engine, or steam turbine), coupling, drive shaft, gear-head, or mechanical seal.

1. Confirm that you have completed these procedures:
 - a) Connected the driver to a power supply.
 - b) Verified that the driver rotates counterclockwise when viewed from above.
 - c) Checked the alignment between the pump and driver.
 - d) Adjusted the impeller.
 - e) Attached the mechanical-seal lock collar to the shaft.
2. Verify that the mechanical seal is properly lubricated and that all piping to the seal is connected.
3. Verify that all cooling, heating, and flushing lines are operating and regulated.
4. Verify that all connections to the driver and starting device match the

wiring diagram.

5. Verify that the voltage, phase, and frequency on the motor nameplate agree with the line current.
6. Rotate the shaft manually to make sure that the impellers are not binding.
7. Verify that the driver bearings are properly lubricated and check the oil level in the housing.
8. Verify that the auxiliary seal components are properly vented.
9. Inspect the suction and discharge-piping connection and pressure gauges for proper operation.

Pump priming



CAUTION:

- The pump must be properly vented through the discharge head connections. This is important for liquids with suction pressures close to their vapor pressures. Vent piping must continuously rise back to the source so that liquid cannot collect in the vent line.
- Vary the capacity with the regulating valve in the discharge line. Never throttle the flow from the suction side. This action can result in decreased performance, unexpected heat generation, and equipment damage.

NOTICE:

Net positive suction head available (NPSHA) must always exceed NPSH required (NPSHR) as shown on the published performance curve of the pump.

Requirements

- The pump must always be flooded with the suction valve fully open.
- Never run the pump dry as this can cause the rotating parts within the pump to gall and seize to the stationary parts.
- The parts are lubricated by the liquid being pumped unless the enclosed lineshaft option is purchased to lubricate the lineshaft bearings with a clean fluid.

Start the pump



CAUTION:

- Observe the pump for vibration levels, bearing temperature, and excessive noise. If normal levels are exceeded, shut down the pump and resolve the issue.

Before you start the pump, you must perform these tasks:

- Open the suction valve.
 - Open any recirculation or cooling lines.
1. Fully close or partially open the discharge valve, depending on system conditions.
 2. Start the driver.

-
3. Slowly open the discharge valve until the pump reaches the desired flow.
 4. Immediately check the pressure gauge to ensure that the pump quickly reaches the correct discharge pressure.
 5. If the pump fails to reach the correct pressure, perform these steps:
 - a) Stop the driver.
 - b) Confirm the minimum submergence.
 - c) Restart the driver.
 6. Monitor the pump while it is operating:
 - a) Check the pump for bearing temperature, excessive vibration, and noise.
 - b) If the pump exceeds normal levels, then shut down the pump immediately and correct the problem.
- A pump can exceed normal levels for several reasons. See Troubleshooting for information about possible solutions to this problem.
7. Repeat steps 5 and 6 until the pump runs properly.

Pump operation precautions

General considerations



CAUTION:

- Vary the capacity with the regulating valve in the discharge line. Never throttle the flow from the suction side since this can result in decreased performance, unexpected heat generation, and equipment damage.
- Do not overload the driver. Driver overload can result in unexpected heat generation and equipment damage. The driver can overload in these circumstances:
 - The specific gravity of the pumped fluid is greater than expected.
 - The pumped fluid exceeds the rated flow rate.
- Make sure to operate the pump at or near the rated conditions. Failure to do so can result in pump damage from cavitation or recirculation.

Operation at reduced capacity



WARNING:

Never operate any pumping system with a blocked suction and discharge. Operation, even for a brief period under these conditions, can cause confined pumped fluid to overheat, which results in a violent explosion. You must take all necessary measures to avoid this condition.

CAUTION:

- Avoid excessive vibration levels. Excessive vibration levels can damage the bearings, stuffing box or seal chamber, and the mechanical

seal, which can result in decreased performance.

- Avoid increased radial load. Failure to do so can cause stress on the shaft and bearings.
 - Avoid heat build-up. Failure to do so can cause rotating parts to score or seize.
 - Avoid cavitation. Failure to do so can cause damage to the internal surfaces of the pump.
-

Operation under freezing conditions

NOTICE:

Do not expose an idle pump to freezing conditions. Drain all liquid that is inside the pump and the cooling coils. Failure to do so can cause liquid to freeze and damage the pump.

