

Torque Table

Pump Rotor Size	Bolt Description (IDP #)	Torque
187	Inlet Bolt (4)	110 ± 10 Lb-Ft (150 ± 14 N-m)
	Thrust Plate Bolt (102)	144 ± 10 Lb-in (16 ± 1 N-m)
	Inboard Cover Bolt (4 or 93)	110 ± 10 Lb-Ft (150 ± 14 N-m)
	Bearing Retainer Bolt (47)	110 ± 10 Lb-in (13 ± 1 N-m)
218	Inlet Bolt (4)	150 ± 10 Lb-FT (203 ± 14 N-m)
	Thrust Plate Bolt (102)	35 ± 2 Lb-Ft (48 ± 3 N-m)
	Inboard Cover Bolt (4)	150 ± 10 Lb-FT (203 ± 14 N-m)
	Bearing Retainer Bolt (47)	25 ± 2 LB-Ft (34 ± 3 N-m)
250	Inlet Bolt (4)	150 ± 10 Lb-FT (203 ± 14 N-m)
	Thrust Plate Bolt (102)	30 ± 2 Lb-Ft (40 ± 3 N-m)
	Inboard Cover Bolt (4)	205 ± 15 Lb-Ft (278 ± 20 N-m)
	Bearing Retainer Bolt (47)	22 ± 2 Lb- Ft (30 ± 3 N-m)
275	Inlet Bolt (4)	55 ± 5 Lb-Ft (75 ± 7 N-m)
	Thrust Plate Bolt (102)	30 ± 2 Lb-Ft (40 ± 3 N-m)
	Inboard Cover Bolt (4)	130 ± 10 Lb-in (176 ± 14 N-m)
	Bearing Retainer Bolt (47)	35 ± 2 Lb-Ft (48 ± 3 N-m)
312	Inlet Bolt (4)	100 ± 10 Lb-Ft (137 ± 14 N-m)
	Thrust Plate Bolt (102)	60 ± 5 Lb-Ft (81 ± 7 N-m)
	Inboard Cover Bolt (4 or 93)	130 ± 10 Lb-in (176 ± 14 N-m)
	Bearing Retainer Bolt (47)	44 ± 2 Lb-Ft (60 ± 3 N-m)

I. TROUBLESHOOTING

For assistance with troubleshooting see General Instruction Manual, SRM00046.

