TF-375

70-14000-001 Power End Parts

10 - 36 KPSI MAWP

GENERAL ASSEMBLY INSTRUCTIONS

1. NOTE THE ORIENTATION OF ALL LUBE HOLES IN THE CONNECTING ROD/CROSSHEAD ASSEMBLY:
   A. THE CROSSHEAD LUBE HOLE IS INSTALLED ON TOP: THIS MATCHES WITH A DRILLED HOLE IN THE POWER FRAME BORE THAT LUBRICATES THE WRISTPIN.
   B. ALL CONNECTING RODS ARE INSTALLED WITH THE WRIST PIN LUBE HOLE ON TOP.
   C. THE IDENTIFICATION NUMBERS ON THE CONNECTING ROD AND CAP MUST BOTH BE ON THE TOP SIDE.
2. THE BEARING LUBRICATION HOLES MUST MATCH THE HOLES IN BOTH THE ROD AND CAP. THE LOCATION KEYS MUST MATCH THE GROOVES MILLED IN BOTH THE ROD AND CAP. THE BEARINGS MAY HAVE ADDITIONAL LUBE HOLES THAT MATCH OTHER CONNECTING CONFIGURATIONS.
3. HANDLE THE BEARINGS NTH CARE. THEY HAVE BEEN COATED WITH A DRY FILM MOLY- DISULFIDE LUBRICANT. THIS PROVIDES IMPROVED LUBRICATION DURING THE BEARING RUN-IN PERIOD.
4. THE JOURNALS SHOULD BE LUBRICATED WITH A 70% MOLY-DISULFIDE GREASE, BEFORE RUNNING.
5. TORQUE CONNECTING ROD CAP SHOULDER SCREWS TO 60 FT./ LBS. LUBRICATED. TORQUE EVENLY AND ALTERNATELY TO ENSURE EVEN LOADING.
6. FILL THE CRANKCASE WITH 5 U.S. GALLONS OF SPARTAN EP 150 OIL.
   A. OIL SELECTION IS BASED ON AMBIENT TEMERATURES BETWEEN 32 - 120° F.
   B. FOR ALTERNATE OIL SPECIFICATIONS, SEE MANUAL.

NOTE:

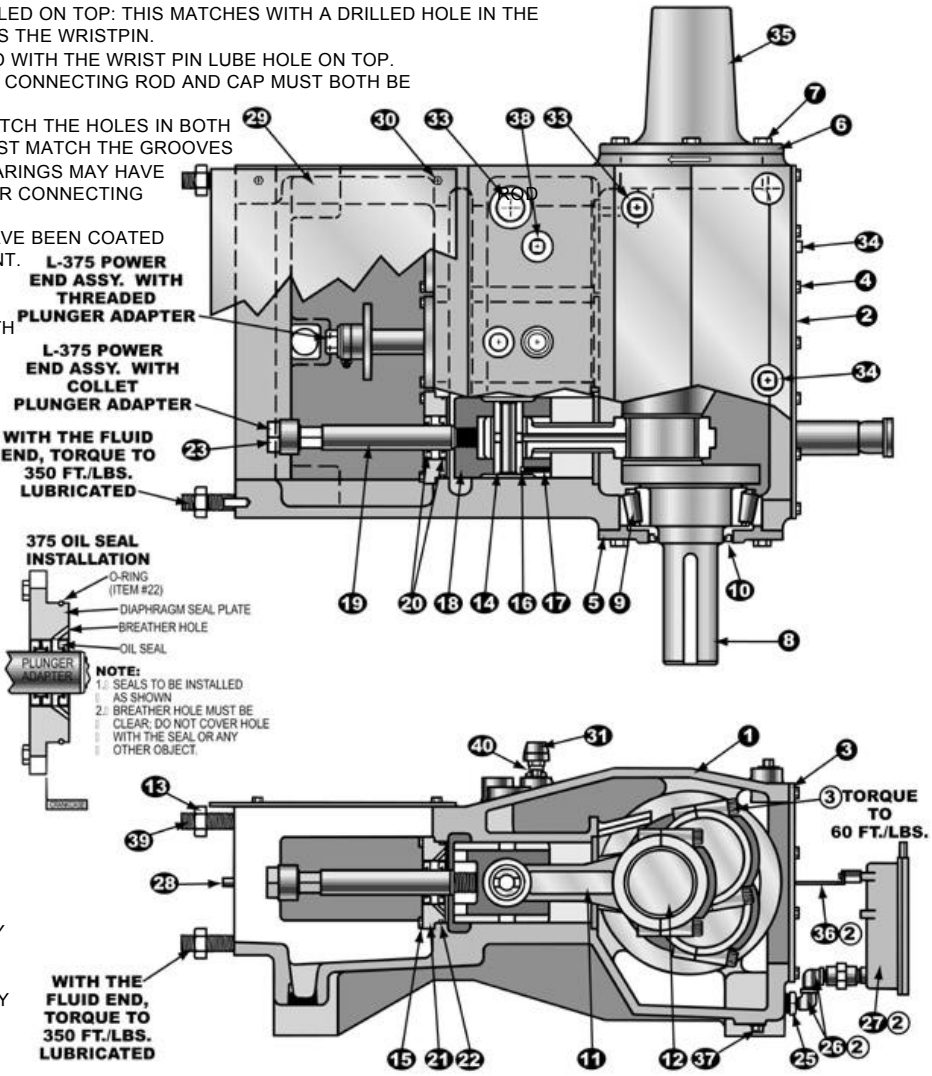
1. KEEP ITEM #31 CRANKCASE BREATHER FREE OF DIRT OR PAINT. CLOGGED BREATHER WILL CAUSE OIL TO LEAK FROM DIAPHRAGM SEAL.
2. OIL LEVEL TO BE 2-5/8" TO 3-1/4" BELOW CENTER LINE OF PUMP.

