



**Venturi Prime Series
Operation & Maintenance Manual
(Enclosed Bracket Style)**

Manual #7001

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Operation and Maintenance Manual

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INTRODUCTION

Thank you for purchasing a Pioneer end-suction centrifugal pump. This is a heavy duty pump intended for use with non-volatile, non-flammable liquids with specified entrained solids, except as approved by the factory.

WARNING!!!

This manual provides installation, operation and maintenance instructions for your Pioneer Pump, whether of venturi-assisted self-priming or conventional configuration. It is intended to make your personnel aware of any procedure that requires special attention because of potential hazards to personnel or equipment. Read all instructions carefully and remember that pump installations are seldom identical. Therefore, this manual cannot possibly provide detailed instructions and precautions for each specific application. Thus, it is the owner/installer's responsibility to ensure that applications not addressed in this manual are performed only after establishing that neither operator safety nor pump integrity are compromised by the installation.

WARNING!!!

Centrifugal Pumps are designed for specific service and may or may not be suited for any other service without loss of performance or potential damage to equipment/personnel. If there is ever any doubt about suitability for a specific purpose; contact your **Pioneer Pump, Inc.** representative or the factory for assistance.

Remember: Pump performance may be affected by changes in pumpage such as, specific gravity, viscosity, temperature, operating speed and NPSHA (net positive suction head available).

INSPECTION

INSPECTION

All equipment is inspected at the factory prior to shipment. However, you should inspect all equipment upon arrival for shipping damage and item shortages from the packing slip. Report any damage or shortages to the carrier and **Pioneer Pump, Inc.**

RECORDING MODEL & SERIAL NUMBERS

Please record the model and serial number for your **Pioneer Pump** in the spaces provided below. The factory will need this information when you require parts or service.

Pump Model: _____

Pump Serial Number: _____

Engine/Motor Serial #: _____

Engine/Motor Model Mgf: _____

WARRANTY INFORMATION

Pioneer Pump's current terms and conditions, including limited warranty policy, can be found on our website <http://www.pioneerpump.com> from the homepage by selecting More > Resources > Terms and Conditions or by following this link:
http://pioneerpump.com/media/232391/M5132_Pioneer_Standard_Terms_and_Conditions-1-.pdf

INSTALLATION

FOUNDATION/BASE PLATE/SKID

Pioneer pumps are available in trailer mounted, skid mounted or conventional channel base mounted configurations, or bare pumps may be mounted by a third party. Typically a channel base mounted unit is intended for a permanent installation, and the following recommendations for permanent installations should be followed.

If using a concrete foundation it should be rigid enough to inhibit vibration. Pour the foundation well in advance of installation of pump equipment to allow time for drying and curing.

If the pump is to be mounted on a steel frame, or similar structure, it should be set directly over the supporting beams. These beams and the structure must be rigid enough to prevent distortion and potential misalignment due to movement within the structure or base.

The location of this structure should be as close as possible to the pumpage source. Provide adequate space for operation, maintenance and inspection of the pump and equipment.

The concrete foundation should be provided with anchor bolts for attachment to the base plate. If required, provide adequate drainage to keep pump and motor dry and clean. Also, provide either leveling nuts or leveling wedges for mounting the base plate to the foundation.

LEVELING

When mounting the base plate to the foundation use leveling nuts or wedges to provide a level, flat base plate. Use a machinist's level on the mounting pads and make adjustments as necessary as the anchor bolts are tightened. This will provide the true alignment between the pump and motor. For portable trailer or skid mounted, engine driven units, it is important that the pump / engine assembly be level so as to assure proper fuel feed and distribution of engine lubricants. Trailer mounted units can be leveled using the tongue jack and blocking under the lower wheel. Wheels should be properly chocked so as to prevent rolling of the trailer. Skid mounted units should be leveled by preparing the ground or blocking under the skid. For portable electric units accurate leveling is not particularly important except as required for proper piping alignment.

GROUT

If a base mounted pump is to be grouted, ensure that you have the mounting surface flat and level for correct alignment of pump and motor. Build a dam around the base plate perimeter that is to be watertight. Use standard grouting practice and be sure to protect (cover) the leveling wedges with caulk or plastic tape if they are to be removed later. After the grout has thoroughly hardened, remove forms. If the wedges are removed, fill holes with grout. Seal grout by covering with a quality paint or sealer.

TRAILER MOUNTED UNITS

See “OPERATION” section.

INSTALLATION

INSTALLING PUMP

Insure that all foreign material has been removed from the pump before mounting. Be sure to remove all shipping protection prior to operation.

NOTE: Many of the bare pumps are shipped with protective guards and coatings.

SUCTION PIPING

For best performance the suction piping should be at least as large as the pump flange, never smaller. Use an eccentric reducer at the suction flange with the straight side up. The use of flow-retarding fittings is to be avoided and if necessary should never be placed closer to the pump suction than four (4) times the pipe diameter. The pump should be at the highest point of the piping. Slope the piping up to the pump to prevent air pockets. Avoid changing pipe size except to reduce a larger suction pipe diameter to the pump suction flange size using the eccentric reducer mentioned above. All suction piping and fittings are to be checked for any foreign material (rocks, bolts, wire, etc.) and also any sharp burrs that could disrupt the flow.

DISCHARGE PIPING

Use a concentric taper on the discharge side to increase from pump discharge flange size to a larger discharge pipe diameter, or maintain discharge piping the same size as the discharge size of the pump. The decision of what size discharge pipe to use in an economic one, a balance between the higher cost of larger piping versus the higher energy requirements imposed by pipe friction. Otherwise, the only detrimental effects of discharge piping size choice derive from the pump running too near shut-off or too far out on its curve. The discharge size should be adequate to maintain reasonable velocities and reduce friction losses. All valving and additional fittings should be the same size as the discharge line.

SUCTION & DISCHARGE PIPE FLANGES

All piping is to be supported, braced and lined up square before connection to the pump flanges. In fixed or permanent installations a flexible fitting is recommended on both suction and discharge, to eliminate any piping strains being transmitted to the pump. Portable installations still require support of discharge and suction piping or hose near the pump so as to avoid undue forces being carried by the pump flanges. Supporting the piping or hoses with the pump flanges can result in rubbing and wear between rotating and stationary portions of the pump, possible breakage of the case or brackets or failure of seals or couplings.

NOTE: Flexible pipe couplings must be restrained so as not to transmit any strain to the pump flanges when expanding or contracting under pressure. Unrestrained expansion fittings can transmit enormous forces to the pump flanges.

INSTALLATION

SCREENING

Make provisions for the installation of a suction screen or strainer to prevent any debris from clogging the impeller. The open area of the strainer should be equal to at least four (4) times the area of the pipe. The screen should be rigid enough to prevent collapse when flow is reduced due to clogging.

SUMP DESIGN

The submergence of the suction pipe into the liquid should be at least four (4) to five (5) times the pipe diameter. If this is not possible then provide a baffle or a floating board. This is to prevent any vortex action allowing air into the pipe. For best performance a bell mouth fitting is recommended. Refer to the Hydraulic Institute Handbooks or other Hydraulic Data books for detailed sump design information.

LIFTING

Any lifting equipment is to be rated for at least five (5) times the weight of the item being lifted. Use only established methods when lifting or moving any heavy components.

ALIGNMENT OF PUMP AND MOTOR

Precise alignment is necessary to achieve correct performance of the system. Every time a component is moved this alignment will have to be checked. The alignment can be checked with a straight edge and an outside caliper, taper thickness gauge, dial indicators or, for best results, use a laser alignment tool. Use the straight edge across the outside diameters of the coupling halves to ensure that they are concentric and parallel. The outside calipers or the taper thickness gauge is to correct for any angular misalignment and to verify the correct gap between the coupling flanges. Use a laser alignment tool or dial indicators to adjust for concentric and angular displacement. With dial indicators, rotate shafts together and take readings every ninety (90) degrees. Make adjustments by placing shims under the driver, and be sure that the mounting bolts are properly tightened while taking readings and after final adjustment then install coupling guard.

If the pump is equipped with an SAE bracket and flywheel coupling for direct mounting of the pump to the engine bell housing, alignment between crankshaft and pump shaft is automatically attained due to the register fits between the bell housing and pump bracket.

ROTATION

Before the pump is started, correct rotation must be confirmed. If the rotation is not correct, then interchange any two of the leads on a three (3) phase driver. For a single-phase driver refer to the wiring diagram. Engine rotation should be confirmed with the engine supplier.

OPERATION

VENTURI PRIMING

Figure 10039A, 10040A

Venturi prime Pioneer pumps prime using the vacuum created by the air from the engine compressor flowing through the jet pump. The vacuum of the jet pump is connected to the pump's priming spool. If this priming device is not supplied on your pump model you will need either a flooded suction or a foot valve and some other means of evacuating air from the pump case and suction line. With a flooded suction use a bleed valve at the top of the volute to allow trapped air to escape. If you are using a foot valve, then fill the suction line and pump case with water and use a bleed valve for trapped gas as above. If a hand primer is to be used it will be necessary to have an air tight check valve or closeable control valve on the discharge line to prevent the entry of air from the discharge side. Rotating the pump shaft will release trapped gas in the impeller. If the pump has a float ball priming chamber connected to the priming spool, the jet pump's vacuum line will automatically be shut when the pump is primed. If the spool does not contain a float ball priming chamber it will emit water once it is primed.

PRE-START CHECKLIST

- 1) Verify that rotation is correct and that the shaft rotates freely.
- 2) Check all piping connections for tightness.
- 3) Inspect all accessories and make sure they are appropriate for your installation.
- 4) Verify that the driver and coupling are aligned correctly and that all guards are in place.
- 5) Ensure that all bearings and grease seals are lubricated.
- 6) Oil levels should also be checked and maintained during pump operation.
- 7) Follow the instruction on all tags, labels and decals attached to the equipment.

WARNING!!!

This pump is designed to handle most non-volatile, non-flammable liquids containing specified entrained solids and corrosives. Do not attempt to pump volatile, corrosive, or flammable liquids which may damage the pump or endanger personnel as a result of pump failure.

OPERATION

CAUTION!!!

Pump speed and operating condition points must be within the continuous performance range shown on the performance curve in the separate Part List Manual for your specific pump model.

STARTING

Any centrifugal pump must be primed before starting unless it is of a self-priming design. See preceding section on priming, and ensure suction pipe is filled with water. With discharge

valve closed, start the pump and slowly open valve. Throttle the flow gradually to fully open. Avoid any abrupt changes in the discharge flow rate to prevent pressure surges in the piping. If the design pressure is not achieved shut the pump down immediately. Ensure that pump is adequately primed and restart.

Never run the pump with the discharge valve closed for extended periods of time. Never use the suction valve to throttle the flow. Check all suction and discharge piping for leaks.

If a suction strainer is installed, check the pressure drop across the strainer. If the differential in pressure exceeds five (5) PSI have the strainer cleaned.

OPERATION OF ENGINE DRIVEN UNITS

Before Starting

Check the fuel level and oil levels in the engine, check the oil level or grease & in the pump bearing housing and seal chamber's run dry reservoir.

CAUTION!!!

Make sure the pump is level. Lower jack stands and chock the wheels. Use caution when positioning the skid-mounted unit to prevent damage to the fuel tank. Consult the engine operations manual before attempting to start the unit.

WARNING!!!

Do not operate the pump without guards in place over the rotating parts. Exposed rotating parts can catch clothing, fingers or tools, causing severe injury to personnel.

MAINTENANCE

WARNING!!!

Before attempting to service this pump, read this manual carefully. Operators and maintenance personnel should have a good understanding of all aspects of this pump and the pumping conditions. Failure of operating personnel to be familiar with all aspects of pump operation outlined in this manual could contribute to equipment damage, bodily injury or possible death.

WARNING!!!

Before any servicing:

- 1) Read this manual carefully.
- 2) Shut down driver and lock out incoming power to ensure that the pump will remain inoperative.
- 3) If the pump or components are hot, allow adequate cooling prior to servicing the unit.
- 4) Close the suction and discharge valves.
- 5) Vent the pump slowly and drain completely.

WARNING!!!

If this pump is used to handle any hazardous materials that can cause illness, either directly or indirectly, take precautions by wearing approved protective clothing and use appropriate safety equipment.

WARNING!!!

Use lifting and moving equipment in good repair and with adequate capacity to prevent injuries to personnel or damage to equipment. Attach lifting equipment to the lifting device fitted to the pump. If chains or cable are wrapped around the pump to lift it make certain that they are positioned so as not to damage the pump and so that the load will be balanced. The bail on trailer or skid mounted units is intended for use in lifting the pump assembly only. Suction and discharge hoses and piping must be removed from the pump before lifting.

CAUTION!!!

When servicing this pump, use only components provided by **Pioneer Pump, Inc.** Any use of non-authorized parts could result in sub standard performance, damage to equipment and possible injury to personnel. Non-authorized parts will also void the warranty.

When using this manual any reference to part numbers or names will be directed to the applicable cross section drawing. These parts will also be called out in the bill of materials for full description.

Drain volute case of pumpage when unit is idle to avoid freezing and possible cracking of pump case, etc.

This manual also provides a troubleshooting section to diagnose many operational or performance problems. The equipment covered in this section is limited to the pump, priming and drive components only. Refer to the applicable vendor's manual for motors, engines and other accessory equipment. Use the troubleshooting section to help determine the cause of any problems, and only disassemble the pump components required to remedy the existing condition.

This manual provides installation, operation and maintenance instructions for your Pioneer Venturi Prime Pump. The manual will also make your personnel aware of any procedure that requires special attention because of potential hazards to personnel or equipment. Read all instructions carefully and remember this manual cannot anticipate or warn of every situation that could occur. Because of this the owner is responsible that only safe procedures be used, if not addressed in this manual. If any question regarding the pump is not covered adequately please contact **Pioneer Pump, Inc.**

WARNING!!!

Select a clean suitable location for any required maintenance, and note that all work must be performed by qualified personnel.

