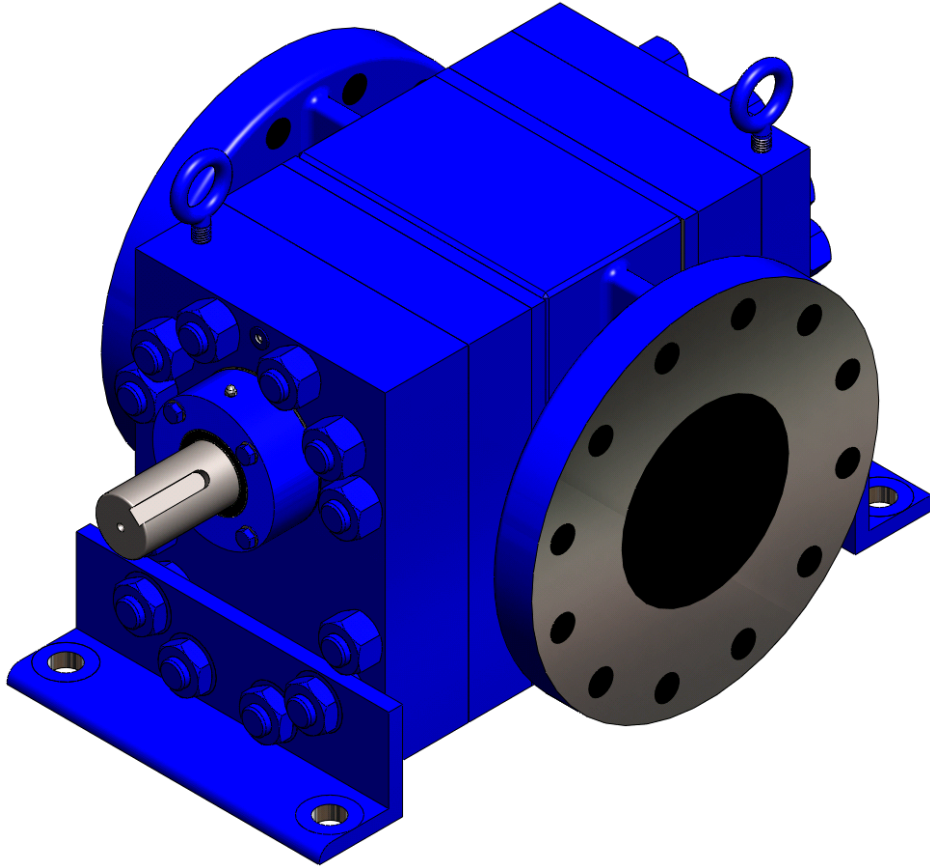


# Operation & Maintenance Manual

For 4900 Series Pumps

Bulletin 134



**NORTHERN<sup>®</sup> PUMP**

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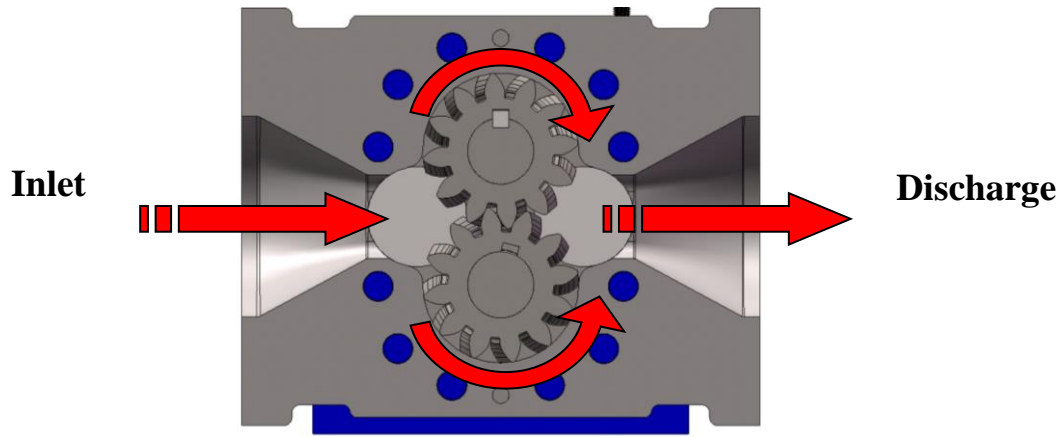
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**Appendix A: Exploded Drawing**

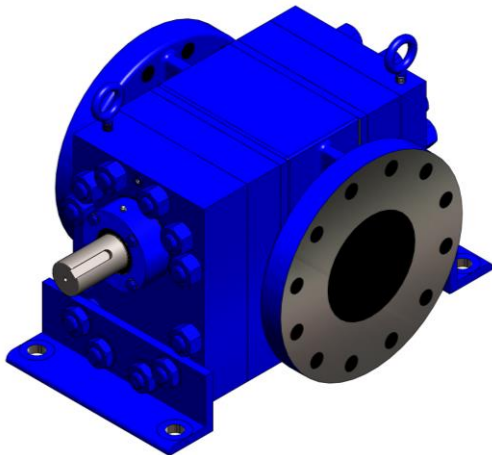
## Introduction

The 4900 Series gear pump is a positive displacement, rotary pump with two gears of equal size. The pump has a constant discharge at constant rotational speed. The inlet port of the pump is on the side where the gears are coming out of mesh. The discharge port is on the side of the pump where the gears are coming in to mesh. The pump transfers fluid trapped in the spaces between adjacent gear teeth and the cylinder from the inlet to the discharge side of the pump.

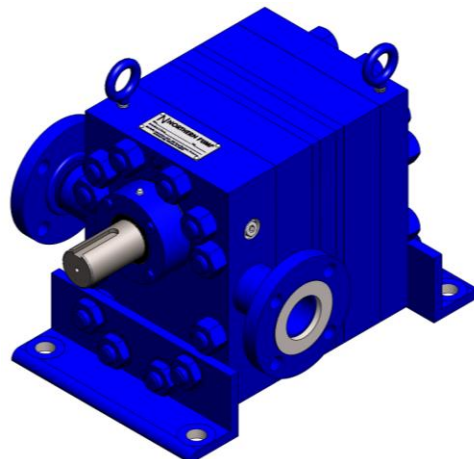


There are virtually unlimited variations of the pump assembly possible depending on the application. The combination of the width of the gear and the speed of the pump determine the flow rate. Generally, with narrower gears, the inlet and discharge ports are NPT connections and located on the seal adapter plate. With wider gears, the inlet and discharge ports are cast flanges and located on the cylinder. Welded flanges on the Seal Adapter Plate or Cylinder may also be used should the application require them. The shaft is typically sealed with a John Crane Type 21, mechanical seal; however, the pump assembly may use Type 8-1, Type 9 or a Type 8B1 seal.

