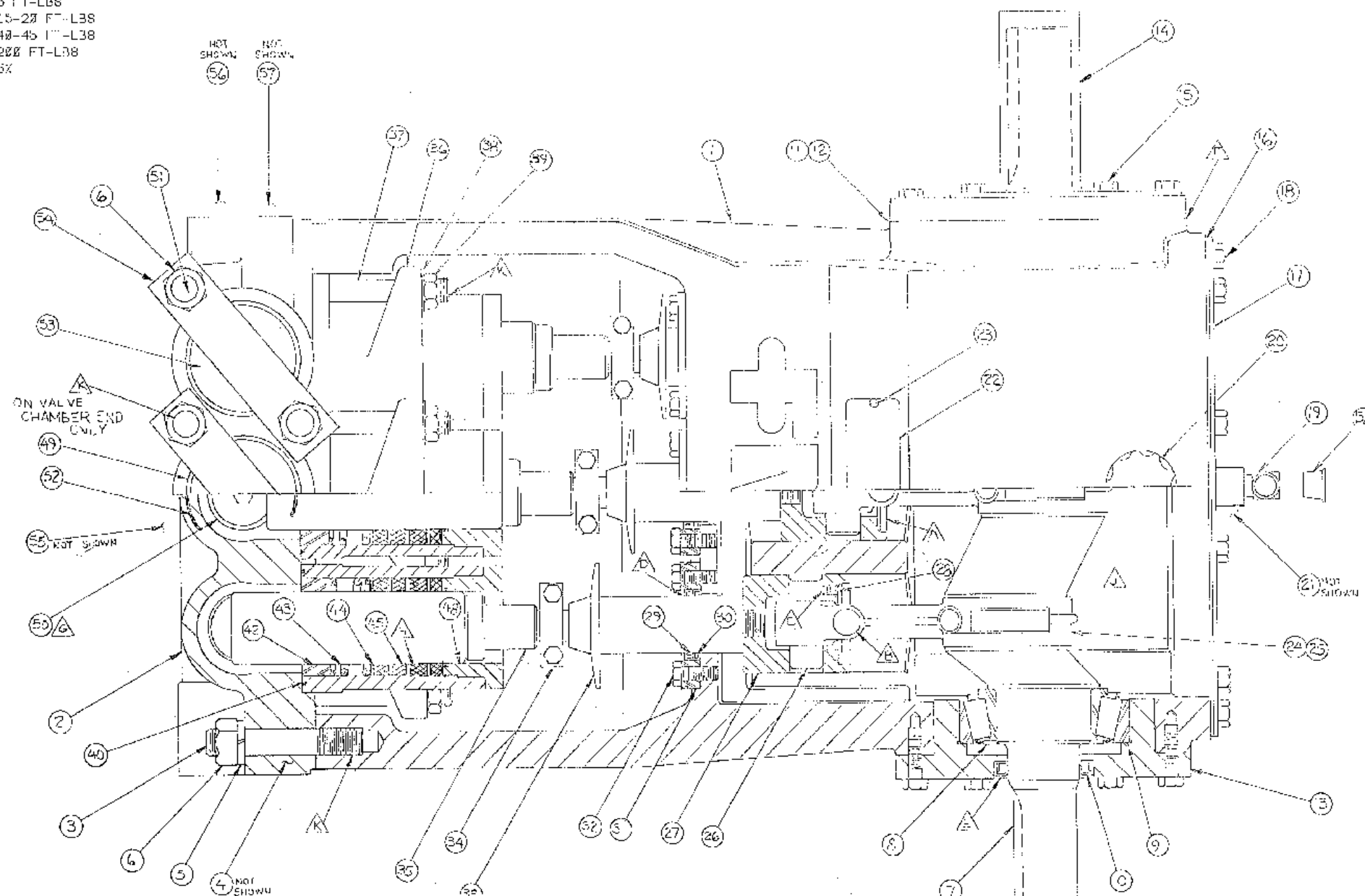


BOLT TORQUE SPECS

VALVE COVER HEX NUTS	200 FT-LBS
STUTTING BOX HEX NUTS	TORQUE SEQUENCE
STEP ONE	10 FT-LBS
STEP TWO	40 FT-LBS
STEP THREE	120 FT-LBS
VALVE COVER STUDS	30-40 FT-LBS
BEARING HOUSING HCS	25 FT-LBS
OIL SEAL HOLDER HCS	15 FT-LBS
PUNGER CLAMP HCS	5 FT-LBS
BACK COVER HCS	15-20 FT-LBS
CONNECTING ROD HEX NUTS	40-45 FT-LBS
VALVE CHAMBER HEX NUTS	200 FT-LBS
TORQUE TOLERANCE	±5%

PUMP TEST SPECS

1. FILL CRANKCASE WITH 1/2 GALLONS OF 30 WT. OIL (NEW OIL ONLY)
2. TEST FOR 15 MINUTES AT 3620 PSI AND 600 RPM. (45 HP)
3. LEST VOLUMETRIC EFFICIENCY OF EACH PUMP AND VERIFY THAT THE EFFICIENCY EXCEEDS 95%.
4. DRAIN OIL FROM PUMP AND CLEAN MAGNETIC DRAIN PLUG. INSPECTION PERSONNEL TO VERIFY THAT THE DRIVE END IS FREE OF OILS.
5. RECORD LB DATA ON LOG SHEET PROVIDED FOR EACH PUMP.