Mechanical seal leaks

NOTICE:

The mechanical seal used in an Ex-classified environment must be properly certified. Prior to startup, make sure that all areas that could leak pumped fluid to the work environment are closed.

Occasional leaks

If the seal leaks slightly at start-up, allow a reasonable amount of time for the seal to adjust itself. Fluids with good lubricating qualities normally take longer to adjust than fluids with lesser lubricating qualities. When a seal starts out with a slight leak and the leak decreases while running, it indicates leaks across the seal faces. Run the pump continuously in order to eliminate this issue.

Continuous leaks

When immediate leaks occur and remain constant, even during operation, it usually indicates either secondary seal (shaft packing) damage, or seal faces that are warped or cracked. See Troubleshooting for probable causes.

Stuffing box leaks



CAUTION:

Packed stuffing boxes are not allowed in an ATEX-classified environment.

Normal leaks

With the pump in operation, there should be some leaking at the stuffing

box packing. The correct leak rate is a rate which keeps the shaft and stuffing box cool. This rate is approximately one drop per second. Check the temperature of the leaked fluid as well as the discharge head.

Decreased leaks

If the pump runs hot and the leaks begin to decrease, stop the pump and allow it to cool down. Loosen the packing gland in order to allow the packing to resume leaking. After the pump has cooled, restart the pump and run it for 15 minutes. Then check the leaks. If the leaks exceed two drops per second, adjust the packing.

Shut down the pump



WARNING:

The pump can handle hazardous and toxic fluids. Identify the contents of the pump and observe proper decontamination procedures in order to eliminate the possible exposure to any hazardous or toxic fluids.

Wear the proper personal protective equipment. Potential hazards include, but are not limited to, high temperature, flammable, acidic, caustic, explosive, and other risks. You must handle and dispose of pumped fluid in compliance with the applicable environmental regulations.

-
1. Slowly close the discharge valve.
 2. Shut down and lock the driver to prevent accidental rotation.
 3. If the driver is not equipped with a non-reverse ratchet (NRR), be certain that the unit is completely stopped before you restart the pump.

Lubricate the thrust pot during a shutdown period

1. Completely immerse the bearings in oil.
This helps to avoid oxidation of the anti-friction bearings during shutdown periods lasting longer than one week.
2. Fill the oil reservoir until the oil runs over the oil retainer tube and down the shaft.
Before startup, drain the oil to its required level.

Maintenance

Maintenance schedule

Maintenance inspections

A maintenance schedule includes these types of inspections:

- Routine maintenance
- Routine inspections
- Three-month inspections
- Annual inspections

Shorten the inspection intervals appropriately if the pumped fluid is abrasive or corrosive or if the environment is classified as potentially explosive.

Routine maintenance

Perform these tasks whenever you perform routine maintenance:

Routine inspections

Perform these tasks whenever you check the pump during routine inspections :

- Check for unusual noise, vibration, and bearing temperatures.
- Check the pump and piping for leaks.
- Analyze the vibration.

Three-month inspections

Perform these tasks every three months:

- Check that the foundation and the hold-down bolts are tight.

Annual inspections

Perform these inspections one time each year:

- Check the pump capacity.
- Check the pump pressure.
- Check the pump power.

If the pump performance does not satisfy your process requirements, and the process requirements have not changed, then perform these steps:

1. Disassemble the pump.
2. Inspect it.
3. Replace worn parts.

Packing adjustment and replacement

Precautions



CAUTION:

Do not over-tighten the stuffing box. Excessive pressure can wear out packing prematurely and seriously damage the shaft.

NOTICE:

Packed stuffing boxes are not allowed in an ATEX-classified environment.

When to replace

Adjust the packing when these conditions occur:

- The leak rate exceeds two drops per second.
- There is overheating or there are no leaks.

Adjust the packing when leaking is excessive

Perform this procedure if leaks exceed two drops per second.

