

**[3. Method of Assembling Casing Side]**

<p><b>3-2S1-1 Attachment of Anti-Wear Plate</b></p>		
	<p><b>Working Process</b></p> <p>Attach the anti-wear plate.</p>	
<p><b>3-2S1-2 Attachment of Anti-Wear Plate</b></p>		
	<p><b>Working Process</b></p> <p>Insert a seal washer, flat washer, spring washer, and nut onto a stud bolt in that order (from left in the drawing below), and lightly tighten them with the socket wrench (13).</p>	<p><b>Tools to Be Used</b></p> <ul style="list-style-type: none"> <li>* socket wrench (13)</li> </ul>
<p><b>3-2S1-3 Attachment of Anti-Wear Plate</b></p>		
	<p><b>Working Process</b></p> <p>Insert the components in the same manner as in 3-2S1-2, and lightly tighten at two positions (see the drawing on the left). Tighten evenly with the socket wrench (13) after the nuts have been lightly tightened at three positions.</p>	<p><b>Tools to Be Used</b></p> <ul style="list-style-type: none"> <li>* socket wrench (13)</li> </ul>
<p><b>3-2S1-4 Clearance Check</b></p>		
	<p><b>Working Process</b></p> <p>Measure dimension A, shown in the drawing on the left, using a depth gauge. The design dimension of the specifications for motor 4P is 38 mm. (For the specifications for motor 2P, please contact the sales agent of the product. ) If dimension A has become larger due to wear, the pumping power will be affected by that dimension change. (for example, 39 mm or more) In such a case, please replace the anti-wear plate.</p>	<p><b>Tools to Be Used</b></p> <ul style="list-style-type: none"> <li>* Depth gauge</li> </ul>

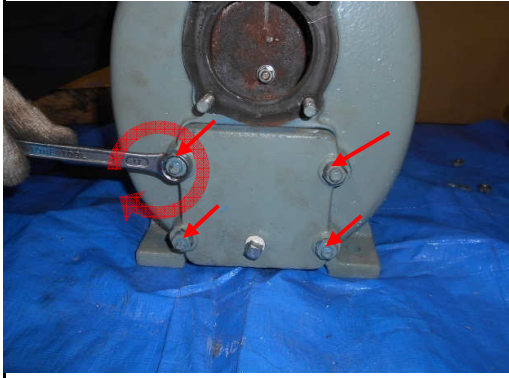
**3-2S1-5 Attachment of Drain cover packing**



Working Process

Attach the drain cover packing

**3-2S1-6 Attachment of Drain cover**

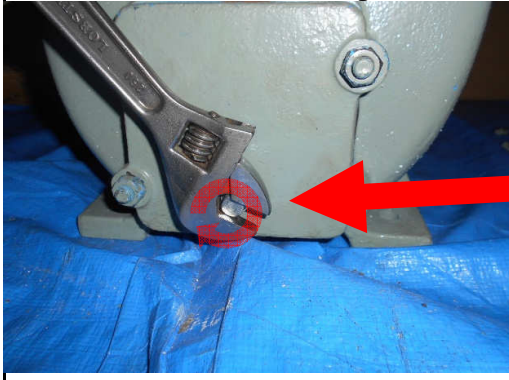


Working Process

Attach the drain cover, and tighten four nuts with equal torque using the combination spanner (17).

**Tools to Be Used**  
 • Combination Spanner (17)

**3-2S1-7 Attachment of Plug**



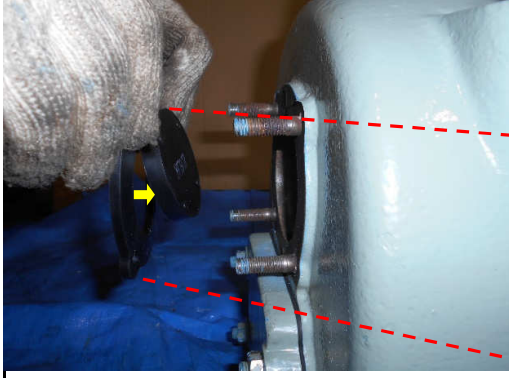
Working Process

Wind some sealant tape around the plug, and tighten with a monkey wrench.