An ongoing record of performance will assist in any troubleshooting and/or analysis of problems. A pressure gauge can be installed on the suction and discharge side of the pump to monitor any changes in differential pressure. Differential pressure is useful in monitoring and diagnosing any possible degradation in pump performance.

MAINTENANCE

VENTURI JET PUMP

(Figure 10039A, 10040A)

Disconnect the priming chamber hose from the venturi jet pump. Unthread the venturi jet pump

from the bracket.

PRIMING CHAMBER

Figure 10039A, 10040A & 10045A

Disconnect and remove suction piping and air tubing from the **priming chamber/suction spool** assembly. While supporting the assembly with a sling, remove the nuts and bolts connecting the suction spool to the pump suction flange.

PRIMING VALVE SERVICING

Figures 09094A-VP, A1784A

The **priming valve** system, housed inside the priming chamber, is adjusted at the factory and should rarely require service. It is possible, after extended use, that wear of the holes in the **upper arm, lower arm, link** or **pins** could necessitate slight adjustment of the **stem washer** to upper arm clearance. Furthermore, it may become necessary to adjust the **valve spring** tension. The procedures for both of these adjustments are delineated in figure A1784A. The only other potential service requirement is replacement of the **stem o-ring**. To replace this o-ring, remove the elbow attached to the outlet of the priming chamber. This will expose the internal valve components. Grasping the lower end of the valve stem, remove the nut and washer located on top of the **valve washer**. Remove the valve washer and valve spring. The valve stem can now be removed through the bottom side of the **priming chamber lid**. Cut the old stem o-ring to remove it, and simply “roll” a new o-ring into place. Reassembly is the opposite of disassembly.

DISCHARGE CHECK VALVE (Venturi Prime only)

Figures 10039A, 10040A, A2170A

Support the **check valve** with a sling and remove the nuts, bolts, and gasket between the check valve and pump discharge flange. If the check valve disc (3) needs to be replaced, remove the top cover (2) and insert new disc. The top cover gasket (4) should be replaced at this time.

SUCTION COVER AND WEAR RING

Figure A2524A

Support the **suction cover** using a suitable sling. Remove the capscrews between the suction cover and **volute**. Jackscrew holes are provided in the suction cover to aid removal from the volute. Insert two of the capscrews attaching the suction cover to the volute into the jackscrew holes, and tighten them evenly to jack the suction cover free of the volute. If the **suction wear ring** shows grooves or uneven wear it should be replaced. Minor irregularities can be dressed with a fine file and crocus cloth. Wear rings may be reworked by light machining, if proper equipment is available to correct minor irregularities. After the removal of any stock, the ring must remain within allowable clearances for maximum performance. (Consult factory for clearances for specific models).

When the pump performance drops below acceptable limits the **suction wear-ring** and **hub wear ring** (if so equipped) should be replaced. These rings can be removed by drilling two holes of the adequate size, axially, through the ring 180° apart. The ring can now be collapsed and removed.

Tap new ring into place evenly around circumference with chamfer toward suction flange. Anti-seize lubrication should be applied to the “OD” of the ring prior to installation in suction cover. Make sure wear ring is installed tight against shoulder.

VOLUTE REMOVAL

Figure A2525A

Support the **volute**, and remove the capscrews attaching the volute to the backplate. Inspect the volute o-ring for cuts or compression set and replace as necessary.

MAINTENANCE

ONE PIECE VOLUTE AND WEAR RING

(Figure A2173A)

Support the **volute** using a suitable sling and remove the capscrews between the volute and **backplate**. There are jackscrew holes in the backplate flange to aid in removal of the volute. Insert two of the volute capscrews in the jackscrew holes, and tighten them evenly to push the volute free of the backplate. If the **suction wear ring** shows grooves or uneven wear it should be replaced. Minor irregularities can be dressed with a fine file and crocus cloth. Wear rings may be reworked by light machining, if proper equipment is available to correct minor irregularities. After the removal of any stock, the ring must remain within allowable clearances for maximum performance. When the pump performance drops below acceptable limits the **volute wear ring** should be replaced. This ring can be removed by drilling two holes, of the proper size, axially, through the ring 180° apart. The ring can now be collapsed and removed.

Tap new ring into place evenly around circumference with chamfer toward suction flange. Anti-seize lubrication should be applied to the outside diameter of the ring prior to installation in volute, make sure wear ring is installed tight against shoulder.

NOTE: Any further disassembly of this pump requires the draining of oil from the integral seal oil reservoir. Remove the pipe plug at the bottom of the **pump bracket** and drain oil..

IMPELLER REMOVAL

Figure A2526A

Remove the **impeller lockcrew** and **washer** at the center of the **impeller**. Utilizing a properly sized gear puller, evenly pry between the back shroud of the impeller and the **backplate**. Take care not to lose or damage any **impeller shims** that may be inside the impeller bore, and do not lose the **impeller key**. As the impeller is being removed from the **shaft** ensure that the **seal spring**, if present, is not lost or damaged. Inspect the impeller and replace or repair if warranted.

SEAL REMOVAL (Rotating Element)

Figure A2520A

Once the **impeller** is removed, the **rotating assembly** of the seal (bellows, spring and retainer) can slide off of the **shaft** as a unit. Apply a light coat of oil to the shaft to help free the rotating assembly. Take care to protect this assembly from any foreign matter or damage.

MAINTENANCE

BACKPLATE REMOVAL

Figure A2521A

The **backplate** can now be removed by removing the capscrews attaching the **bracket** and the backplate. Slide the backplate straight off of the **shaft** to prevent any damage to the **seal seat** or the surface of the shaft. The seal seat can now be pressed out of the backplate bore taking care not to break the seat. The entire **seal assembly** can now be inspected for any damage that will require replacement.

BEARING HOUSING/BRACKET

Figure A2177A

If the frame **bearings** require servicing it will be necessary to remove the **bearing housing** from the driver and the pump end from the bearing housing. Remove the coupling guard as necessary. With the bearing housing supported with a hoist and sling remove bolts holding the housing to the baseplate. Now the bearing housing can be moved away from the driver for further servicing.

On the pump-end of the **bearing housing** remove the capscrews and the **bracket capscrew seals** (washers) connecting the **bracket** and the bearing housing. Later models may use **bracket seal o-rings** rather than bracket capscrew seals. Gently slide the bracket off the **shaft** to protect the **bracket lip seals**. Later models may have drain slot and a **dowel pin** on the side of the bracket facing the pump-end bearings. If these are present, note their positions for reassembly. On the drive-end of the bearing housing, remove the capscrews holding the **bearing cap** or the **SAE bracket** to the housing. Gently slide the bearing cap or the SAE bracket off of the shaft to protect the lip seal if it is to be re-used.

Now the shaft assembly, including the **shaft, bearings and the bearing locknut and washer** can be removed through the drive-end of the bearing housing. This operation may require placing a block of wood against the impeller-end of the shaft and tapping with a “dead blow” hammer or using a mechanical or hydraulic press against the impeller end of the shaft. If the bearings are to be re-used, the shaft should be pressed out rather than tapped out with a hammer. With the shaft and bearing assembly out of the housing the bearings can be inspected and replaced as necessary.

Note: Changes have been made which will alter the following disassembly and reassembly procedures relative to earlier models.

In newer models a rotating **labyrinth seal** has been added between the pump-end bearing and the bracket to protect the bearings. In the event of both a mechanical seal and bracket lip seal leak, this device will prevent contamination of the bearings. To accommodate the labyrinth seal, the pump-end bearing has been moved back on the shaft. If a new shaft is ordered for an earlier pump model that is not equipped with the labyrinth seal it is necessary to make up this gap between the bearing and bracket so that the **wave spring** will still serve to pre-load the pump-end bearing. In such cases a **bearing spacer** can be provided along with the new shaft. This bearing spacer will fit in the pump-end of the bearing housing where the **labyrinth seal carrier** would fit on later models. If the pump is equipped with the labyrinth seal, lubricate the exposed portion of the pump-end of the shaft and remove the shaft assembly, including **shaft, bearings and the bearing locknut and washer** from the drive-end of the bearing

housing. This operation may require placing a block of wood against the impeller-end of the shaft and tapping with a hammer or using a standard press against the impeller end of the shaft. If the bearings are to be re-used, the shaft should be pressed out rather than tapped out with a hammer. The labyrinth seal carrier and labyrinth seal may come out with the shaft or may stay in the housing depending upon the tightness of the carrier fit to the housing. If the labyrinth carrier and labyrinth seal remain in the housing, they can be pushed out after the shaft and bearings have been removed, or they can be pulled off the shaft if they came out with the shaft. If the pump is an earlier model that has had a prior shaft replacement, there may be a bearing spacer in the frame bore in place of the labyrinth seal carrier. This spacer will remain in the bearing housing bore when the shaft is removed. It can be left in place or removed at the discretion of the service mechanic. Whether a spacer or labyrinth carrier was installed, there will be a wave spring between the outer race of the pump-end bearing and the spacer or labyrinth carrier. Do not lose this spring. If your pump was not equipped with this spring, then contact the factory to acquire one. With the shaft and bearing assembly out of the housing the bearings can be inspected and replaced

CAUTION!!!

Any work on the **shaft** and bearing assembly should be done in a properly equipped shop by experienced personnel. We recommend that the **bearings** be replaced any time they are removed from the **bearing housing**. Clean the bearing housing and the shaft and other components except the bearings, with cleaning solvent and a string / lint free cloth. Inspect all parts and blow components dry with compressed air. If the **bearings** are to be replaced, the old bearings can be removed using a suitable gear puller. It is recommended that backplate and **bearing cap lip seals** also be replaced at this time. These lip seals can be driven out of their bores with a drift, punch or screw driver. Before removing the lip seals note the orientation of the lips, and be certain to install the new seals with the same orientation. When driving or pressing in the lip seals use a flat block or plate which applies pressure around the entire circumference of the seal – **do not drive the seal in with a drift or punch**.

WARNING!!!

When using cleaning solvent be sure to have adequate ventilation, as most solvents are toxic and flammable. Follow all precautions pertaining to the solvent and keep area free from excessive heat, sparks and flame.

Rotate the bearings by hand and check for any roughness or wear. If any roughness, wear or discolored areas are present, replace the bearings. Also, check the fit between the bearings and shaft for a tight press fit and between the bearings and the housing for a snug slip fit. If the fits are not correct then replace the bearings, shaft or the bearing housing as indicated by wear. If bearings are to be replaced use a bearing puller to remove them from the shaft.

BEARING HOUSING REASSEMBLY

Figure A2177A / A2055A

After all components have been inspected, repaired, and or replaced ensure all parts are clean and ready for assembly as indicated above. Use extreme caution, during assembly, to protect all parts from dirt and damage. The bearings should be installed using the bearing manufacturer's recommended installation procedure.

CAUTION!!!

If heat is used to install the **bearing** use an induction heater, electric oven or hot plate. Do not use a direct flame. Heat the bearings to a uniform temperature of 220E F (105EC) maximum, and slide each bearing onto the **shaft** until firmly seated against the shaft shoulder. Once the bearing is removed from the heat it must be placed over the shaft and seated against the shoulder very quickly or it will seize to the shaft in the wrong position. After the bearings have cooled; ensure that they are still seated against the shaft shoulder. If they are not seated use a sleeve, of the correct size, and a press to seat bearing. This sleeve and press can be used if heating the bearing is not practical, but only press against the inner race of the bearing.

If a single drive-end bearing is to be used in conjunction with a new shaft, make sure that the **shaft bearing spacer** is installed on the drive-end of the shaft before the bearing is installed. Heat the shaft bearing spacer just as with the bearing, and slide it over the shaft and firmly against the shaft shoulder. If an older shaft is to be used, a shaft bearing spacer will not be needed. The older, single bearing shaft design can be identified by the length of the bearing step at the drive-end of the shaft – it will be wide enough to accommodate only one bearing. If double angular contact bearings are to be used, a shaft bearing spacer will not be used. If an earlier, single drive-end bearing pump is to be retrofitted to a double angular contact drive-end bearing arrangement, be sure to remove the **bearing spacer** which is mounted in the drive-end bore of the bearing housing.

CAUTION!!!

With the **Drive-End bearing** firmly seated against the shaft shoulder install the **bearing lockwasher** and the **bearing locknut**. Refer to **figure A2055A** for the correct orientation. Ensure the washer tab on the inside diameter is engaged in the slot in the shaft and the tab pointed toward the bearing. After the bearing nut has been tightened, bend one of the tabs on the outside diameter of the washer to engage one of the slots in the nut.

Some pumps are equipped with double angular contact bearings at the drive end. It is imperative that these bearings be installed in the correct orientation relative to one another. When installing the first of the two angular contact bearings onto the shaft make certain that the side of the inner race with the largest diameter is located against the shaft shoulder. The next bearing must be installed with smaller diameter side of the inner race against the first bearing. **Refer to illustration A2055A.**

Check that the **bearing housing** is clean and that the bearing bores are free of any burrs or nicks. Ensure that the **bearing housing spacer** (not used with double drive-end bearings) is installed in the drive-end bore of the housing. Wait for bearing to cool, then, from the drive-end of the bearing housing, slide the shaft/bearing assembly into the drive-end of the housing. Press the drive end of the **shaft** until the **drive-end bearing** contacts the housing or bearing spacer shoulder. Apply a light coat of oil or grease to the **bearing cap lipseal(s)** that is installed in the or **SAE bracket lip seal(s)**. Slide the bearing cap or SAE bracket over the drive end of the shaft taking care to protect the lip seal. Secure the bearing cap to the bearing housing using the capscrews. For oil lubricated bearing frames make sure that the **bearing cap o-ring** is installed on the bearing cap register

For pumps to be equipped with the Labyrinth bearing protector, install as follows. Lubricate the pump-end bore of the bearing housing with a film of grease or motor oil. Install the **labyrinth carrier o-ring** into the shallower of the two grooves in the outside diameter of the **labyrinth seal carrier**. Lubricate this o-ring with grease or motor oil. Place the **wave spring**

over the shaft and up against the outer race of the **pump-end bearing**. Place the labyrinth seal carrier into the bearing housing bore with the four small holes facing the bearing.