1. With the pump in operation, tighten the gland nuts one-quarter turn.
2. Before you make any more adjustments, check to see if the packing has equalized against the increased pressure by making sure the leaks have decreased to a steady state.
If the leaks decrease to two drops per second, then you are finished.
If the leaks continue to exceed two drops per second, continue to the next step.
3. Shut down the pump.
4. Allow the packing to compress enough so that the gland is about to contact the upper face of the stuffing box.
5. Remove the split gland, add one extra packing ring, and readjust.
6. If this fails to reduce the leak to two drops per second, then remove all packing rings and replace them with new rings:
 - a) Remove the packing with the aid of a packing hook.
 - b) If a lantern ring is provided, remove it by inserting a wire hook in the slots of the ring and pull it from the stuffing box.
 - c) Thoroughly clean the stuffing box of all foreign matter.
7. If the replacement packing is in the form of a continuous coil or rope, cut it into rings before installing:
 - a) Tightly wrap one end of the packing material around the top shaft like one coil spring.
 - b) Cut through the coil with a sharp knife.

See Installation for details about how to properly reinstall the stuffing box.

Adjust the packing when there is overheating or no leaks



CAUTION:

If there are no leaks or the stuffing box overheats, do not back off the gland nuts while the pump is running.

This causes the entire set of packing rings to move away from the bottom of the box without relieving pressure of the packing on the shaft.

A small amount of leaking is required in order to prevent overheating.

1. Stop the pump and allow the packing to cool.
2. Restart the pump.
3. Repeat these steps until two drops of liquid per second comes through.
4. If this fails to fix the problem, then you must replace the packing.

Thrust pot lubrication guidelines

Flushing the oil reservoir

Flush the oil reservoir in order to remove all grit particles in the oil reservoir sump. Use the same type of oil to flush the reservoir as specified for lubrication. Always keep a supply of turbine oil on-hand.

NOTICE:

Pumps are shipped without oil. Oil-lubricated anti-friction bearings must be lubricated at the job site.

Oil levels

Pump status	Oil level
Not operating	At or lower than 1/8in. to 1/4in. (0.635 to 0.3175 mm) from the top of the oil sight gauge. Never operate the pump when the oil in the sight gauge is not at the required level.
Operating	Lower than the required level as indicated on the oil sight gauge.

Changing the oil

The frequency with which you change the oil depends on the severity of the environment. When the oil in the sight gauge is a dark brown color, it is time for an oil change. However, for a longer bearing life, it is recommended that you change the oil every six months. Be sure to flush the oil reservoir with each oil change.

Disassembly

Disassembly precautions



WARNING:

- Make sure that the pump is isolated from the system and that pressure is relieved before you disassemble the pump, remove plugs, open vent or drain valves, or disconnect the piping.
- Always disconnect and lock out power to the driver before you perform any installation or maintenance tasks.
Failure to disconnect and lock out driver power will result in serious physical injury.
- Crush hazard. The unit and the components can be heavy. Use proper lifting methods and wear steeltoed shoes at all times.

-
- The pump can handle hazardous and toxic fluids. Identify the contents of the pump and observe proper decontamination procedures in order to eliminate the possible exposure to any hazardous or toxic fluids. Wear the proper personal protective equipment. Potential hazards include, but are not limited to, high temperature, flammable, acidic, caustic, explosive, and other risks. You must handle and dispose of pumped fluid in compliance with the applicable environmental regulations.
-

NOTICE:

Make sure that all replacement parts are available before you disassemble the pump for overhaul.

Disassemble the head and column



WARNING:

Never try to lift the entire pump assembly by the lifting lugs or eyebolts furnished for the driver only. Always lift the pump with shackles through the lifting lugs or with eyebolts inserted through the flanges.

1. If equipped with mechanical seals, loosen the setscrews that fasten the seal to the pump shaft so that the pump shaft can slide up or down within the seal.

2. Remove the necessary components:

If the pump is...	Then remove...
Gear-driven	The driveshaft between the gear and the prime mover.
Electric-motor driven	The electrical connections at the conduit box and label the electrical leads so they can be reassembled correctly

3. Uncouple the driver, or gear box, from the pump shaft and mounting flanges, and then lift off by the lifting lugs or eyebolts as furnished.
4. Disconnect the head from the suction and discharge piping.
5. Remove all hold-down bolts and integral piping.
6. Remove the coupling, packing box, or mechanical seal.
7. Continue with disassembly down to the bowls as described in the next section.

Bowl disassembly

The bowl assembly is composed of these parts:

- Suction bell
- Intermediate bowls
- Top bowl
- Impellers and securing hardware
- Bearings
- Pump shaft

Turbine bowl impellers are secured to the shaft by either a taper collet or a key and split-thrust ring. Follow only the procedures that apply to your

particular construction. These types of impeller attachments can apply to any vertical pump less than 18in. (46 cm) in diameter.