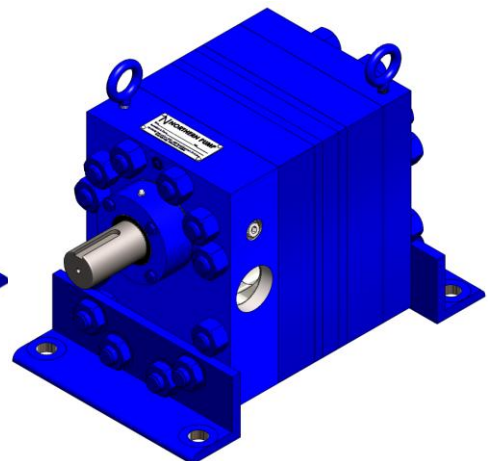
**Cylinder with Flanged Connections**



**Seal Adapter plate with welded flange assembly**

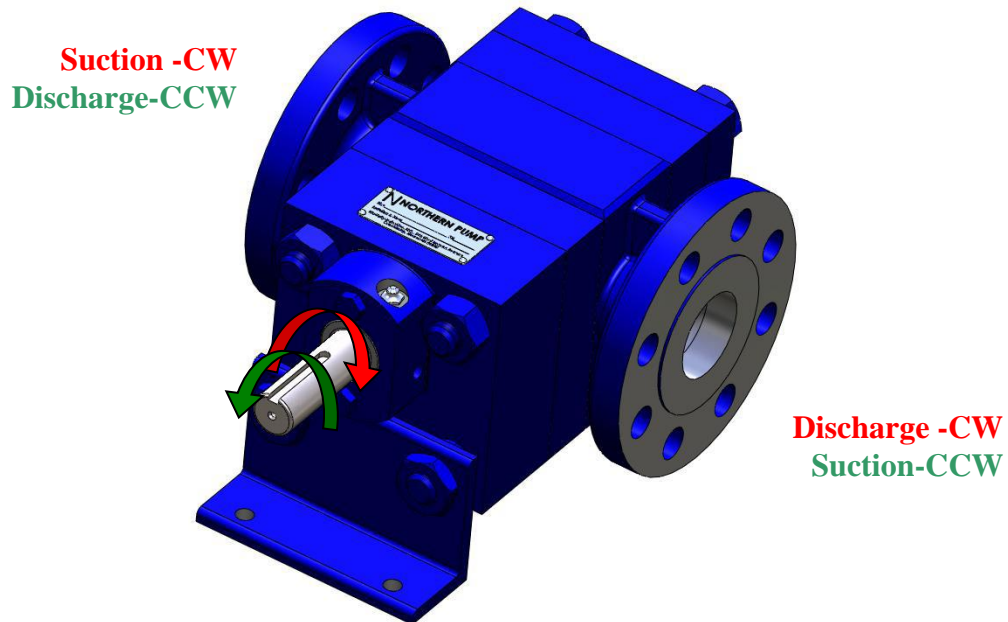


**Seal adapter plate with NPT Connections**



## Rotation

Rotation of the pump is determined by facing the end of the pump with the drive shaft protruding from it. (looking at the pump with the drive shaft pointed at you) If the discharge of the fluid comes out of the right side of the pump, it is clockwise rotation orientated. If the discharge of the fluid come out of the left side of the pump, it is counter-clockwise orientated. Both of the orientations are depicted below. The designed rotational orientation of the pump is printed on the ID Tag.



## **Cautionary Statements**

**Failure to heed these cautionary statements may result in personal injury and/or damage to equipment.**

1. Disable and lock-out the drive system before any work is done to install, maintain, or remove the pump.
2. Fully depressurize the entire system.
3. Close the valves closest to the pump in both the suction and discharge pipe.
4. Wear protective eyewear, and any other required face protection.
5. When handling corrosive, caustic, toxic, or hazardous liquids, wear protective clothing to prevent contact with skin.
6. Wear protective footwear such as safety shoes.
7. When handling liquids with toxic vapors, wear a properly rated breathing mask.
8. Work area must be properly ventilated.
9. Work area must be properly grounded.
10. Do not work alone.
11. Clean up any spilled liquid immediately.

## **Pump Installation**

1. 4900 series pumps are heavy. Use appropriate lifting and transportation methods and means (hoist, forklift, pallet jack, etc) when moving a pump.
2. Turn off and lock out the drive mechanism.
3. Fully depressurize both the suction and discharge lines to the pump.
4. Close the valve in the suction and discharge lines closest to the pump.
5. Place a pan or other liquid collecting device under the pump to collect the liquid that may drain from the pump and the suction and discharge lines when connected to the pump.
6. Level and properly align pump.
7. Line pipes up naturally. Forcing pipes into place with flange bolts can draw pump out of alignment. Support pipes independently to eliminate strain on pump casing. Check alignment again and correct if necessary.
8. Test inlet pipe lines with pressure for leaks to ensure that they are completely airtight. The inlet piping must have a diameter equal to, or larger than, the pump inlet port.
9. Test rotation of the motor to ensure that the pump rotates in the direction indicated by arrow on pump casing.
10. Do not subject pumps to thermal shock by exposing a cold pump to a hot liquid supply or vice versa.

