



NOTES:

- 1 TORQUE FASTENERS PER FMC ENGR SPEC AS-22
- 2 TEST PUMP PER FMC ENGR SPEC AS-15, AT 2000 PSI, 1620 RPM FOR 1 HOUR
- 3 STAMP NAMEPLATE WITH FOLLOWING DATA
 MODEL.....L1618 SC
 PART NO.....P504560
 SERIAL NO.....FOLLOWED BY "V"
 DISCH. PRESS.....2000 PSI
 FLOW RATE.....80 GPM
 SPEED.....1620 RPM
 POWER.....110 BHP
- 4 FOR DIMENSIONAL INFORMATION, SEE SHEET 2 OF DRAWING "P504486".
- 5 HAND DRILL $\frac{9}{64}$ DIA X $\frac{3}{16}$ " DEEP HOLES 4 PLACES ON TOP OF POWER FRAME FOR VAC-CON PLATE, ITEM 5. ATTACH PLATE WITH SELF TAPPING SCREWS, ITEM 6. SEE SHEET 2 OF DWG P504486 FOR LOCATION OF TAG.
- 6 RECORD PINION REF. NUMBER ON WIP LOG. SEND TO QA FOR RECORDING IN DATA BASE ALONG WITH SERIAL NUMBER AND PART NUMBER.
- 7 REPLACEMENT O-RING IS PART NO. A90-120
- 8 REMOVE THE TOP CAPSCREW FROM THE PINION COVER OPPOSITE THE DRIVE SIDE. REPLACE WITH BUSHING ITEM 39, CLAMP ITEM 37 AND CAPSCREW ITEM 40.
- 9 REMOVE THE BOTTOM DRAIN PLUG FROM THE POWER FRAME OPPOSITE THE DRIVE SIDE. REPLACE WITH ADAPTER ITEM 38, ELBOW ITEM 36, TUBE ITEM 35 AND DIPSTICK ITEM 34.
- 10 PAINT PUMP PER FMC ENGR SPEC C85024.

ITEM	NO. REQD	PART NO.	PART NAME
1	1	P526159	POWER END ASSEMBLY: RH, 2" BRG
2	1	P505080	NAME PLATE: F/VAC-CON PUMPS (NS)
3	4	1187413	SELF-TAPPING SCREW: #4 X $\frac{3}{16}$ " LG (NS)
4	1	3268021	MANUAL: L16 SC
5	1	5267113	FLUID CYLINDER: NITRIDED
6	6	5255419	VALVE ASSEMBLY: DISC, 440 SST
7	3	1283530	VALVE COVER: R6-60
8	3	1181154	O-RING: 2 $\frac{3}{8}$ " OD X $\frac{1}{8}$ " NOM, BUNA
9	3	1247716	VALVE COVER CLAMP:
10	6	1248372	STUD: $\frac{1}{2}$ -13UNC-2A X 4.00 LG
11	6	3235702	HEX NUT: $\frac{1}{2}$ -13UNC
12	4	P501267	PLUG: $\frac{1}{8}$ " PIPE, SST
13	2	1177202	CAPLUG: (N/S)
14	3	1105121	PLUG: 2" PIPE
15	2	1177205	CAPLUG: (N/S)
16	3	3269586	COVER: CYLINDER
17	3	8309	HEX NUT: 1/2-13
18	3	A90-234	O-RING: 3 ID X $\frac{3}{4}$ OD X $\frac{1}{8}$ NOM, UNIFORM NO. 234, BUNA-N, 90 DURO
19	3	P522864	PISTON HOLDER: W/O-RING
20	3	P508349	CYLINDER: CERAMIC LINED
21	3	A5016	PISTON NUT:
22			
23	3	P513766	PISTON CUP: SUPER GOLD
24	3	1207289	SEAL WASHER:
25	8	P524581	STUD: $\frac{3}{4}$ -10UNC-2A X 14.25 LG
26			
27			
28	3	1177476	O-RING: 3 $\frac{1}{8}$ " OD X $\frac{1}{8}$ " NOM, BUNA
29	8	504-086	HVY HEX NUT: $\frac{3}{4}$ -10UNC-2B
30	1	P519297	CYLINDER COVER CLAMP: HEAVY DUTY
31	3	P514731	BACK-UP RING: UNIFORM #233
32	2	P527057	HEX JAM NUT: $\frac{3}{4}$ -10UNC-2B
33	3	P519280	CAP SCREW: $\frac{7}{8}$ -9UNC-2A X 2.00 LONG
34	1	P527501	DIPSTICK: N.S.
35	1	P528673	DIPSTICK TUBE: N.S.
36	1	P527499	ELBOW: N.S.
37	1	P527500	CLAMP: N.S.
38	1	P522687	ADAPTER FITTING: N.S.
39	1	P528672	BUSHING: N.S.
40	1	P528238	CAP SCREW: $\frac{3}{16}$ -16UNC-2A X 2.25 LG

O	ADD DIPSTICK	5013864	TM	06-29-05
N	CORRECT BACKUP RG	5013487	TM	01-31-05
M	REV BOM	5022479	BKM	10-21-04
L	REV STUD LENGTH	5012823	TM	05-18-04
K	REV NOTE 8	5011598	SJK	02-25-04
J	REV BOM	5011551	SJK	02-18-04
I	REV BOM	5011361	CRT	01-02-04
H	REV BOM	5009552	CRT	11-05-03
G	REV BOM	5007640	BKM	03-25-02
F	REV BOM	5007780	JMW	03-01-02
E	REV BOM	5005438	DRG	02-07-01
D	REV BOM	5005270	SJK	10-15-00
C	REV BOM, NOTE 2	5003480	BKM	10-05-99
B	REV BOM, ADD NOTE	5002807	BKM	04-29-98
A	NEW RELEASE	L1	BKM	12-18-97
REV	WAS	ECN	BY	DATE

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Unless Otherwise Specified:
 Remove all burrs & sharp corners .005 R.
 All diameters concentric within .010 TLR.
 Angles $\frac{1}{2}$ "
 .X $\pm .1$
 .XX $\pm .015$
 .XXX $\pm .005$
 Finish 125 RMS
 All dimensions are in inches

FMC Technologies

PUMP ASSEMBLY;
 L1618 SC HD RH, W/2- $\frac{1}{2}$ NPT X 1- $\frac{1}{4}$ NPT FLUID END, GOLD PISTON, 440 SST DISC VALVE ASSEMBLIES, VAC-CON

P	REV TO MATCH DBI	5013555	BKM	08-11-05	REV	WAS	ECN	BY	DATE	5001706	01-24-98
APPD.	RMC	01-20-98	SIZE	DP504560	SCALE:	NONE	CKD.	SJK	01-16-98	DRAWING NO.	5001706
APPD.	RMC	01-20-98	SIZE	DP504560	SCALE:	NONE	CKD.	SJK	01-16-98	DRAWING NO.	5001706

P504560