NOTICE:

Mark the components in sequence in order to aid the reassembly.

Disassemble the taper collet bowl

1. Remove the capscrews that secure the top bowl to the intermediate bowl.
2. Slide the top bowl off the pump shaft.
3. Pull the shaft out as far as possible and strike the impeller hub using a collet driver or equivalent, sliding along the pump shaft to drive the impeller off the taper collet.
4. After the impeller is freed, insert a screwdriver into the slot in the taper collet, spread it, and remove the taper collet.
5. Slide the impeller off the pump shaft.
6. Repeat these steps until the bowl assembly is completely disassembled.

Disassemble the keyed bowl

1. Remove the capscrews that secure the top bowl to the intermediate bowl.
2. Slide the top bowl off the pump shaft.
3. Remove the capscrews and the split-thrust ring from the pump shaft.
4. Slide the impeller off the pump shaft and remove the key.

NOTICE:

If the impeller is seized to the shaft, then strike the impeller with a fiber mallet and drive the impeller off the pump shaft.

5. Repeat these steps until the bowl assembly is completely disassembled.

Remove the turbine bowl and impeller wear rings

1. Remove the setscrews or grind off the tack weld if the rings are furnished with those locking methods.
2. Use a diamond-point chisel in order to cut two V-shaped grooves on the bowl or impeller wear ring approximately 180° apart.
Use extreme care not to damage the wear ring seat.
3. With a chisel or drift punch, knock the end of one half of the ring in, and pry the ring out.
4. On high-alloy materials such as chrome steel, set up the bowl or the impeller in a lathe and machine the wear ring off, using extreme care not to machine or damage the ring seat.

Remove the bowl, suction bell, and lineshaft bearings

NOTICE:

Bowl bearings are press fit. Do not remove the bowl bearings unless replacement is necessary.

1. Press the bearing off.
Use an arbor press and a piece of pipe or sleeve with an outside diameter that is slightly smaller than the diameter of the bowl or lineshaft bearing housing bore.
2. Remove the suction bell bearing by setting the suction bell in a lathe and machining the bearing off. The suction bell bearing can also be removed using bearing pullers to pull the bearings out.

Pre-assembly inspections

Guidelines

Before you assemble the pump parts, make sure you follow these guidelines :

- Inspect the pump parts according to the information in these pre-assembly topics before you reassemble your pump. Replace any part that does not meet the required criteria.
- Make sure that the parts are clean. Clean the pump parts in solvent in order to remove oil, grease, and dirt.

NOTICE:

Protect machined surfaces while you clean the parts. Failure to do so may result in equipment damage.

Replacement guidelines

Casing check and replacement

Inspect the casing for cracks and excessive wear or pitting. Thoroughly clean gasket surfaces and alignment fits in order to remove rust and debris.

Impeller replacement

table shows the criteria for replacing the impeller:

Impeller parts	When to replace
Impeller vanes	<ul style="list-style-type: none">• When grooved deeper than 1/16in. (1.6 mm), or• When worn evenly more than 1/32in. (0.8 mm)
Vane edges	When you see cracks, pitting, or corrosion damage
Keyway and bores	When you see damage

Gaskets, O-rings, and seats replacement

- Replace all gaskets and O-rings at each overhaul and disassembly.
- Inspect the seats. They must be smooth and free of physical defects.
In order to repair worn seats, skin cut them in a lathe while you maintain dimensional relationships with other surfaces.

-
- Replace parts if the seats are defective.

Bearing retainer check

Check the bearing retainer for deformation and wear.

Mechanical seal checks

On pumps equipped with a mechanical seal, check that the shaft or sleeve is free of pits, burrs, or sharp edges in order to prevent cutting or improper sealing of the seal O-rings. Remove any burrs and sharp edges by polishing with a fine emery cloth..

Impeller and bowl checks

Visually check impellers and bowls for cracks and pitting. Check all bowl bearings for excessive wear and Corrosion

Reassembly

Install the turbine bowl and impeller wear ring

1. Place the chamfered face of the bowl or impeller wear ring towards the ring seat and press the ring into the seat.
2. Use an arbor press or equivalent and make sure the ring is flush with the edge or the wear ring seat.

