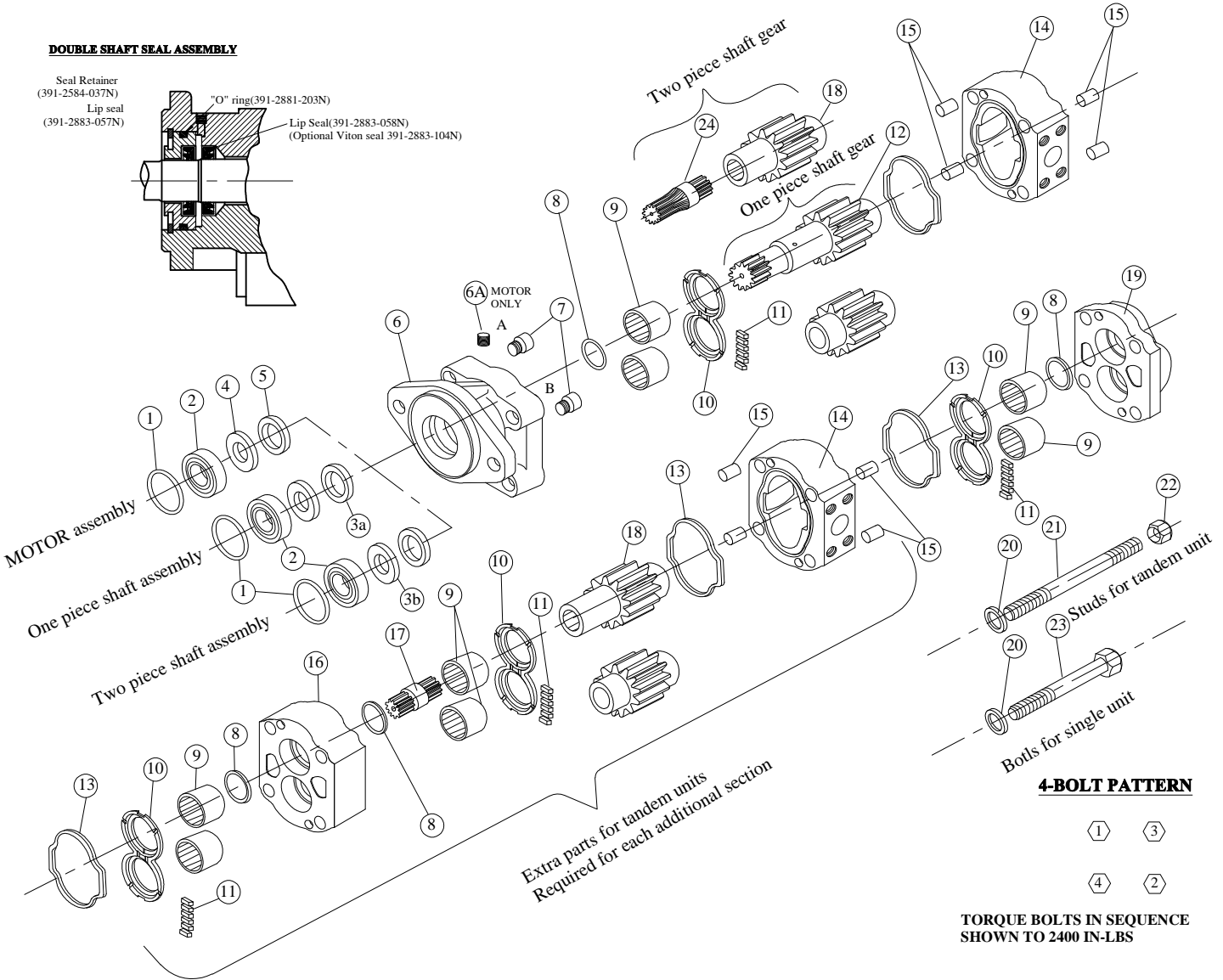
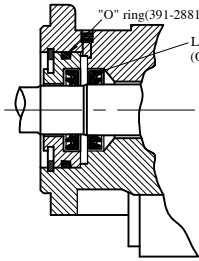


IFP IP3100 PUMPS and MOTORS SERVICE PARTS INFORMATION

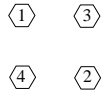


DOUBLE SHAFT SEAL ASSEMBLY

Seal Retainer (391-2584-037N)
Lip seal (391-2883-057N)
"O" ring(391-2881-203N)
Lip Seal(391-2883-058N)
(Optional Viton seal 391-2883-104N)



4-BOLT PATTERN



TORQUE BOLTS IN SEQUENCE
SHOWN TO 2400 IN-LBS

PLUG 7 IN POSITION **B** FOR CLOCKWISE ROTATION.
PLUG 7 IN POSITION **A** FOR COUNTER CLOCKWISE ROTATION.
CHECK VALVE IN BOTH POSITIONS FOR BI-DIRECTIONAL UNITS.

DESCRIPTION & CODES

ITEM	DESCRIPTION	REQ'S	PART NO.	ITEM	DESCRIPTION	REQ'S	PART NO.
1	SNAP RING	1	391-2686-063N	11	POCKET SEALS(PER GEAR SECTION)	1 STRIP	391-2882-051N
2	OUTBOARD BEARING	1	391-0381-040N	12	DRIVE SHAFT AND GEAR SET	1 SET	312-29xx-xxxN
3a	DOUBLE LIP SEAL (PUMPS)(one piece gear)	1	391-2883-107N	13	GASKET SEALS(PER GEAR SET)	2	319-2884-050N
3b	DOUBLE LIP SEAL (PUMPS)(two piece gear)	1	391-2883-058N	14	GEAR HOUSING	1 or more	312-8xxx-xxxN
4	SEAL RETAINER	1	391-3381-040N	15	DOWEL PINS	4	391-2082-032N
5	HI-PRESSURE SEAL (MOTORS)	1	391-2883-119N	16	BEARING CARRIER	1 or more	312-7xxx-xxxN
6	SHAFT END COVER	1	312-50xx-xxxN	17	CONNECTING SHAFT	1 or more	312-1133-001N
6A	DRAIN PLUG (MOTORS ONLY)	1	391-2282-056N	18	MATCHED GEARS	1 set or more	312-28xx-xxxN
7	CHECK ASSEMBLIES FOR MOTORS & BI-DIRECTIONAL PUMPS	2	391-3681-001N	19	PORT END COVER	1	312-3120-100N
	PLUG (PUMPS ONLY)	1	391-2286-004N	20	WASHERS	4	391-3784-028N
8	RING SEALS(PER GEAR SECTION)	2	391-2585-006N	21	BOLTS(SINGLE UNITS)	4	391-1401-xxxN
9	ROLLER BEARINGS(PER GEAR SECTYION)	4	391-0381-906N	22	STUDS(MULTIPLE UNITES)	4	391-1425-xxxN
10	THRUST PLATES(PER GEAR SECTION)	2	391-2185-913N	23	NUT(MULTIPLE UNITS)	4	391-1451-076N
				24	CONTINENTAL DRIVE SHAFT	1	312-xxxx-xxxN