



**MODELS 30520-4XXXX  
30520-2XXXX**

a xylem brand

## SELF-PRIMING PUMPS

### FEATURES

<b>Pump Type:</b>	30520-4XXX Close Coupled 30520-2XXX Pump Head
<b>Body:</b>	316 Stainless Steel
<b>Impeller:</b>	Neoprene, Nitrile, Viton* or EPDM
<b>Shaft Seal:</b>	Mechanical, Carbon-on-Ceramic; or Tungsten Carbide; Nitrile and Viton
<b>Ports:</b>	1" NPT Internal
<b>Shaft:</b>	316 Stainless Steel
<b>Motor:</b>	115/230 Vac, Single Phase, 60Hz, 1-1/2 HP, 1740 RPM, TEFC, C- Face, H145TC Frame, Overload Protected, Capacitor Start.
<b>Weight:</b>	30520-4XXX 56.0 lb (25,4 kg) Approx. 30520-2XXX 12.0 lb (5,5 kg) Approx.

	<b>WARNING</b> Explosion hazard. Motor can spark. Explosion & death can occur. Do not use where flammable vapors are present.
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### VARIATIONS AVAILABLE

MODEL NO.	DESCRIPTION
<b>30520-4001</b>	Standard Pressure, Neoprene Impeller, Carbon Seal
<b>30520-2001</b>	
<b>30520-4003</b>	Standard Pressure, Nitrile Impeller, Carbon Seal
<b>30520-2003</b>	
<b>30520-4004</b>	Standard Pressure, Viton Impeller, Carbon Seal
<b>30520-2004</b>	
<b>30520-4101</b>	Standard Pressure, Neoprene Impeller, Tungsten Carbide Seal
<b>30520-2101</b>	
<b>30520-4103</b>	Standard Pressure, Nitrile Impeller, Tungsten Carbide Seal
<b>30520-2103</b>	
<b>30520-4104</b>	Standard Pressure, Viton Impeller, Tungsten Carbide Seal
<b>30520-2104</b>	

### APPLICATIONS

**INDUSTRIAL:** Circulating and transferring, velocity-mixing, pumping machine tool coolants, spill return, sump drainage, chemicals, pharmaceuticals, soap, liquors, ink, dyes, alcohol, dilute acids, tanning liquors, glycerine, brine, etc.

\*Viton is a trademark of E.I. Du Pont de Nemours and Company.



**Models 30520-4XXX, 30520-2XXX**

**PHARMACEUTICAL:** Processing medicines, lotions and preparations. Filtering pharmaceutical solutions. Filling line supply pump.

**PAPER PROCESSING:** Transferring and applying starches, sizes, etc. Circulating and processing wood pulp slurries.

**FOOD, BEVERAGE & DAIRY:** Transfer brines, vinegar, syrups during processing, liquids containing solids in suspension such as chopped tomatoes, nuts, etc. Removal of distillery wort and brewery slop. Processing viscous materials such as peanut butter, mayonnaise, ketchup, honey, etc. (low speed). Pumping whisky, wine, rums, juices and ciders.

**AGRICULTURAL:** Transferring liquid fertilizers, herbicides and pesticides.

### OPERATING INSTRUCTIONS

- INSTALLATION** – Pump may be installed in any position. The rotation of the pump shaft determines the location of the pump's intake and discharge ports. (Refer to dimensional drawing). Pump is normally assembled at factory for clockwise rotation (looking at end cover). If counter clockwise rotation is desired, follow steps 1 and 2 of disassembly and step 7 of assembly instructions to change direction of impeller blade deflection under cam.
- MOTOR SELECTION** – Pump head is designed to fit a H145TC Frame NEMA C-face motor. Motor should be rated 1-1/2 horsepower at 1750 RPM with a service

	<b>WARNING</b> Explosion hazard. Do not pump gasoline, solvents, thinners or other flammable liquids. To do so can cause an explosion resulting in injury or death.
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## OPERATING INSTRUCTIONS (Cont)

factor of one. Due to high bearing loads, motor should be ball bearing equipped with the front bearing locked against axial movement. Motor should be capacitor start and foot mounted.

