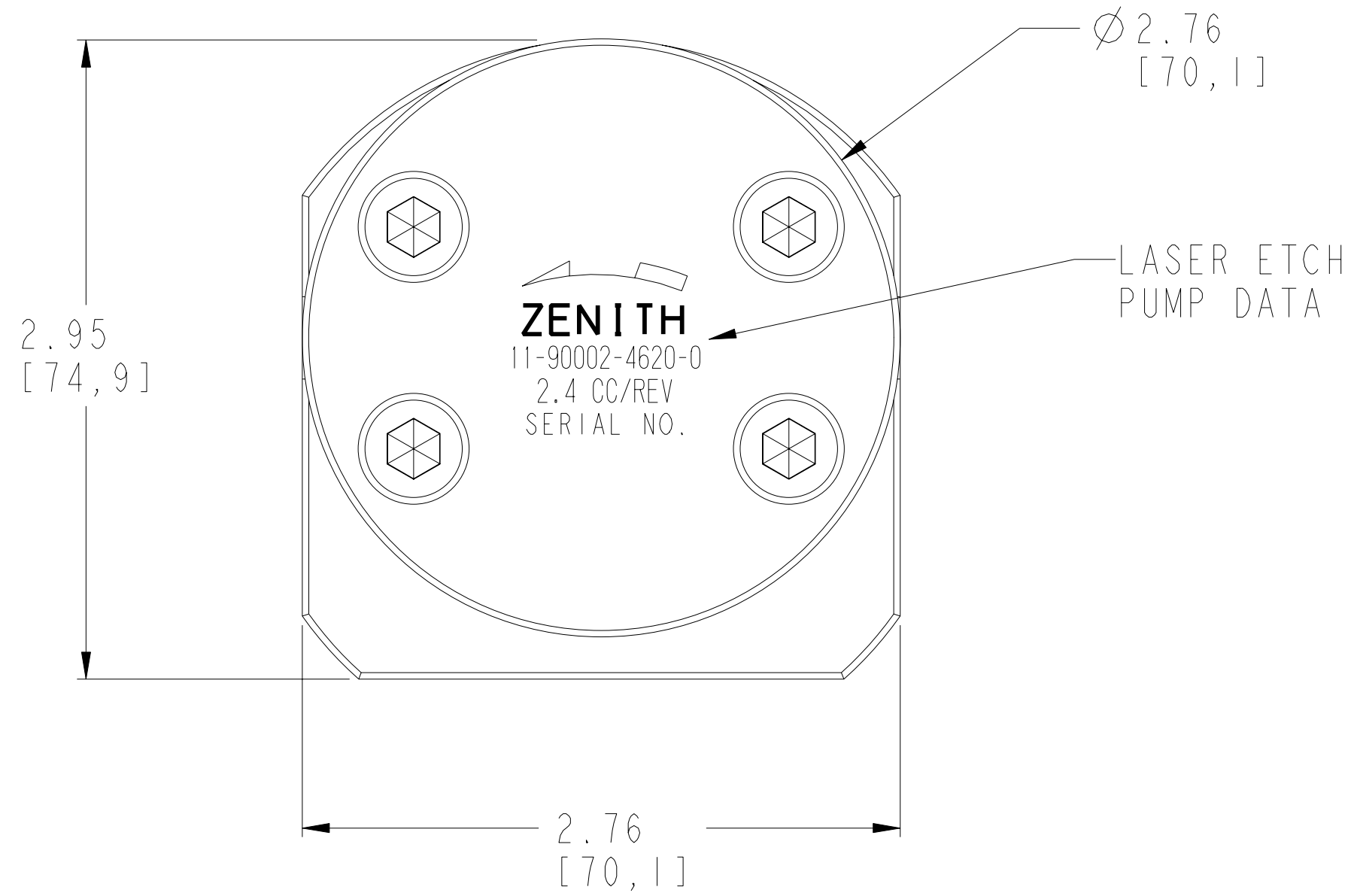


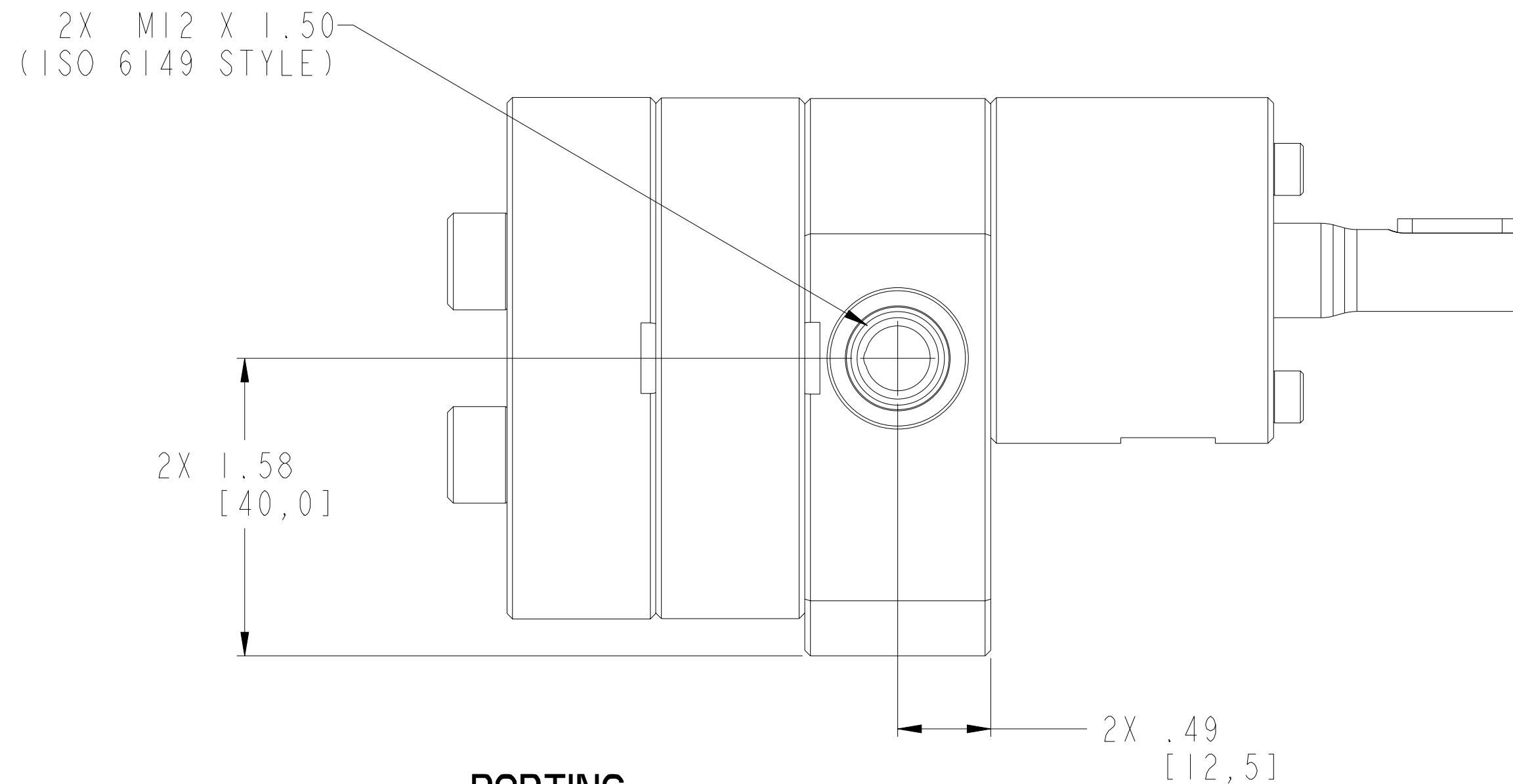
