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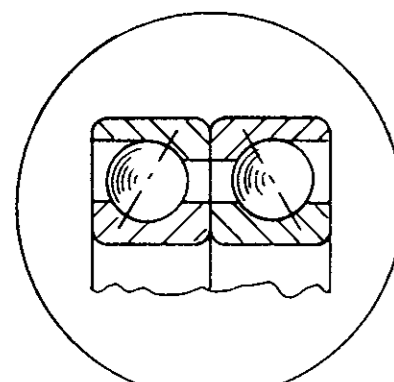
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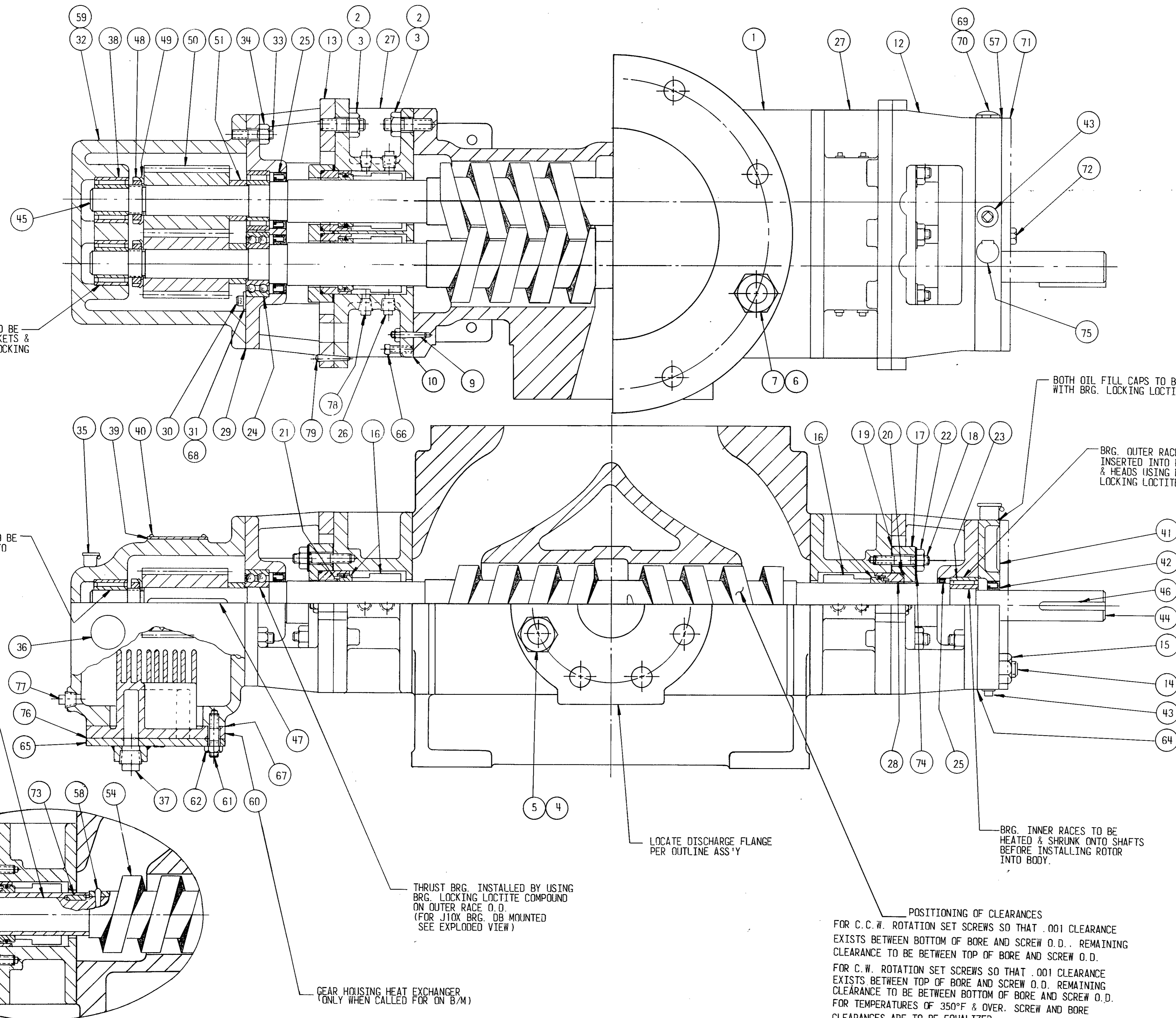
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D-4542

REVISIONS				DATE	APPROVED	MICRO FILM
ZONE	LTR	DESCRIPTION				
	A	RELOCATED PC.' 21. WAS IN PC.' 28 TO PC.' 17		3/16/84	EMS	



EXPLODED VIEW OF DB MOUNTED THRUST BRG.



