

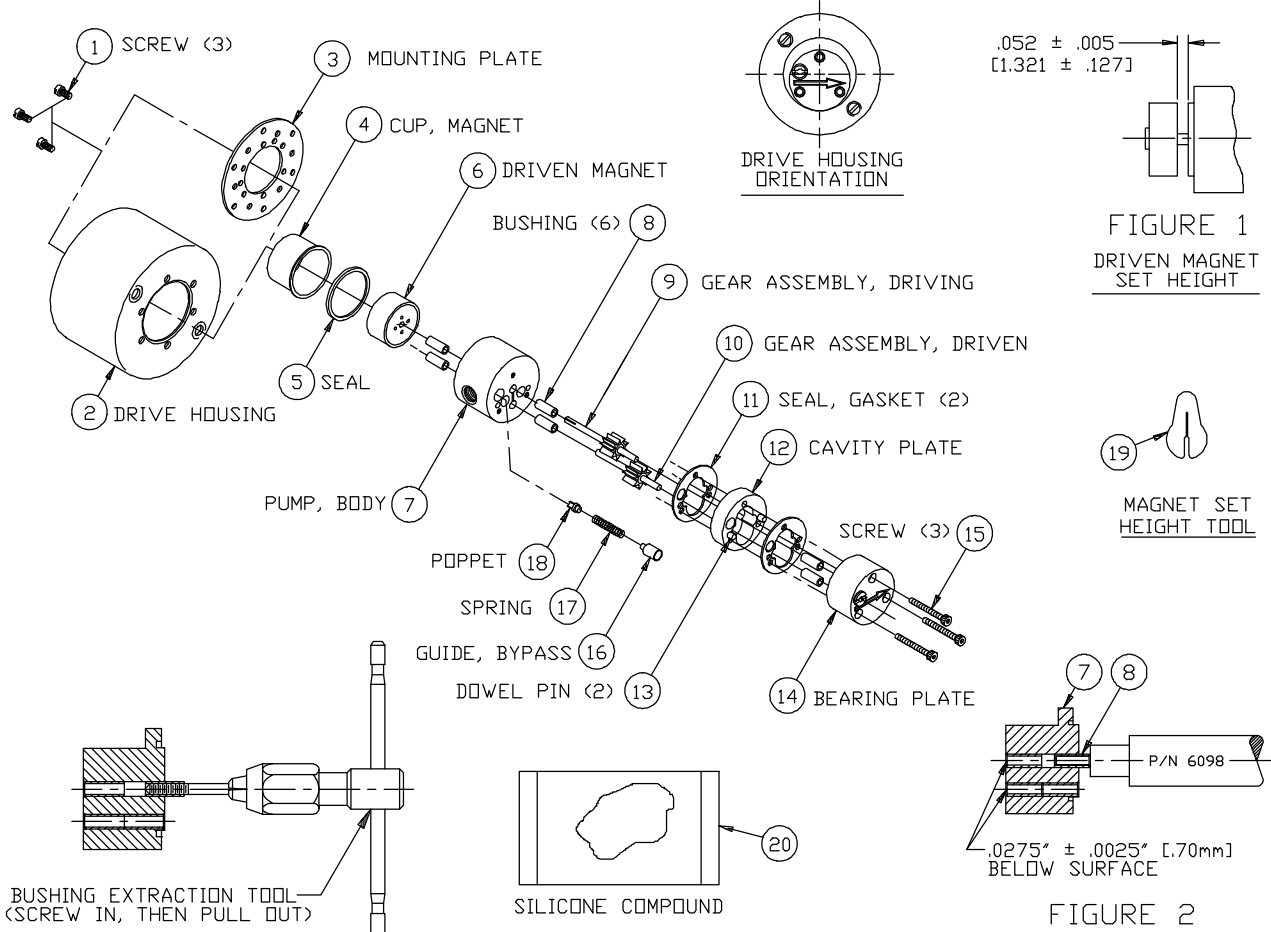


PART NUMBER: 6452

REVISION			
LTR.	DESCRIPTION	DATE	BY
D	REVISED PER ECN-4423	3/15/00	DMS

SERVICE INSTRUCTIONS:

MOD: 030, 050



BUSHING EXTRACTION TOOL
(SCREW IN, THEN PULL OUT)

FIGURE 3
BUSHING REMOVAL

FIGURE 2
BUSHING INSTALLATION

GENERAL:

1. All service work should be performed in a clean area.
2. Care should be taken to avoid scratching any sealing surfaces or allowing metal chips to come in contact with the Driven Magnet Assembly.
3. An even, light coat of high vacuum silicone grease (Dow Corning or equiv.) should be applied to all seals or O-Ring.
4. O-Ring with chamfers should always be installed with the chamfer up, away from the groove.
5. All assembly screws should be tightened evenly and in an alternating pattern.
6. Only Micropump factory authorized replacement parts should be used when servicing any Micropump product

MICROPUMP, INC.

