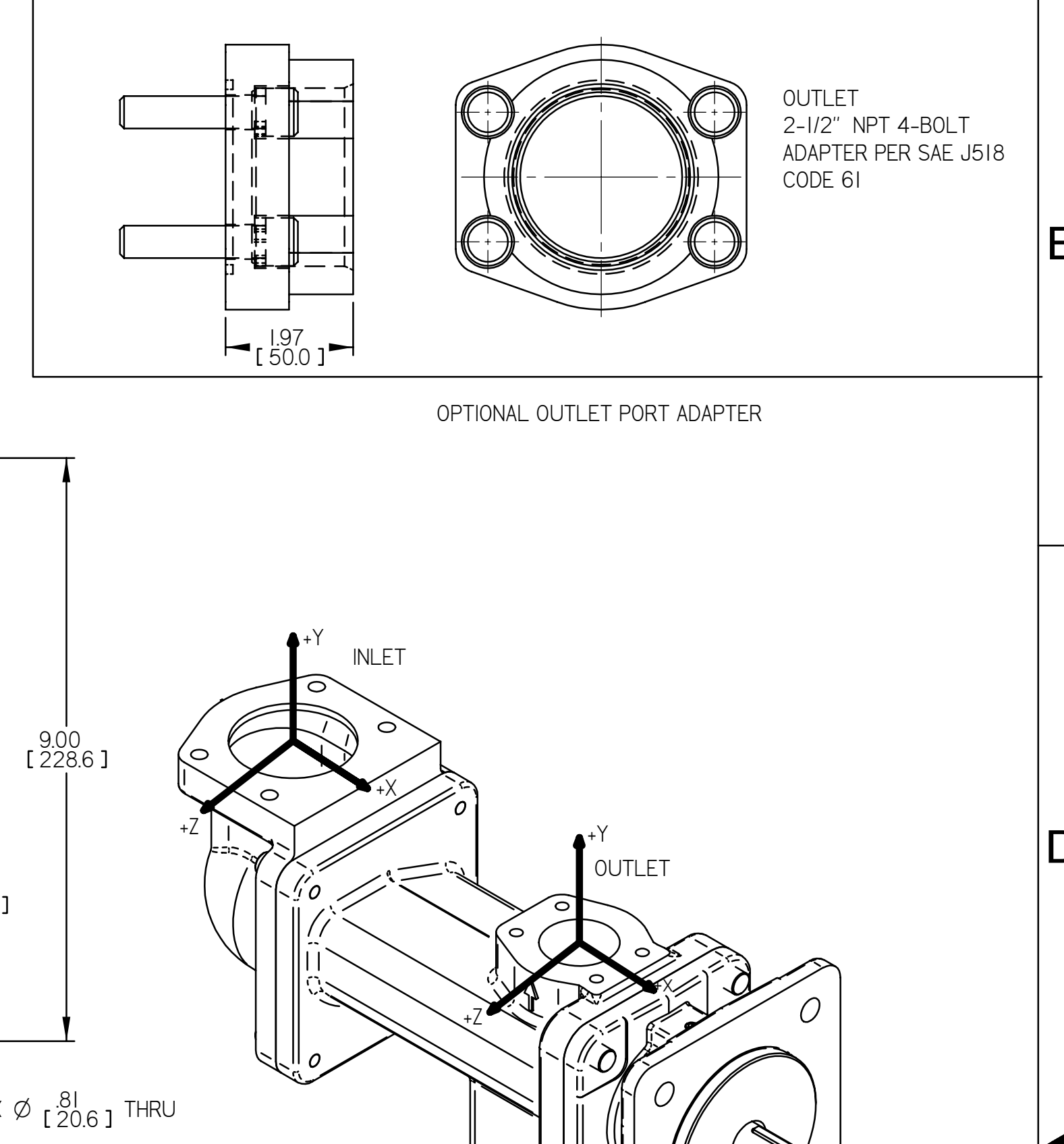
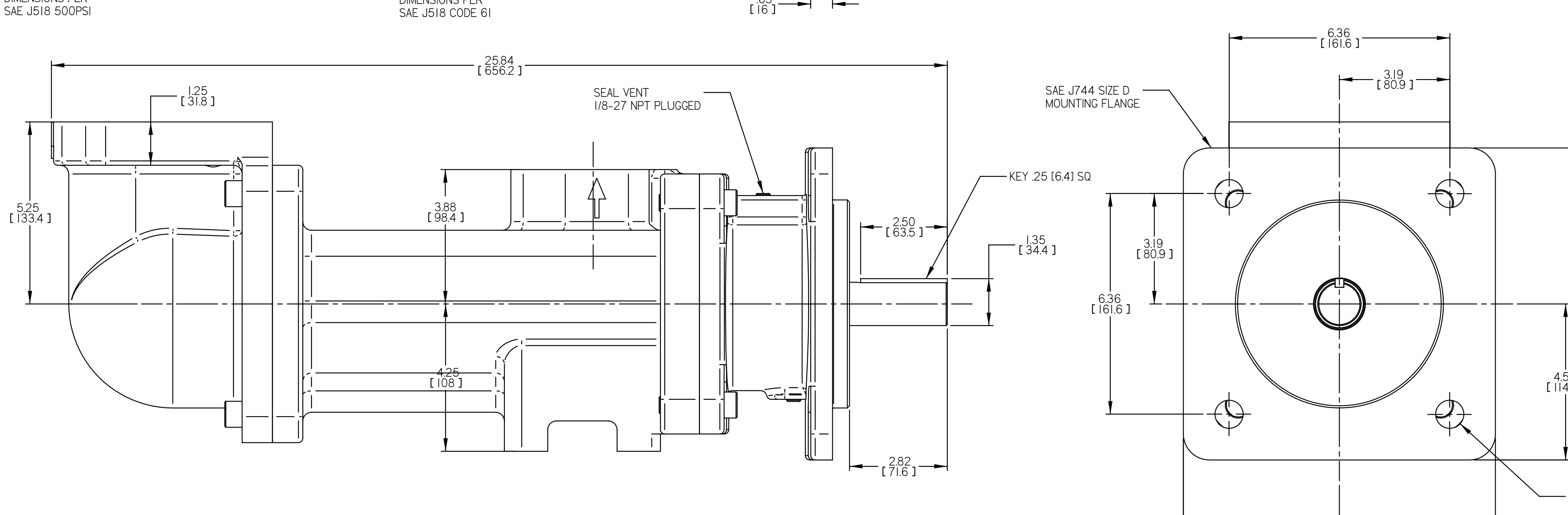
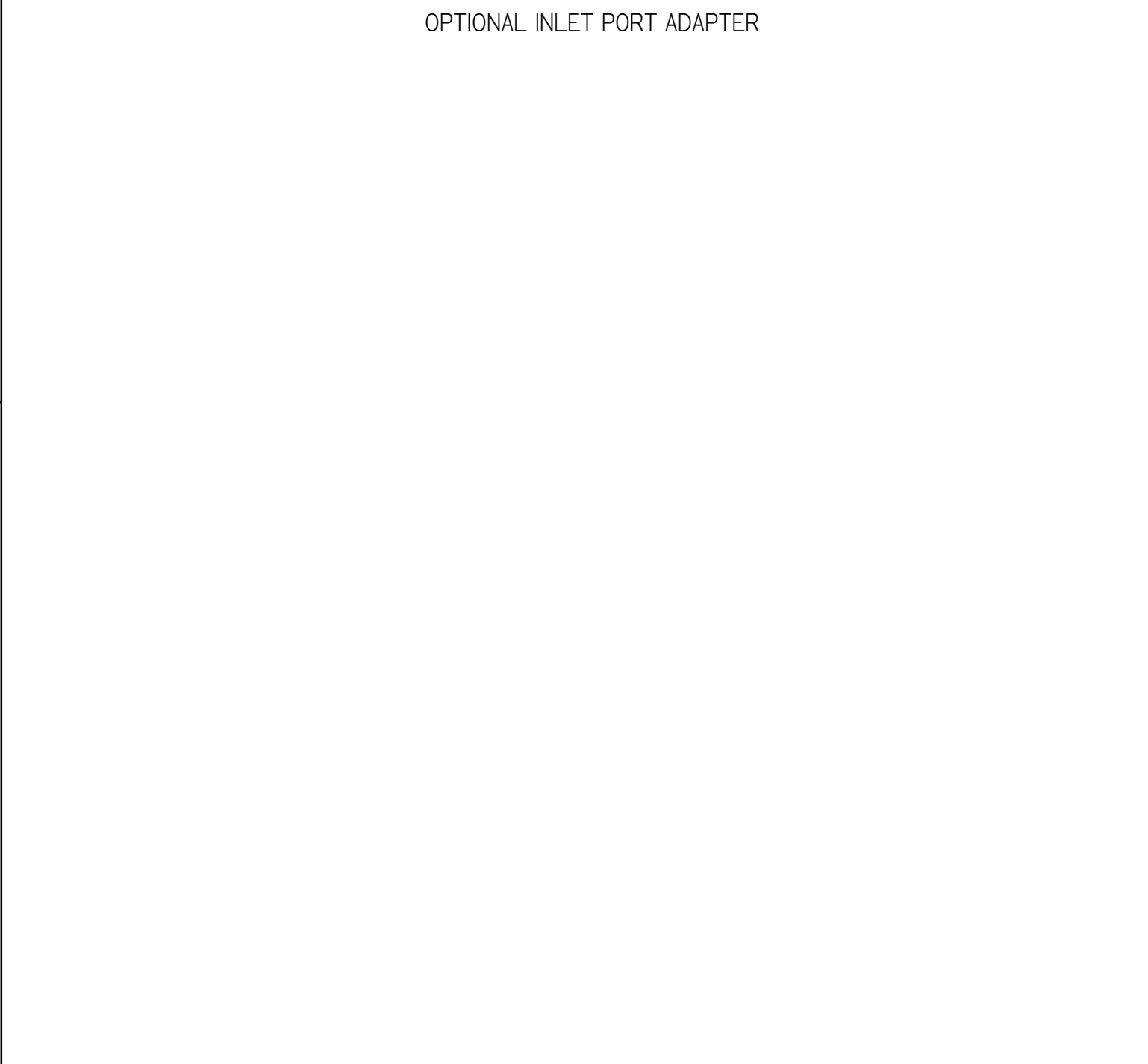


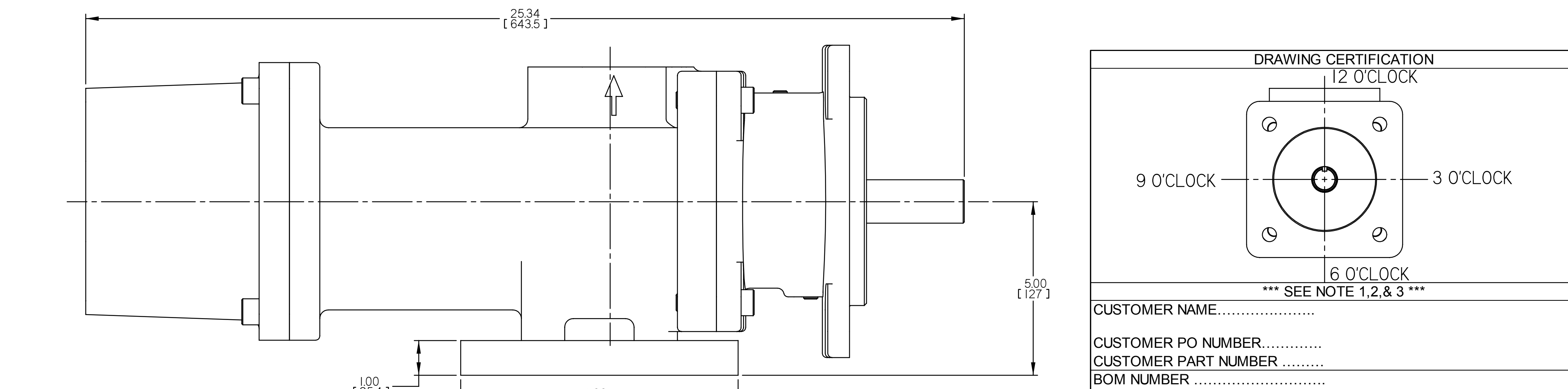