BRG. OUTER RACES TO BE INSERTED INTO BRACKETS & HEADS USING BRG. LOCKING LOCTITE COMPOUND

BOTH OIL FILL CAPS TO BE ASSEMBLED WITH BRG. LOCKING LOCTITE COMPOUND

BRG. INNER RACES TO BE HEATED & SHRUNK ONTO SHAFTS

BRG. OUTER RACES TO BE INSERTED INTO BRACKETS & HEADS USING BRG. LOCKING LOCTITE COMPOUND

SLEEVES TO BE INSTALLED USING BF GOODRICH A1367B ADHESIVE

FRONT BRACKET ASSEMBLY - J-30X & J-60X
 FRONT HEAD 002B0393 MUST FIT FRONT BRGT. OF BOTH J-20X & J-30X. ON THE J-30X. NOTE THAT STUDS ON FRONT FACE OF BRACKET ARE ORIENTED CLOSER TO ONE END OF THE BRACKET FLANGE. ASSEMBLE J-30X FRONT BRACKET WITH STUDS OFFSET TOWARD LONG SHAFT SIDE. THE FRONT BRACKET FOR THE J20X CAN BE MOUNTED EITHER WAY SINCE THERE IS NO OFFSET.

FRONT HEAD 002B0395 MUST FIT FRONT BRKT. OF BOTH J-50X & J-60X. THE J-60X FRONT BRACKET MUST BE ASSEMBLED WITH STUDS OFFSET TOWARD LONG SHAFT SIDE. THE FRONT BRACKET FOR THE J-50X CAN BE MOUNTED EITHER WAY.

LOCATE DISCHARGE FLANGE PER OUTLINE ASS'Y

BRG. INNER RACES TO BE HEATED & SHRUNK ONTO SHAFTS BEFORE INSTALLING ROTOR INTO BODY.

THRUST BRG. INSTALLED BY USING BRG. LOCKING LOCTITE COMPOUND ON OUTER RACE O.D. (FOR J10X BRG. DB MOUNTED SEE EXPLODED VIEW)

GEAR HOUSING HEAT EXCHANGER (ONLY WHEN CALLED FOR ON B/M)

POSITIONING OF CLEARANCES
 FOR C.C.W. ROTATION SET SCREWS SO THAT .001 CLEARANCE EXISTS BETWEEN BOTTOM OF BORE AND SCREW O.D. REMAINING CLEARANCE TO BE BETWEEN TOP OF BORE AND SCREW O.D.
 FOR C.W. ROTATION SET SCREWS SO THAT .001 CLEARANCE EXISTS BETWEEN TOP OF BORE AND SCREW O.D. REMAINING CLEARANCE TO BE BETWEEN BOTTOM OF BORE AND SCREW O.D.
 FOR TEMPERATURES OF 350°F & OVER. SCREW AND BORE CLEARANCES ARE TO BE EQUALIZED.
 (FOR BOTH C.W. & C.C.W. ROTATIONS)

BEARING MUST SHOULD AGAINST SLEEVE & NOT AGAINST SHAFT SHOULDER

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES FRACTIONS- DECIMALS- ANGLES-	CONTRACT NO.	WARREN PUMPS DIV. HOUDAILLE INDUSTRIES, INC. WARREN, MASS. 01083	
	APPROVED	DATE	DRAWING TITLE
	CHECKED JSN	1/10/84	TYPICAL SECTIONAL ASS'Y.
DRAWN D.T.	1/6/84	FOR JAGUAR XH SCR. PUMPS W/MECH. SEALS	REV. A
APPROVED		SIZE CODE IDENT NO. DWG. NO.	
		D 63857	D-4542
		SCALE: NTS	SHEET 1 OF 1 SHEETS

BRUNING 40-534 2131213