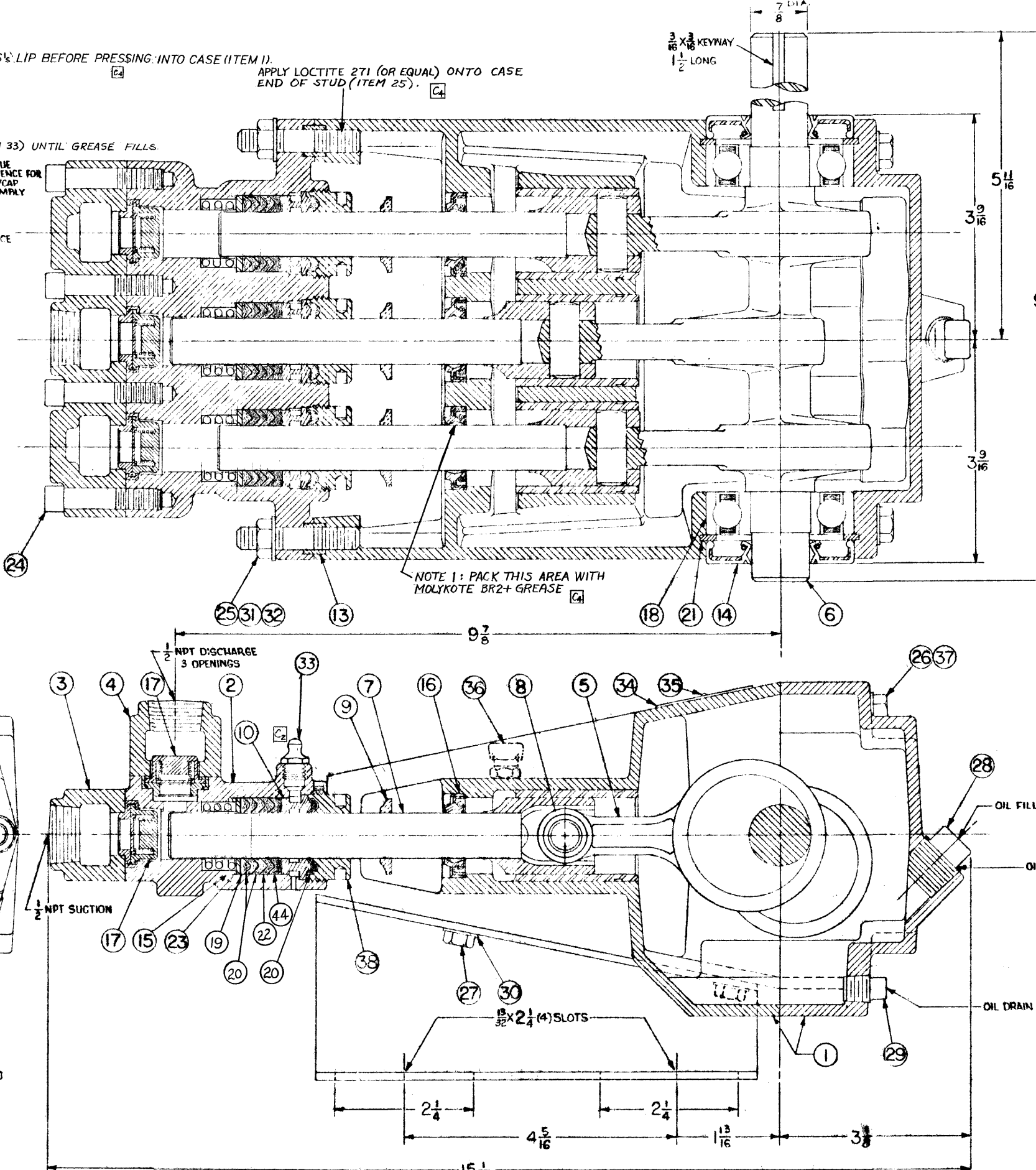
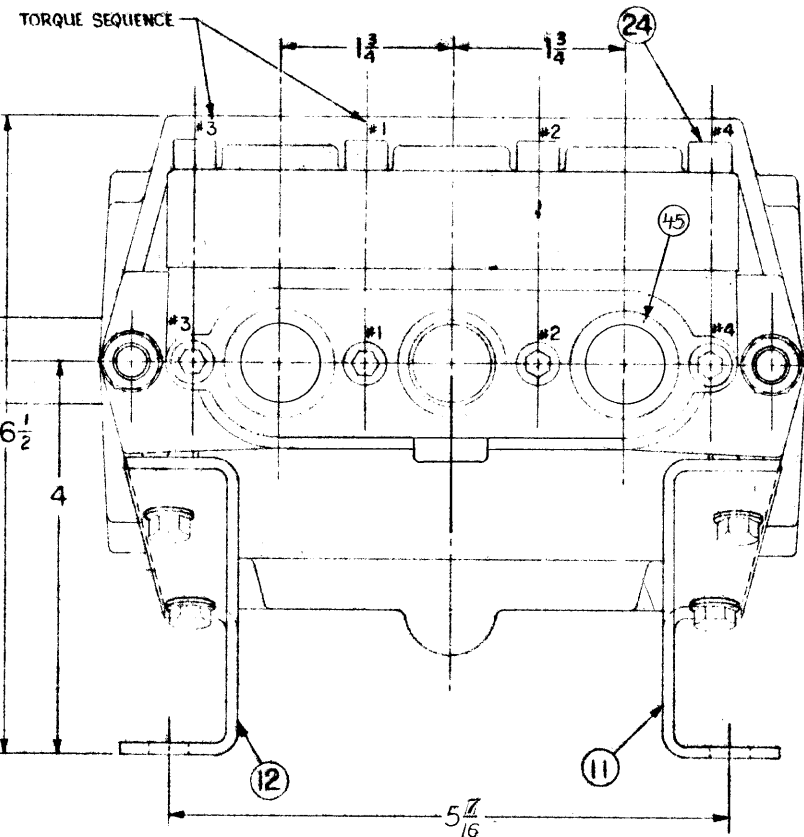