ITEM NO.	REV.	PART NUMBER	QTY REQD	DESCRIPTION	MATERIAL	DIMENSIONS
1	D	5263721	1	PUMP CASE		
2	D	5263712	1	VALVE CHAMBER		
3	A	5273518	2	VALVE CHAMBER STUD		
4	N	1116149	2	DOWEL PIN 1/2 X 1-1/2		
5	N	1100248	2	LOCK WASHER 3/4		
6	N	1123514	8	HEX NUT 3/4-18		
7	D	5263694	1	CRANKSHAFT		
8	A	328339	2	BEARING CONE		
9	A	328340	2	BEARING CUP		
10	A	5263702	2	CRANKSHAFT OIL SEAL		
11	B	5263698	2	BEARING COVER GASKET		
12	B	5263699	18	BEARING COVER SHIM		
13	D	5263699	2	BEARING HOUSING		
14	B	5263695	1	SHAFT END WELD		
15	N	1100243	12	WASHER 3/8 X 1-1/4		
16	B	5263695	2	BACK COVER GASKET		
17	B	5263697	2	BACK COVER WELD		
18	N	1100243	12	WASHER 3/8 X 1-1/4		
19	A	1100243	1	SHIM 3/8		
20	B	5263694	1	FLYER CAP		
21	A	1100243	1	FLYER TO DRIVE PLUG		
22	A	5263698	1	NAME PLATE		
23	N	1100243	4	SP F TAPPING 3/8 X 1/2		
24	B	5263698	1	BEARING HOUSING		
25	C	52710	3	CONNECTING ROD		
26	A	5263698	3	WASHER PIN		
27	B	5263725	3	CROSSHEAD ASSEMBLY		
28	N	1100243	3	SET SCREW 1/4-20 X 1/2		
29	A	5263698	3	OIL SEAL		
30	N	1100243	3	OIL SEAL		
31	A	5263698	3	SEAL RING		
32	N	1100243	4	HCS 3/8-16 X 1		
33	A	5263698	3	DEFLECTOR SHIELD		
34	A	5263698	2	PUNGER CLAMP ASSY		
35	C	5263698	2	PUNGER COLUMN ONLY 1/4		
36	C	5263698	2	STUTTING BOX ONLY		
37	A	5263698	2	STUTTING BOX STUD		
38	N	1100243	6	FLA WASHER 5/8		
39	N	1100243	6	HEX NUT 3/8-18		
40	N	5263698	3	O-RING 2 1/2 X 1/2		
41						
42	A	5273502	3	FRONT RING		
43	A	5263698	3	PACKING SPRING		
44	A	5273502	3	PACKING COMPRESSION RING		
45	A	5273502	3	PACKING SET		
46						
47						
48	A	5273502	3	CLAND NUT 1/4		
49	B	5273502	3	DEFLECTOR VALVE		
50	B	5273502	3	DEFLECTOR VALVE		
51	A	5273502	3	VALVE COVER SHIELD		
52	N	5263698	3	O-RING 2-7/8 X 1/8		
53	E	5263698	3	VALVE COVER		
54	A	5263698	3	VALVE COVER CLAMP		
55	N	1100243	3	3/4 PLUG 1/4 X		
56	N	1100243	2	CAP PLUG 3/4 X		
57	N	1100243	2	CAP PLUG 3/4 X		
58	N	1100243	1	CAP PLUG 3/4 X		
59						
60	N	5263698	4	HEX SCREW 1/4 X 1/2		
61	C	5263698	1	COVER ARM		

NOTE: ITEM (19) TO BE PLACED UNDER ACCESS COVER.
ITEM (14) TO BE WIRED TO VALVE COVER STUD.

ASSEMBLY NOTES

- ▲ CROSS-HEAD SLOT MUST BE FACING UPWARD.
- ▲ LUBRICATING OIL WELL MUST BE FACING UPWARD.
- ▲ WRIST PIN LOCK HOLE MUST ALIGN WITH SET SCREW. APPLY LOCTITE 271 TO SET SCREW BEFORE ASY.
- ▲ LUBRICATE OIL SEAL WITH LUBRILPLAC.
- ▲ LUBRICATE CRANKSHAFT OIL SEALS WITH LIGHT OIL ONLY.
- ▲ BEARING END PLAY TO BE .025 LOOSE TO .002 TIGHT
- ▲ GASKETS (ITEM 11) ARE AGAINST PUMP CASE.
- ▲ INSTALL SUCTION VALVE (LOWER VALVE) BEFORE INSTALLING DISCHARGE VALVE SEAT VALVES WITH A WOODEN DOWEL.
- ▲ LUBRICATE PACKING WITH LIGHT OIL BEFORE ASSEMBLY.
- ▲ ALL MOVING PARTS IN THE DRIVE END SHOULD BE LUBRICATED WITH SAE 30 WT. OIL AT ASSEMBLY.
- ▲ LUBRICATE THREADS SHOWN WITH FUEL-PRO C-5A ANTI-SIEZE COMPOUND.

PAINT SPECS

NO PAINT IS ALLOWED ON THE PUNGER, PUNGER RODS, PUNGER CLAMP DEFLECTOR SHIELD, CLAND NUTS, OR CRANKSHAFT EXTENSIONS.

THIRD ANGLE PROJECTION		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES BREAK SHARP EDGES 0.020 R		STRECKER		FMC CORPORATION Agricultural Machinery Division Jonestown, Arkansas	
TOLERANCES XX.XX ± .01 XX.XXX ± .005 ANGLES ± .5°		SURFACE ROUGHNESS PROTECTIVE FINISH		DATE 0-14-81		TITLE MOBIODI PUMP ASSY	
FRACTIONAL CLEARANCE = .001		POINT SPOT		SCALE 1/2"		MATERIAL	
REDRAWN		BY		FIRST MADE FOR		SEE PARTS LIST	
PART NO.		REV.		DATE		D5264369	