3. SPEEDS – 100 RPM to the maximum shown in the performance curves. Consult the factory for operation at speeds above these shown. For longer pump life, operate at lowest possible speeds. Lower speeds are required for viscous liquids. Consult the factory for proper speeds and horsepower requirements.
4. SELF-PRIMING – Primes at low or high speeds. For vertical dry suction lift of 10 feet, a minimum of 860 RPM is required. Pump will produce suction lift up to 22 feet when wet. BE SURE SUCTION LINES ARE AIRTIGHT OR PUMP WILL NOT SELF-PRIME.
5. DISCHARGE – When transferring liquids further than 25 feet, use one size larger discharge line than discharge port size.
6. RUNNING DRY – Unit depends on liquid pumped for lubrication. DO NOT RUN DRY for more than 30 seconds. Lack of liquid will damage the impeller and seal.
7. CHEMICAL COMPATIBILITY – Consult the Chemical Resistance Guide in the JABSCO Industrial Pump Catalog (available upon request from ITT Jabsco) or factory for proper body materials and impeller compounds. If corrosive fluids are handled, pump life will be prolonged if pump is flushed with a neutralizing solution after each use or after each work day. A Tungsten Carbide Seal variation is available for pumping liquids that contain abrasives or are highly corrosive.
8. PRESSURES – Consult Performance Curves for maximum recommended pressures for pumps in continuous operation. If pressures exceed those shown, consult the factory.
9. TEMPERATURES – The operating temperature limits of the pump depend on the impeller compound. The following ranges apply: Neoprene - 45° to 180° F (7° to 82° C), Nitrile - 50° to 180° F (10° to 82° C), Viton - 60° to 180° F (15° to 82° C), EPDM - 45° to 185° F (7° to 85° C).
10. IMPELLER TORQUE – The torque required to initiate rotation of a new impeller in a dry pump body is:  
Standard Pressure Impeller (14282-Series):  
Forward = 4.8 pounds force - feet  
Reverse = 11.2 pounds force - feet  
These values may vary slightly due to impeller compounding, blade set, and body material of construction. Consult factory for more information.
11. SPARE PARTS – To avoid costly shutdowns, keep a spare JABSCO impeller, seal and O-ring set on hand.

## SERVICE INSTRUCTIONS

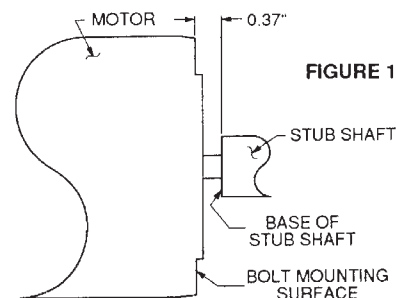
### DISASSEMBLY

1. Remove the four end cover screws. Remove end cover and O-ring.
2. Remove the four screws holding the body to the adapter flange. Slide body, complete with impeller and wearplate, from adapter and shaft.

3. Remove mechanical seal by inserting two screwdrivers behind seal collar, and gently lever collar and seal assembly forward on shaft. Use extreme care not to mar shaft surface. Remove seal seat and rubber cup from recess in wearplate.
4. Remove the four screws holding the adapter to the motor and remove the adapter.
5. The stub shaft is held in place with set screws and Loctite\* RC/680 retaining ring compound. Extreme care must be taken not to damage the motor shaft and bearings when removing the stub shaft. Heat shaft joint area to facilitate disassembly of set screws and stub shaft from motor shaft. DO NOT EXCEED 300°F when heating joint area. Once joint area has been heated, remove set screws and slide stub shaft from motor shaft.

