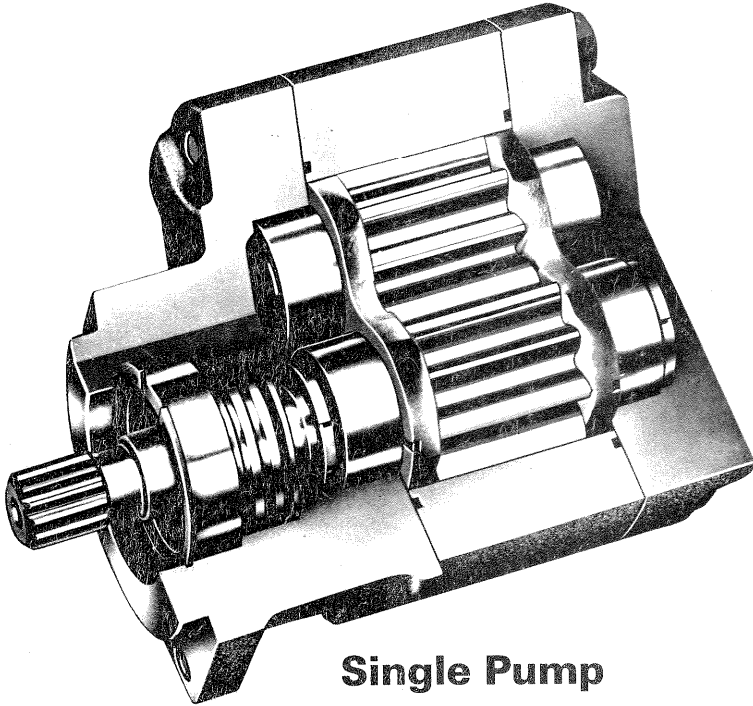
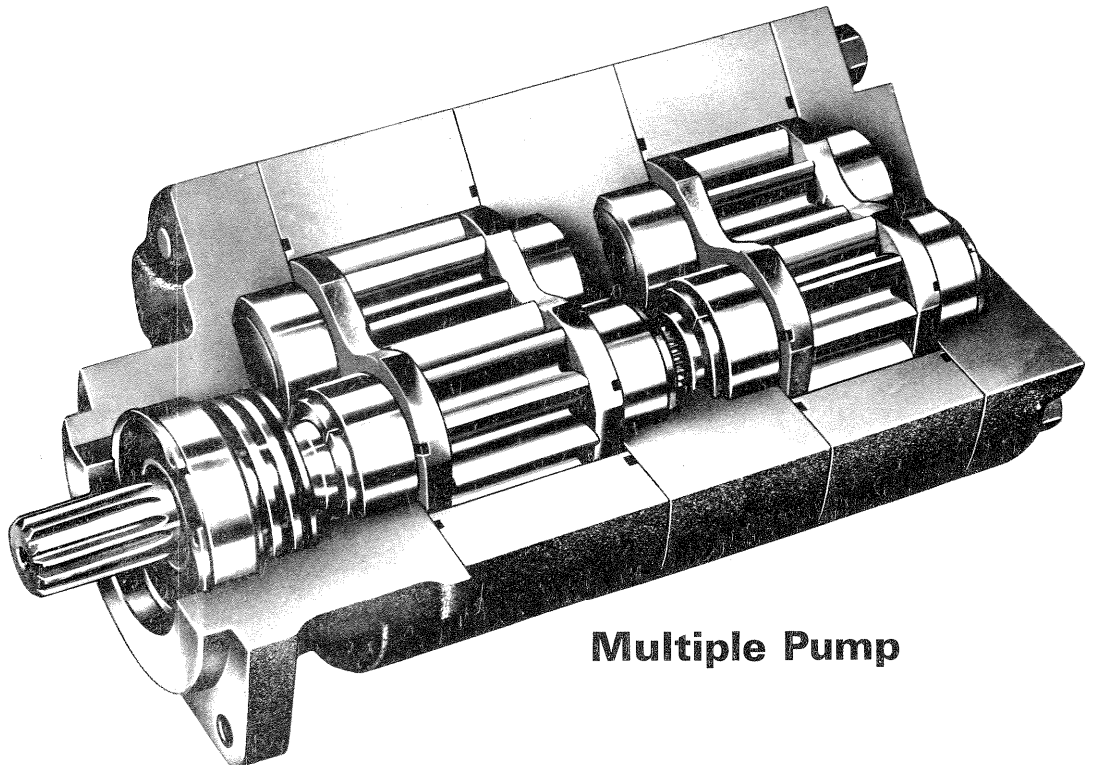


COMMERCIAL SHEARING PUMP ROTATION



Single Pump



Multiple Pump

COMMERCIAL PUMP ROTATION

To determine pump rotation, check the part number located on the metal plate which is attached to the pump port end cover.

The first digit of the three digit number on the metal plate determines pump rotation. Example; P75A478BE0V17-7. In this case, the number (4) is the determining factor. This particular pump has a clockwise rotation. The inlet port, largest of the two ports, is located on the left hand side as viewed from the shaft end of the pump.

An example of a counterclockwise rotating pump; P75A578BE0S17-7. The number (5) is the determining factor here. The inlet port is on the right hand side as viewed from the shaft.

A third example is; P25X342BESC22-7. Again, the number (3) determines rotation. In this case, the number (3) signifies that the pump rotation can be either clock or counterclockwise. This is also known as "double rotation". Port sizes are the same for both the inlet and outlet ports.

The key for all Commercial pump rotations is shown below. One of the six numbers listed will be the first digit of the three digit numbers.

<u>CLOCKWISE</u>	<u>COUNTERCLOCKWISE</u>	<u>DOUBLE ROTATION</u>
1	2	3
4	5	6

REVERSING ROTATION

Inverting the pump will reverse the inlet and outlet ports but not the direction of rotation. To reverse pump flow the following must be done:

Remove the shaft end cover from the pump. To accomplish this, the entire pump must be disassembled. On the machined surface of the shaft end cover are two orifices, side by side, and slightly lower than center. One of these orifices will contain a threaded check assembly or plug. Remove the plug and place it in the opposite orifice. Now, rotate the gear housing 180° to reverse the ports. Reassemble the pump and put into service.

There is no set rule to determine pump rotation from the plug being on the left or right side. In other words, a clockwise rotating pump may have the plug on the left side on one application and on the right side on another. Remember that the plug is always on the high pressure or discharge side of the pump.