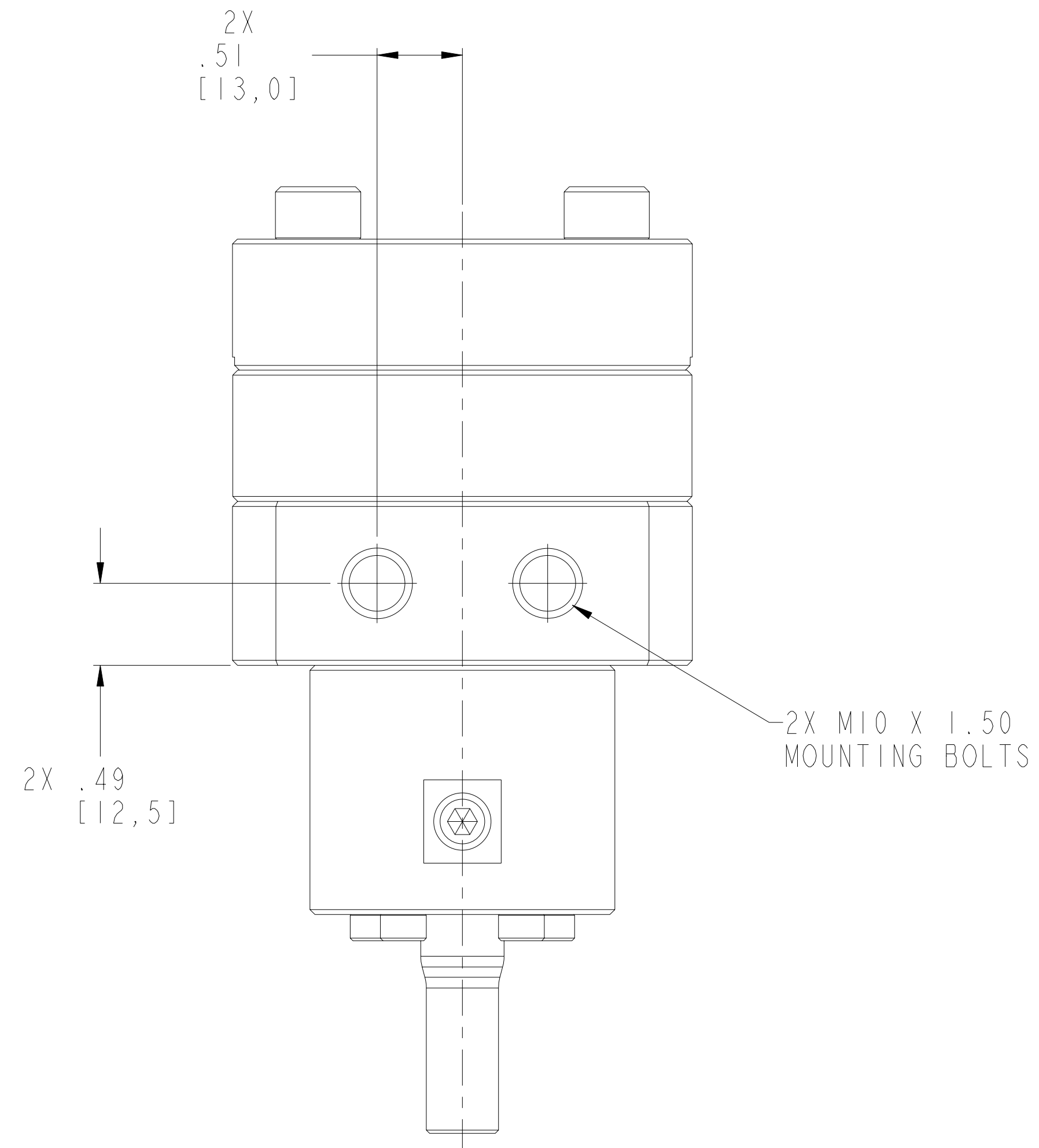
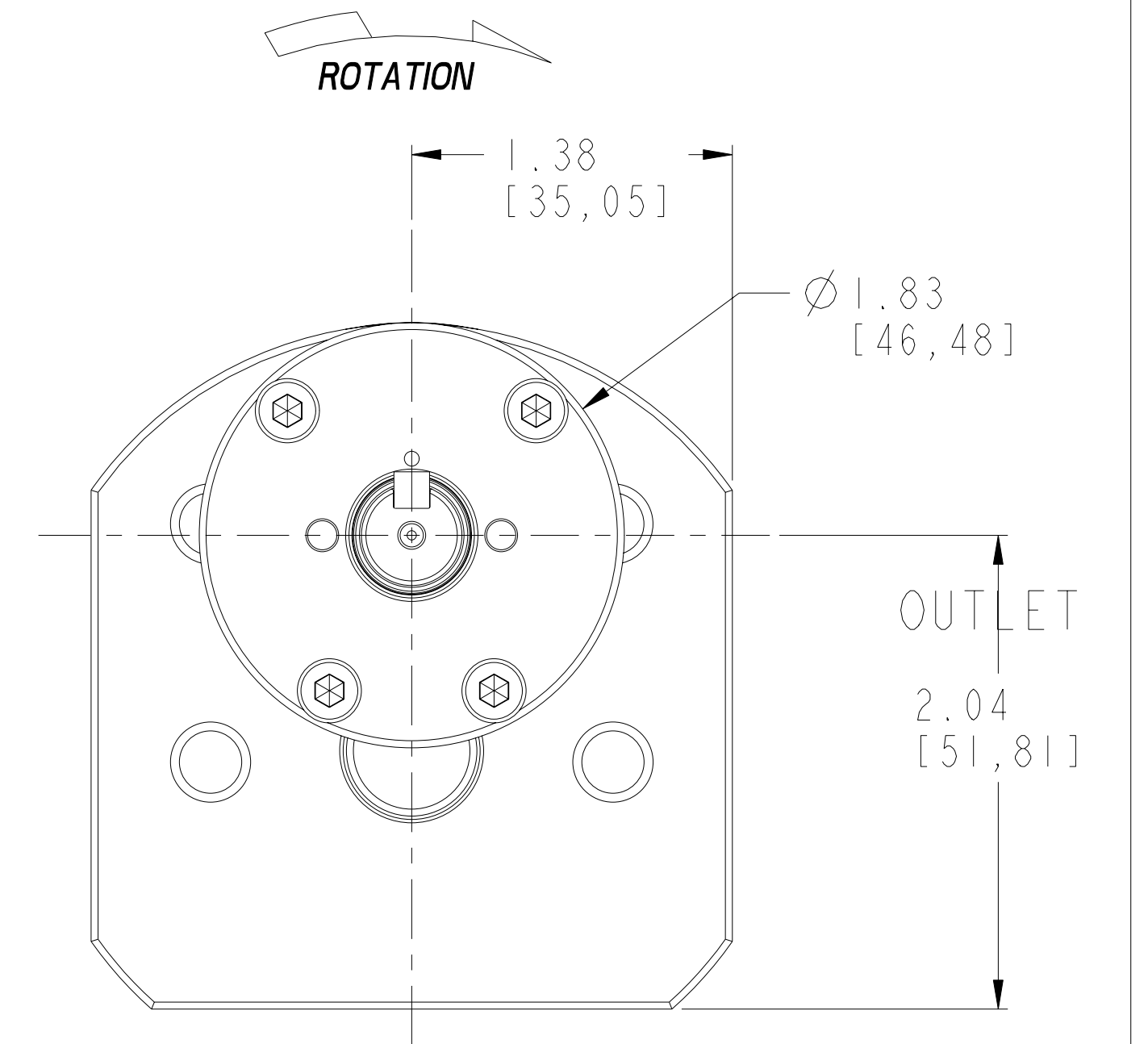
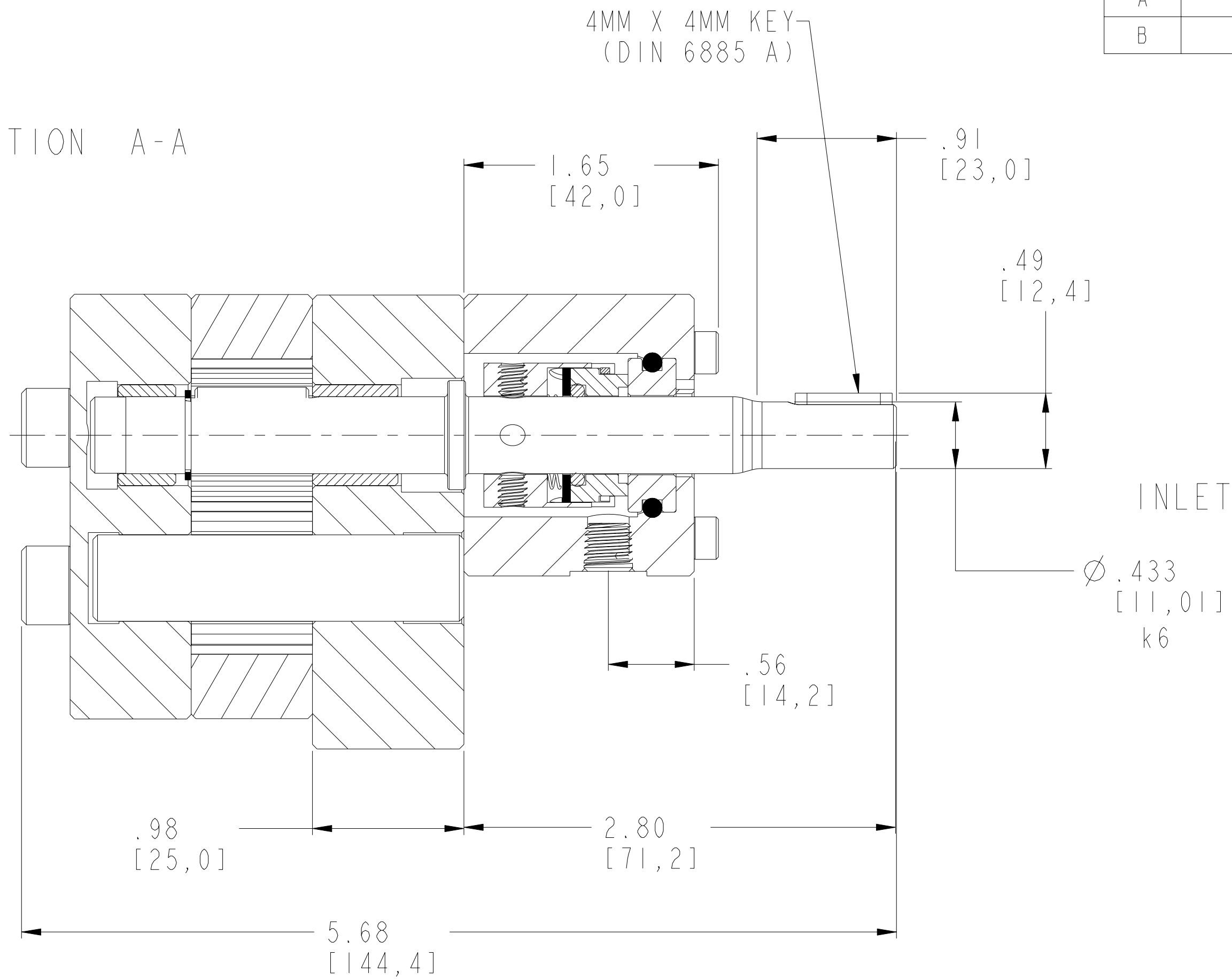
TORQUE SPECIFICATION FOR M4 SHCS
41 IN-LB (LUBRICATED) OR 28 IN-LB (NON-LUBRICATED)

