

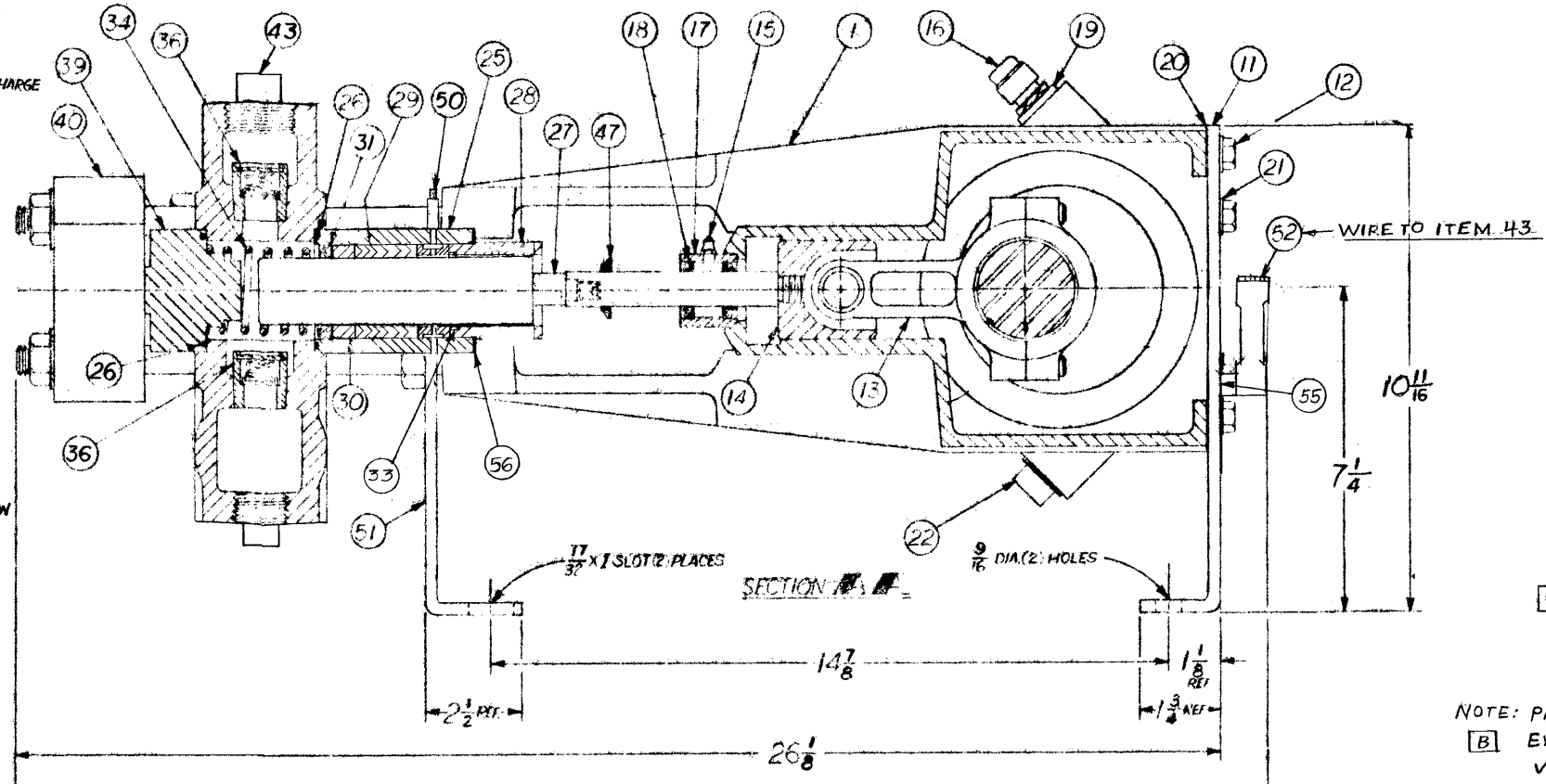
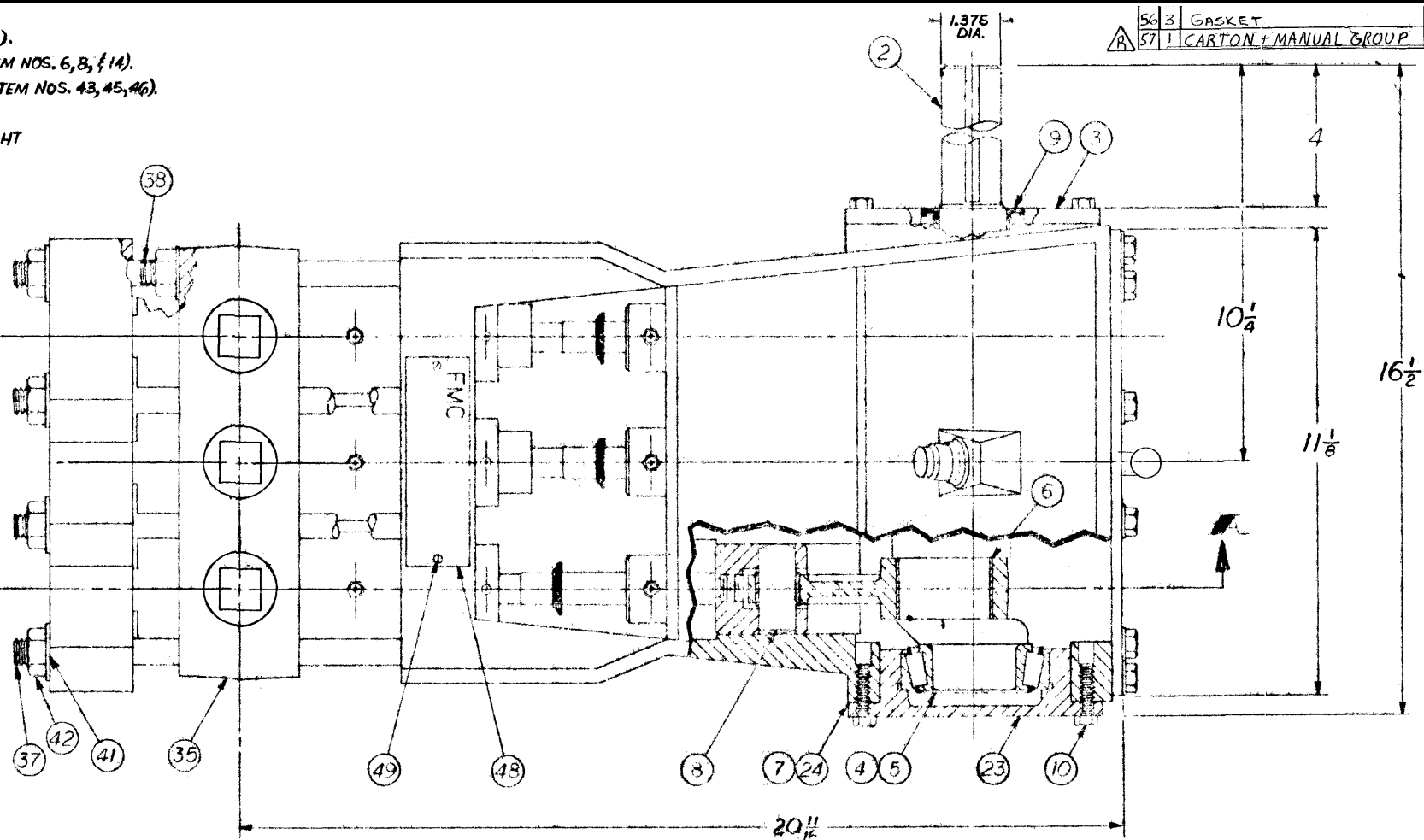
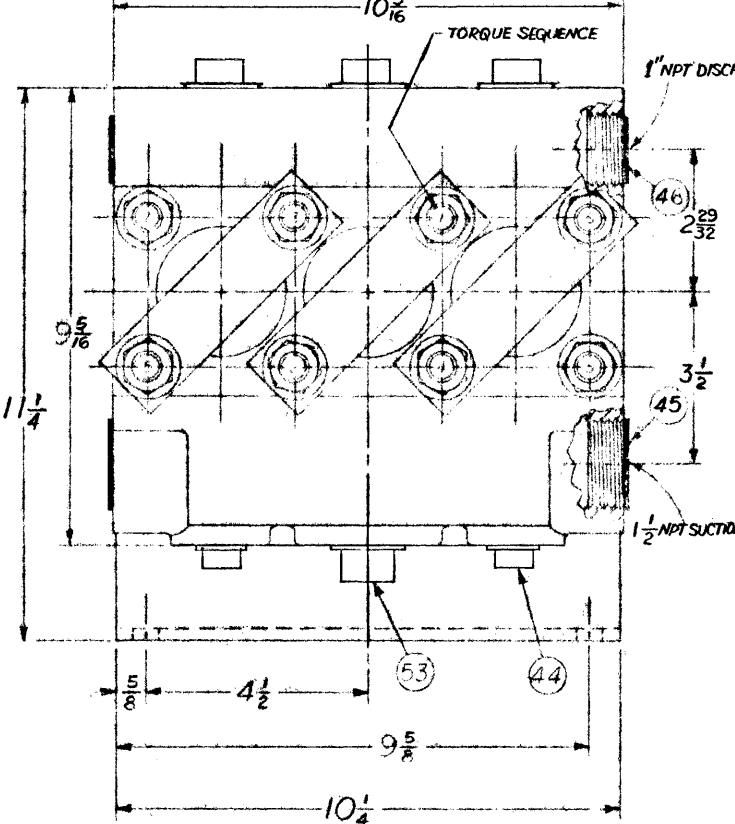
APPLY PERMATX NO. 2 TO HOLDER (ITEM 17) BEFORE PRESSING INTO CASE (ITEM 1).
 APPLY LUBRAPLATE TO CONNECTING ROD BEARING, WRIST PINS & CROSSHEAD (ITEM NOS. 6, 8, & 14).
 APPLY LOCTITE PIPE SEALANT WITH TEFLON (CAT. NO. 92-31) TO PIPE PLUG (ITEM NOS. 43, 45, 46).
 OIL PACKING (ITEM 30) BEFORE INSERTING INTO STUFFING BOX (ITEM 25).
 5. CRANKSHAFT/TIMKEN BEARING-ASSEMBLE TO PROVIDE ENDPLAY OF .002 TIGHT TO .005 LOOSE. USE SHIM (ITEM 24) AS REQ'D.
 6. BOLT AND NUT TORQUE-