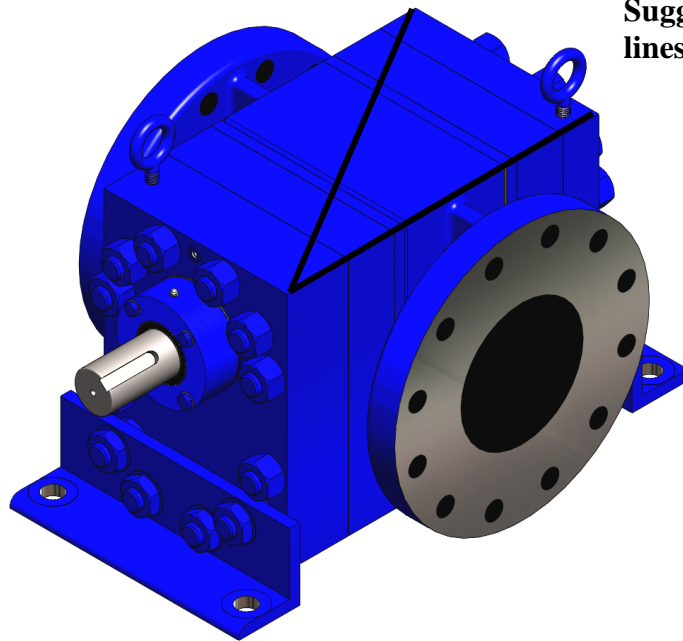
## **Removal from Installation**

1. Turn off and lock out the drive mechanism.
2. Fully depressurize both the suction and discharge lines to the pump.
3. Close the valve in the suction and discharge lines closest to the pump.
4. Place a pan or other liquid collecting device under the pump to collect the liquid that may drain from the pump or the suction and base plate when assembly is disconnected.
5. Remove the coupling hub and key from the drive shaft. Clean any residue from the drive shaft. Remove any burrs or upset metal from the surface of the drive shaft.

## Disassembly

The 4900 Series Pump assembly is a series of plates held together with Pump Studs (25) and two Dowel Pins (24). The dowels provide the alignment of the pump plates and are precision parts. The faying surfaces of the plates are ground flat and sealed with an O-ring. Be prepared to use some force to take the pump apart. However, you are also trying to reuse as much of the pump as possible, so be careful not to damage parts unnecessarily.

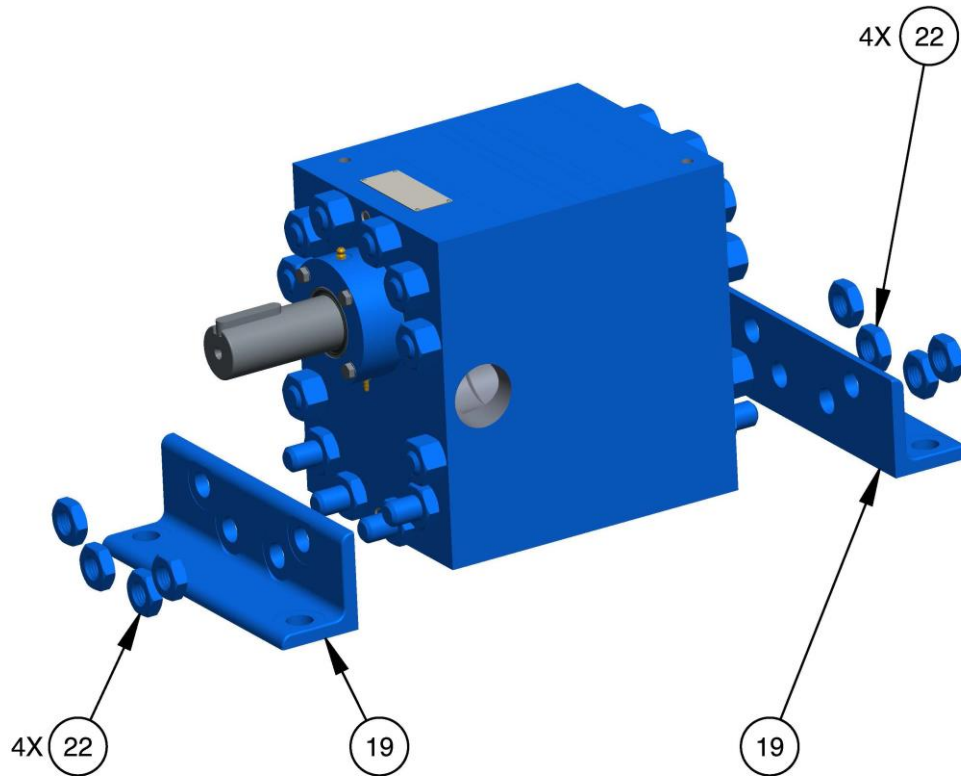
**It is important to re-assemble the plates in the same order and orientation as they were when shipped from our factory.** The plates are marked and numbered when shipped, but it is advisable before disassembly to mark the pump housing as shown to ensure that you will know how the parts were arranged before the pump was taken apart. A scribe line or permanent marker line along one edge and a diagonal from corner to corner works quite well.



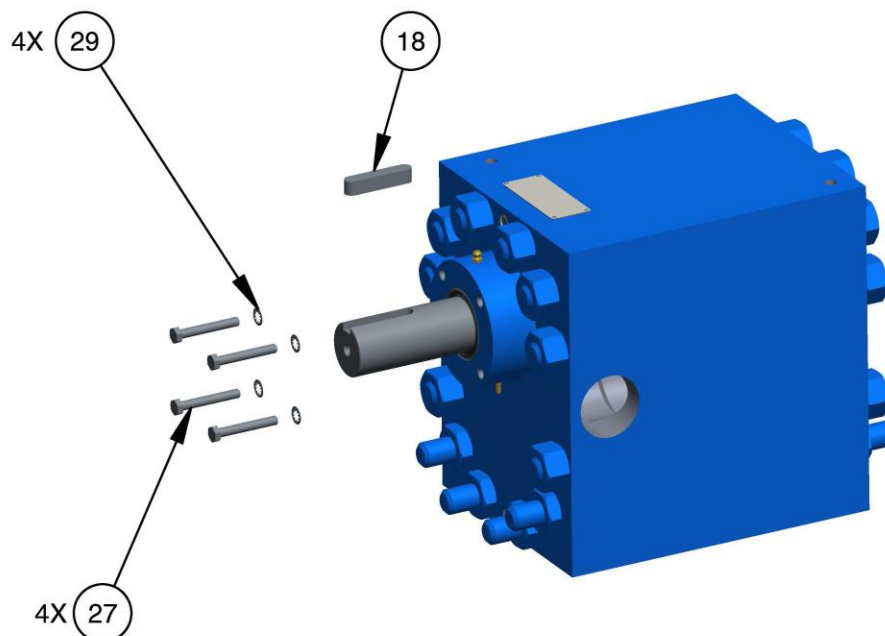
**Suggested marker or scribed lines across plates.**