TORQUE SPECIFICATION FOR M8 SHCS
350 IN-LB (LUBRICATED) OR 232 IN-LB (NON-LUBRICATED)

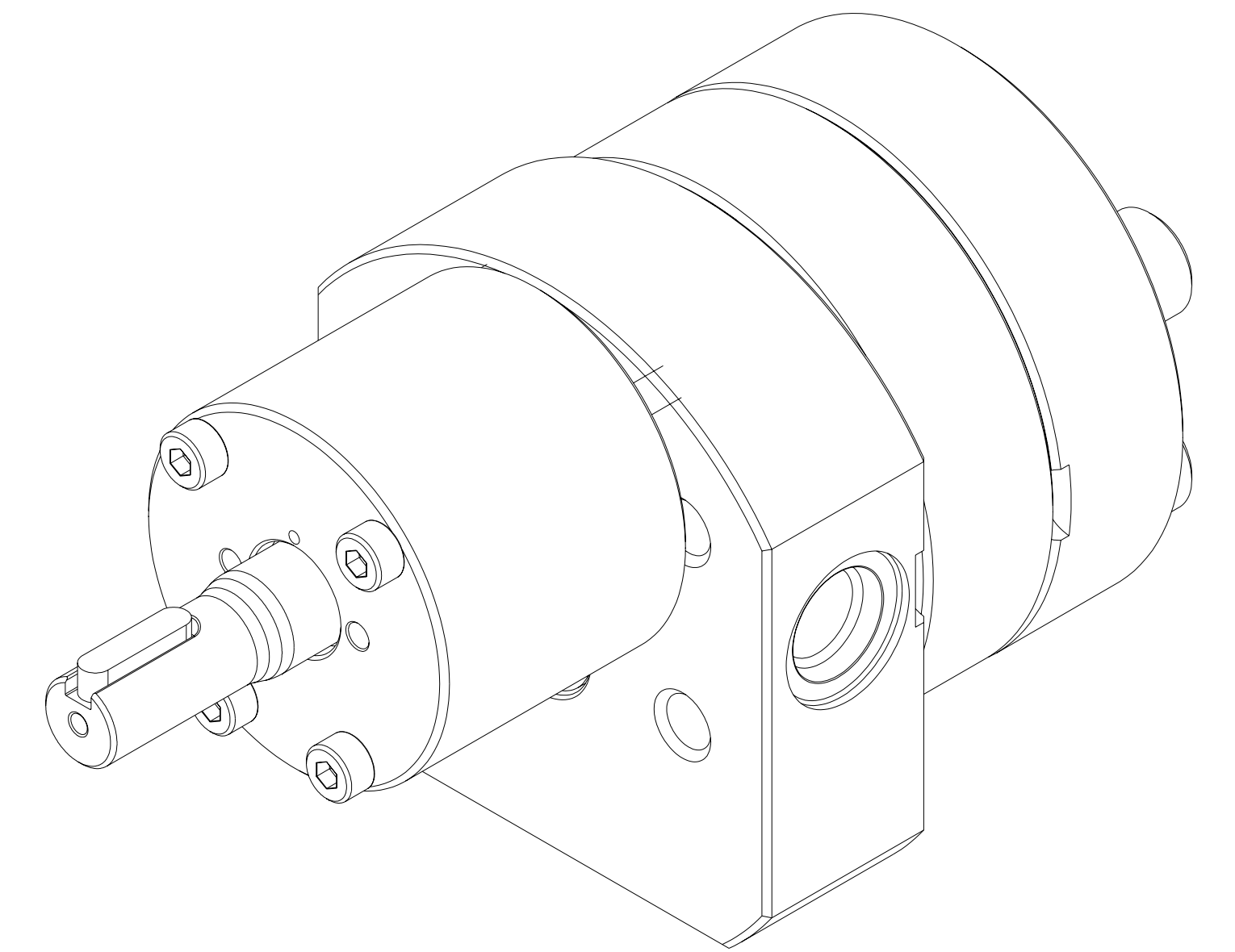
REVISIONS			
LTR	DESCRIPTION	DATE	ECN NO.
A	DOWEL WAS 15-16091-0016-1	9/9/04	317-2004
B	CLARIFIED SEAL INSTALLATION	6/9/05	171-2005