Install the bowl, suction bell, and lineshaft bearings

Make sure you have an arbor press or equivalent for pressing the bearings.

1. Press the bearing into the retainer.
2. Press the bearing into the suction bell.
The top of the bearing should protrude above the suction hub equal to the depth of the counter bore in the sand collar.
3. Press the bearings into the intermediate bowl and the top bowl.
4. Place the bowl with the flange downward and press the bearing through the chamfered side of the bowl hub until the bearing is flush with the hub.

Install the taper collet bowl assembly



WARNING:

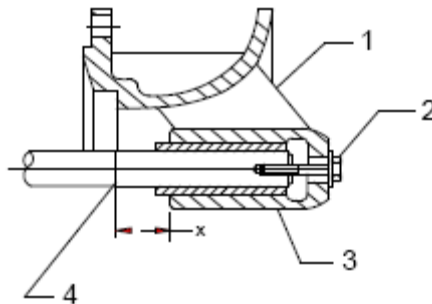
Wear protective gloves and use the appropriate eye protection in order to

prevent injury when you handle hot parts.

1. Apply a thin film of turbine oil to all mating and threaded parts.
2. If the pump is equipped with a sand collar, then perform these steps:
 - a) If the sand collar is not assembled to the shaft, then heat the sand collar until it slips over the shaft and quickly position it so that the top of the sand collar is even with the locating groove before it cools.

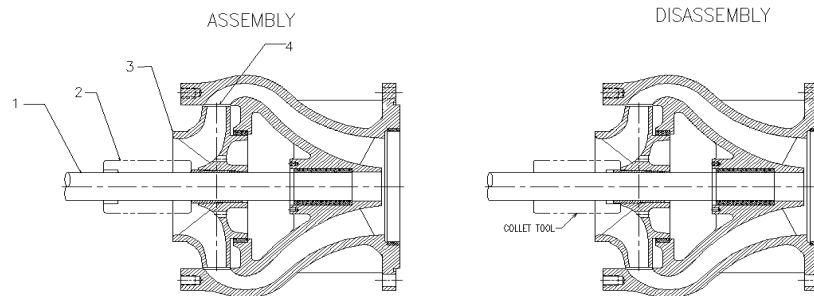
The sand collar is attached to the shaft with a shrink fit. The shaft is machined with a 0.01in. (0.25mm) groove to locate the sand collar. The large diameter of the counterbore of the sand collar goes toward the suction bell bearing.
 - b) Slide the end of the pump shaft with the sand collar into the suction bell bearing until the sand collar rests against the suction bell.
 - c) Skip the next step and proceed to installing the impellers.
3. If the pump is not equipped with a sand collar, then locate the pump shaft with respect to the suction bell:
 - a) Insert the pump shaft into the suction bell bearing until it bottoms out.
 - b) Pull the shaft out until the distance between the groove on the shaft and the top of the suction bell hub, and not the top of the bearing, is correct for the particular pump.

Use the X dimension in the Pump shaft dimensions table in the Maintenance chapter.



1. Suction bell
2. Capscrew screwed into the tapped hole in the shaft with washers, as required
3. Suction bell hub
4. 0.01in. (0.25 mm groove)

- c) Hold the shaft in this position by inserting a capscrew with a washer into the hole in the end of the suction bell and then into the threaded hole in the end of the shaft.
4. Install the impeller:
 - a) Slide the first impeller over the shaft until it seats on the suction bell.
 - b) Insert a screwdriver into the slot in the taper collet, spread the slot, and slide the collet over the pump shaft.
 - c) Hold the impeller against the bowl and slide the collet into the impeller hub.
5. Hold the shaft with a capscrew and washer against the suction bell and drive the taper collet into place with a collet driver.



1. Shaft
2. Collet
3. Impeller
4. Location to hold impeller against the bowl and drive collet into impeller hub

6. After the collet is in place, recheck the X dimension.
7. Slide the intermediate bowl onto the shaft and secure it with the capscrews provided.
8. Repeat this procedure for the number of stages required.
9. Remove the capscrew and washer and perform these checks:
 - Check that the shaft rotates freely without dragging or binding.
 - Check that there is adequate lateral end play.

Install the keyed bowl assembly

1. Install the key into the keyway of the pump shaft, slide the impeller over the shaft, and position the impeller on the key.
2. Install a split-thrust ring on the pump shaft groove and secure it to the impeller with capscrews.
3. Slide an intermediate bowl over the pump shaft and secure it to the suction bell with capscrews.
4. Repeat these steps for the number of stages required.