## Disassembly Instructions

1. Remove the Jam Nuts (22) and the Mounting Brackets(19) from the front and rear of the pump.

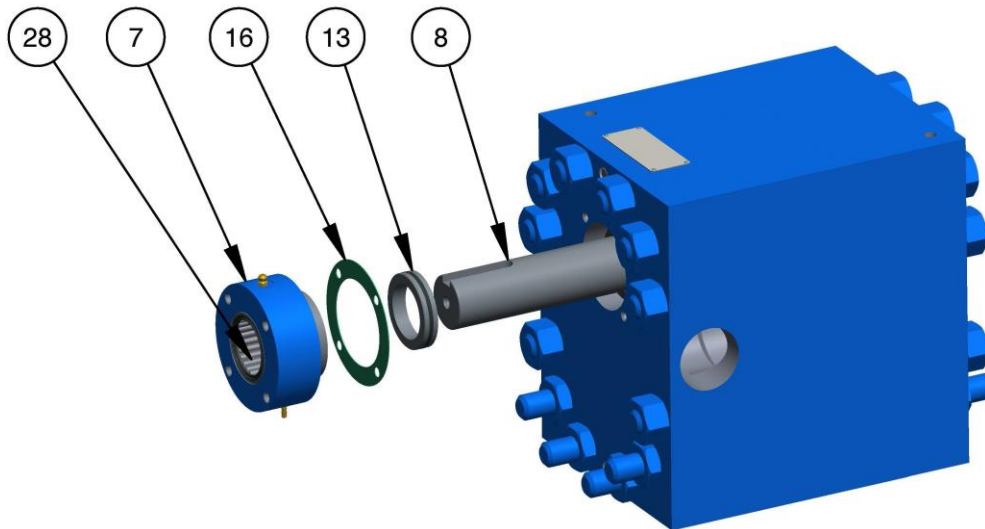


2. Loosen and remove the Cap Screws (27) and the Lock Washers (29) and remove the End Key (18).

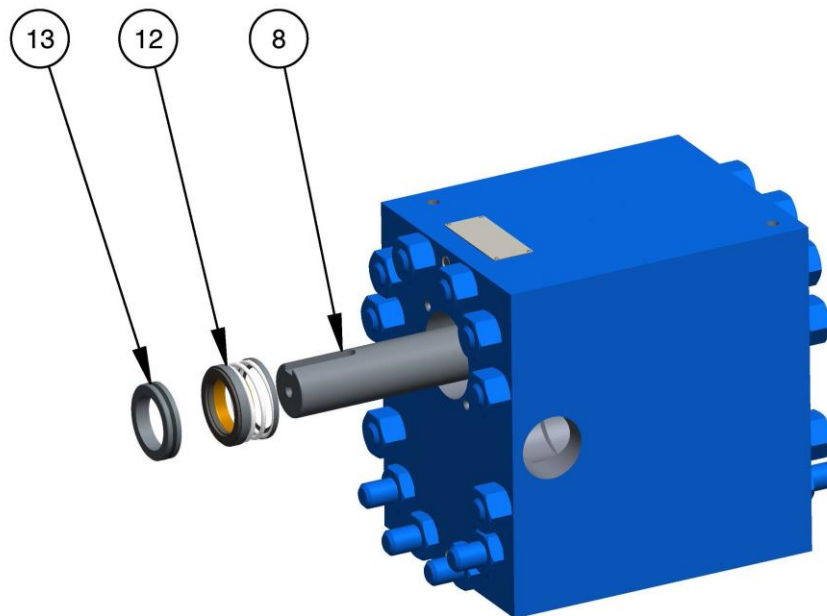




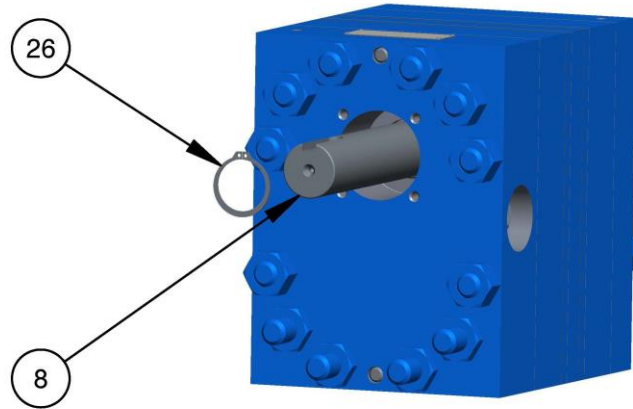
3. Remove the Bearing & Seat Housing (7) with the Support Bearing (28) and the Gasket (16) from the front of the pump. The Mechanical Seal Seat (13) may remain in the Bearing & Seat Housing.