Press the labyrinth seal carrier into the bore until it contacts the wave spring. Lubricate the orings

at the inside diameter and outside diameter of the **labyrinth seal** with motor oil or hose assembly lube. **DO NOT USE GREASE OR SILICONE LUBRICANT** for this step. Press the seal into the bore of the labyrinth seal carrier. Be sure to orient the labyrinth seal with the notch at the bottom. If the pump is to be assembled without the labyrinth seal bearing protector, then the pump-end **bearing spacer** must be installed to take up the room where the labyrinth seal carrier would ordinarily go. After the shaft and bearings are installed into the bearing housing and the bearing cap or SAE bracket is installed, place the wave spring against the outer race of the pump-end bearing. Slide the bearing spacer into the pump-end bore of the bearing housing and up against the wave spring. If an earlier style shaft is used, it will not be necessary to use the pump-end bearing spacer. Again, the earlier shaft can be identified by checking the bearing step at the drive-end of the shaft; if it is wide enough for only one bearing, then this is the older style shaft. Apply a coat of oil or grease to the **pump-end bracket lip seals**. If new bracket lip seals are to be installed, make sure they are pressed into the bracket bore with the lips both faced toward the impeller (tandem arrangement). Press one of the lip seals in from either side of the bracket until it is flush with the face of the bracket bore. Press the second lip seal in from the opposite side until it is either flush with the face of the bracket bore or firmly seated against the first lip seal. Slide the **bracket** over the pump-end of the **shaft**, protecting the lip seals. Check that the **bracket drain plug** is located in the bottom position. Secure the bracket to the **bearing housing** using capscrews and new **bracket capscrew seals**. Newer pumps will not use bracket capscrew seals but, instead, use small **bracket seal o-rings**. If the bracket is a newer style which uses these o-rings it can be identified as such by the presence of o-ring counterbores on the backside of each bracket mounting hole (the side of the bracket that faces the bearing housing). These o-rings are most easily installed by inserting the bracket capscrews through the holes and then sliding the o-rings over the capscrew threads and up against their counterbores. Moving the shaft in both axial directions should produce a total endplay between 0.002" and 0.010". Use **bearing shims** to obtain the proper endplay..

MAINTENANCE

BEARING HOUSING TO DRIVER REASSEMBLY

Figures A2177A

Install the **shaft key** and **flexible coupling hub** onto the pump shaft, but do not secure. Position the bearing housing assembly into its running location and align to the driver as per the alignment section in this manual.

After the **bearing housing** assembly and driver have been aligned, secure the bearing housing assembly to the baseplate, then recheck alignment. Check that the coupling hub is secured to the **shaft** and install the coupling guard.

NOTE: For SAE bracket equipped bearing frames, coupling alignment is attained by simply bolting the bearing frame SAE bracket to the engine bellhousing.

FLYWHEEL COUPLING INSTALLATION / SAE BRACKET EQUIPPED PUMPS

Figure A2184A

Pioneer pumps purchased with SAE brackets and Flywheel couplings are shipped with the coupling mounted to the shaft in the correct axial location for engines with bell housings and flywheels manufactured to SAE standard dimensions.

CAUTION!!!

If the pump is to be mounted to the engine by other than Pioneer Pump, Inc. factory personnel, the assembler must take full responsibility to verify that the pump shaft does not bear against or make any contact with the engine crankshaft or flywheel and that the flywheel coupling is mounted in such a position so as not to transmit any axial thrust to the flywheel. Failure to verify this could result in severe engine damage.

Bolt the aluminum drive ring of the flywheel coupling to the flywheel register, and torque the fasteners (grade 8) to 372 in-lbs. Place the notched key (provided by Pioneer) into the taperlock bushing, and position the rubber element and taperlock bushing on the shaft as shown on illustration A2184A (refer to the preceding caution). Torque the taperlock bushing screws to 430 in-lbs.

MAINTENANCE

BACKPLATE REASSEMBLY

Figure A2521A

With the driver and **bearing housing** assemblies now in their final position, the **backplate** can be installed. Install a new **bracket o-ring** over the register of the **pump-end bracket** and ensure it is against the face of the bracket. Slide the **backplate** over the shaft and secure it to the bracket with capscrews from the bracket side..

SEAL REASSEMBLY

Figure A2520A

Always handle all seal parts with extreme care to prevent damage. Be especially cautious not to contaminate the precision finished mating faces as even fingerprints can shorten seal life. If required, clean the faces with a non-oil based solvent and a clean, lint-free cloth. Use a concentric pattern while wiping to prevent scratching the faces.

Carefully inspect all seal parts for any damage or wear. Any scoring or grooves in the mating faces could cause the seal to leak, so it should be refurbished and mating faces relapped or replaced with a new complete **seal assembly**.

Clean the **shaft** and remove any nicks, cuts or burrs. Lubricate the outside diameter of the **seat o-ring** with 30 wt. to 80 wt. motor oil or hydraulic hose assembly lube and apply a drop of light lubricating oil to the seal faces. Lubricate the seat bore of the **backplate** and ensure it has a chamfer.

Slide the **stationary seat** over the shaft and carefully press into the bore of the **backplate**. Ensure that it is squarely seated into the backplate. Alternately, the seat can be installed into the backplate counterbore before the backplate is installed, but extreme caution will be required

when installing the backplate to avoid bumping the stationary seat against the shaft surface and chipping it. Lubricate the shaft surface and the inside diameter of the rubber bellows. Spray the stationary seal face with penetrating oil to create a film. Now slide the **rotating element** over the **shaft** up to the stationary seat with the polished face (primary ring) of the rotating element toward the polished face of the seat. Slide the spring over the outside of the seal assembly up to the retainer flange.

IMPELLER REASSEMBLY

Figure A2526A

Inspect the **impeller** for any cracks or badly worn areas. Replace if necessary. Install the **impeller key** and slide impeller over the **shaft**. Ensure that the **seal spring** is in place over the outside diameter of the impeller hub. Install the **impeller washer** and **impeller lockscrew** (use #262 red loctite™ on threads of the impeller lockscrew when reinstalling in the shaft) and tighten (See torque specs, page 19). **For impellers that are equipped with “backvanes” rather than a hub wear-ring, use the following procedure:**

With the impeller firmly against the shaft end, measure the gap between the back vanes of the impeller and the face of the **backplate**. Remove the impeller and place **impeller shims** (0.005, 0.010 and 0.015 thick) in the bore of the impeller until the gap is the same as it was when originally removed. Each time the impeller is installed on the shaft make sure the seal spring is in place over the outside diameter of the impeller hub. Once the desired gap between the back vanes and backplate is attained, install the **impeller washer** and **impeller lockscrew** (use #262 red loctite™ on threads of the impeller lockscrew when reinstalling on the shaft) and tighten (See torque specs, page 19).

MAINTENANCE

VOLUTE REASSEMBLY

Figure A2173A

For a one-piece **volute** and suction cover, inspect the **suction wear-ring** and review the wear ring section in this manual if replacement is required. Slide a new **o-ring** over the register of the **backplate**. Make sure the o-ring is up against the face of the backplate flange. Lubricate the o-ring with grease. Position the volute, with the discharge nozzle in the same orientation as the piping, and secure with capscrews.

For separate volute and **suction cover**, check on the wear ring section in this manual for replacement, if required. Place a new **o-ring** over the register of the suction cover, lubricate with grease and seat it against the cover face. Secure to **volute** with appropriate capscrews.

DISCHARGE CHECK VALVE REASSEMBLY

Figures A2170A

Refer to the **discharge check valve** parts illustration if any repairs are to be made. Install the **gasket** and secure to the discharge nozzle with bolts and nuts. Ensure that the check valve is installed for the correct flow direction.

PRIMING CHAMBER REASSEMBLY

Figure 10045A

Refer to the **Priming Chamber / Valve** section if any repairs or adjustments are required. Install the gasket and use nuts and bolts to attach the priming chamber, with spool, to the suction flange of the pump.

MAINTENANCE

LUBRICATION – BEARING FRAME

The lubrication of the ball bearings will depend on speed, load, ambient temperature, contamination, moisture, intermittent or continuous service and other factors. These regreasing recommendations are general in nature and are to be used with good judgment and consideration of the pump service. The following is a suggested lubrication interval chart:

Pioneer Frame Size	2200 RPM	1800 RPM	1200 RPM
8.5 AK Frame	5,000 hrs.	7,500 hrs.	10,000 hrs.
12.5 AK Frame	2,500	3,500	5,000

To lubricate the ball bearings, remove the plastic covers from the zerk fittings. Ensure that the zerk fitting and the end of the grease gun are clean. Use only a hand-operated grease gun with ball bearing grease as shown below, or equal:

Texaco Starplex Moly 2
Mobile Mobilux No. EP2
Shell Alvania EP2
Chevron SRI

An oil level gauge is attached to the bearing frame and marked at the factory for proper oil level. ISO viscosity grade 32 turbine oil is installed at the factory. This oil is suitable for a wide range of temperatures. However, during operation temperature measurements should be taken on the bearing frame at the oil sump location. If the indicated temperature is greater than 160°F then the oil should be changed to an ISO viscosity grade 68 turbine oil at the next maintenance interval. Oil should be changed approximately every three months of continuous operation.

LUBRICATION – SEAL OIL RESERVOIR

See Figure A2173A / A2143A

This pump is provided with a seal oil reservoir that permits this unit to run dry. The reservoir supplies lubrication and cooling to the outboard side of the mechanical seal without any liquid in the pump. Monitor the oil level sight gauge and add oil as indicated. During normal operation it is suggested to change this oil every three (3) months. If the sight gauge shows indications of contamination or discoloration, then change oil more frequently. Use turbine oil with an ISO rating of 32 or lower. If you have unusual pumping conditions consult **Pioneer Pump, Inc.** Fill and/or drain the oil by removing the bracket plugs. Oil used in the reservoir should be ISO VG 32 Turbine Oil or Automatic transmission oil, equivalent to one of the

following manufacturer's products:

Chevron Turbine oil GST 32

Mobile DTE 797

Shell Turbo T oil 32

MAINTENANCE

TORQUE VALUES FOR FASTENERS

SIZE UNC	MATERIAL		
	304 SS	GRADE 5 BOLTS	GRADE 8 BOLTS
¼	3.0 lb-ft	9 lb-ft	13 lb-ft
5/16	7.0 lb-ft	19 lb-ft	27 lb-ft
3/8	13 lb-ft	34 lb-ft	48 lb-ft
7/16	20 lb-ft	54 lb-ft	77 lb-ft
1/2	31 lb-ft	83 lb-ft	117 lb-ft
9/16	45 lb-ft	120 lb-ft	170 lb-ft
5/8	63 lb-ft	165 lb-ft	234 lb-ft
3/4	112 lb-ft	293 lb-ft	415 lb-ft
7/8	180 lb-ft	474 lb-ft	670 lb-ft
1	270 lb-ft	710 lb-ft	1000 lb-ft
1 1/4	540 lb-ft	1421 lb-ft	2000 lb-ft

The above values are general in nature. If a grade 2 or 5 capscrew is threaded into stainless steel, use the lower value i.e. 304 stainless.

PARTS ORDERING

When ordering parts from **Pioneer Pump, Inc.** please provide the following information:

- 1) Pump serial number
- 2) Pump model
- 3) Cross section drawing number
- 4) Part number from cross section drawing
- 5) Description of part
- 6) Quantity required
- 7) Package VIN (Vehicle Identification Number)

SPARE PARTS

Spare parts should be kept on hand to reduce downtime. Service of a particular pump determines the quantity and range of spares. At a minimum the following parts should be stocked.

Suction wear ring

All O-rings

Set of bearings

Mechanical seal

Set of grease seals

If you have unusual pumping conditions, consult **Pioneer Pump, Inc.** for additional recommended spare parts

TROUBLESHOOTING

Symptom	Possible Causes	Symptom	Possible Causes
No Discharge	1,2,3,4,5,7,8,9,10,17,18,19,20,37	Vibration and noise	2,4,9,10,14,15,17,26,27,28,29,30,31,32,33,34,35,36,39,40,41,42,43,44,48
Reduced Capacity	2,3,4,5,7,8,9,10,11,17,19,20,21,38,39,40,47	Seal: excessive leakage, short life, seal housing overheating	22,23,25,33,34,35,36,41,44,45,46
Reduces Pressure	5,7,8,11,13,18,19,38,39,40,47	Bearings: over heating, short life, noise	26,27,28,29,30,31,32,33,34,35,36,41,42,43,44
Loss of Prime	2,3,4,7,10,11,20,21,22,23	Pump overheating, seizes	1,8,9,14,33,34,35,36,41,42,43,44
Power consumption excessive, driver runs hot	6,12,13,17,18,19,24,33,34,35,36,37,38,41,42,43,44	Corrosion, erosion, pitting, oxidation or other loss of material	7,8,11,14,15,16

- | | | |
|---|--|---|
| 1. Pump not primed | 19. Low speed | 39. Impeller damage |
| 2. Suction line not filled | 20. Air leak into suction line | 40. Improper balance (after repair) |
| 3. Air pocket in suction line | 21. Air leak through mechanical seal | 41. Bent shaft |
| 4. Suction inlet or foot valve obstructed, insufficiently submerged, or too small | 22. Seal fluid contaminated, hot or insufficient | 42. Excessive thrust |
| 5. System head higher than pump design head | 23. Seal fluid system not vented | 43. Rotational element dragging |
| 6. System head lower than pump design head | 24. High speed | 44. Worn or incorrectly installed bearings |
| 7. Insufficient NPSH | 25. Mechanical seal insufficient | 45. Mechanical seal not properly set, O-rings damaged or hardened |
| 8. Parallel pump application is incorrect | 26. Bearing housing excessively cooled | 46. Shaft scored at seal |
| 9. Suction pressure to vapor pressure below minimum | 27. Low oil pressure (oil lube bearings) | 47. Volute O-ring |
| 10. Suction lift too high | 28. Improper or poor lubrication | 48. Foundation not rigid or settled |
| 11. Excess vapor in pumpage | 29. Lubrication defective | |
| 12. Specific gravity of pumpage different than design | 30. Dirt in lubrication/bearings | |
| 13. Viscosity of pumpage different than design | 31. Moisture in lubricant/bearing housing | |
| 14. Operation at below rated capacity | 32. Lubricant excess | |
| 15. Cavitation | 33. Pipe strain | |
| 16. Electrolysis | 34. Temperature growth | |
| 17. Impeller obstructed with foreign material | 35. Misalignment | |
| 18. Rotation direction wrong | 36. Coupling improperly installed | |
| | 37. Impeller installed backwards | |
| | 38. Worn wear rings | |

STORAGE

This is adequately prepared for outside storage prior to shipment, but use the following list of additional suggestions for extended storage.