**ASSEMBLY NOTES**

1. APPLY MOLYCOTE BR2+ TO ITEM 16'S LIP BEFORE PRESSING INTO CASE (ITEM 1).
2. APPLY OIL TO CONNECTING ROD, WRIST PINS, CROSSHEADS (ITEMS 5,7,8)
3. USE ROLLER TO APPLY LOCTITE NO 515 GASKET COMPOUND TO BASE OF PUMP CASE. ALSO APPLY THIN COAT OF COMPOUND INSIDE FRONT HALF OF ECCENTRIC BRG BORES. INSTALL PUMP CASE CAP AND WIPE EXCESS GASKET COMPOUND SQUEEZED FROM JOINT.
4. OIL PACKING (ITEM 19) BEFORE INSERTING PLUNGER (ITEM 7). FILL (REASE ZIRK (ITEM 33) UNTIL GREASE FILLS RING AND EXITS THRU WEEP HOLE
5. BOLT & NUT TORQUES:  
 CASE/CAP 12-15 FT. LBS.  
 VALVE CHAMBER/CASE 20-25 FT. LBS.  
 SUCTION & DISCHARGE CHAMBER 15-20 FT. LBS.  
 TORQUE TO 1/3, 2/3, AND FULL TORQUE IN SEQUENCE SHOWN.
6. FILL WITH 1PT. SAE 30 NON-DETERGENT OIL.
7. TEST PUMP FOR 15 MIN. AT 1200 PSIG.
8. PUMP RUST PREVENTIVE SOLUTION THROUGH VALVE CHAMBER.
9. DRAIN OIL.
10. TURN VALVE CHAMBER UPSIDE DOWN (DISCHARGE AT BOTTOM) AND PURGE WITH COMPRESSED AIR.
11. STAMP NAMEPLATE WITH THIS INFORMATION —

**BEAN PUMP**  
 MODEL NO. MD406 PART NO. 5260000 SERIAL NO. \_\_\_\_\_  
 ○ INTERMIT. H.P. 4.1 @ 1250 PSI MAX CAP 5 GPM @ 900 RPM  
 CONTINUOUS H.P. 3.4 @ 1000 PSI U.S. PATENTS