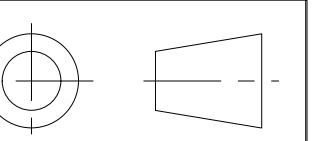
SECTION A-A



PORTING



INTERPRET PER ASME-Y14.5M 1994



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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCH TOLERANCES
.XX ± 0.01
.XXX ± 0.005
ANG ± 0.5

MATERIAL
SEE BILL OF MATERIALS SHEET 2

DRAWN	PLC	10.19.01
CHECKED		
PART WEIGHT = LBS		
SURFACE AREA = IN ²		
MODEL NUMBER =	119000246200	
DRAWING =	119000246200	
PRO/ENGINEER DRAWING	SIZE D	



ZENITH PUMPS
5910 ELWIN BUCHANAN DRIVE
SANFORD, NC 27330

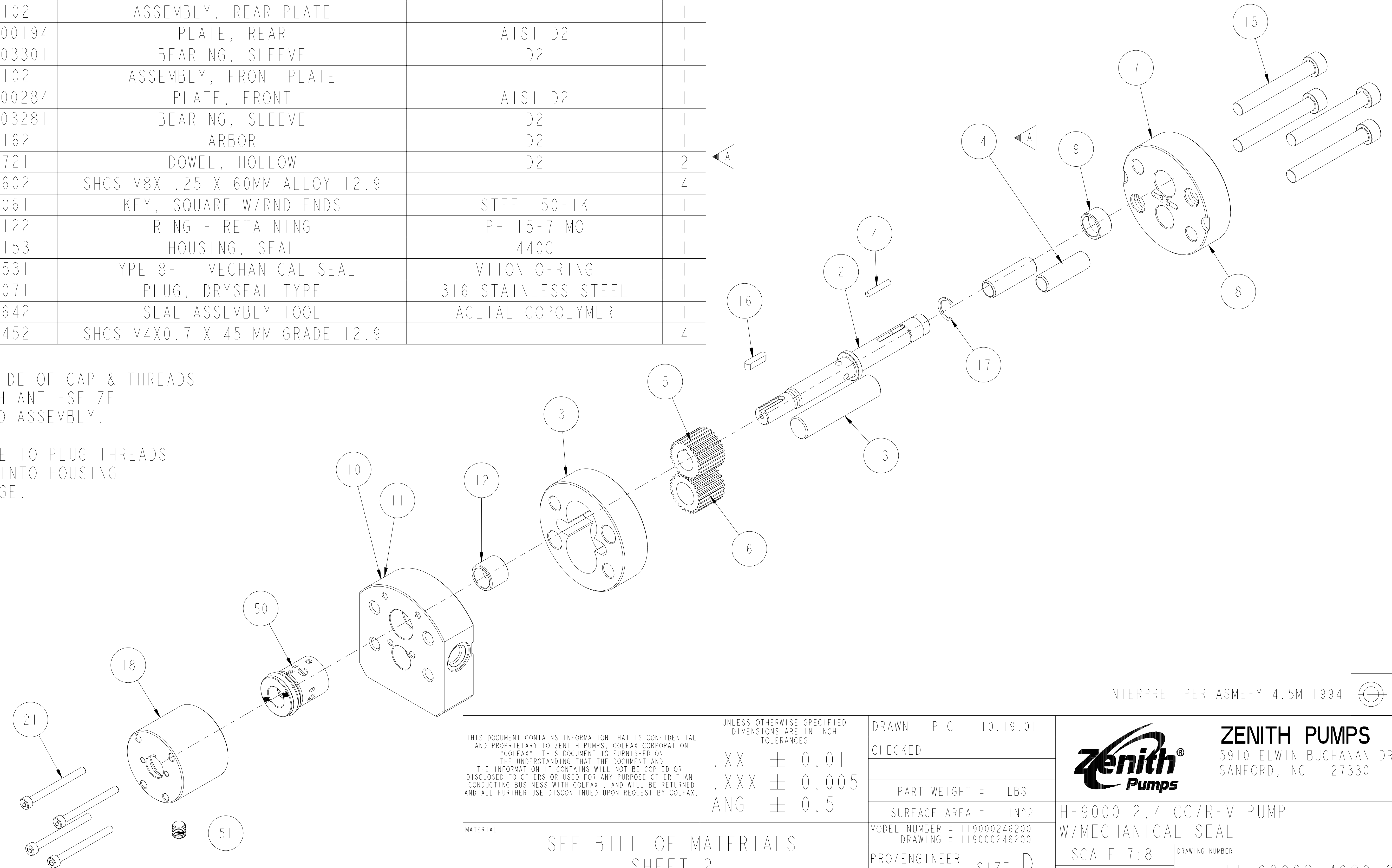
H-9000 2.4 CC/REV PUMP
W/MECHANICAL SEAL