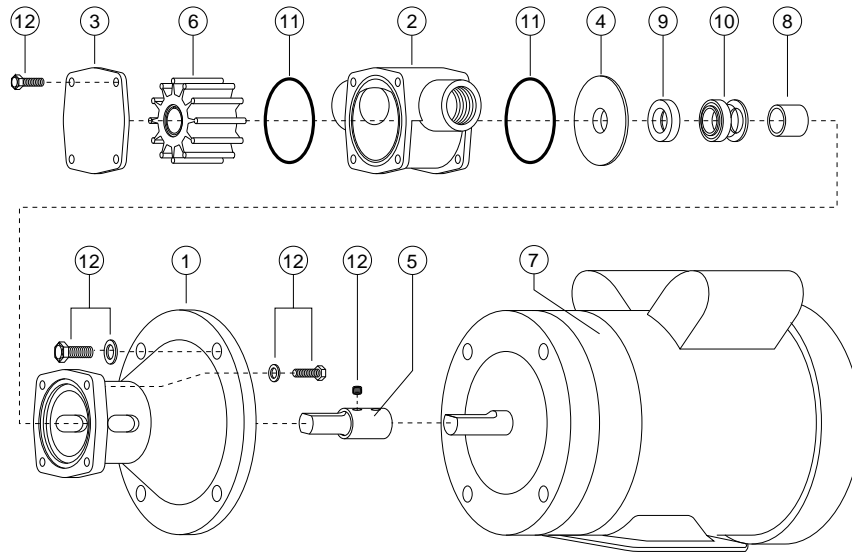
### ASSEMBLY

1. Liberally apply Loctite RC/680 retaining compound to the motor shaft and slide the stub shaft on, positioning the base of the stub shaft 0.37" from the bolt mounting surface of the motor and two of the four set screw holes over the keyway in the motor shaft. For clarification refer to Figure 1 below. Loctite aids in preventing fretting and subsequent shaft failure. Apply Loctite to the two dog point (flat point) set screws, position in the set screw holes aligned with the keyway of the motor shaft and torque to 55 - 60 in. lbs. Apply Loctite to the two cup point set screws and torque to 85 - 90 in. lbs. Wipe off excess Loctite.
2. Replace the adapter on the motor and torque the four mounting screws to 20 ft. lbs.
3. Replace mechanical seal by sliding spacer onto shaft up to locating shoulder, then smear shaft with light lubricating oil. Push on seal gently until it engages with spacer. Fit rubber cup and seal seat into wearplate.
4. Insert impeller in pump body, fit O-ring in each end of the pump body.
5. Slide wearplate and body assembly over shaft, position wearplate in housing. Fit body to pedestal with screws. Torque screws to 60 in. lbs.  
NOTE: A gap should be maintained between bearing housing and body. DO NOT overtighten screws.
6. Fit end cover and end cover screws. Torque screws to 60 in. lbs.
7. Changing Pump Rotation (looking at end cover):
  - a. Clockwise Rotation: Insert impeller into pump body with blades bending counterclockwise.
  - b. Counterclockwise Rotation: Insert impeller into pump body with blades bending clockwise.



Loctite\* is a trademark of the Loctite Corporation.