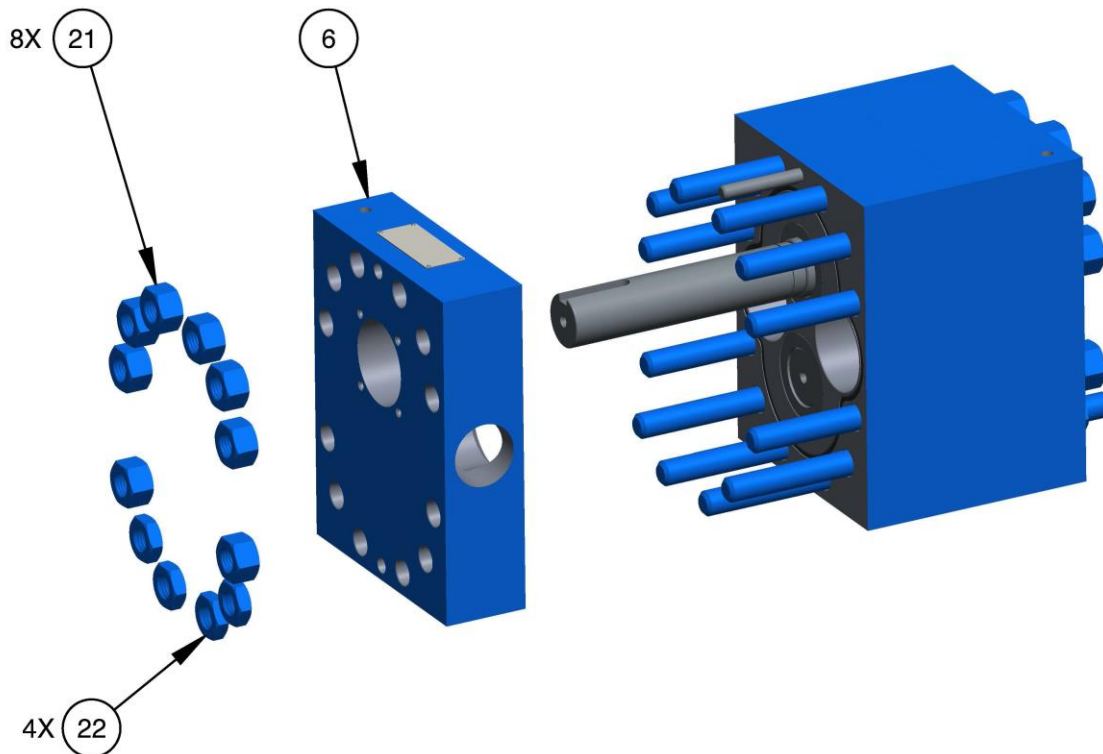
4. Slide the Type 21 Mechanical Seal (12) off of the end of the Drive Shaft (8). The Mechanical Seal Seat (13) may have already been removed in step 3. Note: other seal types may require additional steps for removal. See **Bulletin 102** for additional information.



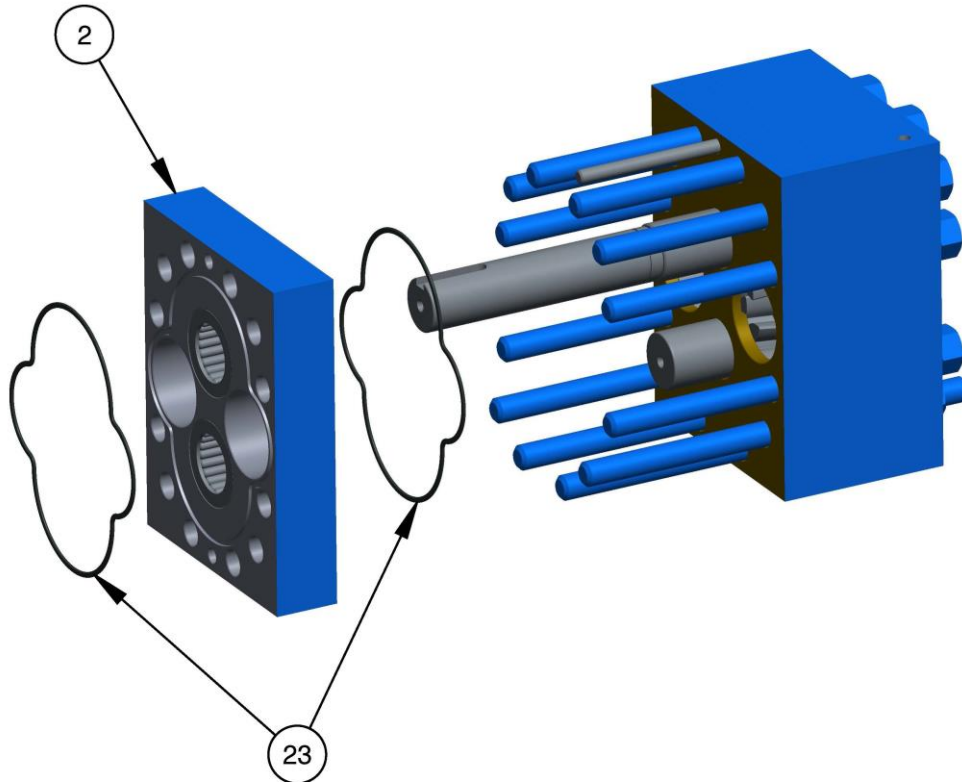
5. Remove the Retaining Ring (26) from the end of the Drive Shaft (8). Not required with some seal types.



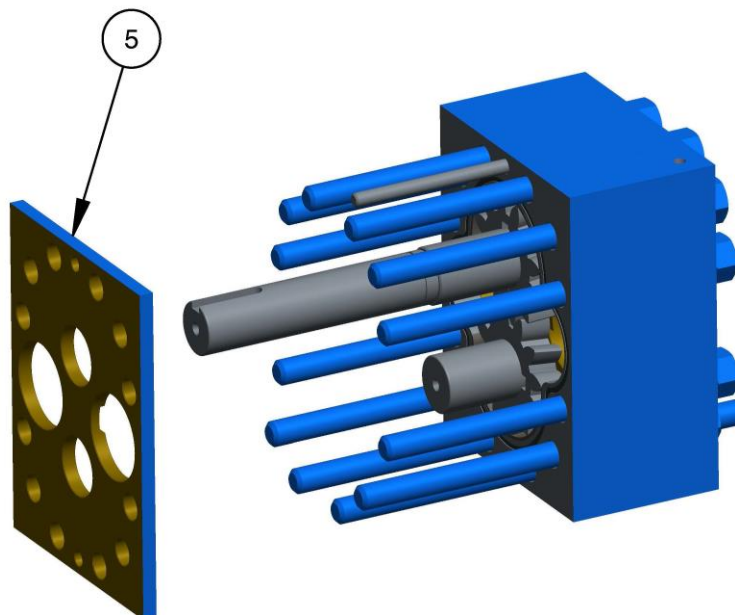
6. Loosen and remove the Whole Nuts (21) and Jam Nuts (22) from the front of the pump. Slide the Seal Adapter Plate (6) off of the front of the pump.