Troubleshooting

Operation troubleshooting

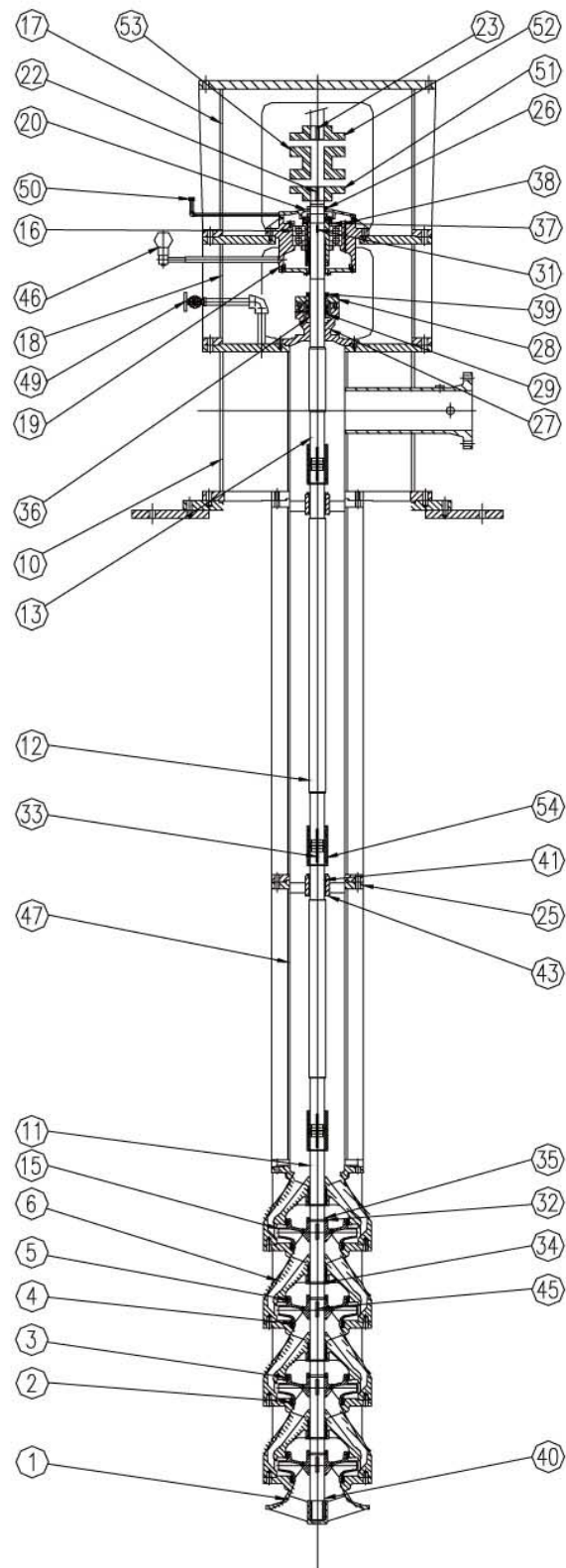
Symptom	Cause	Remedy
Pump does not start.	The electrical circuit is open or not complete.	Check the circuit and make any necessary corrections.
	The impellers are binding against the bowls	Reset the impeller adjustment. See Installation for details.
	The electric driver is not receiving enough voltage.	Make sure that the driver is wired correctly and receiving full voltage.
	The motor is defective.	Consult TRUFLO representative.
The pump is not delivering liquid.	The bowl assembly is not submerged enough.	Adjust the liquid level in the sump as necessary.
	The suction strainer is clogged.	Remove the obstructions.
	There is an obstruction in the liquid passage.	Pull the pump and inspect the impeller and bowl.
	The discharge head is not properly vented.	Open the vent.
The pump is not delivering enough liquid.	The suction or discharge valves are closed.	Open the valves. For more information, see Commissioning, Operation, Startup, and Shutdown.
The pump is not producing the rated flow or head.	The impellers are not rotating fast enough.	Make sure that the driver is wired correctly and receiving full voltage.
	The impellers are rotating the wrong direction.	Make sure the impellers are spinning Counter clockwise when viewed from above. Check the engagement of the motor