- 1) Store the unit off the ground so no water will accumulate around the equipment.
- 2) Protect unit from blowing sand and dirt.
- 3) Stack no other items on top of pump/equipment.
- 4) Protect unit from the entry of any animals.
- 5) Periodically rotate shaft to lubricate bearings and protect bearings from brinelling.
- 6) Protect unit with approved drying agents.
- 7) Ensure all bare metal areas are coated with a rust preventive.
- 8) Inspect unit every four (4) weeks and replace drying agents (Silica Gel) as required or a minimum of ever six (6) months.
- 9) Keep an inspection record showing dates of inspection with any maintenance performed and condition of drying agents.
- 10) Before installation ensure that all rust protection has been removed. Also, remove any foreign material that may have accumulated during storage.
- 11) Before installation remove all drying agents (Silica Gel).

CONDITIONS AND TERMS OF SALE

CONTROLLING PROVISIONS: These terms and conditions shall control with respect to any purchase order or sale of Seller's products. No waiver, alteration or modification of these terms and conditions whether on Buyer's purchase order or otherwise shall be valid unless the waiver, alteration or modification is specifically accepted in writing and signed by an authorized representative of Seller.

DELIVERY: Seller will make every effort to complete delivery of products as indicated on Seller's acceptance of an order, but Seller assumes no responsibility or liability, and will accept no backcharge, for loss or damage due to delay or inability to deliver caused by acts of God, war, labor difficulties, accident, delays of carriers, by contractors or suppliers inability to obtain materials, shortages of fuel and energy, or any other causes of any kind whatever beyond the control of Seller. Seller may terminate any contract of sale of its products without liability of any nature, by written notice to Buyer, in the event that the delay in delivery or performance resulting from any of the aforesaid causes shall continue for a period of sixty (60) days. Under no circumstances shall Seller be liable for any special or consequential damages or for loss, damage, or expense (whether or not based on negligence) directly or indirectly arising from delays or failure to give notice of delay.

SELLER'S LIABILITY: Seller will not be liable for any loss, damage, cost of repairs, incidental or consequential damages of any kind, whether based upon warranty (except for the obligation accepted by Seller under "Warranty" above), contract or negligence arising in connection with the design, manufacture, sale, use or repair of the products or of the engineering designs supplied to Buyer.

RETURNS: Seller cannot accept return of any products unless its written permission has been first obtained, in which case same will be credited subject to the following: (a) All material returned must, on its arrival at Seller's plant, be found to be in first-class condition; if not, cost of putting in saleable condition will be deducted from credit memoranda. (b) A handling charge deduction of twenty percent (20%) will be made for all credit memoranda issued for material returned. (c) Transportation charges, if not prepaid, will be deducted from credit memoranda.

CANCELLATION OR ALTERATION: Cancellation or unless made in writing within ten (10) days of receipt of a shipment. Claims for products damaged or lost in transit should

alteration of an order by Buyer may not be made without advance written consent of Seller and shall be subject to a cancellation charge. The cancellation charge will be a minimum of fifteen percent (15%) or actual cost incurred by Seller at the time of cancellation or alteration, whichever is greater.

SHIPMENTS: All products sent out will be carefully examined, counted and packed. The cost of any special packing or special handling caused by Buyer's requirements or requests shall be added to the amount of the order. No claim for shortages will be allowed

SPECIAL PRODUCTS: Orders covering special or non-standard products are not subject to cancellation except on such terms as Seller may specify on application.

QUOTATIONS: All quotations are subject to approval, acceptance and correction at the home office. Any errors in quotations resulting in orders will be corrected and re-submitted to the customer for their acceptance or refusal. All quotations are valid for 45 days from the date on the quotation.

PRICES AND DESIGNS: Prices and designs are subject to change without notice. All prices are **F.O.B. Point of Shipment**, unless otherwise stated.

TAXES: The amount of any sales, excise or other taxes, if any, applicable to the products covered by this order, shall be added to the purchase price and shall be paid by Buyer unless Buyer provides Seller with an exemption certificate acceptable to the taxing authorities.

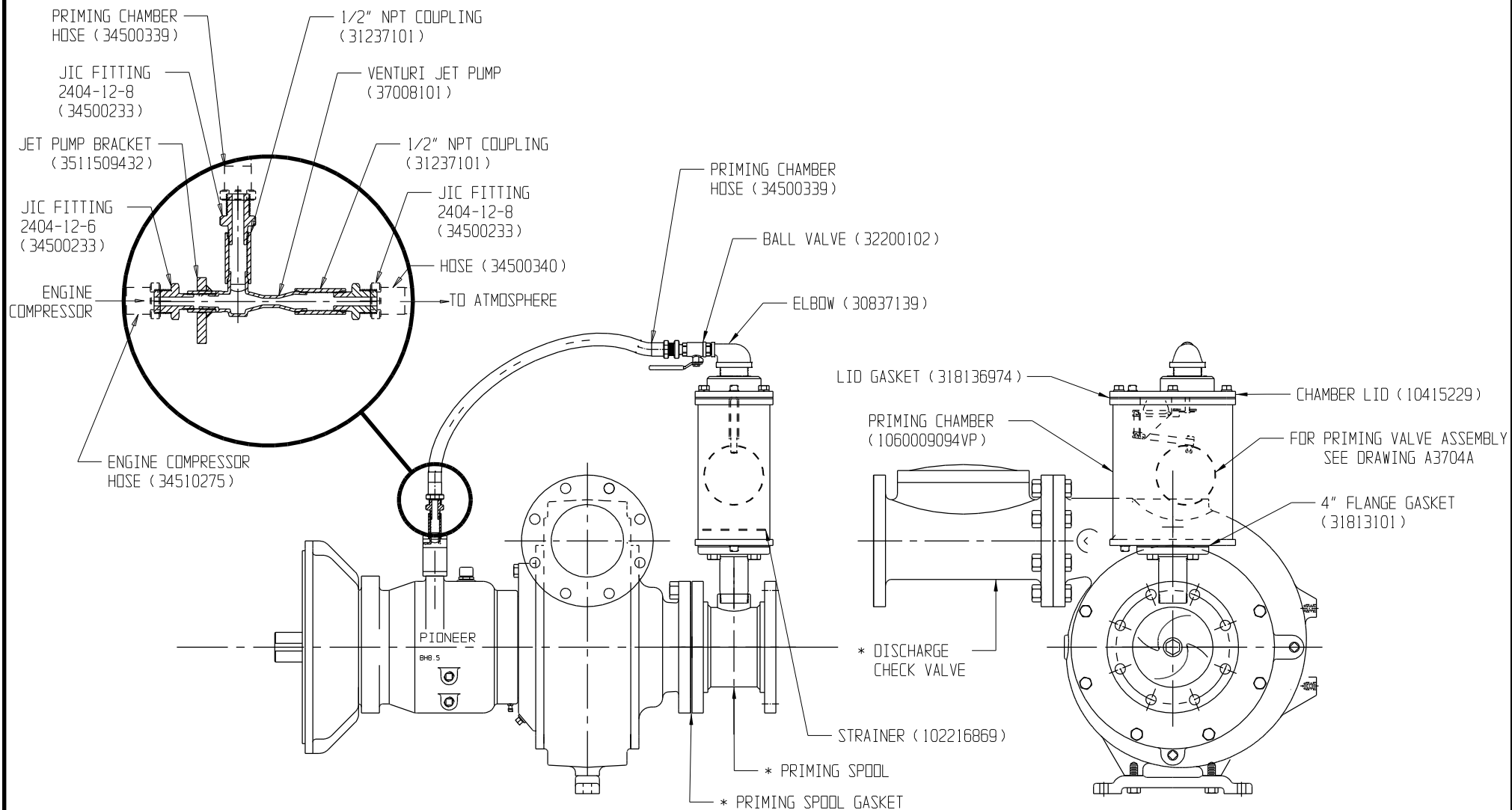
TERMS OF SALE: For value received, Buyer agrees to honor all terms of the sale, as outlined on the reverse hereof, including, but not limited to the following:

- ◆ 3% 10, net 30 days unless otherwise specified in writing.
- ◆ Buyer agrees and understands that payments will be considered past due if payment is not received within thirty (30) days of the invoice date.
- ◆ Buyer agrees that all past due payments shall bear interest at the rate of 1.5% per month (18% per annum) until paid in full.
- ◆ Buyer agrees that it is the intention of Buyer and Seller to conform strictly to all usury laws now in force and effect in the state of purchase.
- ◆ Buyer further agrees not to suffer or permit any charge, lien, security interest, adverse claim or encumbrance of any and every nature whatsoever against the equipment until the indebtedness secured thereby is satisfied in full.
- ◆ Minimum invoice amount will be no less than \$25.00 plus transportation.

USE OF EQUIPMENT: Buyer agrees to maintain and use the equipment solely in the conduct of its own business, in a careful and proper manner, and in conformity with all applicable permits, licenses, statutes, ordinances, regulations and laws.

INSURANCE: Buyer shall have and maintain at all times with respect to all equipment insuring against risk of fire, theft and other risks as Seller may require, until the indebtedness secured thereby is satisfied in full.

be made on the carrier, as Seller's responsibility ceases, and title passes, on delivery to the carrier.



NOTE:

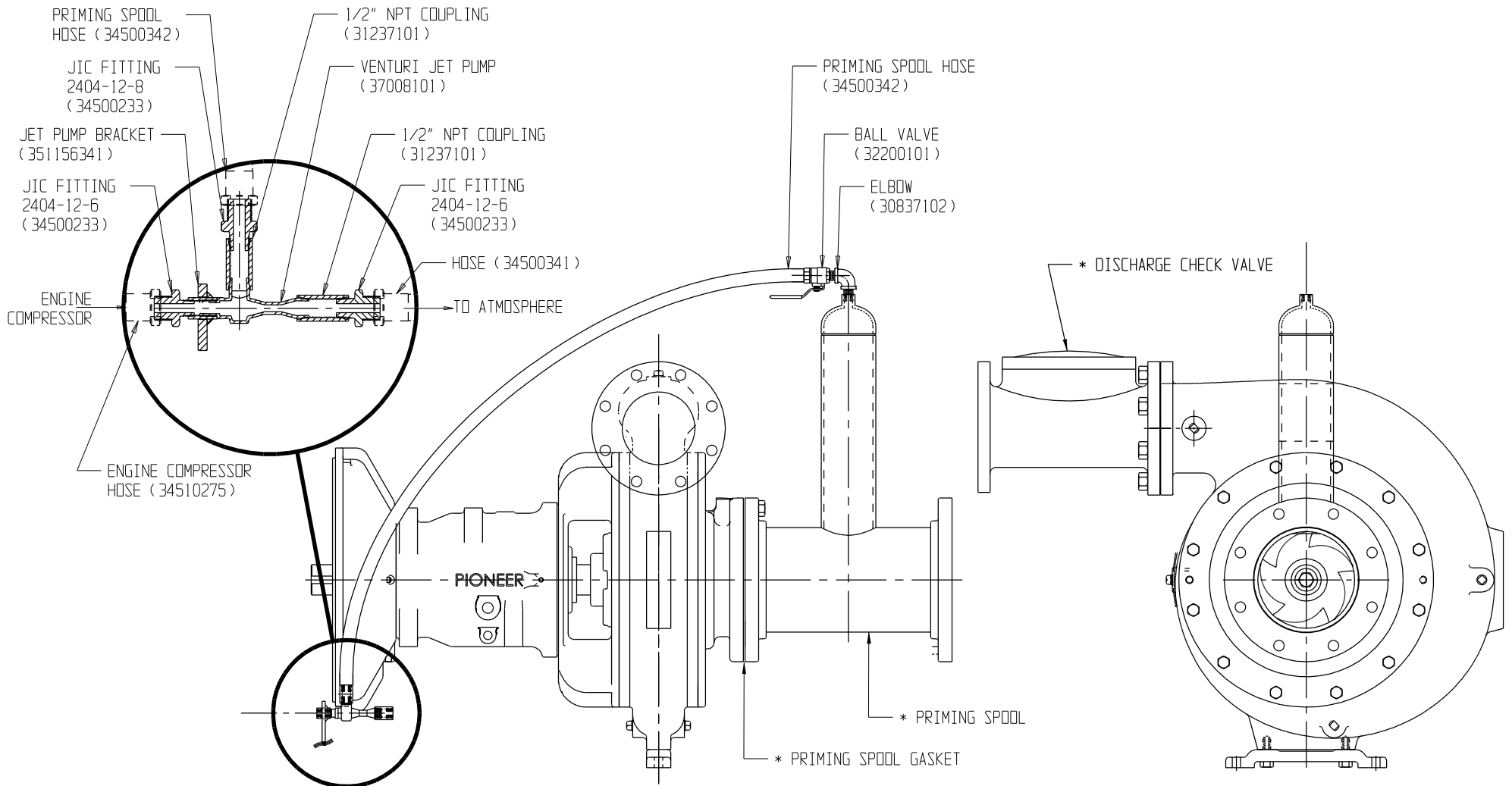
- PIONEER PUMP PART NUMBERS IN ()
- * CONTACT PIONEER PUMP FOR DIFFERENT SIZES



PIONEER PUMP
PERFORMANCE THROUGH INNOVATION™

MODEL: VENTURI PRIMING COMPONENTS
WITH POSIVALVE

DWG NO. 10039A
REVISION: 001
DRAWN BY: ESW
DATE: 7/22/2011



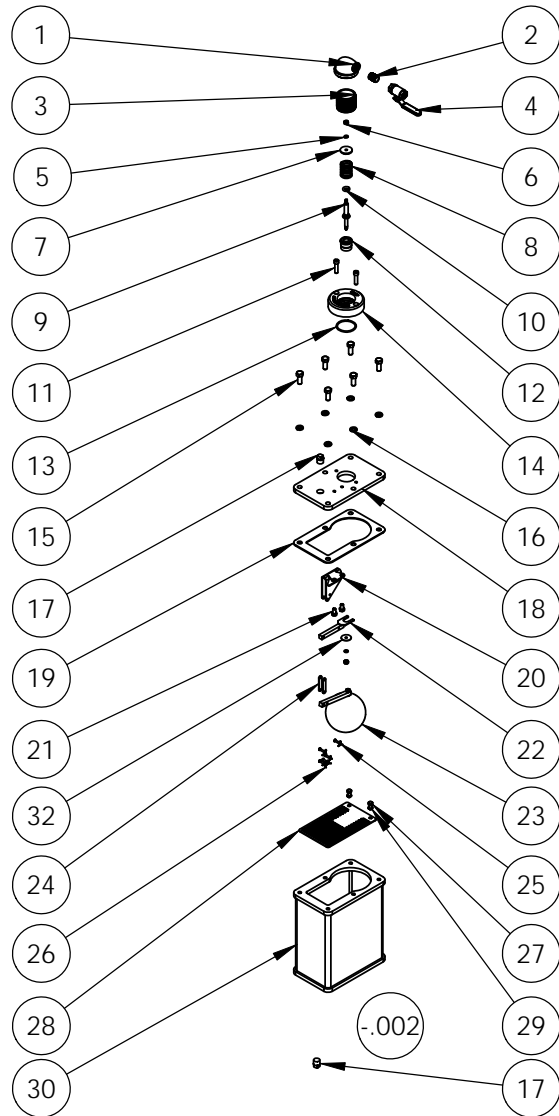
NOTE:

- PIONEER PUMP PART NUMBERS IN ()
- * CONTACT PIONEER PUMP FOR DIFFERENT SIZES



MODEL: VENTURI PRIMING COMPONENTS
WITHOUT POSIVALVE

DWG NO. 10040A
REVISION: 001
DRAWN BY: ESW
DATE: 7/22/2011



ITEM NO.	PART NUMBER	Description	QTY.
1	30837139	ELBOW 2" X 1/2" NPT 90°	1
2	30637301	NIPPLE 1/2" NPT x CLOSE	1
3	30638339	NIPPLE 2.0" NPT x CLOSE	1
4	32200101	VALVE 1/2" BRONZE BALL	1
5	37821208	WASHER SPLIT LOCK .25 304SS	2
6	37721204	NUT HVY MACHINE .25-20 304SS	2
7	10621597	VALVE WASHER	1
8	33021108	SPRING 2" LONG x 1.46 OD	1
9	10621799	VALVE STEM 304SS	1
10	30103310	O-RING 2-310 VITON	1
11	37621038SC0150	BOLT SOC HD .38-16UNC x 1.5 304SS	2
12	10621800	VALVE SEAT	1
13	30103228	O-RING 2-228 VITON	1
14	106042033	VALVE ADAPTER	1
15	32632050C125	BOLT .50-13UNC x 1.25 G5 PL	6
16	32839401	WASHER SPLIT LOCK .50 STLPL	6
17	31138103	NPT PIPE PLUG, SQUARE HEAD, 1/2"	2
18	104157207	LID FOR PRIMING CHAMBER (COMPACT)	1
19	318136974	LID GASKET, PRIMING CHAMBER	1
20	10621594	LINKAGE BRACKET 304SS	1
21	37621038C062	BOLT .38-16UNC x .63 304SS	2
22	10621595	LINKAGE UPPER ARM	1
23	1060008527	FLOAT BALL AND ARM FOR COMPACT PRIMING CHAMBER	1
24	10621605	LINK UPPER & LOWER ARM	2
25	33021101	CLEVIS PIN .187 DIAx1.0 304SS	5
26	33021102	COTTER PIN .094 DIAx.50 304SS	5
27	37621031C075	BOLT .31-18UNC x .75	2
28	102216896	STRAINER PLATE, PRIMING CHAMBER	1
29	37821213	WASHER SPLIT LOCK .31 304SS	2
30	103156969	PRIMING CHAMBER	1
32	37821209	WASHER FENDER .25 x1.25OD 304S	1

JAW	-.002	REMOVED BOTTOM FLANGE, GASKET, & NIPPLE	5/11/2011
JAW	-.001	CORRECTED BALL VALVE DIRECTION	4/30/2011
JAW	-.000	INITIAL CHECK IN	3/11/2011
BY	REV.	DESCRIPTION	DATE

REVISIONS

TITLE:

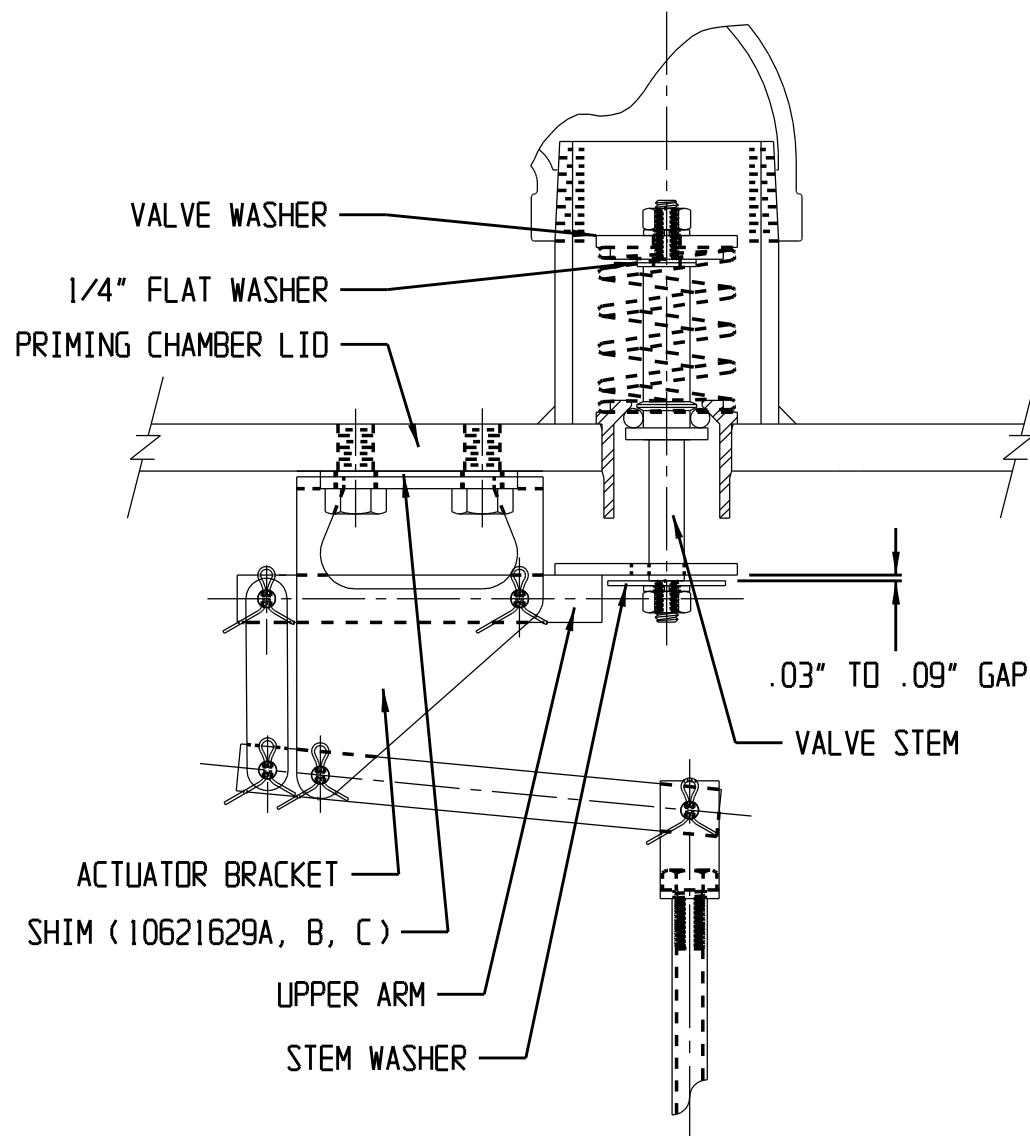
PARTS PAGE, COMPACT PRIMING CHAMBER VENTURI PRIME

WEIGHT:	NAME	DATE	SIZE	DWG. NO.	REV.
DRAWN BY	JAW	6/27/2011	A	09094A-VP	-.002
CHECKED BY	XXX	X/X/XXXX	SCALE: 1:24	DO NOT SCALE DRAWING	SHEET 1 OF 1

PROPRIETARY AND CONFIDENTIAL

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF **PIONEER PUMP, INC.** ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF **PIONEER PUMP, INC.** IS PROHIBITED.





ADJUSTMENT INSTRUCTIONS:

WITH THE FORKED PORTION OF THE UPPER ARM PARALLEL TO THE STEM WASHER, THE GAP BETWEEN THEM SHOULD BE .03" - .09".

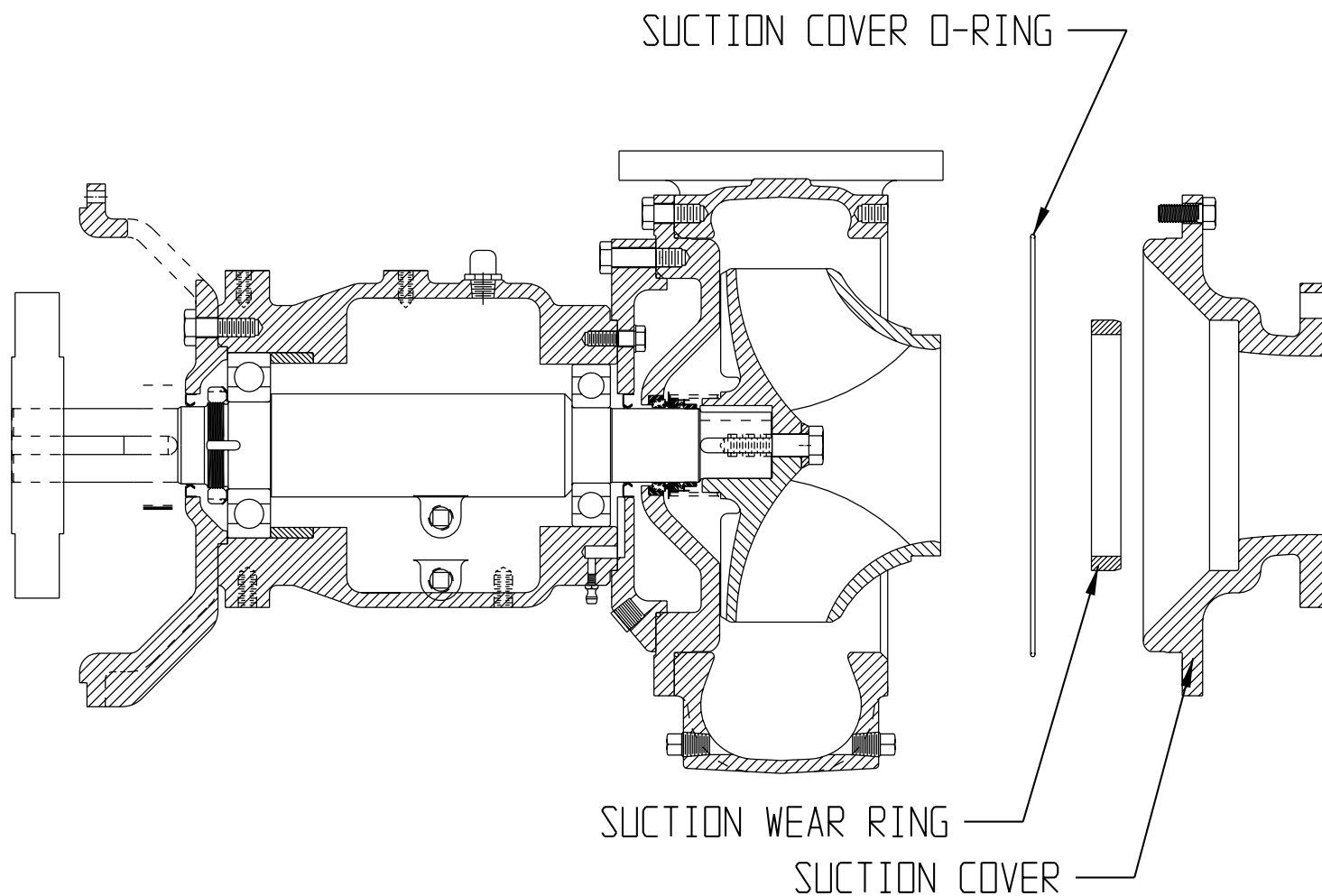
IF THIS GAP IS TOO LARGE, PLACE A SHIM BETWEEN THE ACTUATOR BRACKET AND THE PRIMING CHAMBER LID.