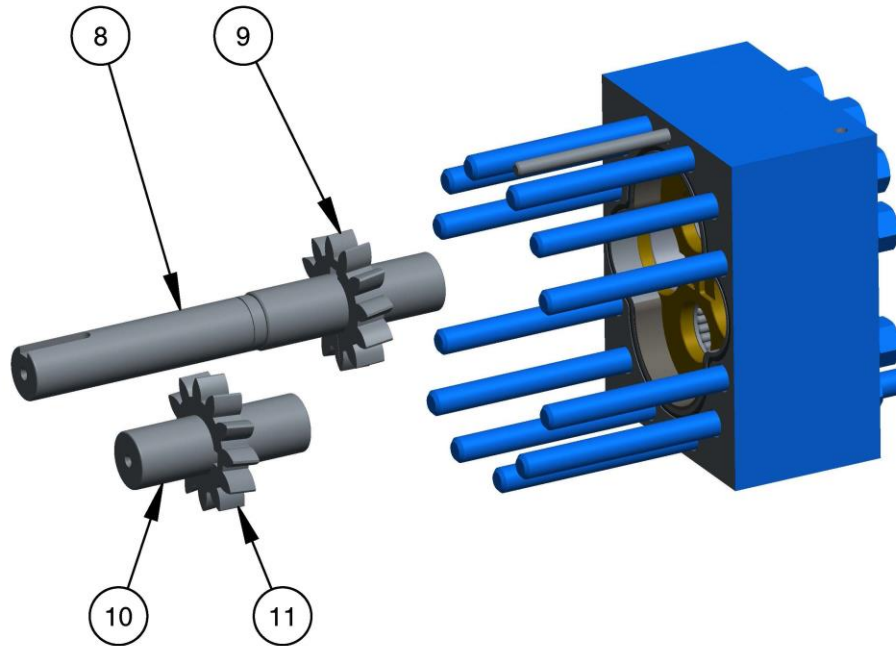
7. Slide the front Bearing Plate off the front of the pump. Some bearing rollers may fall out during this process. This is normal Separate the O'Rings (23) from the plate.



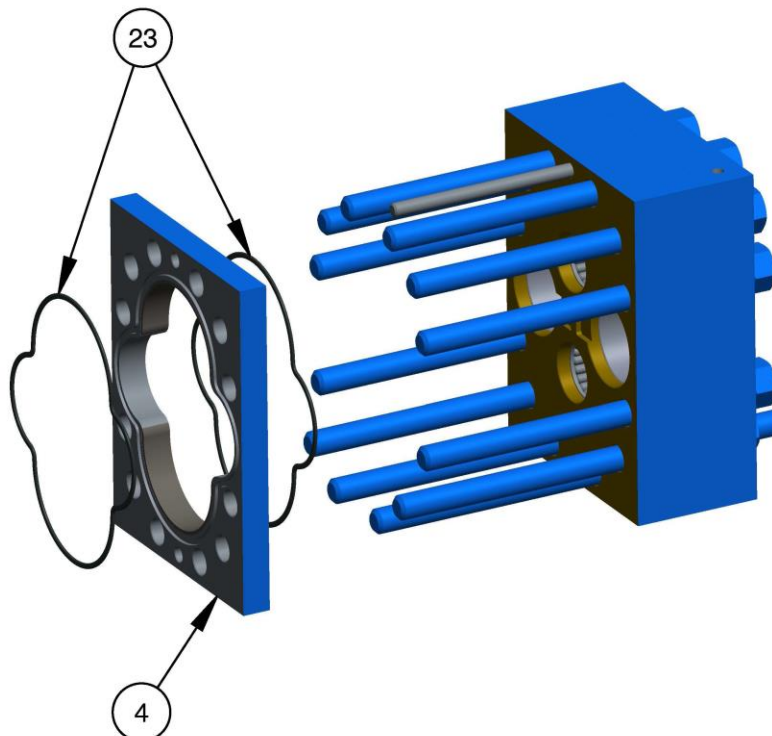
8. Slide the Front Liner Plate (5) from the front of the pump.



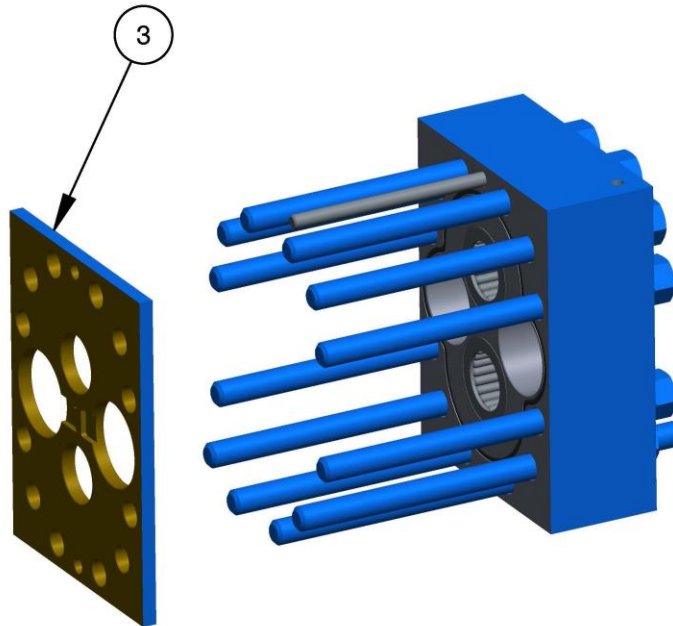
9. Remove the Drive Shaft (8) and Gear (9) and the Driven Shaft (10) and Gear (11) from the front of the pump.