		coupling.
	The total pump head is too high.	Check the pipe friction losses. Use larger discharge piping.
	The liquid passages are partially obstructed.	Inspect the impellers and bowls and remove any obstructions.
	There is cavitation.	Insufficient NPSH is available.
	The impellers are too high (semi-open construction only).	Reset the impeller adjustment. See Installation for details.
There is not enough pressure.	The impellers are not rotating fast enough.	Make sure that the turbine is receiving full steam pressure.
	The liquid passage is obstructed.	Inspect the impellers and bowls and remove any obstructions.
	The impellers are rotating in the wrong direction.	Make sure the impellers are spinning Counter clockwise when viewed from above. Check the engagement of the motor coupling.
	The impellers are too high (semi-open construction only).	Reset the impeller adjustment. See Installation for details.
The pump starts and then stops pumping.	Excessive power is required.	Use a larger driver. Consult TRUFLO representative.
	The pump is pumping a higher viscosity or different specific gravity liquid than it was designed to handle.	Test the liquid for viscosity and specific gravity. Consult TRUFLO representative.
	Critical parts have experienced mechanical failure.	Check the bearings, wear rings, and impellers for damage. Any irregularities in these parts will cause a drag on the shaft. Replace any damaged parts as necessary.
	The impellers are rotating too fast.	Check the frequency on the motor.
	The pump and driver are misaligned.	Realign the pump and driver.
	The discharge head is not properly vented.	Open the vent.
The pump requires excessive power	The impellers are damaged.	Inspect the impellers for damage and replace them if necessary.
	A foreign object is lodged between the impeller and the bowl.	Remove the object.
	The liquid is heavier than expected.	Check the specific gravity and viscosity.
	The liquid viscosity is too high or the pumped fluid is partially freezing.	Check for both conditions. They can cause drag on the impeller. Consult TRUFLO representative.
	The bearings are defective.	Replace the bearings and check the shaft or shaft sleeve for scoring.
	The stuffing-box packing is too tight.	Release the gland pressure and retighten. Keep the leaking fluid flowing. If there are no leaks, then check the packing, sleeve, or shaft. See maintenance for

		details.
The pump is noisy.	The pump is cavitating.	Increase the liquid level in the pump.
	The shaft is bent.	Straighten as necessary.
	Rotating parts are binding, loose, or broken.	Replace parts as necessary.
	The bearings are worn.	Replace the bearings.
	The discharge head is not properly vented.	Open the vent.
The pump is vibrating excessively.	One of these conditions might exist: <ul style="list-style-type: none"> • The coupling is misaligned. • The shaft is bent. • The impellers are not balanced. • The bearings are worn. • There is cavitation. • There is strain on the discharge piping. • There is resonance. 	Determine the cause by using a vibration frequency analyzer or by disassembling the pump. A complex problem might require the assistance of TRUFLO representative.
	The driver shaft is not adjusted properly.	Readjust the driver. See Installation for details.
There is excessive leakage from the stuffing box.	The packing is defective.	Replace any packing that is worn or damaged.
	The wrong kind of packing was used.	Consult TRUFLO representative.
The stuffing box is overheating.	The packing is too tight.	Release the gland pressure and retighten. Keep the leakage flowing. If there is no leakage, then check the packing, sleeve, or shaft. See Maintenance for details.
	The packing is not lubricated.	Release the gland pressure and replace any packing that is burned or damaged. Regrease the packing as necessary.
	The wrong grade of packing was used.	Consult TRUFLO representative.
	The stuffing box was improperly packed.	Repack the stuffing box.
The packing wears out too fast.	The shaft or shaft sleeve is worn or scored.	Remachine or replace any parts as necessary.
	There is insufficient leakage across the packing.	Repack the stuffing box and make sure that the packing is loose enough to allow some leakage.
	The stuffing box was improperly packed.	Repack the stuffing box properly, making sure that all old packing is removed and the stuffing box is clean.
	The wrong grade of packing was used.	Consult TRUFLO representative.
The mechanical seal leaks.	The seal faces are not flat because the gland bolts are too tight. This causes the gland and insert to warp.	Remove the gland bolts and then reinstall them properly.
	The shaft packing has been chipped during installation.	Replace the packing.