CONNECTING RODS — 40-45 FT. LBS.
 MOUNTING BASE — 20-25 FT. LBS.
 BEARING COVERS — 30-35 FT. LBS.
 VALVE CHAMBER — 115-120 FT. LBS. TORQUE TO $\frac{1}{3}$, $\frac{2}{3}$, $\frac{1}{2}$ FULL TORQUE AND RETORQUE AFTER 5 MIN. OF TESTING IN THE TORQUE SEQUENCE SHOWN.

7. FILL WITH 2 1/2 QTS. OF SAE 30 WT. NON DETERGENT OIL.
 8. TEST PUMP FOR 30 MINUTES.
 9. PUMP RUST PREVENTIVE SOLUTION THROUGH VALVE CHAMBER.
 10. DRAIN OIL
 11. TURN VALVE CHAMBER UPSIDE DOWN (DISCHARGE AT BOTTOM) AND PURGE WITH COMPRESSED AIR.
 12. STAMP NAMEPLATE WITH THIS INFORMATION —

BEAN PUMP
 MODEL NO. F PART NO. G SERIAL NO.
 ○ INTERMITTENT H.P. A @ B PSI MAX. CAP E GPM @ 600 RPM
 CONTINUOUS H.P. C @ D PSI U.S. PATENTS
FMC

MODEL (F)	A	B	C	D	E	G
MO606	15.2	5000	15.2	5000	4.4	
MO608	19.4	3400	16.0	2800	8.3	5261937
MO610	20.6	2200	16.9	1800	13.6	
MO612	20.3	1500	16.2	1200	19.6	5259871
MO615		1000	22.3	1000	32.3	