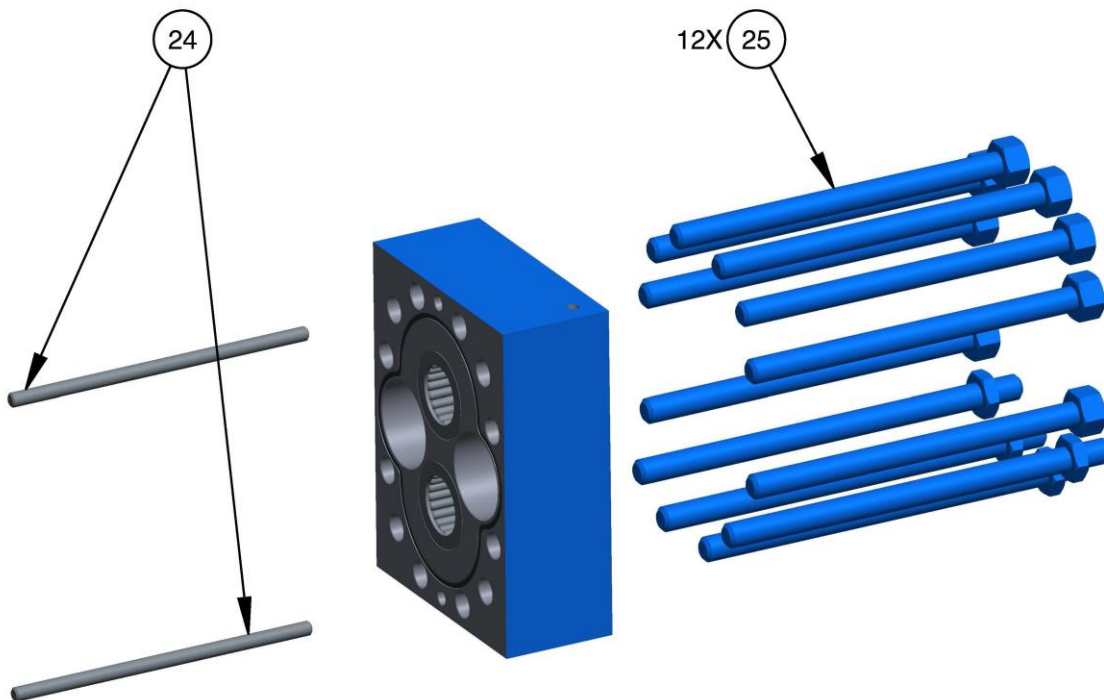
10. Slide the Cylinder (4) from the front of the pump and separate the O'Rings (23) from the plate.



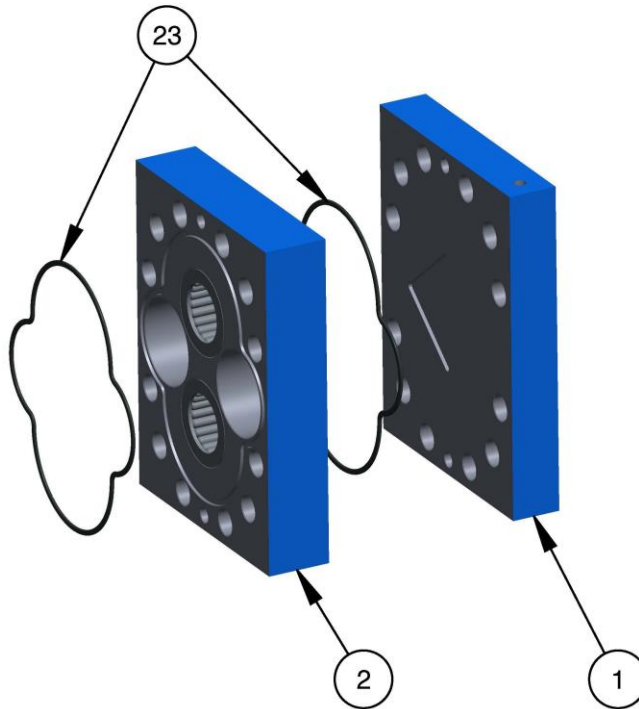
11. Remove the Rear Liner Plate (3) from the front of the pump.



12. Remove the Dowel Pins (24) from the front of the pump and remove the Pump Studs (25) from the rear of the pump.



13. Separate the rear Bearing Plate (2) from the End Plate (1) also separating the O'Rings (23) from the Bearing Plate. Some Bearing rollers may fall out during this process. This is normal



## Clean-up

1. Clean all parts of the pump in accordance with your specified cleaning procedures. Take all appropriate precautions to prevent damage to the parts of the pump during the cleaning process.
2. All pump parts should accept a wide variety of acceptable cleaning methods or chemicals.
3. All parts of the pump may be heated to 320°F (160 °C).
4. Clean the flat surfaces of the pump body parts by rubbing them lightly on a fine sand paper (240-320 grit) stretched or laid on a flat ground surface. Move the part in either a circular or figure eight pattern so that fine scratches are not produced across the part. Wetting the sand paper with solvent will improve the ability of the sandpaper to clean the parts.

## Inspection

1. Visually inspect all parts for obvious problems- scratches on surfaces that mate with seals, cracks, upset metal that will affect how parts mate together, burrs, or other serious wear. Correct problem or replace part as necessary.
2. Inspect the shaft and bearing plates for excessive grooves or other signs of severe wear in bearing bores and gear wear surfaces.
  - 2.1 The bearing bores must be free of major scratches and major scoring.
  - 2.2 The lubrication groove must be clean.
3. Inspect the drive shaft and gear for wear:
  - 3.1 No burrs or upset material is allowed on the surface of the drive shaft that mates with the coupling.
  - 3.2 Visually inspect the end surfaces of the gear. Major nicks, scratches, grooves, or other defects could be a sign of imminent gear failure.
  - 3.3 Visually inspect the Outside Diameter of the gear. No major nicks, scratches, grooves, or other defects are allowed.
  - 3.4 Visually inspect the gear teeth. The surfaces of the gear teeth must be smooth and free of obvious wear or damage.
4. Inspect the driven shaft and gear for wear:
  - 4.1 No burrs or upset material is allowed on the surface of the drive shaft that mates with the coupling.

- 4.2 Visually inspect the end surfaces of the gear. Major nicks, scratches, grooves, or other defects could be a sign of imminent gear failure.
  - 4.3 Visually inspect the Outside Diameter of the gear. No major nicks, scratches, grooves, or other defects are allowed.
  - 4.4 Visually inspect the gear teeth. The surfaces of the gear teeth must be smooth and free of obvious wear or damage.
5. Inspect the cylinder for wear:
    - 5.1 Visually inspect the end surfaces of the cylinder. No nicks, burrs, or scratches are allowed on the ends of the cylinder.
    - 5.2 Visually inspect the gear bores for any sign that the gear has contacted the surface of the gear bore. No major nicks, scratches, grooves, or galling is allowed on the gear bore surface. If any of these conditions exist, check the gear outer diameter, shaft bearing diameter, and bearing bore diameter for wear and replace as necessary.
6. Inspect the seal adapter plate:
    - 6.1 Visually inspect the seal adapter plate for nicks, scratches, or burrs on the mating surfaces. No nicks, scratches, or burrs that will affect the mate-up of the parts at assembly or that will affect the ability of the O-ring to properly seal are allowed.
7. Inspect the Bearing & Seat housing:
    - 7.1 Inspect the bearing and bore. No scoring or other abnormal wear patterns are allowed. If necessary, the bearing may be pressed out of the Bearing housing and replaced by pressing in a new one.
8. Inspect the O-rings:
    - 8.1 Visually inspect the O-rings. No nicks, scratches, cuts, tears, or permanent deformation are allowed.
    - 8.2 Inspect the O-rings for aging. The O-rings must be firm and pliable. Replacement of O-rings is recommended whenever the pump is disassembled.