	One of these conditions exists: • The carbon insert is cracked. • The insert face or seal ring was chipped during installation.	Remove the mechanical seal, inspect, and replace as necessary.
	The seal faces are scored from foreign particles between the faces.	Install a strainer, and then filter or cyclone the separator as required in order to filter out any foreign particles.
The seal squeals during operation.	There is an inadequate amount of liquid at the seal faces.	A bypass flush line is necessary. If a bypass line is already in use, then enlarge it in order to produce more flow.
Carbon dust is accumulating on the outside of the gland ring.	There is an inadequate amount of liquid at the seal faces.	Bypass the flush line. If a bypass line is already in use, then enlarge it to produce more flow.
	Liquid film is flashing and evaporating between the seal faces and leaving residue, which is grinding away the carbon.	Consult TRUFLO representative.
The seal leaks but nothing appears to be wrong.	The seal faces are not flat.	Relap or replace the seal faces.
The seal is wearing out too quickly.	This product is abrasive. This causes excessive seal face wear.	Determine the source of the abrasives and install a bypass flushing in order to prevent abrasives from accumulating in the seal area. Install a cyclone separator as necessary.
	Abrasives are forming due to the process liquid cooling and crystallizing or partially solidifying in the seal area.	Install a bypass flush line in order to hold the liquid temperature around the seal above the crystallization point.
	The seal is running too hot.	Check for possible rubbing of the seal components. Recirculation or a bypass line may be necessary.
	The wrong kind of seal was used.	Consult TRUFLO representative.

Sectional drawing



TVP

NO.	PART NAME
1	SUCTION BELL
2	CASE WEARING RING(FRONT)
3	CASE WEARING RING(BACK)
4	IMPELLER WEARING RING(FRONT)
4	IMPELLER WEARING RING(BACK)
6	BOWL
10	DISCHARGE HEAD
11	LOWER SHAFT
12	INTER SHAFT
13	UPPER SHAFT
15	IMPELLER(1st~4th)
16	THRUST RINGTHRUST BEARING
17	MOTOR PEDESTAL
18	BEARING BRAKET
19	BEARING HOUSING
20	BEARING COVER
22	COUPLING KEY(PUMP SIDE)
23	COUPLING KEY(MOTOR SIDE)
25	BEARING RETAINER
26	LABYRINTH OIL SEAL
27	STUFFING BOX
28	SEAL COVER
29	MECHANICAL SEAL UNIT
31	BEARING HOLDER KEY
32	SPLIT RING HODER
33	INTER COUPLING KEY
34	SPLIT RING
35	SPACER RING
36	M/S SLEEVE
37	THRUST BEARING HOLDER
38	THRUST BEARING HOLDER
39	M/S SLEEVE HOLDER
40	LOCK NUT & SLEEVE
41	SLEEVE(RETAINER)
43	SLEEVE BEARING
45	IMPELLER KEY(1st~4th)
46	CONSTANT LEVEL OILER
47	COLUMN PIPE
49	FOUALIZING PIPE LINE
50	OIL FILLING CAP
51	COUPLING(PUMP SIDE)
52	COUPLING(MOTOR SIDE)
53	COUPLING SPACER
54	INTER COUPLING UNIT

Local TRUFLO Contacts

REGIONAL OFFICES

Region	Address	Telephone	Fax
USA(Headquarters)	7105 Cessna Dr Greensboro, NC 27409 United States	(336)664-9225	(336)664-1353

COMPANY OVERVIEW

Will be a globally leading company in the pump industry based on world-class technology and know-how

Since the foundation in 1984, we have strived to develop the technology only for industrial pumps and become what we are today.

Particularly, we are proud of the wide experience and know-how accumulated during the period, which have been the asset differentiating TRUFLO PUMPS from the other pump manufacturers.

TRUFLO PUMPS will never be satisfied with just being a simple pump maker but try to increase customers' profit and help them continuously grow, striving ceaselessly to achieve the goal of prosperity along with customers. We also put our energy more into the win-win management for sharing the company's success with all our employees and the society.

Thank you very much.

MANAGEMENT PHILOSOPHY

We shall produce quality products with solid competitiveness and realize the mental and financial welfare of all our employees. A company is the means to carry out the mental and financial happiness. The stability of employment affects the quality of life.

By offering good job opportunity, we shall make an effort to help create a happy family, a sound company, and a healthy society.

For this, we shall continuously grow together with customers as a creative enthusiastic partner by securing international competitiveness through constant technology development and service innovation.

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