PARTS LIST		DESCRIPTION	PART NUMBER	DWG. NO.	NO. REQ'D.	P. 3
1	ASSY, PUMP CASE & CAP (PAIR)	5257352	D	1		
J2	2	VALVE CHAMBER	5263321	D	1	
J3	3	SUCTION CHAMBER	5263322	C	1	
J4	4	DISCHARGE CHAMBER	5263323	C	1	
5	5	ROD, CONNECTING	5257361	A	3	
6	6	SHAFT, ECCENTRIC	5257365	C	1	
7	7	ASSY, PLUNGER & CROSSHEAD	5257367	B	3	
8	8	PIN, WRIST	5257368	A	3	
9	9	WASHER, BARRIER	5257373	A	3	
E1	10	GLAND, LANTERN, 303 STN STL	5261854	A	3	
11	11	RAIL, MOUNTING (RIGHT)	5257375	B	1	
12	12	RAIL, MOUNTING (LEFT)	5257376	B	1	
13	13	BUSHING, ALIGNMENT	5257487	A	2	
14	14	SEAL, ECCENTRIC SHAFT	5257488	A	2	
E2	15	SPRING, PACKING	5261788	A	3	
16	16	SEAL, CROSSHEAD	5257490	A	3	
17	17	ASSY, VALVE (CUSTOM 450 S.S.)	5260000	A	6	
18	18	BEARING, ECCENTRIC SHAFT	1104443	-	2	
F1	19	MALE ADAPTOR	5262027	A	3	
F2	20	TEFLON V RING	5262030	A	9	
21	21	RING, RETAINING 2.44 Ø	1118553	-	2	
F3	22	SEALSAVER V RING	5262029	A	3	
E3	23	THROAT RING, 303 STN STL	5261857	A	3	
24	24	BOLT, ALLENHEAD 5/16X18X1/2	1112273	-	8	
25	25	STUD 3/8-16X2	5257667	A	2	
G2	26	HHCS 5/16-18X2 C/Z	1111606	-	8	
G1	27	HHCS 5/16-18X 5/8 C/Z	1106872	-	4	FS
28	28	PLUG, 1/2 NPT BLK	1105043	-	1	
29	29	PLUG, 1/4 NPT BLK	1101305	-	1	
30	30	L/W 5/16 C/Z	1100242	-	4	FS
31	31	L/W 3/8 C/Z	1100243	-	2	FS
32	32	HEX NUT 3/8-16 C/Z	1121509	-	2	FS
C2	33	GREASE ZIRK 1/8 NPT	1100759	-	3	
I	34	NAMEPLATE	5262738	A	1	FS
35	35	#4 X 3/16 SCREW	1187413	-	2	FS
36	36	AIR VENT	1177536	-	1	
G3	37	SPRING WASHER 5/16 C/E	1101152	-	8	
E4	38	PACKING NUT, 303 STN STL	5261855	A	3	
D	39	SHIPPING CARTON	5261276	B	1	
D2	40	DIE CUT PAD	5261277	B	1	
J3	41	10-32 X 1/4 NYLON TIP SET SCREW	320222	A	3	
D3	42	DIE CUT PAD	5261278	B	1	
D4	43	SERVICE MANUAL	5260849	L	1	
F4	44	FEMALE ADAPTOR	5262028	A	3	
H	45	8 X CAPLUG	1177207	-	4	
M	46				1	

**PAINT NOTE:** NO PAINT ALLOWED ON EXPOSED PLUNGERS OR SHAFTS

M WAS 5266224	7/25/88	H ADDED ITEM 45	8-28	D) Was Part # 5260654 Del Was Part # 5260655	4/27/78	B. REVISED NAMEPLATE DATA	6-12-78	APPROVED	FILE NO. NC	FILE SIZE D
L ADDED ITEM 46	4-25-86	G CHANGED QUAN. OF ITEMS 26-37	7-23	C) WAS GREASE CUP	8/14/78	A. ADDED ITEMS 39 & 40	3/30/78	APPROVED	YES	
K MODULIZED BOM	6-14-85	F PACKING CHANGE ITEMS 19, 20, 22, 44	3-6	C2. ADD SET SCREWS					NO	
J PARTS LIST CHANGES	11-9-81	E NUMEROUS CHANGES	4-11-78	C3. ADD SET SCREWS					NO	

**FMC** Corporation Agricultural Machinery Division Jonesboro, Arkansas

ASSEMBLY, MO4 PUMP  
 DUCTILE IRON VALVE CHAMBER

SEE DETAILS

PART NO. 5260000

DATE 7-5-77  
 SCALE FULL