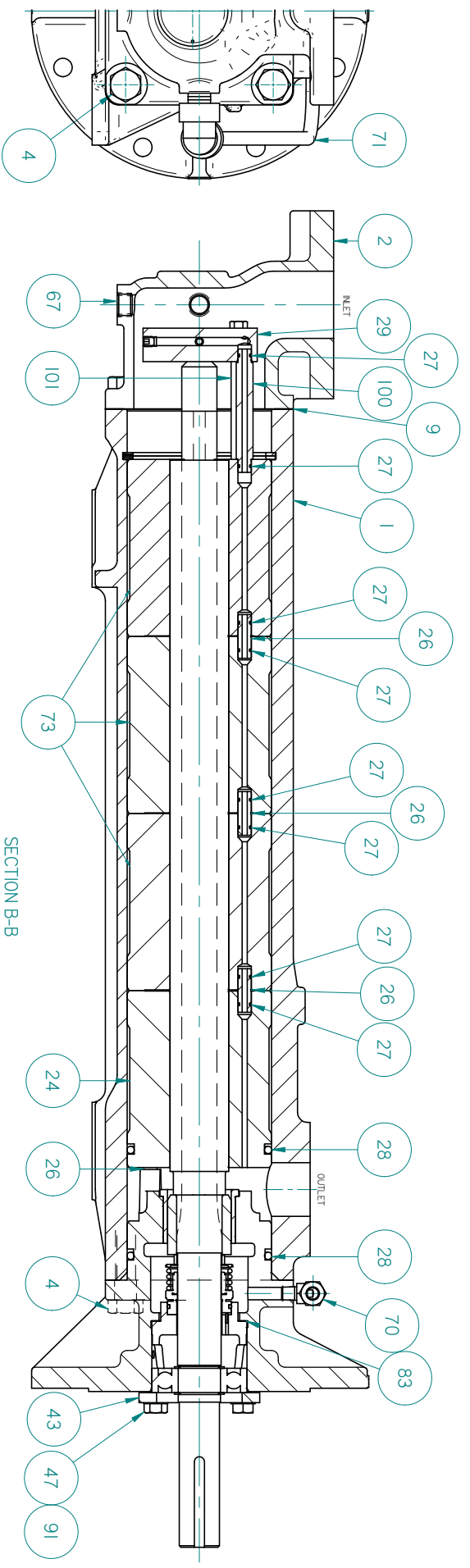
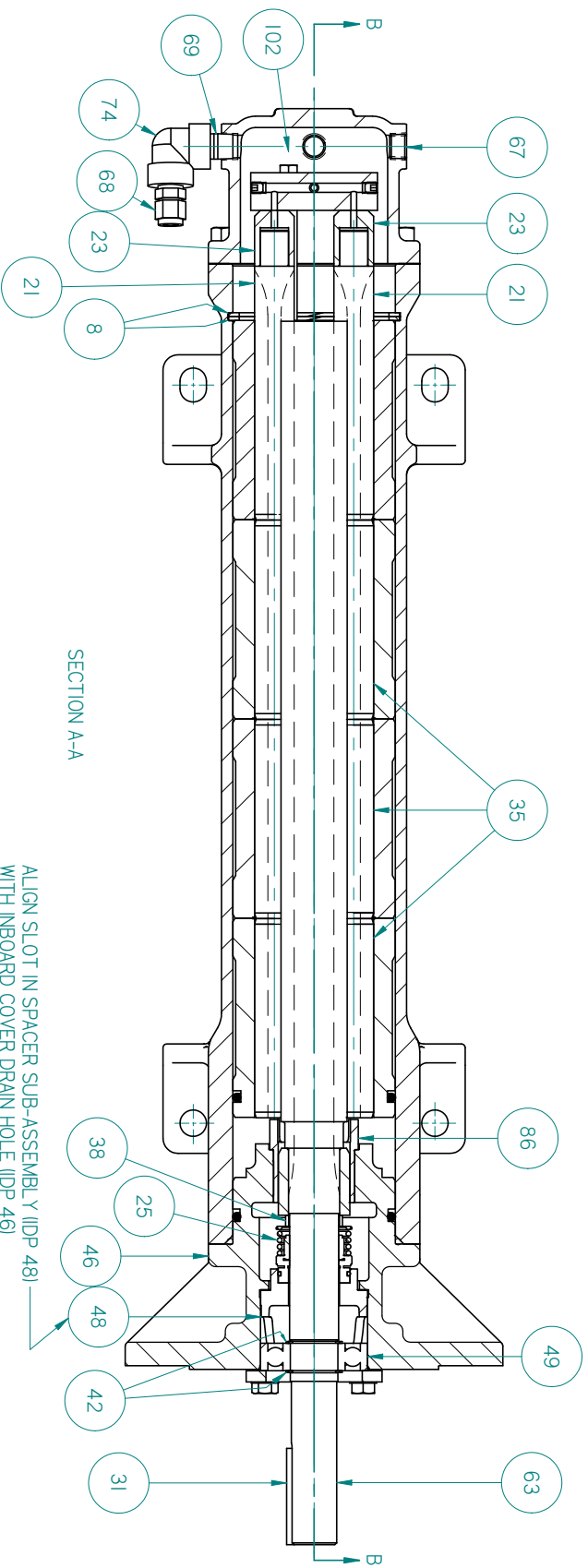
J. FIELD AND FACTORY SERVICE AND PARTS

Imo Pump maintains a staff of trained service personnel to provide pump installation, pump start-up, maintenance/overhaul and troubleshooting supervision as well as installation and maintenance training.

Our factories provide maintenance as well as overhaul and test facilities in the event user prefers to return pumps for inspection or overhaul. Factory-overhauled pumps are normally tested and warranted “as-new” for a period of one year from date of shipment. For either field service or factory overhaul assistance, contact your local Imo Sales Office or representative at Technical/ Customer Service Department in Monroe, NC, USA.

