

MACHINING INSTRUCTIONS FOR CONVERTING THE GOULDS 6" ST BACK COVER/SEAL CHAMBER FOR USE ON THE FRAME S

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Form
565

Section	Forms
Effective	Oct. 2004
Replaces	ASD 132

Parts needed

Hardware Conversion Kit No. 99700

- Includes:
- (2) 1/4-20 Studs
 - (2) 1/4-20 Nuts
 - (4) 3/8-16 Regular Hex Nuts
 - (4) 3/8 D-Shaped Washers

Newer Goulds 6" ST Back Cover/Seal Chambers have been modified to eliminate some machining operations when converting it for use on Frame S. Two 1/4-20 UNC tapped holes for use when mounting the Back Cover/Seal Chamber to the Frame S frame adapter have been added. A raised O-ring surface (45 RMS) has been extended on to a 3.00 diameter to leave a sealing surface for both O-ring and gasket mounted seals.

The original design must have these (2) 1/4-20 tapped holes machined to mount onto the Frame S frame adapter.

NEW VERSION

1. Remove the (4) 3/8-16 studs and (2) 5/16 studs.
2. Bore out the Back Cover/Seal Chamber to 2.38 diameter .09 deep, then machine 25° angle.
3. Bore out the bottom of the Back Cover/Seal Chamber from 2.18 diameter to 2.38 diameter to existing depth and from 1.41 diameter to a 1.520 diameter.
4. Install the (2) 1/4-20 studs and (4) 3/8-16 seal chamber gland studs.

OLD VERSION

1. Remove the (4) 3/8-16 studs and (2) 5/16-18 studs.
2. Drf11 and tap the (2) 1/4-20 UNC holes as shown, deburr surface.
3. Bore out the Back Cover/Seal Chamber to 2.38 diameter .09 deep, then machine 25° angle.
4. Bore out the bottom of the Back Cover/Seal Chamber from 2.18 diameter to 2.38 diameter and bore out the 1.41 diameter to 1.520 diameter.
5. Install the (2) 1/4-20 studs and (4) 3/8-16 seal chamber gland studs.



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