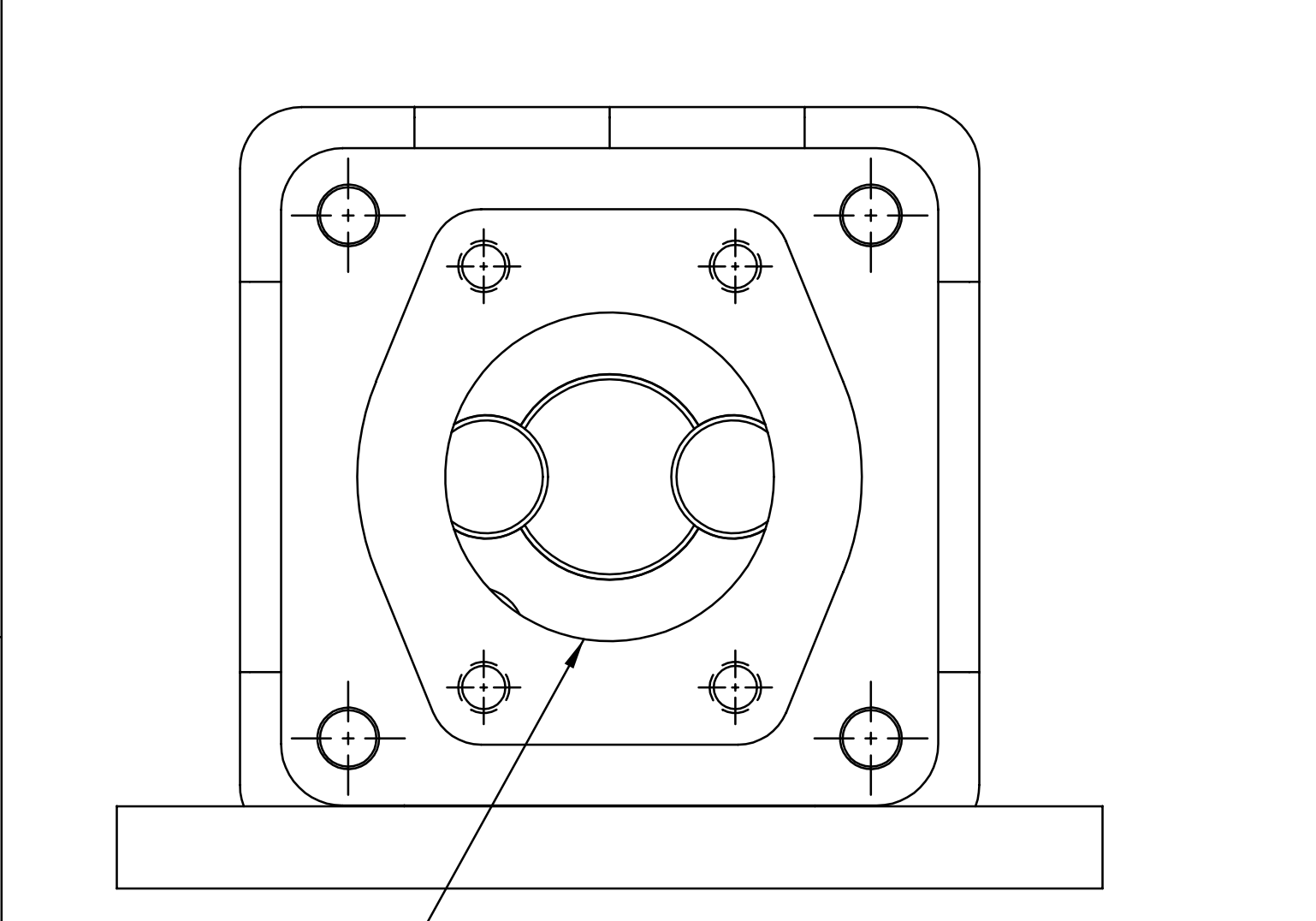
REVISION HISTORY						
CHG NO	ZONE	REV	DESCRIPTION	DATE	BY	APPROVED
02-0031	A5	02	CHANGED FOOT BRKT THK AND WIDTH	1-29-02	VAH	VAH