SCALE 3:2
SHEET 1 OF 3

DRAWING NUMBER
11-90002-4620-0

ITEM No.	PART NUMBER	PART NAME	MATERIAL	QTY
	119000246200	H-9000 2.4 CC/REV PUMP		1
2	157956800432	SHAFT, DRIVE	D2	1
3	156925100164	PLATE, GEAR	AISI D2	1
4	155600200411	KEY, ROUND		1
5	152360000122	GEAR, DRIVING	D2	1
6	152370000122	GEAR, DRIVEN	D2	1
7	146915100102	ASSEMBLY, REAR PLATE		1
8	156915100194	PLATE, REAR	AISI D2	1
9	150451303301	BEARING, SLEEVE	D2	1
10	146945200102	ASSEMBLY, FRONT PLATE		1
11	156945200284	PLATE, FRONT	AISI D2	1
12	150451303281	BEARING, SLEEVE	D2	1
13	150115600162	ARBOR	D2	1
14	151609100721	DOWEL, HOLLOW	D2	2
15	187860810602	SHCS M8X1.25 X 60MM ALLOY 12.9		4
16	185600800061	KEY, SQUARE W/RND ENDS	STEEL 50-1K	1
17	181831800122	RING - RETAINING	PH 15-7 MO	1
18	155402000153	HOUSING, SEAL	440C	1
50	187900300531	TYPE 8-IT MECHANICAL SEAL	VITON O-RING	1
51	187300000071	PLUG, DRYSEAL TYPE	316 STAINLESS STEEL	1
52	150013100642	SEAL ASSEMBLY TOOL	ACETAL COPOLYMER	1
21	187860410452	SHCS M4X0.7 X 45 MM GRADE 12.9		4

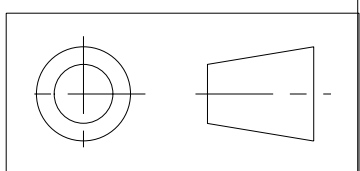
REVISIONS			
LTR	DESCRIPTION	DATE	ECN NO.
A	DOWEL WAS 15-16091-0016-1	9/9/04	317-2004
B	CLARIFIED SEAL INSTALLATION	6/9/05	171-2005



LUBRICATE UNDERSIDE OF CAP & THREADS ON FASTENERS WITH ANTI-SEIZE COMPOUND PRIOR TO ASSEMBLY.

