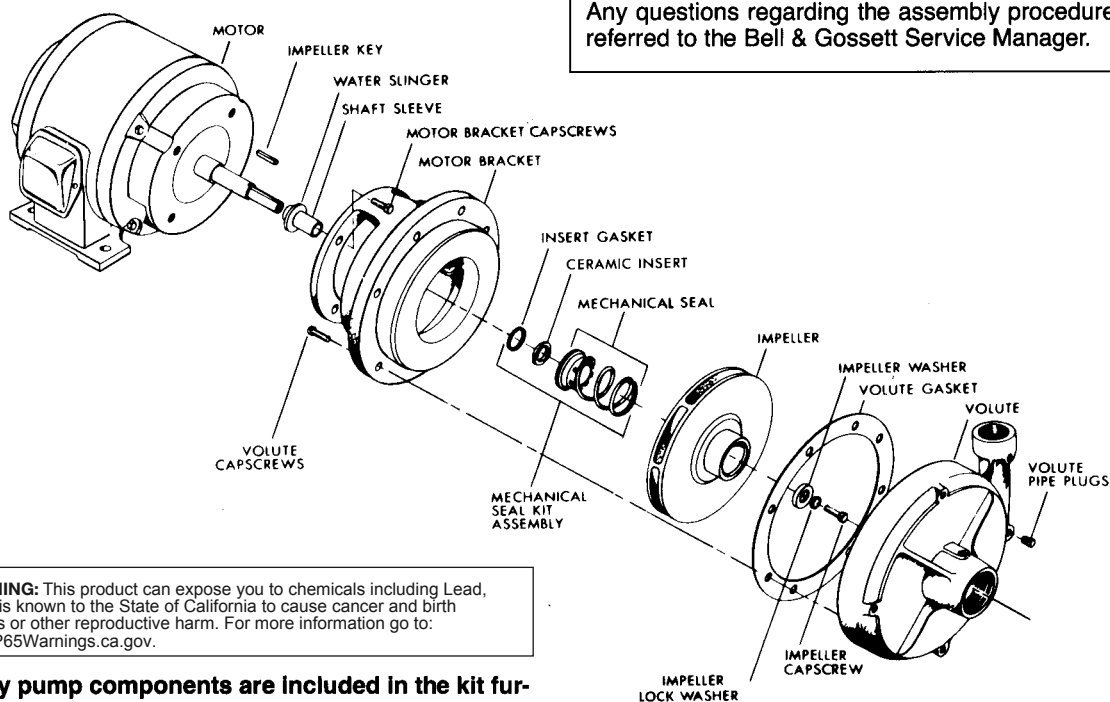




Series 1531 Base Mounted Centrifugal Pump Kits Assembly Instructions

IMPORTANT: The Series 1531 pump kits are to be assembled by qualified personnel only.

Any questions regarding the assembly procedure should be referred to the Bell & Gossett Service Manager.

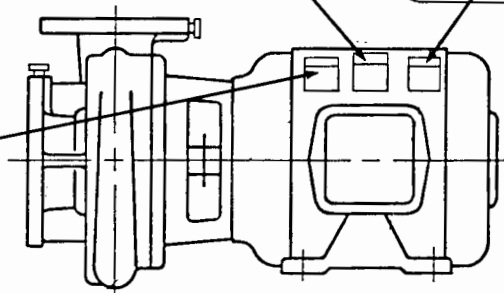
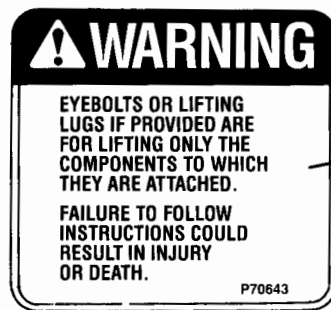


WARNING: This product can expose you to chemicals including Lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to: www.P65Warnings.ca.gov.

All necessary pump components are included in the kit furnished. For proper assembly follow these instructions:

1. Mount Shaft Sleeve onto motor shaft using sealant included in Sleeve Kit. Apply sealant to complete circumference of shaft to insure watertight seal.
2. Slide Water Slinger over Shaft Sleeve and locate near the Sleeve edge closest to the motor.
3. Mount the Motor Bracket Assembly to motor using motor bracket cap screws. Tighten per torque chart.
4. Press seal insert in Motor Bracket Assembly. Moisten the inner diameter of the seal assembly with soapy water and press seal firmly in place. Carbon seal face must be tight against the ceramic insert. Apply small end of tapered spring on seal.

5. Make certain that the impeller has been properly cut to size for required GPM and feet of head and balanced. Slide impeller into motor shaft until it bottoms against the shaft sleeve shoulder. Install Impeller Key in slot. Fasten the impeller using (1) capscrew, (1) internal lockwasher and (1) large impeller washer. Make certain that the capscrew is tightened to 10-14 foot pounds on 1" shaft motors and 25-34 foot pounds on 1 1/4" motors.
6. Mount the Volute Gasket and Volute to the motor bracket assembly using the Volute Capscrews. Tighten per torque chart.
7. Complete all nameplate data and affix to Volute.
8. Install warning decals per Figure.
9. Complete and return Pump Kit Data Card to the Customer Service Dept., ITT Bell & Gossett, 8200 N. Austin Ave., Morton Grove, IL 60053.
10. Affix Installation & Service Instruction Sheet P81567.



Capscrew Type	Head Marking	CAPSCREW TORQUE (FOOT-POUND)								
		Capscrew Diameter								
		1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1
SAE Grade 2		6	13	25	38	60	120	190	210	300
Brass Stainless Steel	or	4	10	17	27	42	83	130	200	300
SAE Grade 5		10	20	35	60	90	180	325	525	800

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Let's Solve Water

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