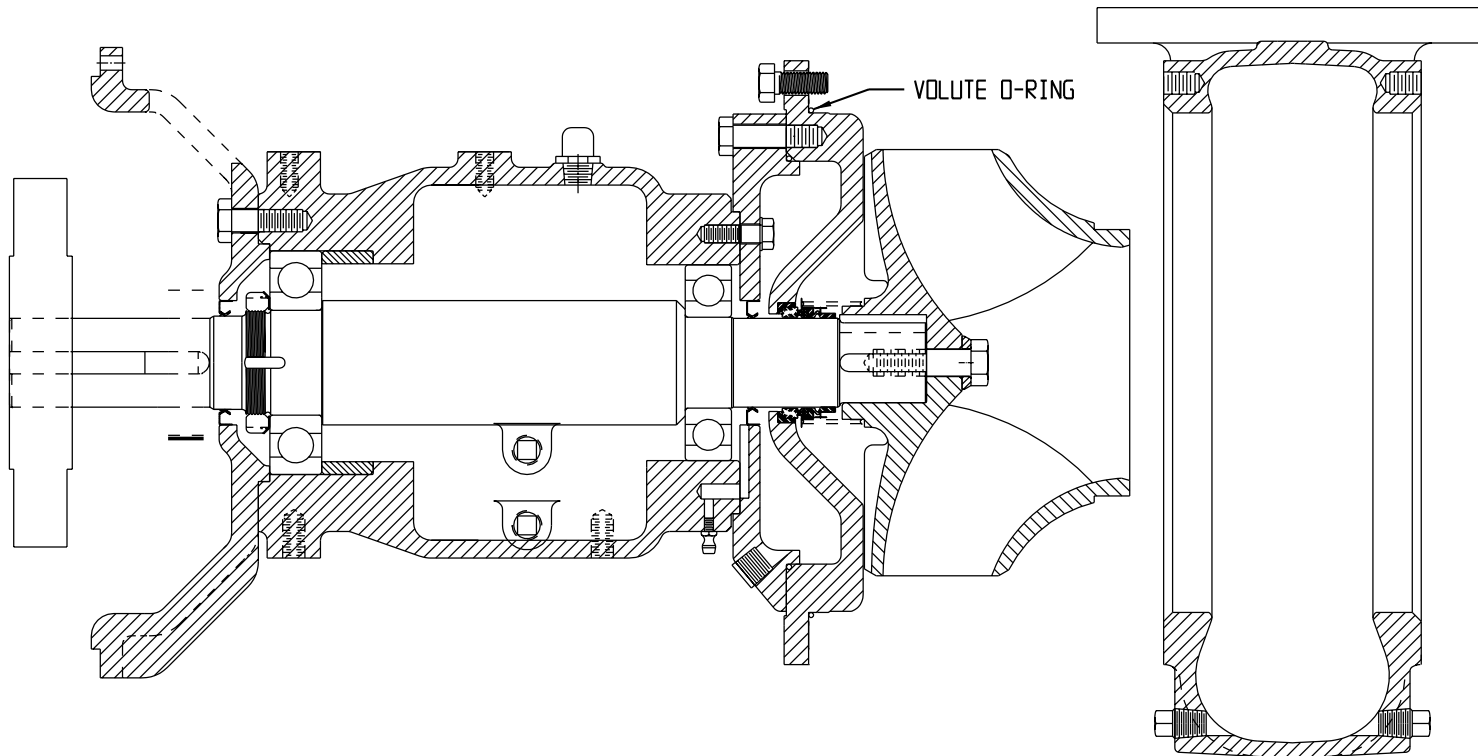
- (10621629A = 10 GAGE SHIM = .125" THICK),
- (10621629B = 16 GAGE SHIM = .062" THICK),
- (10621629C = 12 GAGE SHIM = .099" THICK)

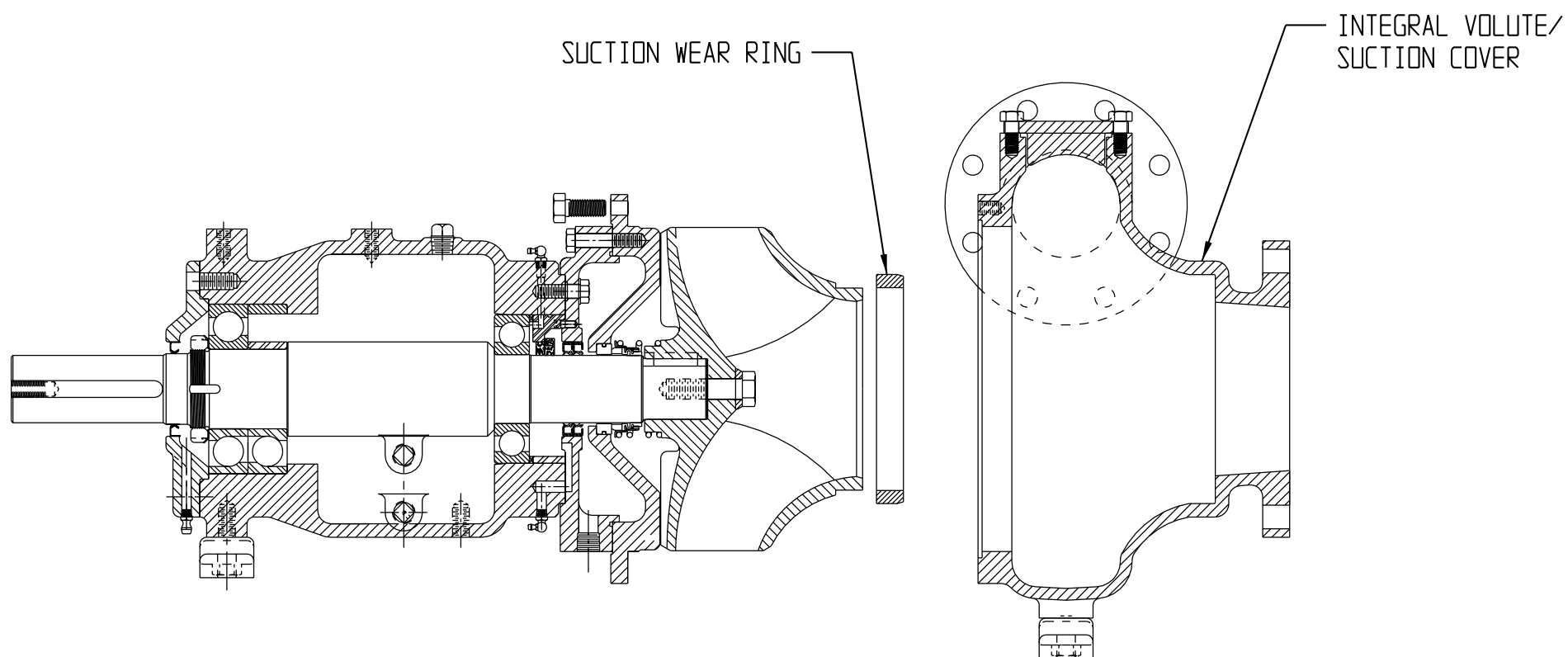
THIS WILL LOWER THE BRACKET AND REDUCE THE GAP ALLOWING THE VALVE TO OPEN UP AS NECESSARY TO DRAW A VACUUM MORE EFFICIENTLY.

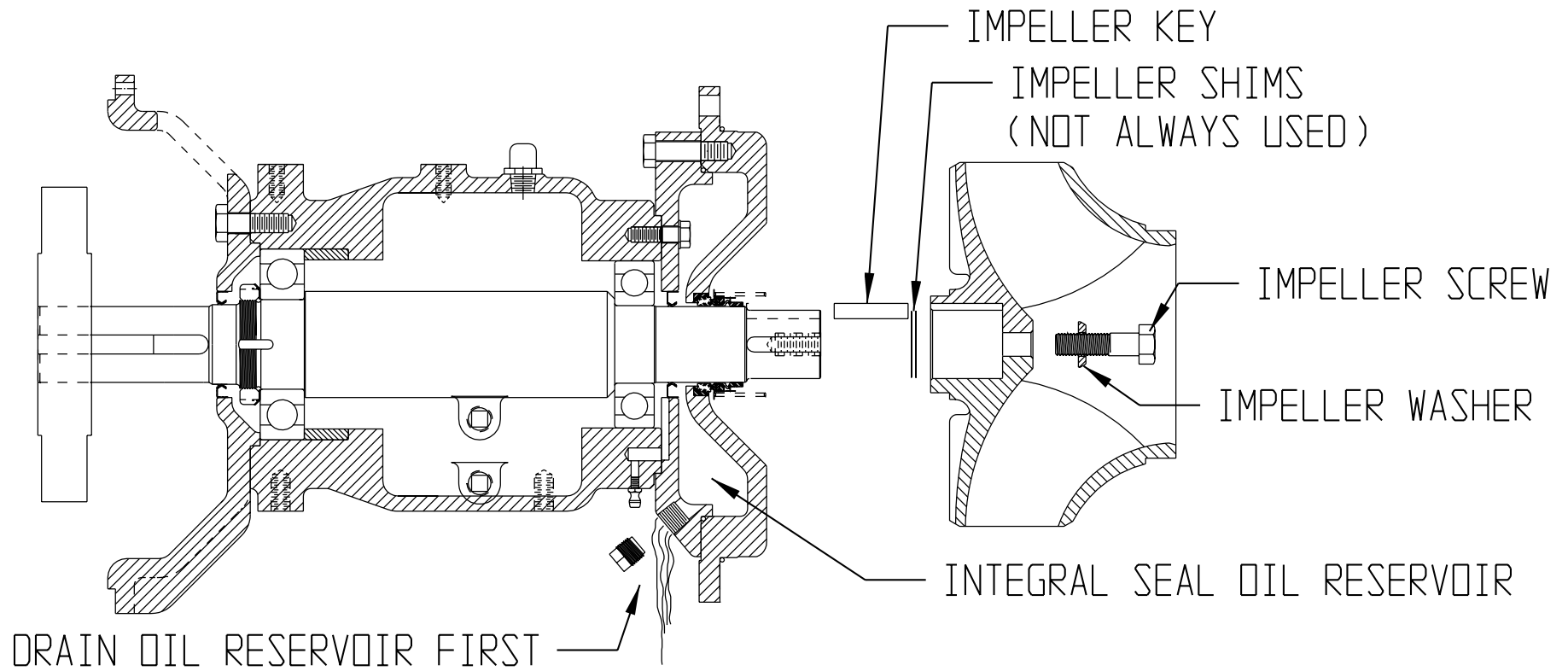
NOTE: THERE HAVE BEEN SOME CASES WHERE THE VALVE HAS STILL FAILED TO OPEN PROPERLY WHEN THE GAP IS SHIMMED CORRECTLY. AT THIS POINT THE SPRING TENSION NEEDS TO BE REDUCED, THIS DONE BY ADDING ONE OR TWO 1/4" STAINLESS FLAT WASHERS (32821201) BETWEEN THE STEM AND VALVE WASHER.