ITEM	QTY	DESCRIPTION	MO606	MO608	MO615	MO612
1	1	PUMP CASE				5253742
2	1	CRANKSHAFT				5253744
3	1	BEARING HOUSING				5254176
4	2	CONE-TIMKEN JM 205149				320125
5	2	CUP-TIMKEN JM 205112				320124
6	6	BEARING-CONNECTING ROD				5254180
7	2	GASKET-BEARING CAP				5254177
8	3	PIN, WRIST				5262026
9	1	SEAL GARLOCK 94 X 0760				5257492
10	12	3/8-16 X 1 1/4 HHCS				1100043
11	1	FOOT, REAR				5267122
12	12	HHCS 3/8-16 X 3/4				3205665
13	3	CONNECTING ROD				5262025
14	3	ASSEMBLY, CROSSHEAD				5259573
15	3	GREASE FITTING				1104954
16	1	BREATHER				1177536
17	3	HOLDER-OIL SEAL				5254195
18	6	OIL SEAL				1283603
19	1	3/4 X 1/8 BRUSH				1106430
20	1	GASKET-BASE				5254217
21	12	WASHER 3/8 WAVE				1177455
22	1	3/4 PLUG-MAGNETIC				1187037
23	1	HOUSING-BEARING				5256653
24	6	SHIM (USE AS REQUIRED)				5254178
25		SEE CHART				
26						
27						
28						
29						
30						
31						
32						
33						
34						
35						
36						
37	6	STUDS-LONG				5264059
38	2	STUDS-SHORT				5264060
39		SEE CHART				
40	3	CLAMP-COVER				5260055
41	8	WASHER 5/8-11-8-SS				3203821
42	10	NUT 5/8-11-18-8-SS				3203388
43	3	PLUG 1/4 BRASS SQ. HEAD				320226
44	2	PLUG 1/2 BRASS SQ. HEAD				320225
45	2	PLUG 1/2 PLASTIC				1177203
46	1	PLUG 1 PLASTIC				1177201
47	3	WASHER, BARRIER				5257373
48	1	NAMEPLATE				5262738
49	2	#4 X 3/16 SCREWS				1187413
50	3	GREASE FITTING				1100759
51	1	FOOT-FRONT				5254219
52	1	LIQUID LEVEL GAGE				5267123
53	1	PLUG 1/2 BRASS SQ. HEAD				320227
54	6	1/4-20 x 1/2 SET SCREW				103444
55	1	CAP PLUG				1177197

ITEM	QTY	DESCRIPTION	MO606	MO608	MO615	MO612
25	3	STUFFING BOX		5261941		5259810
26	6	O-RING		320506		320487
27	3	PLUNGER		5259341		5259632
28	3	BACKUP-STUFF BOX		5261940		5259814
29	3	LANTERN GLAND		5261938		5259866
30	3	PACKING, PLUNGER		5259395		5272410
31	3	THROAT RING		5261939		5259863
36	6	VALVE ASSEMBLY		5261934		5261934
33	3	WIPER RINGS		5262100		5262102
34	3	SPRING-PACKING		5259640		5259642
35	1	VALVE CHAMBER	5261701			5261393
39	3	COVER, VALVE CHAMBER	5261933			5261390
1	1	PUMP CASE				

NOTE: PAINT PUMP 1403050-11
 EXCEPT DO NOT PAINT ALUM BRONZE VALVE CHAMBER OR STUFFING BOX.

R	REVISED BOM	10/22/82	3-8-93	K	ADDED 1187151 & REMOVED 1177197	DL	9/11/82
Q	REMODULIZED BOM'S	9-5-90	9-5-90	J	WAS 5260065 AND 5256759	HL	11-12-87
P	MODULIZED 5268380 PUMP	8/11/88	8/11/88	H	WAS 5253742	HL	7-10-81
O	MODULIZATION OF BOM'S	5-22-85	5-22-85	G	WAS 1276364	HL	4-6-81
N	ADDED ITEM 55	1-22-85	1-22-85	F	WAS 6	DL	3-24-81
M	WAS 1187151, 5254214	10-15-84	10-15-84	E	ADDED ITEM 55	DL	4-2-80
L	WAS 5263652	7/26/83	7/26/83	D	ADDED SKID AND BOX	DL	2-12-80

T DEL 5268380 MO615
 S REV ITEM 33 FROM 5259868

REVISIONS BY DATE EGN

10/22/82
 10/25/88 11/93

10-10-94 (12/75)
 10-25-98 11/93

1403050-11

ADDED WIPER RINGS - (5-481) DL 7-23-79
 ADDED PAINT SPEC. DL 6-20-79
 (1) WAS 5259751 (2) WAS 5253742
 (3) ADD 1103444 DL 5/31/79

REVISIONS BY DATE
 TOTAL WEIGHT TOTAL WELD
 1403050-11 NOTE

11-10-78 FULL

FMC CORPORATION
 PUMP ASSEMBLY
 MO6 ALUM. BRONZE
 SERIAL PARTS LIST
 5259871