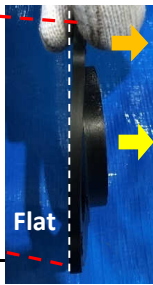
**Tools to Be Used**  
 • Monkey wrench  
 • Industrial sealant tape

**3-2S1-8 Attachment of Self-priming packing**



Working Process

Attach the self-priming packing while referring to the drawing on the left and the drawing below.  
 \* Some products do not have self-priming packing at the center.



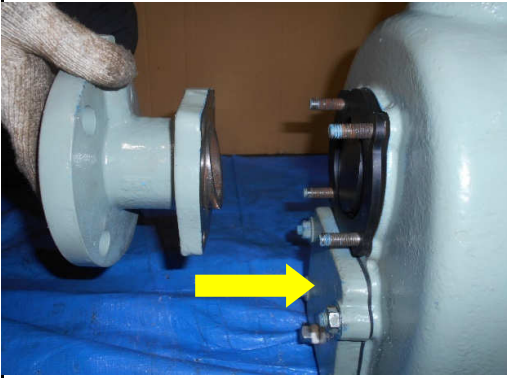
**3-2S1-9 Attachment of Self-priming packing**



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**3-2S1-10 Attachment of Valve case**



<b>Working Process</b>	Attach the valve case to the casing.

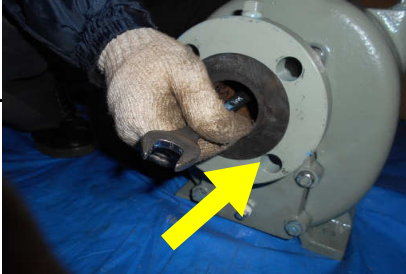
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**3-2S1-11 Attachment of Valve case**



<b>Working Process</b>	tighten four nuts with equal torque using the combination spanner (17).
	Use a spanner to check whether the self-priming packing is working properly.

<b>Tools to Be Used</b>
• combination spanner (17)



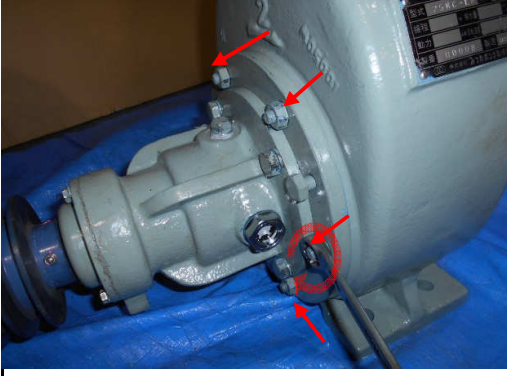
**3-2S1-12 Attachment of Rotating parts**



<b>Working Process</b>	Attach the rotating parts to the casing.

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### 3-2S1-13 Attachment of Rotating parts



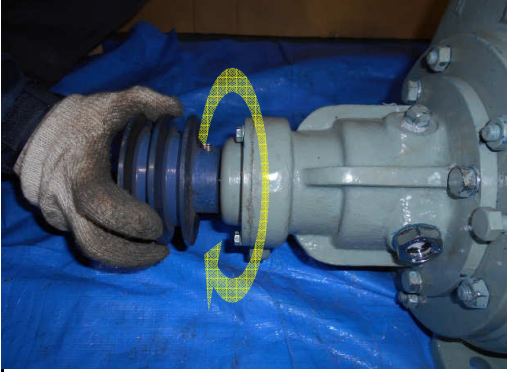
Working Process

Tighten six nuts with equal torque using the combination spanner (17) to fix the rotating part.

#### Tools to Be Used

- combination spanner (17)

### 3-2S1-14 Confirmation of Operation



Working Process

Rotate the shaft by hand and make sure that nothing is making contact inside.

### 3-2S1-15 Pressure hold check



Working Process

Here, a pressure hold check should be carried out. Seal the casing so that it is airtight. Then, apply an air pressure of 0.3 MPa and hold it for 10 minutes. If the pressure drops, find and fix the leaking part, and then mount the components again.

#### Tools to Be Used

- Pressure hold checker
- pressure gauge

### 3-2S1-16 Completion



Working Process

Attachment of the rotating part is completed.