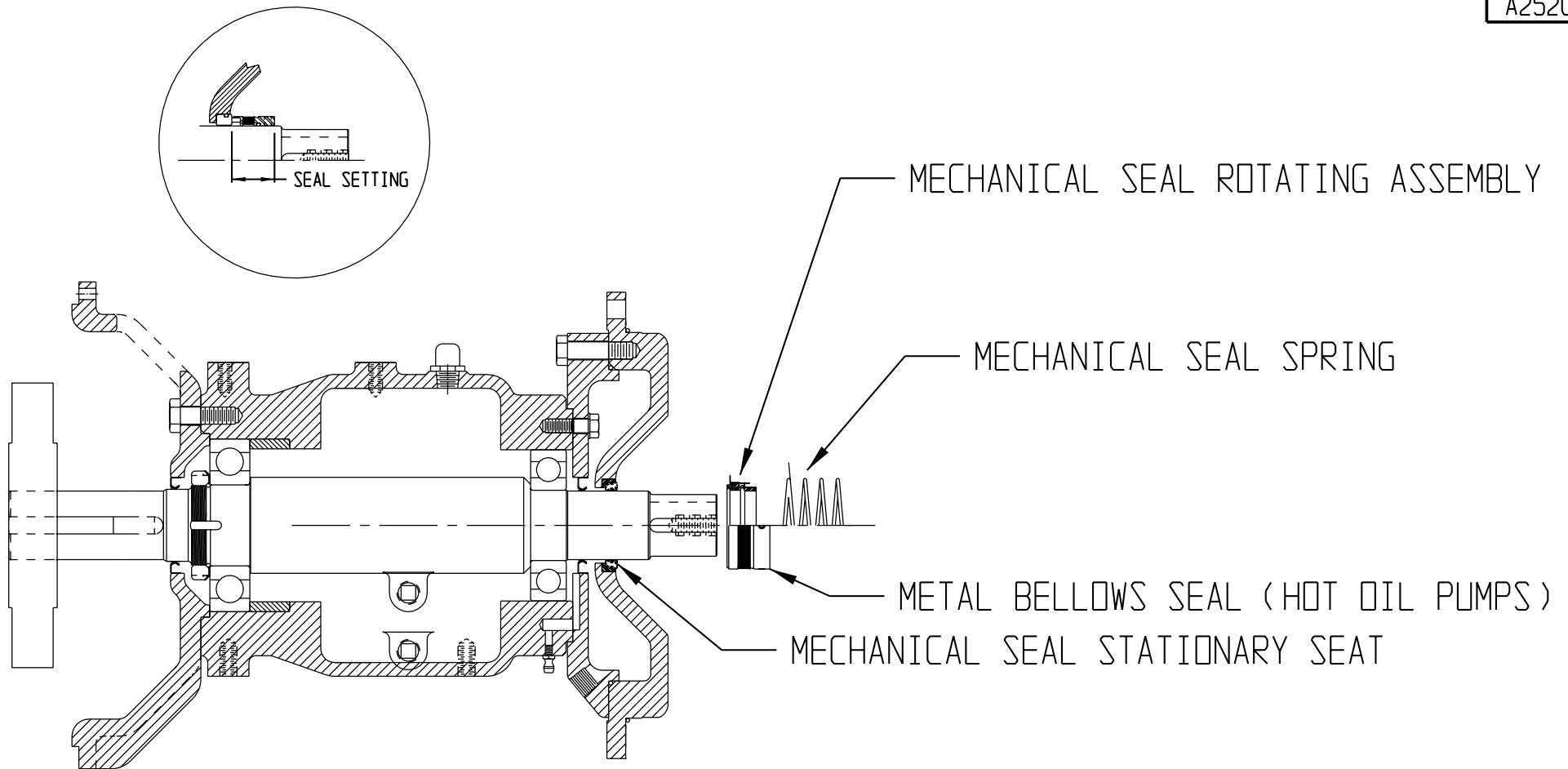


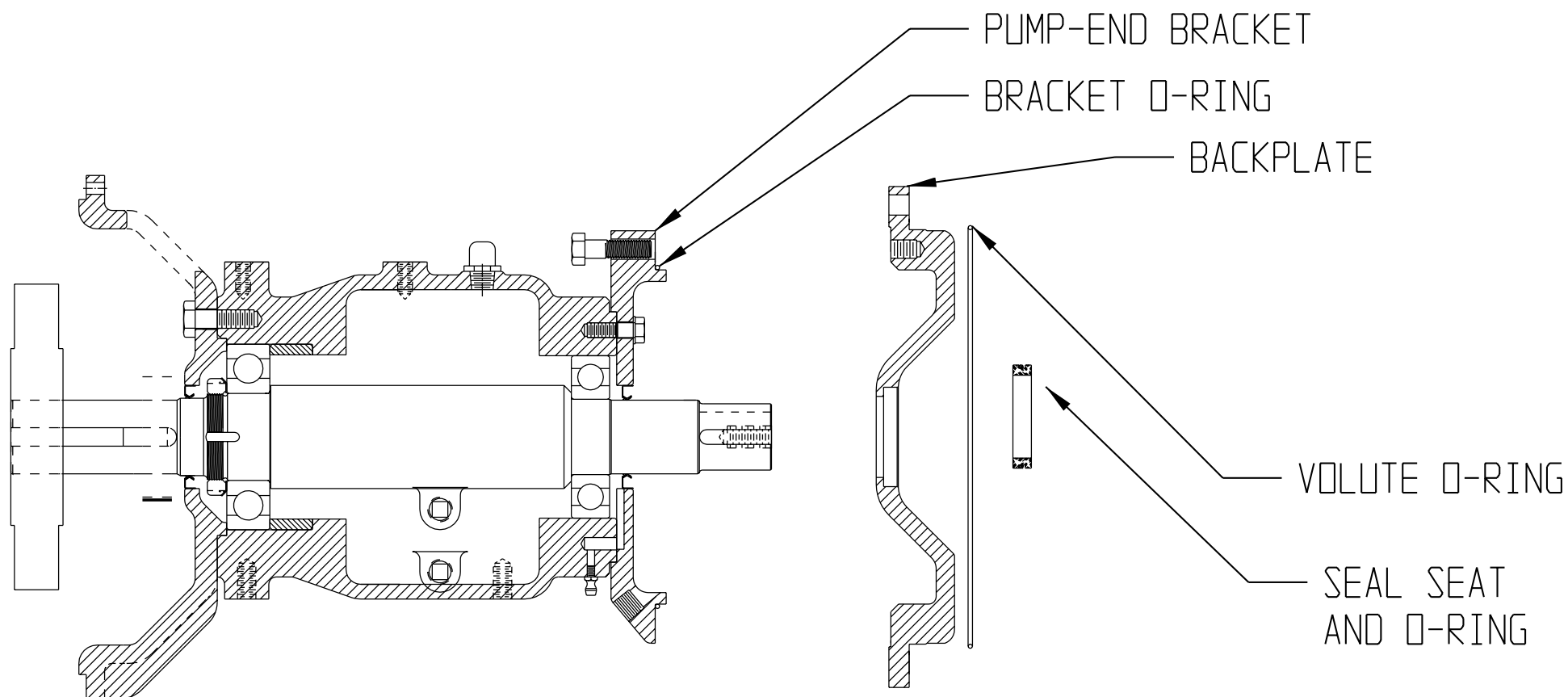


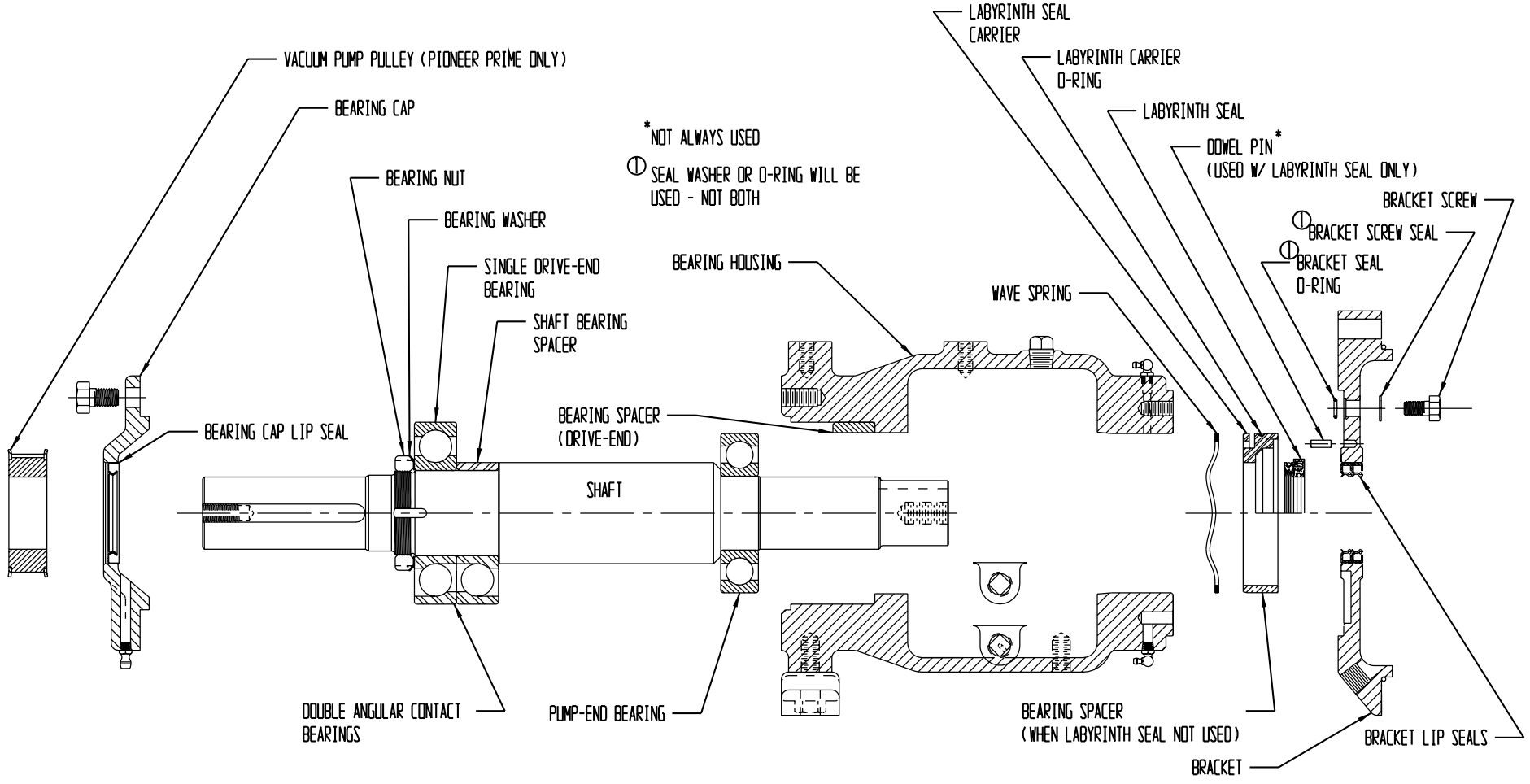


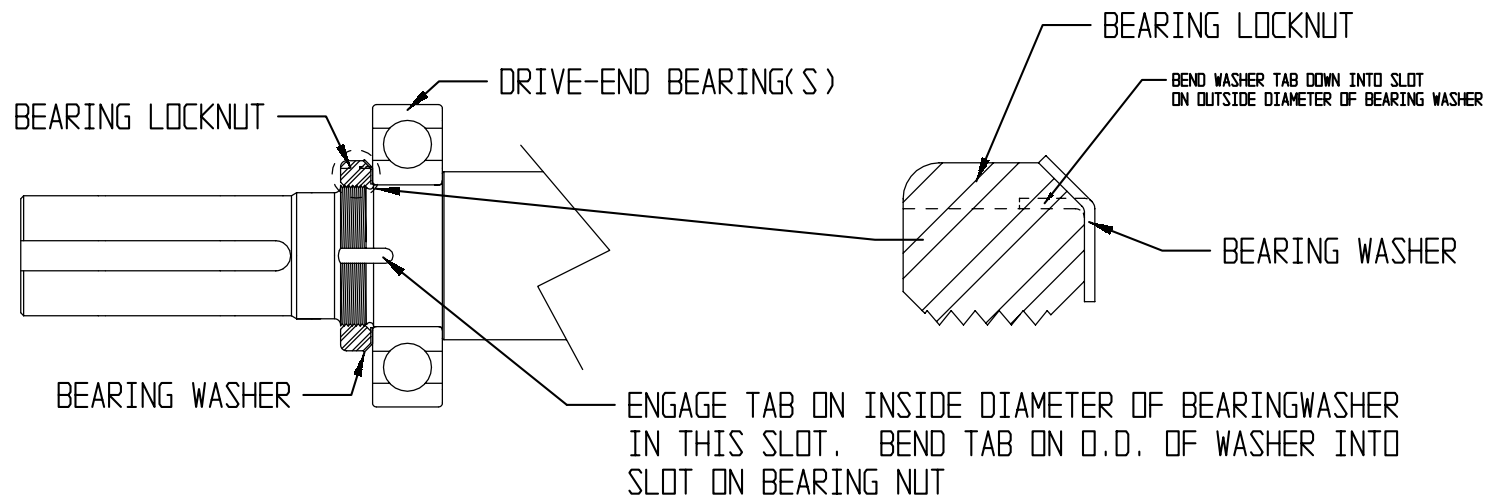












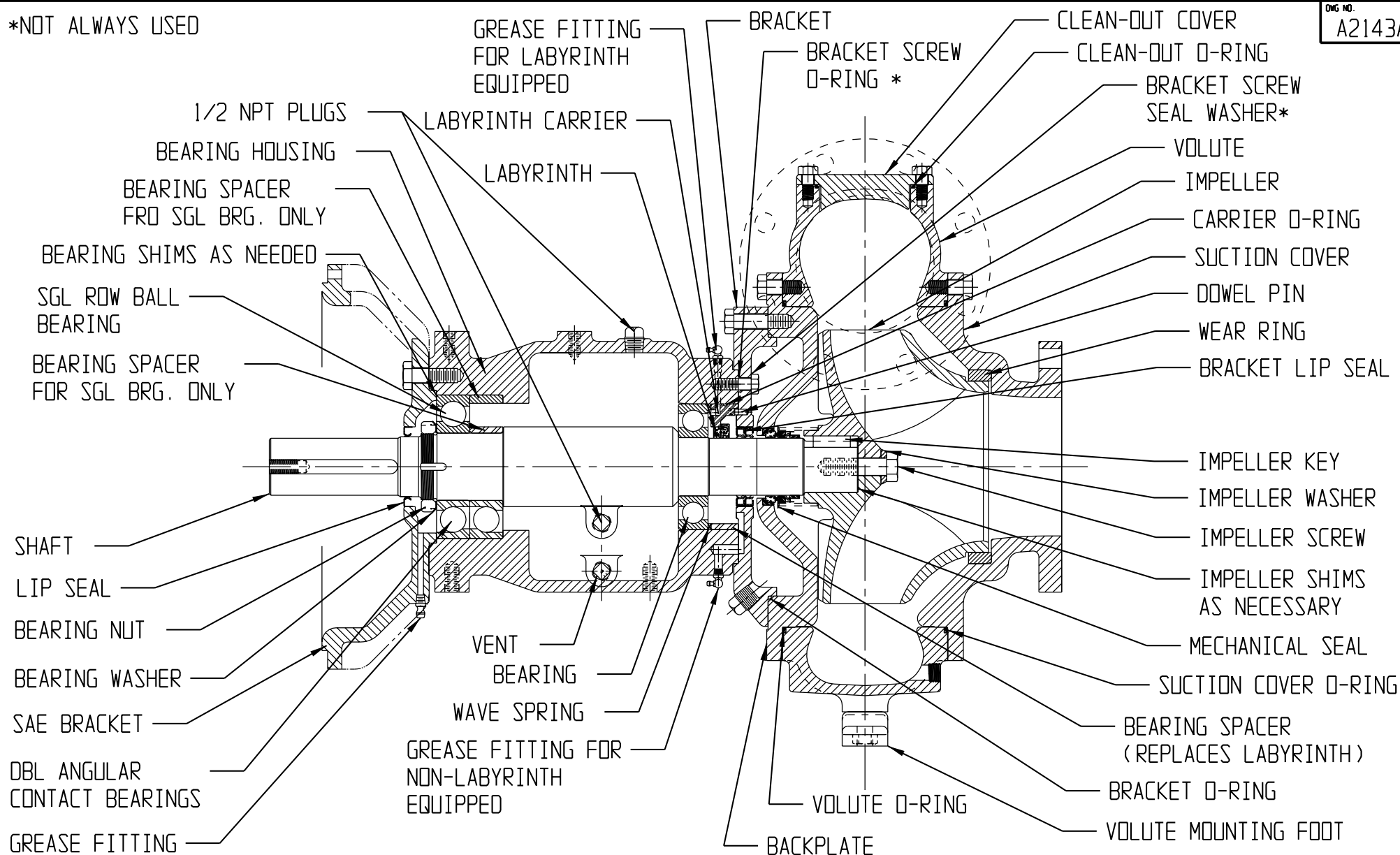
REFERENCE DRAWINGS
PATTERN DWG.
MACHINE DWG.
HYDRAULIC DWG.
PATTERN NO.