A Unit of IDEX Corporation

PO Box 8975, Vancouver, WA 98668-8975 • Phone: 360/253-2008 • Fax: 360/253-8294

MICROPUMP LIMITED

A Subsidiary of Micropump, Inc.

Forge Close, Eaton Socon, St. Neots, Cambridgeshire, PE 19 3TP England, • Phone: (44) (0) 1480-219844 • Fax: (44) (0) 1480-476959

PART NUMBER:	6452
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REVISION			
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SPECIFIC:

1. Remove old Bushings (8) with Extraction Tool. Four from body (7) & two from bearing plate(14). The use of a #6 or M4.5 tap with T-Handle is recommended .(See Figure 3)
2. New Bushing installation is a press fit. Install using P/N 6098 Tool. (See Figure 2)
3. The first two Bushings should be installed into the Pump Body (7) from the gear side. These Bushings should be inserted to .0275 inch (.70mm) below sealing surface. Next insert two Bushings into the Pump Body from the Driven Magnet (6) side. (See Figure 1) The remaining two bushings should be inserted into the Bearing Plate Assembly (14).
4. Next install the Driving Gear (9) into the Body (7), Install the Driven Magnet (6) on the Driving Gear (9). Set Driven Magnet height from Pump Body (7) pilot as shown. (See Figure 1)
5. Driven Magnet and Gears must rotate freely. Tight Bushings may be reamed with a #30 reamer.
6. Install two Dowel Pins (13) in the Pump Body (7).
7. Place first Gasket Seal (11) over the Dowel Pins (13). Lubricate Gasket Seal per General Instructions, paragraph 3.
8. Place Cavity Plate (12) over the Dowel Pins (13).
9. Place second Gasket Seal (11) over the Dowel Pins (13). Lubricate Gasket Seal per General Instructions, paragraph 3.
10. Install Driven Gear (10).
11. Install Bypass Assembly (16, 17 & 18).
12. Install Bearing Plate Assembly (14).
13. Torque Bearing Plate Screws (15) to 14 +/- 1 in-pounds.
14. Torque Mounting Screws (1) to 10 (plus 1, minus 0) in-pounds.

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SPARE PARTS LIST
FOR GEAR PUMP MODEL 030, 050

ITEM NO.	PART NO.	DESCRIPTION	UNITS PER ASSEMBLY
1	795	SCREW, 4-40 X .250	3
2	5508	DRIVE HOUSING	1
3	2301	MOUNTING PLATE	1
4	3279	CUP, MAGNET	1
5	2619	* SEAL , O-RING	1
6	80071	MAGNET ASSEMBLY , DRIVE	1
7	5437	PUMP BODY (MODEL 030)	1
7	5444	PUMP BODY (MODEL 050)	1
8	6101	* BUSHING	6
9	81975	* GEAR ASSEMBLY , DRIVING	1
10	81976	* GEAR ASSEMBLY , DRIVEN	1
11	5369	* SEAL-GASKET	2
12	4214	CAVITY PLATE	1
13	4217	DOWEL PIN	2
14	4965	BEARING PLATE (MODEL 030)	1
14	4971	BEARING PLATE (MODEL 050)	1
15	2826	SCREW , 4-40 X 1.000 SLOTTED HD , (MOD 030)	3
15	5463	SCREW, 4-40 X 1.000 HEX HD ,	3
16	4959	GUIDE, BYPASS (MODEL 030)	1
17	5419	SPRING, BYPASS (MODEL 030)	1
18	4513	POPPET, BYPASS (MODEL 030)	1
19	6009	* MAGNET SET HEIGHT TOOL	
20	9766	* GREASE PACKAGE	
81981		GEAR SERVICE KIT	
6098		BUSHING INSERTION TOOL	
81977		PUMP ASSEMBLY, MOD. 030 W/MOUNTING. PLATE.	
81978		PUMP ASSEMBLY, MOD. 030 W/DRIVE HOUSING.	
81979		PUMP ASSEMBLY, MOD. 050 W/MOUNTING. PLATE.	
81980		PUMP ASSEMBLY, MOD. 050 W/ DRIVE HOUSING.	
		* Parts contained in Gear Service Kit.	

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