TF-450 70-20000 Power End Parts

10 - 20 KPSI MAWP

GENERAL ASSEMBLY INSTRUCTIONS

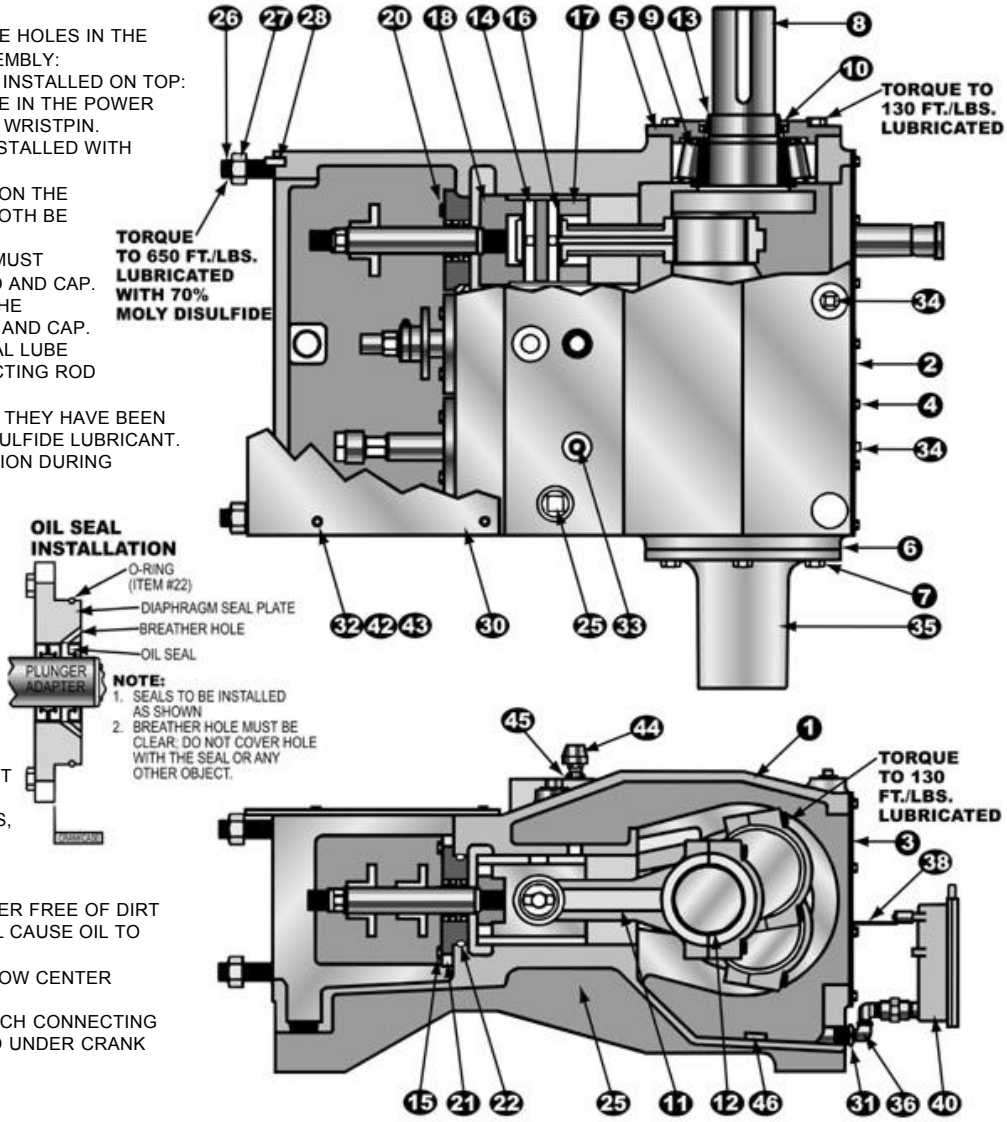
1. NOTE THE ORIENTATION OF ALL LUBE HOLES IN THE CONNECTING ROD/CROSSHEAD ASSEMBLY:
   A. THE CROSSHEAD LUBE HOLE IS INSTALLED ON TOP: THIS MATCHES WITH A DRILLED HOLE IN THE POWER FRAME BORE.THAT LUBRICATES THE WRISTPIN.
   B. ALL CONNECTING RODS ARE INSTALLED WITH THE WRISTPIN LUBE HOLE ON TOP.
   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 ROD CONFIGURATIONS.
3. HANDLE THE BEARINGS WITH CARE. THEY HAVE BEEN COATED WITH A DRY FLIM MOLY- DISULFIDE LUBRICANT. THIS PROVIDESIMPROVED 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 85 FT./LBS. LUBRICATED. TORQUE EVENLY AND ALTERNATELY TO ENSURE EVEN LOADING.
6. FILL THE CRANKCASE WITH 8 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 #44 CRANKCASE BREATHER FREE OF DIRT OR PAINT. CLOGGED BREATHER WILL CAUSE OIL TO LEAK FROM DIAPHRAGM SEAL.
2. OIL LEVEL TO BE 3-1/4" TO 3-7/8" BELOW CENTER LINE OF PUMP.
3. ITEM #46 TO BE LOCATED UNDER EACH CONNECTING ROD JOURNAL, TWO TO BE LOCATED UNDER CRANK SHAFT.