## EXPLODED VIEW

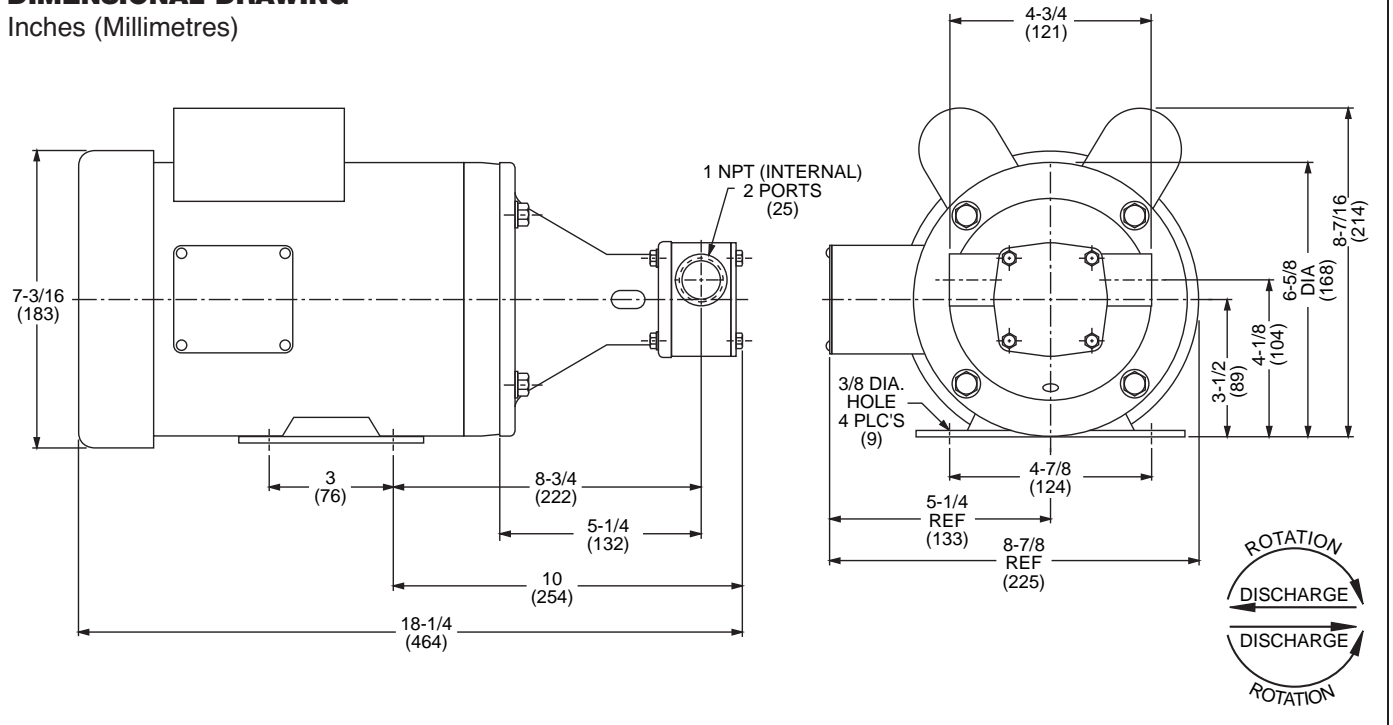


## PARTS LIST

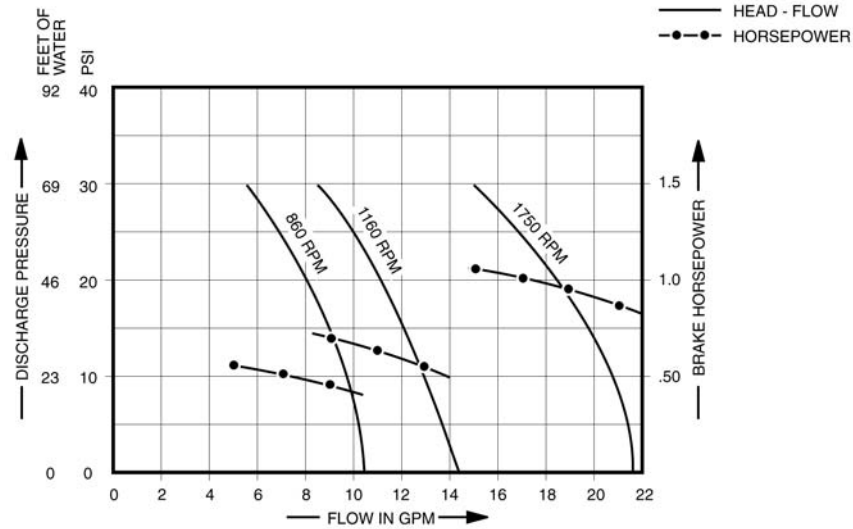
Key	Description	Qty. Req.	30520-4XXX Part Number	Qty. Req.	30520-2XXX Part Number
1	Adaptor	1	18753-0216	1	18753-0216
2	Body	1	18753-0189	1	18753-0189
3	End Cover	1	18753-0195	1	18753-0195
4	Wearplate	1	18753-0200	1	18753-0200
5	Shaft	1	18753-0211	1	18753-0211
6	Impeller:	1		1	
	Standard Pressure – Neoprene		14282-0001		14282-0001
	Standard Pressure – Nitrile		14282-0003		14282-0003
	Standard Pressure – Viton		14282-0004		14282-0004
	Standard Pressure – EPDM		8981-0002		8981-0002
7	Motor, 1-1/2 HP, 115/230 Vac, 1Ph, 60 Hz, TEFC, C-Face, H145 TC Frame	1	18753-0339		
8	Spacer	1	18753-0227	1	18753-0227
9	Seal Seat:	1		1	
	Nitrile		18753-0235		18753-0235
	Ceramic Viton		18753-0236		18753-0236
10	Seal Mech.:	1		1	
	Carbon – Nitrile		18753-0245		18753-0245
	Carbon – Viton		18753-0246		18753-0246
	Tungsten Carbide – Nitrile		18753-0247		18753-0247
	Tungsten Carbide – Viton		18753-0248		18753-0248
11	O-Ring:	2		2	
	Nitrile		18753-0263		18753-0263
	Viton		18753-0264		18753-0264
12	Screw Kit:	1	18753-0282	1	18753-0282
	consists of				
	Screws, Hex Hd 3/8 -16 x 1" (4)				
	Screws, Hex Hd M6 x 16mm (4)				
	Screws, Hex Hd M6 x 10mm (4)				
	Set Screw, Cup Pt. 1/4-20 x 3/8 (2)				
	Set Screw, Dog Pt. 1/4-20 x 3/8 (2)				
	Washers, Flat 3/8 (4)				
	Washers, Flat M6 (4)				

**DIMENSIONAL DRAWING**

Inches (Millimetres)



**PERFORMANCE CURVES**



NOTE: Curves show approximate head-flow for new pumps with neoprene impeller pumping water.

Capacities should be reduced approximately 10% with nitrile impeller and approximately 20% with viton impellers.

Consult factory for specific performance information.

THE PRODUCTS DESCRIBED HEREIN ARE SUBJECT TO THE JABSCO ONE YEAR LIMITED WARRANTY, WHICH IS AVAILABLE FOR YOUR INSPECTION UPON REQUEST.

[www.xylemflowcontrol.com](http://www.xylemflowcontrol.com)

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