02-0359	A3	03	CHANGED BORDER TO OUTLINE FORMAT	10-29-02	VAH	VAH
03-0110	E1	04	CHANGED ANCHOR FLANGE ADAPTOR	5-8-03	VAH	VAH

OUTLET  
2-1/2" SIZE 4-BOLT  
SOCKET WELDING ADAPTER  
PER SAE J518 CODE 61  
Ø2.995 (76.07) SOCKET  
1" (25.4) DEEP

OPTIONAL OUTLET PORT ADAPTER

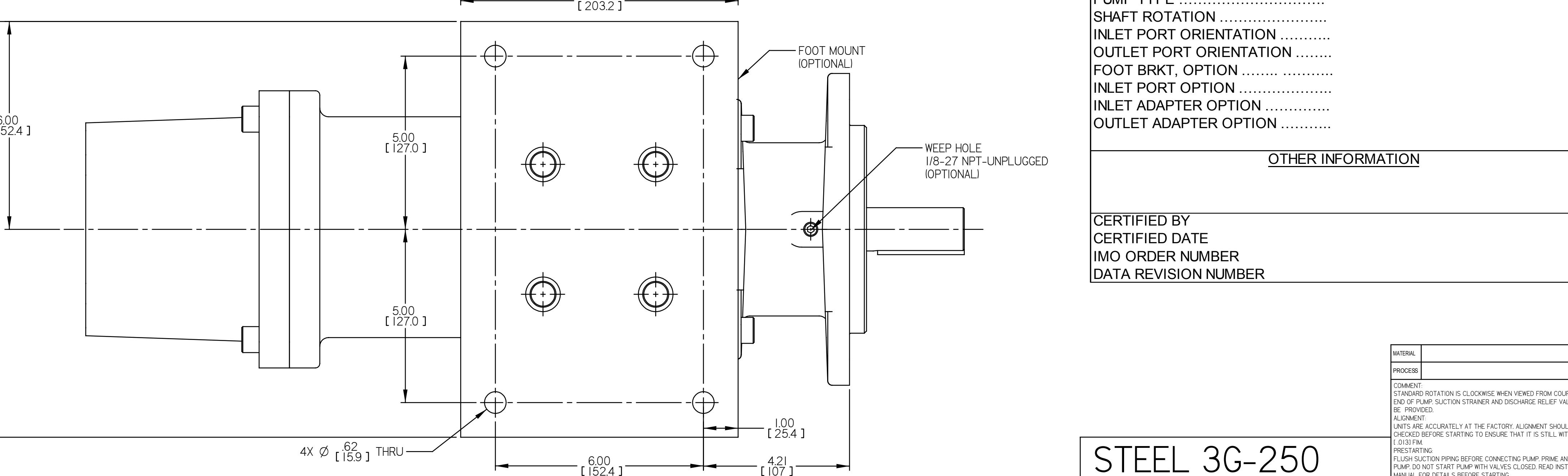


VIEWS FOR ALTERNATIVE AXIAL INLET, FOOT MOUNT, AND WEEP HOLE



DRAWING CERTIFICATION					
12 O'CLOCK					
9 O'CLOCK		3 O'CLOCK		6 O'CLOCK	
*** SEE NOTE 1, 2, & 3 ***					
CUSTOMER NAME .....					