## Assembly

1. Visually inspect all parts for obvious problems- scratches on surfaces that mate with seals, cracks, upset metal that will affect how parts mate together, burrs, or other serious wear. Correct problem or replace part as necessary.
2. During pump assembly the End Plate (1) should be lying flat with the Dowel Pins (24) and Pump Studs (25) extending vertically from the face of the plate. This vertical orientation will aid in alignment of the shafts and plates in relation to the main pump and support bearings.
3. Complete disassembly procedures in reverse order.
4. Use a light coat of a stable, pure, synthetic oil on the shafts, gear, and studs to facilitate assembly.
5. Avoid touching the polished faying surfaces of the Mechanical Seal Head (13) and Seat (12).
6. Torque the Whole nuts (21) and Jam nuts (22) to not more than 180 foot-pounds.
7. Drive shaft & gear should turn freely after completion of assembly.

## Trouble Shooting Guide (Standard for all 4000 series pumps)

Problem	Solution
Key will not fit into keyway in drive shaft	Check for burrs and nicks in the keyway and on the key. Remove as required. Measure width of key and keyway, if an interference fit is found, reduce the width of the key.
Motor shaft turns but pump shaft does not	Verify that the coupling has been properly installed with the correct key in each hub. Verify that the set screws are properly tightened in each coupling hub.
Pump will not prime	<p>Check for air leaks in the suction line.</p> <p>Check for correct rotation of the pump shaft -- CW when facing the shaft end of the pump.</p> <p>“Wet” the internals of the pump with the liquid to be pumped to provide a liquid hydraulic seal in the pumping chamber.</p> <p>Make sure that all suction and discharge line valves are open.</p> <p>Make sure that the suction and discharge lines are free of obstructions.</p>
Pump requires too much torque	Make sure that the viscosity of the liquid being pumped is not abnormally high. Check alignment of pump.
Pumped liquid has entrained air	Check for air leaks in suction line.
Flow rate is too low	<p>Make sure that the viscosity of the liquid being pumped is not abnormally low.</p> <p>Make sure that the discharge pressure is not abnormally high.</p> <p>Make sure that there are no air leaks in the suction line.</p> <p>Verify that the rotational speed is correct.</p> <p>Disassemble pump and verify that the internal clearances are within specification.</p>

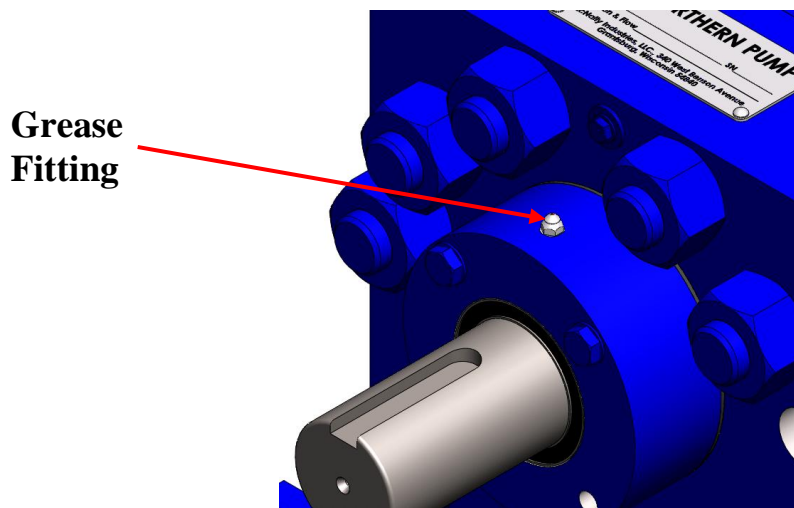
## Lubrication and Preventative Maintenance

The pump is fully lubricated by the pumped liquid. Dry running must be avoided, as it will cause internal damage to the pump.

It is recommended that a very small amount of a liquid compatible with the liquid to be pumped be put into the pump at startup. This will lubricate the pump during the startup period and make the pump much easier to prime.

Grease Outer Support Bearing (28) located in the Bearing & Seat Housing (7) with Mobilith SHC 1500 or equivalent every 6 months or every 500 hours of operation, whichever occurs first (see image below).

There are no other maintenance requirements.



APPENDIX A

PARTS LIST		
ITEM NO.	DESCRIPTION	QUANTITY
1	PLATE, END	1
2	BEARING PLATE	2
3	LINER PLATE, REAR	1
4	CYLINDER	1
5	LINER PLATE, FRONT	1
6	SEAL ADAPTER PLATE	1
7	HOUSING, BEARING AND SEAT	1
8	DRIVE SHAFT	1
9	GEAR, PUMP, HELICAL L.H.	1
10	DRIVEN SHAFT	1
11	GEAR, PUMP, HELICAL R.H.	1
12	SEAL, MECHANICAL TYPE 21	1
13	MECHANICAL SEAL SEAT	1
14	BEARING ASSEMBLY	4
15	FITTING, BARB, 1/16TH NPT TO 1/8" BRASS	1
16	GASKET	1
17	GREASE FITTING	1
18	KEY, END	1
19	MOUNTING BRACKET	2
20	NAME PLATE AND PINS	1
21	NUT, HEX, HEAVY	16
22	NUT, HEX, HEAVY JAM	16
23	O-RING	6
24	PIN, DOWEL	2
25	PUMP STUD	12
26	RETAINING RING	1
27	SCREW, CAP	4
28	SUPPORT BEARING	1
29	WASHER, LOCK	4

