

Precision Shop  
Acceptance Inspection  
Impco 300 Thick Stock Pump  
SAP# 1115851, PO# 4206250  
Eq. # 7538, S.N. 2612R

3/26/13

This unit was rebuilt by Schur and Company. We found the following measurements:

1. Input shaft- .0015 runout; .002" deflection; .0005" axial play; diameter is 4.000" at the end, and 4.002" in eight inches. Keyway is 1".
2. Runout at sleeves- input end drive, .001"; input end driven, .0015"; gear end drive, .0005"; gear end driven, .0005" (maximum allowable runout is .003").
3. Suction side rotor clearances- Drive, coupling side, .016"; gear, .022"; driven, coupling side, .015"; gear, .023"
4. Discharge side rotor clearances- drive, coupling side, .023"; gear, .017"; driven, coupling side, .022"; gear, .017"

The measurements did not change with rotation, so the case is slightly out of square- should not be an issue. Standard range is .010" to .020"

There was paint overspray on all four sleeves, which we cleaned off with solvent. The gear end gland toggle bolt had been hit by a truck fork and bent. Took it off and repaired it, then packed unit with ML2240.

The gland water ports on the coupling side are 3/4" NPT, all the way to the stuffing box bore, which leaves the first ring of packing unsupported for about an inch. We'll have to watch this for squeeze-out. The gear side ports are 3/8" NPT.

The bolts in both covers and the main case are a hodge-podge of Gr2, 5, 8, 304 & 316 ss. We don't have torque specs, and the old manuals don't speak to the issue.

We had to turn the gear end cover 180° to put the sight glass at the proper level for horizontal operation. We called Schur, who

said the orientation of the cover doesn't matter, unless the pump has a back-stop clutch. They said not to re-pin it. We reassembled with new bolts.

It is not practical to store this unit in run position, so we moved the sight glasses and installed plugs in the drain and breather ports, and added a pint of Vaprotect oil in each end. We also greased the four inboard seals and coupling shaft seal.

Brian Abbott

PLANT CODE : 0630 BUCKS PORT - VER SO PA PER

MATERIAL: 1115 851 PUMP, THK STOCK 70PS I IMP CO 30 0 UoM: EA EACH

FOR G WD TH ICKEN ER ST OCK P UMP P OSITI ON LO CATED ON  
TOP F LOOR IN TM P PLA NT, E Q. 75 38,75 17, 4-SP- 93',

TOTAL ONH: 0.000  
RESER VED: 0.000  
UNRES TRICT TOT: 0.000  
IN TR ANSIT : 0.000  
CONSI GNMENT T: 0.000  
PROJE CT: 0.000  
OTHER : 0.000  
REORD ER PT : 1.000  
MAX L EVEL: 1.000  
ON OR DER: 1.000  
MRP T YPE: VB MA NUAL REORD ER PO INT P LANNI NG

ABC I ND.:  
Old M aterial: 98420 4354  
MATL. GRP. : 26026 PUMP MAKER S NAM E I  
VAL. CLASS : 6709 PUMPS AND PARTS  
ORIGI N GRO UP:  
AVG. PRICE : 0.00  
PR. U NIT: 1  
USAGE L12: 0.000  
USAGE YTD: 0.000  
ITM C LASS CODE: 06 RE PAIR AND R ETURN  
ITM C LASS CODE:  
ITM C LASS CODE:

REVIE W DAT E: 03/20 /2009  
REVIE W NOT ES: STAR

STG L OC.: 0001

UNRES TRICT ED: 0.000  
CONSI GNMENT T: 0.000  
PROJE CT: 0.000  
OTHER : 0.000  
BIN L OC.: 90260 1  
LST C YCL: 10/24 /2012  
DATE STOCK ED: 11/16 /2001  
LAST ISSUE DATE 08/10 /2011

VENDO R CO NTRAC T #VE NDOR NAME CON TRACT PRI CE DA TE FIXE D MRP REL. C ONTAC T P LND.D AYS PH ONE TAX CODE

15423 3 VE RSO P APER MECHA NICAL SHOP S 1 12/ 31/99 99 X 28 00 00000 00

LAST 4  
P.O.- ITEMS  
42062 50 0000 1 1.00 0 0 .000 0 10/26 /2011 1 0/31/ 2012 00 /00/0 000  
41543 17 0000 1 1.00 0 0 .000 0 05/26 /2010 0 6/26/ 2010 00 /00/0 000  
C0028 34423 0000 1 1.00 0 1 .000 127 08/01 /2006 1 0/02/ 2006 C12 /06/2 006