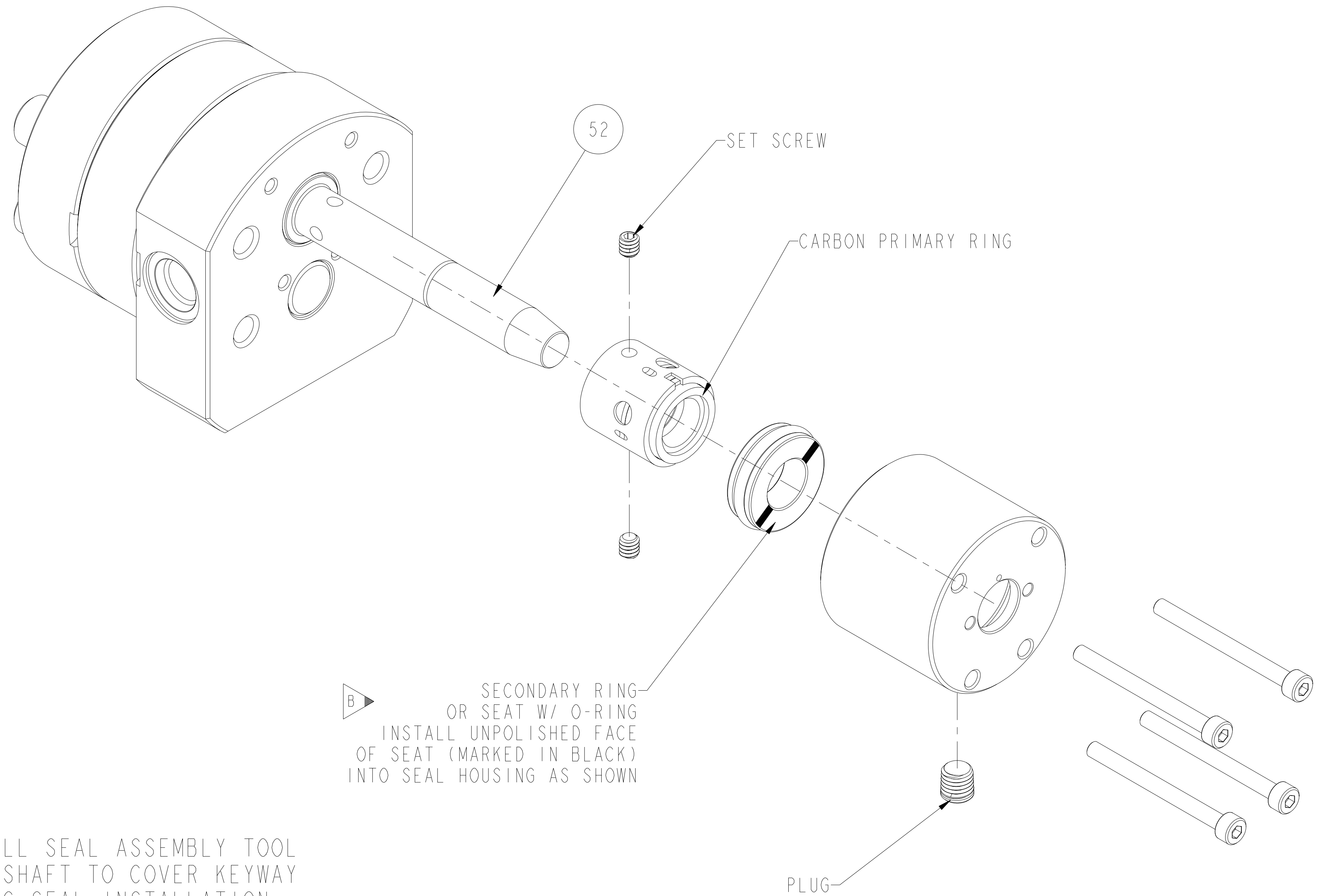
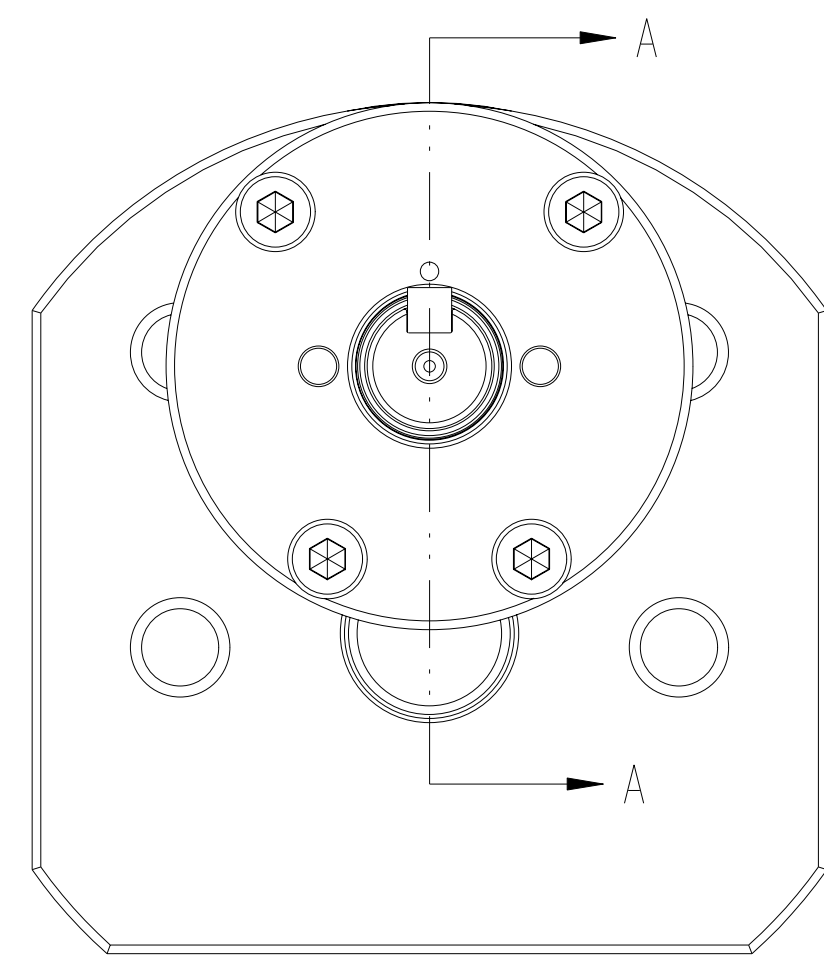
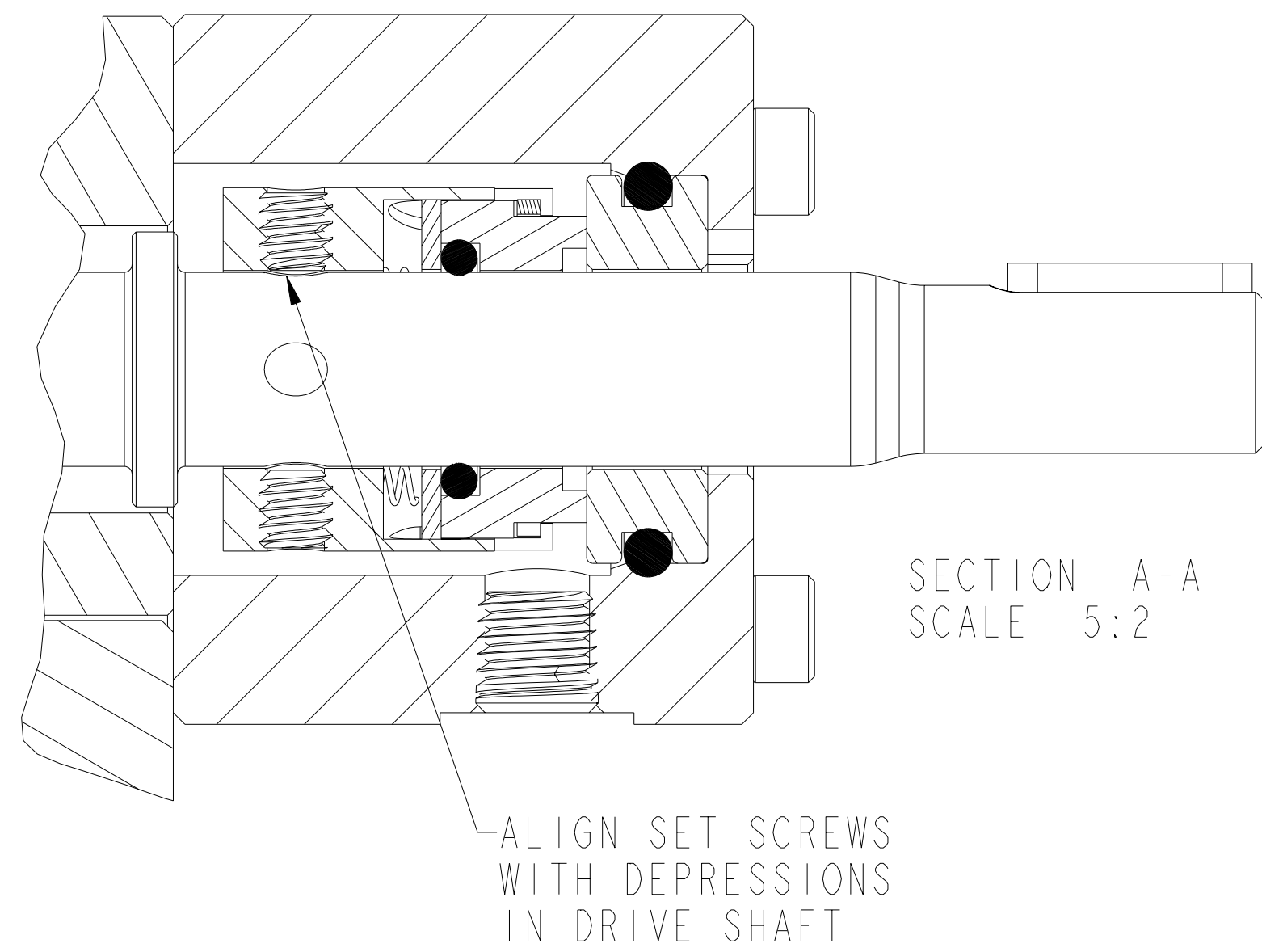
APPLY TEFLON TAPE TO PLUG THREADS WHEN ASSEMBLING INTO HOUSING TO PREVENT LEAKAGE.