CUSTOMER PO NUMBER .....					
CUSTOMER PART NUMBER .....					
BOM NUMBER .....					
PUMP TYPE .....					
SHAFT ROTATION .....					
INLET PORT ORIENTATION .....					
OUTLET PORT ORIENTATION .....					
FOOT BRKT, OPTION .....					
INLET PORT OPTION .....					
INLET ADAPTER OPTION .....					
OUTLET ADAPTER OPTION .....					
OTHER INFORMATION					
CERTIFIED BY .....					
CERTIFIED DATE .....					
IMO ORDER NUMBER .....					
DATA REVISION NUMBER .....					

COORDINATE SYSTEM FOR MAXIMUM PUMP FORCES (F) AND MOMENTS (M)					
INLET					
FX=	300 LBF [ 1334 N]	MY=	500 LB FT [ 678 N m]		
FY=	300 LBF [ 1334 N]	MZ=	500 LB FT [ 678 N m]		
FZ=	300 LBF [ 1334 N]				
OUTLET					
FX=	188 LBF [ 836 N]	MY=	313 LB FT [ 424 N m]		
FY=	188 LBF [ 836 N]	MZ=	313 LB FT [ 424 N m]		
FZ=	188 LBF [ 836 N]				
NOTE: FORCE AND MOMENT VALUES ARE RELATIVE TO CENTER OF INLET AND OUTLET PORT FACES					
NOTES:					
1. TO MAXIMIZE SEAL LIFE, SEAL VENT MUST BE ORIENTED UPWARD (12 O'CLOCK) WHEN PUMP IS INSTALLED HORIZONTALLY. VENT ORIENTATION IS NOT CRITICAL WHEN PUMP IS INSTALLED WITH SHAFT VERTICALLY UPWARD.					
2. PORT, FOOT, AND SEAL VENT ORIENTATIONS ARE SPECIFIED AS SHOWN ON DRAWING UNLESS OTHERWISE SPECIFIED					
3. ALTERNATE PORT AND FOOT ORIENTATIONS ARE PROVIDED IF SPECIFIED ON ORDER. AVAILABLE ORIENTATIONS ARE 3, 6, 9, AND 12 O'CLOCK.					
4. BOLT PATTERN FOR SAE 4-BOLT AXIAL INLET IS ALWAYS ORIENTED AS SHOWN WITH RESPECT TO OUTLET PORT.					
5. APPROXIMATE PUMP WEIGHT (WITHOUT ADAPTERS) FLANGE MOUNT PUMP-----190 LBS. [86.2 kgs] FOOT MOUNT PUMP-----220 LBS. [99.8 kgs]					
6. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES. DIMENSIONS IN [ ] ARE MILLIMETERS					



DRAWN	VAH	9-13-01	 IMO Pump 1710 Airport Road PO Box 5020 Monroe, NC USA 28111.5020		
CHECKED	DMM	11-12-01			
APPD	BES	11-21-01			
METHODS			TITLE	OUTLINE STANDARD (STEEL)	
PROCESS			SIZE	F	CAGE CODE
COMMENT			FIRST ORDER	E1109A	DWG NO
STANDARD ROTATION IS CLOCKWISE WHEN VIEWED FROM COUPLING END OF PUMP. SUCTION STRAINER AND DISCHARGE RELIEF VALVE MUST BE PROVIDED.			SCALE	1/2	WEIGHT
ALIGNMENT			WEIGHT	160 LBS	SHEET
UNITS ARE ACCURATELY AT THE FACTORY. ALIGNMENT SHOULD BE CHECKED BEFORE STARTING TO ENSURE THAT IT IS STEEL WITHIN .005 (0.13) MM.			PRESTARTING		OF 1
FLUSH SUCTION PIPING BEFORE CONNECTING PUMP. PRIME AND VENT PUMP. DO NOT START PUMP WITH VALVES CLOSED. READ INSTRUCTION MANUAL FOR DETAILS BEFORE STARTING.					

STEEL 3G-250