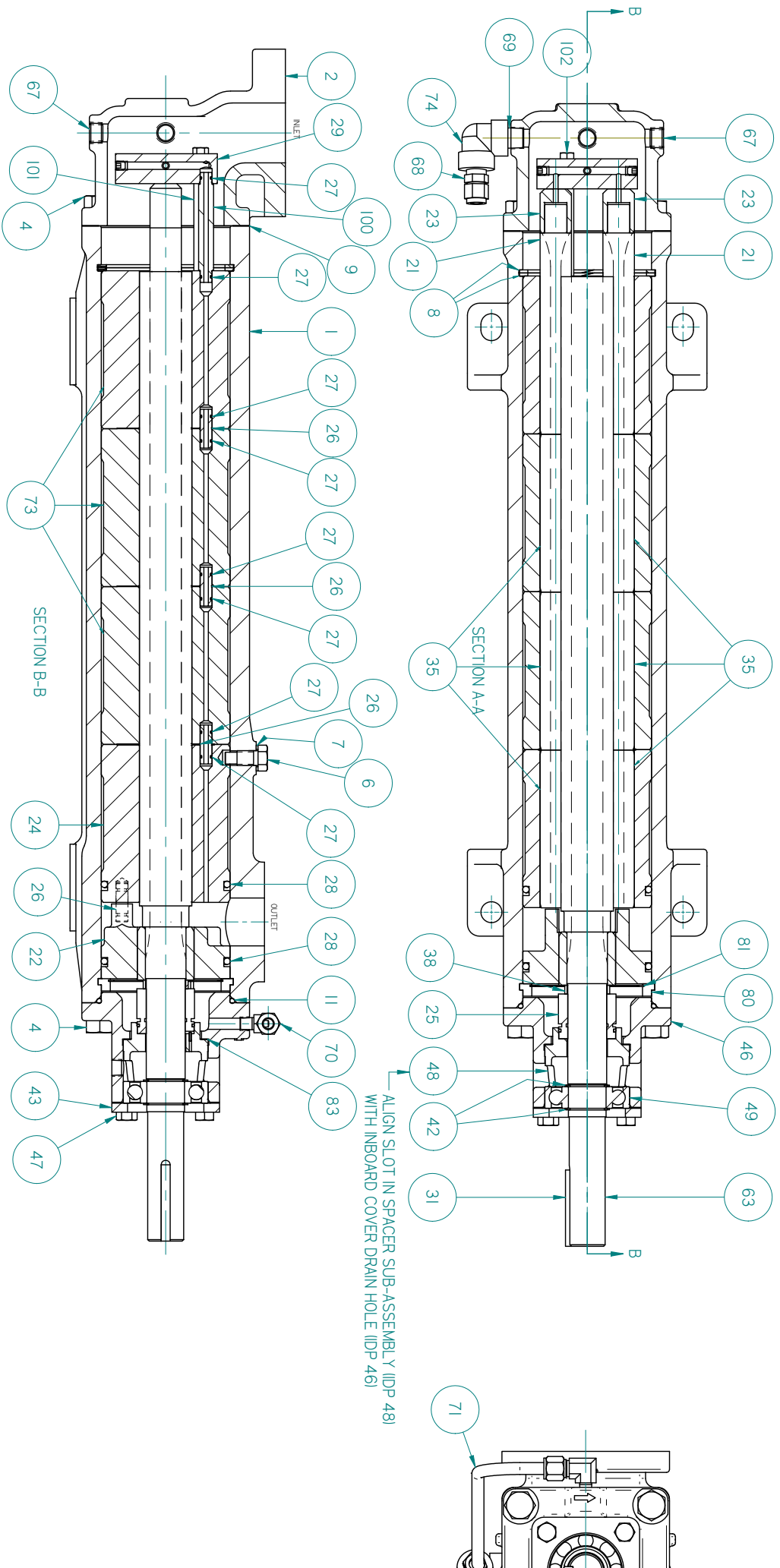
Most pumps have repair kits available. Minor Repair Kits are used to repair leaking seals, bad bearings and/or for re-assembly after pump tear-down. They include (as applicable) pump shaft seals, packing, all gaskets/O-rings and bearings. Major Repair Kits are sufficient to rebuild completely worn-out pumps to “as-new” condition. They include all parts found in Minor Repair Kits plus all major internal parts subject to wear. Since kits have all necessary parts, kit purchase is preferred rather than selecting individual parts. When parts are individually selected from Parts List, some needed components are often overlooked. In addition, mixing worn or used parts with new parts risks rapid wear and shortened service life from new parts.