70-14000-102 IS A T-375 POWER END ASSEMBLY WITH CAST CRANKSHAFT AND THREADED PLUNGERS

70-14000-103 IS A T-375 POWER END ASSEMBLY WITH CAST CRANKSHAFT AND COLLET PLUNGERS

70-14000-202 IS A TF-375 POWER END ASSEMBLY WITH FORGED CRANKSHAFT AND THREADED PLUNGERS

70-14000-203 IS A TF-375 POWER END ASSEMBLY WITH FORGED CRANKSHAFT AND COLLET PLUNGERS



T-375 POWER END WITH THREADED PLUNGERS

ITEM	PART NO.	QTY.	DESCRIPTION:
19	70-13005-001	3	PLUNGER ADAPTER
23	22-13012	3	DEFLECTOR STUB
24	16-01639	3	HOSE CLAMP

T-375 POWER END WITH COLLET PLUNGERS

ITEM	PART NO.	QTY.	DESCRIPTION:
19	70-13050-200	3	PLUNGER ADAPTER
23	70-13032	3	COLLET NUT

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ITEM	PART NO.	QUAN.	DESCRIPTION:
1	70-13001-002	1	FRAME, POWER
2	70-13011	1	COVER, CRANKCASE
3	22-13004	1	GASKET, CRANKCASE COVER
4	16-15212	18	SCREW, HEX HEAD 3/8" - 16 UNC x 3/4"
5	70-13007	1	CAP, SEAL END
6	22-13005	AS REQ'D.	SHIM SET
7	16-15055	12	SCREW, HEX HEAD 5/8" - 11 UNC x 1-1/2"
8A	70-13002	1	CRANKSHAFT
8B	70-13002-414	1	CRANKSHAFT, FORGED, T-375
9	52-32053	2	BEARING, CRANKSHAFT, TF-375
10	22-13001	2	SEAL, CRANKSHAFT OIL
11	70-13004	3	CONNECTING ROD ASSEMBLY
12	70-13013	3	BEARING, CONNECTING ROD
13	16-13002	4	HEX NUT, 1-1/8" - 7 UNC
14	70-13006	3	PIN, CROSSHEAD
15	16-13000	6	SCREW, HEX HEAD 5/16" - 18 UNC x 1-1/4"
16	16-75660	3	SCREW, HEX SOCKET 3/8" - 16 UNC (HALF DOG)
17	16-75246	3	SCREW, HEX SOCKET 3/8" - 16 UNC (CUP POINT)
18	70-13003	3	CROSSHEAD
19			SEE BILL OF MATERIAL CHART BELOW
20	22-13002	6	OIL SEAL, DIAPHRAGM PLATE
21	70-13009	3	PLATE, DIAPHRAGM SEAL
22	22-13003	3	O-RING (2-250-N674-70)
23			SEE BILL OF MATERIAL CHART BELOW
24			SEE BILL OF MATERIAL CHART BELOW
25	19-33220-001	1	PIPE BUSHING 1" x 1/2" NPT BRASS
26 (2)	19-32020-001	2	STREET ELBOW, 1/2" NPT
27 (2)	37-77063	1	OIL LEVEL GAUGE
28	16-15442	2	PIN, DOWEL 1/2" x 1-1/2" LONG
29	70-13018	1	COVER, WELL
30	16-15025	4	SCREW, HEX HEAD 1/4" - 20 UNC x 1/2" LONG
31	70-75515	1	BREATHER CRANKCASE
32	70-02355	5	MAGNET, POWER END (NOT SHOWN)
33	19-00370	4	PIPE PLUG, 1-1/2" NPT
34	19-77014	2	PIPE PLUG, 1" NPT
35	70-13008	1	CRANKSHAFT COVER
36	16-07035	1	OIL GAUGE SUPPORT, 800 SERIES
37	19-32031	1	PIPE PLUG, 1/2" NPT
38	19-00321	2	PIPE PLUG, 3/4" NPT
39	16-13001	4	STUD, 1-1/8" - 7 UNC B7 x 5" LONG
40	19-32023-001	1	3/4" NPT x 1/2" NPT BUSHING