INTERPRET PER ASME-Y14.5M 1994



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		PART WEIGHT = LBS SURFACE AREA = IN ²	
MATERIAL SEE BILL OF MATERIALS SHEET 2		MODEL NUMBER = 119000246200 DRAWING = 119000246200	SCALE 7:8 SHEET 2 OF 3
		PRO/ENGINEER DRAWING SIZE D	DRAWING NUMBER 11-90002-4620-0

REVISIONS			
LTR	DESCRIPTION	DATE	ECN NO.
A	DOWEL WAS 15-16091-0016-1	9/9/04	317-2004
B	CLARIFIED SEAL INSTALLATION	6/9/05	171-2005



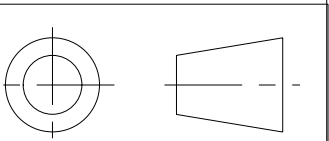
INSTALL SEAL ASSEMBLY TOOL ONTO SHAFT TO COVER KEYWAY DURING SEAL INSTALLATION, TO PREVENT DAMAGE.

LUBRICATE UNDERSIDE OF CAP & THREADS ON FASTENERS WITH ANTI-SEIZE COMPOUND PRIOR TO ASSEMBLY.

LUBRICATE ALL O-RINGS ON LIP SEAL WITH PARKER O-RING LUBE OR EQUIVALENT, PRIOR TO INSTALLING INTO HOUSING.

APPLY TEFLON TAPE TO PLUG THREADS WHEN ASSEMBLING INTO HOUSING TO PREVENT LEAKAGE.

INTERPRET PER ASME-Y14.5M 1994



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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCH TOLERANCES

.XX ± 0.01
.XXX ± 0.005
ANG ± 0.5

DRAWN	PLC	10.19.01
CHECKED		
PART WEIGHT = LBS		
SURFACE AREA = IN ²		
MODEL NUMBER =	119000246200	
DRAWING =	119000246200	
PRO/ENGINEER DRAWING	SIZE D	



ZENITH PUMPS
5910 ELWIN BUCHANAN DRIVE
SANFORD, NC 27330

H-9000 2.4 CC/REV PUMP W/MECHANICAL SEAL	
SCALE 3:2 SHEET 3 OF 3	DRAWING NUMBER 11-90002-4620-0

SEE BILL OF MATERIALS SHEET 2