FIGURE 6



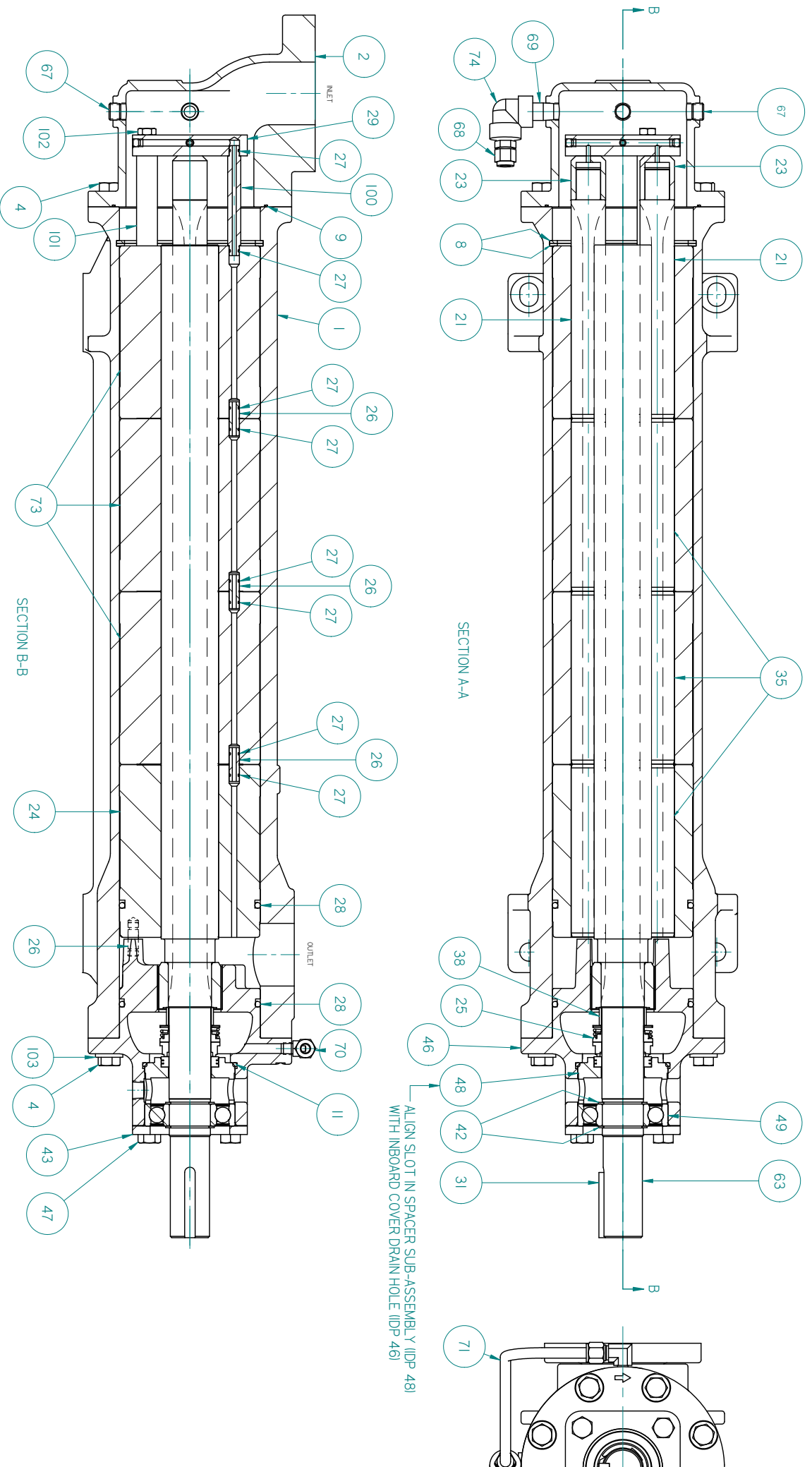
G12D-C-218 ASSEMBLY

Figure 7



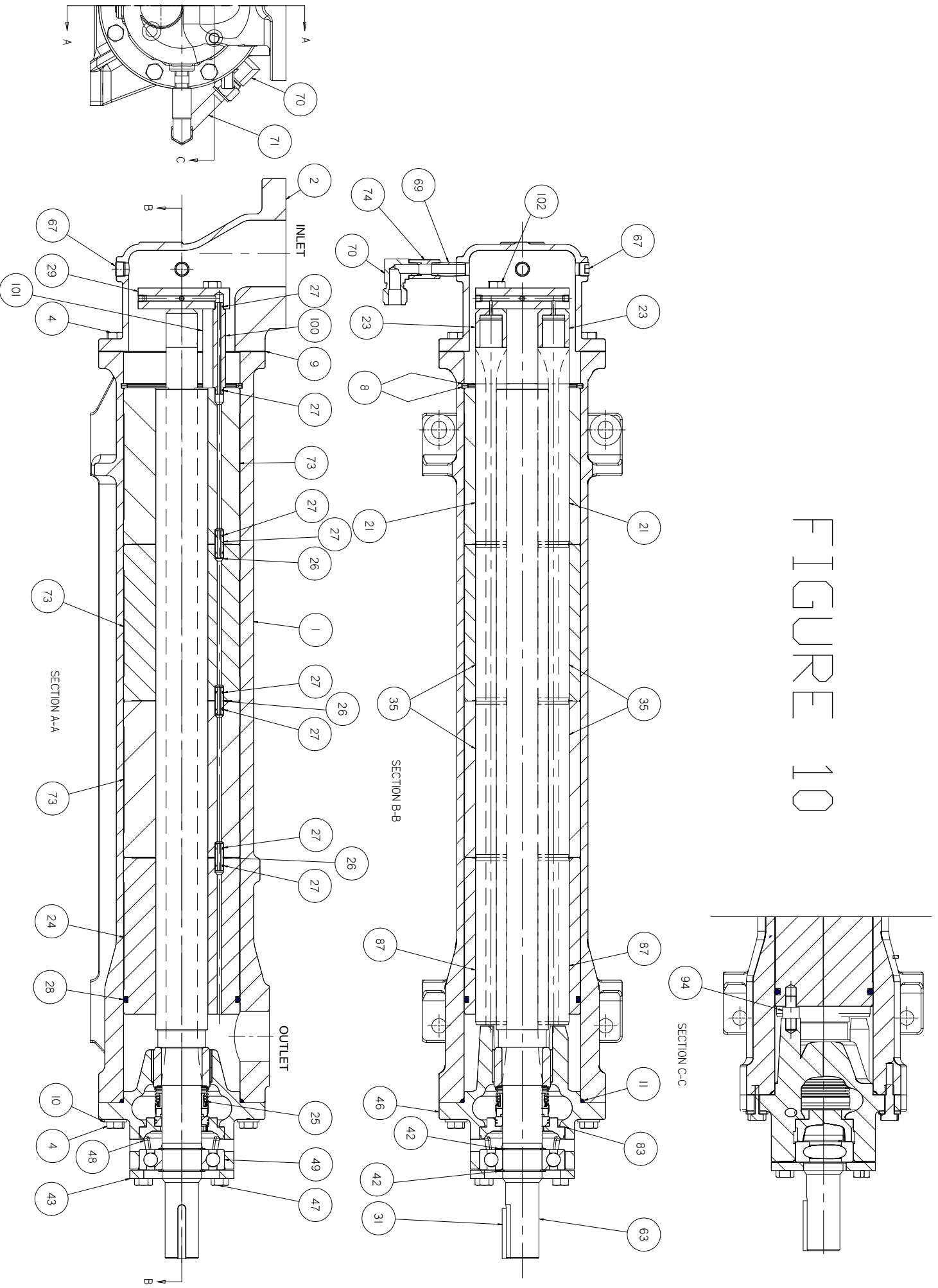
G12D_S-218 ASSEMBLY

FIGURE 9

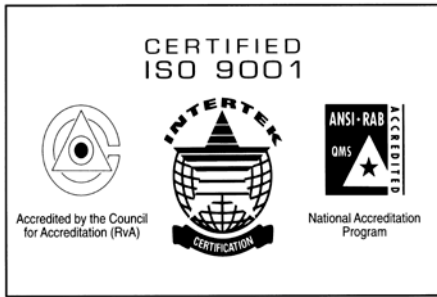


G12D-275 ASSEMBLY

FIGURE 10



G12D-312 ASSEMBLY



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