DRAWING CONTAINS PROPRIETARY DATA
NO DISCLOSURE WITHOUT WRITTEN
AUTHORIZATION FROM PIONEER PUMP, INC.

TOLERANCES EXCEPT WHEN OTHERWISE SPECIFIED	REV. NO.	REVISION	DATE
.XXX = $\pm .003$.XX = $\pm .010$.X = $\pm .03$			
ANGLES = $\pm 1^\circ$ MAX MACH R. .03			
MANUAL ILLUSTRATION - DRIVE-END BEARING ASSEMBLY			
DR. BC	CHECKED	DATE 8/19/02	SCALE 1/4
PIONEER PUMP, INC. - CANBY, OREGON			DWG NO. A2055M

*NOT ALWAYS USED

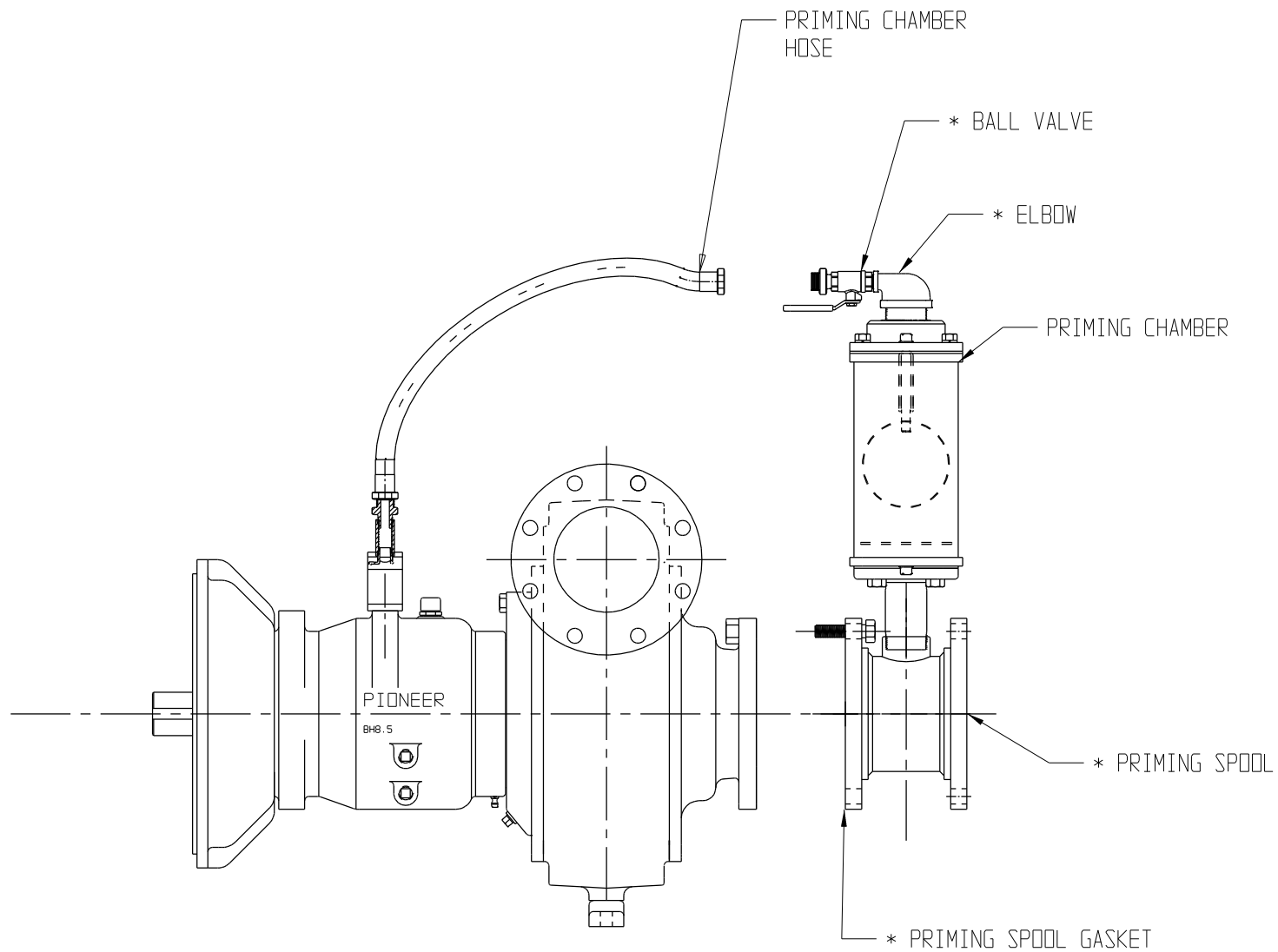
ENG. NO.
A2143A



PIONEER PUMP, INC.

TYPICAL ENCLOSED BRACKET PUMP - SAE

ENG. NO.
A2143A



NOTE:

- PIONEER PUMP PART NUMBERS IN ()
- * CONTACT PIONEER PUMP FOR DIFFERENT SIZES

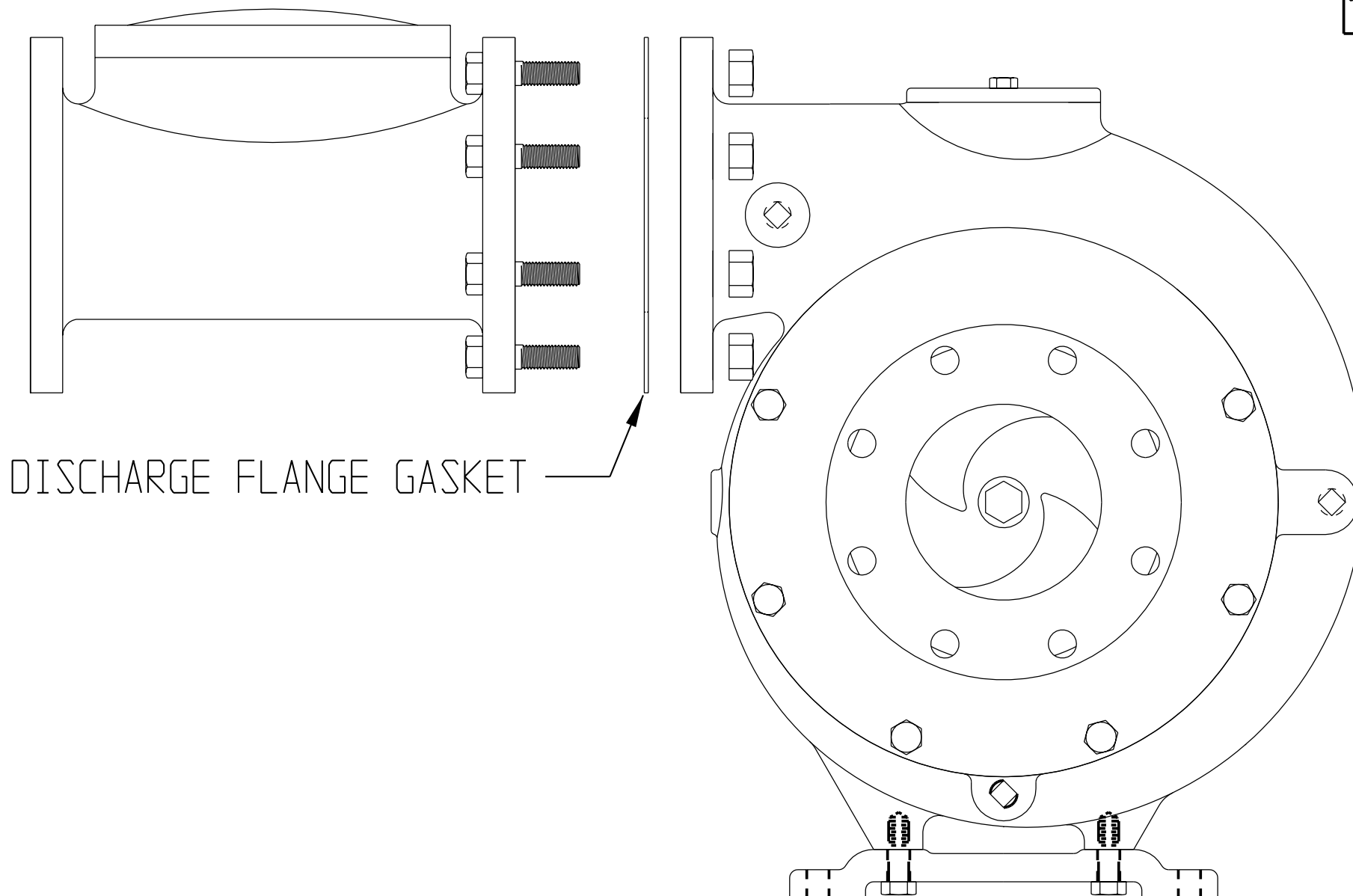


PIONEER PUMP
PERFORMANCE THROUGH INNOVATION™

REMOVING PRIMING CHAMBER & SPOOL

DWG NO. 10045A
REVISION: 000
DRAWN BY: ESW
DATE: 7/24/2011

DWG NO.
A2170A



PIONEER PUMP, INC.

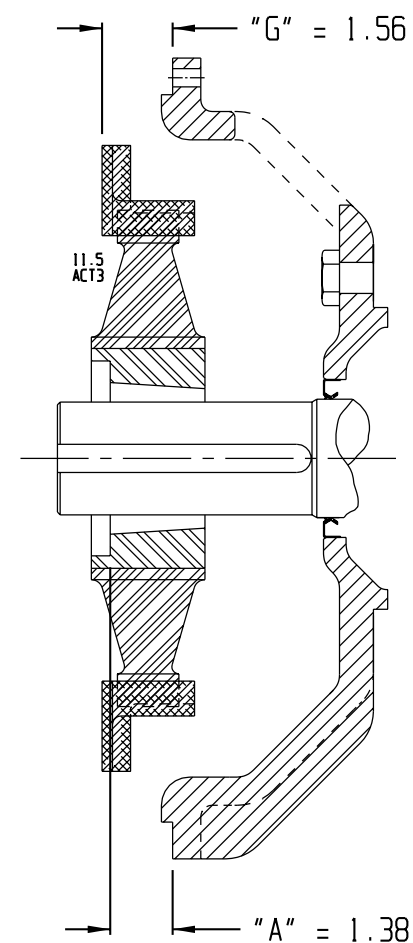
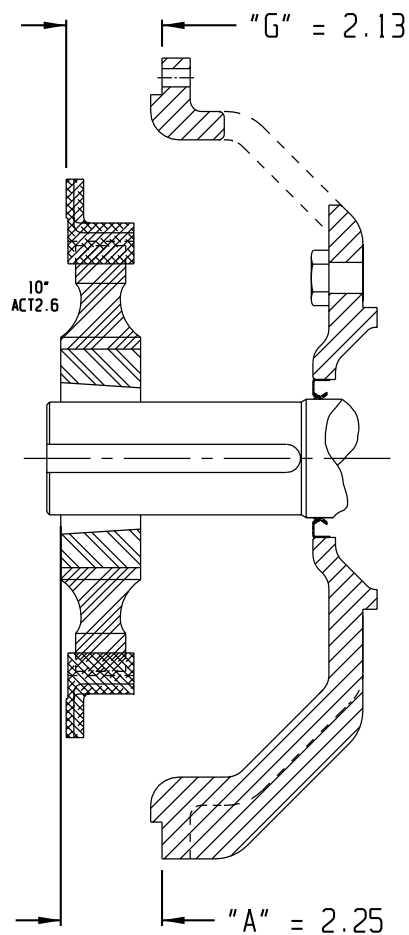
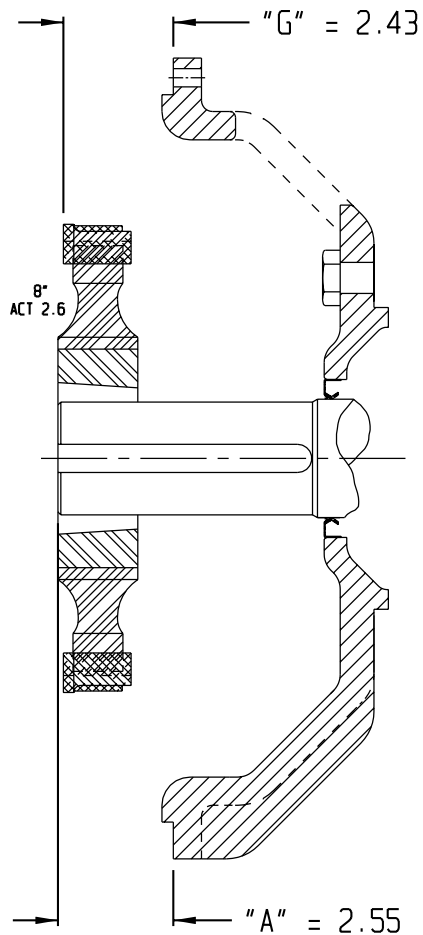
REMOVING DISCHARGE CHECK VALVE

DWG NO.
A2170A

INSTALLER MUST CONFIRM THAT PUMP SHAFT
MAKES NO DIRECT CONTACT WITH ENGINE FLYWHEEL
OR CRANKSHAFT AND THAT COUPLING IS INSTALLED
SO AS TO TRANSMIT NO AXIAL THRUST TO THE ENGINE
FLYWHEEL OR CRANKSHAFT

DIMENSIONS SHOWN ARE BASED ON SAE STANDARD
BELLHOUSING AND FLYWHEEL DIMENSIONS. INSTALLER
ASSUMES FULL RESPONSIBILITY FOR VERIFYING
DIMENSIONS CORRECT FOR ANY PARTICULAR ENGINE

DWG NO.
A2184A



PIONEER PUMP, INC. CORRECT COUPLING POSITION FOR SAE 3 & 4 W/8", 10" & 11.5" DRIVES

DWG NO.
A2184A