T-450 POWER END WITH FORGED CRANK

ITEM	PART NO.	QTY.	DESCRIPTION:
8	70-20002-414	1	CRANKSHAFT, T-450, FORGED

T-450 POWER END WITH CAST CRANK

ITEM	PART NO.	QTY.	DESCRIPTION:
8	70-20002	1	CRANKSHAFT, T-450, CAST

70-20000 Power End Parts

TF-450

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ITEM	PART NO.	QUAN.	DESCRIPTION:
1	70-20001	1	POWER FRAME
2	70-20011	1	COVER, CRANKCASE
3	22-20003	1	GASKET, CRANKCASE COVER
4	16-15212	18	BOLT, HXHD, 3/8" - 16 x 3/4"
5	70-20007	1	CAP, SEAL END
6	22-20005	1	SHIM SET
7	16-15054	12	BOLT, HXHD, 3/4" - 10 x 2"
9	52-32042	2	BEARING, CRANKSHAFT
10	22-20001	2	SEAL, CRANKSHAFT OIL
11	70-20004	3	CONNECTING ROD ASSEMBLY
12	70-20021	3	BEARING, CONNECTING ROD
13	70-20012	2	WEAR RING, CRANKSHAFT SEAL
14	70-20006	3	PIN, CROSSHEAD
15	16-75658	6	BOLT, HXHD, 1/2" - 13 x 1-1/4"
16	16-15440	3	SCREW, SET, 1/2" - 13 x 1/2" (HALF DOG)
17	16-15439-001	3	SCREW, SET, 1/2" - 13 x 1/2" (CUP POINT)
18	70-20003	3	CROSSHEAD
20	22-20002	9	SEAL, DIAPHRAGM PLATE OIL
21	70-20009	3	PLATE, DIAPHRAGM SEAL
22	22-20015	3	O-RING, 6-1/4", 2-258-70
25	19-00370	2	PLUG, 1-1/2" NPT PIPE
26	16-15444	4	STUD, 1-1/4" - 7 x 5", GR.8
27	16-15441	4	NUT, HEX, 1-1/4" - 7
28	16-15442	2	PIN, DOWEL, 1/2" x 1-1/2"
30	70-20010	1	COVER, WELL
31	19-33220-001	1	BUSHING, 1" x 1/2"
32	16-77970	4	BOLT, HXHD, 1/4" - 20 x 3/4"
33	19-33283	2	PLUG, 3/4" NPT PIPE
34	19-77014	2	PLUG, 1" NPT PIPE
35	70-20008	1	COVER, CRANKSHAFT
36	19-32020-001	2	ELL, 1/2" STREET
38	16-07035	1	BRACE, OIL LEVEL GAUGE
40	37-77063	1	GAUGE, OIL LEVEL
42	16-15214	4	WASHER, FLAT, 1/4"
43	16-15007	4	WASHER, LOCK, 1/4"
44	70-75515	1	BREATHER, CRANKCASE
45	19-32023-001	1	BUSHING, 3/4" x 1/2"
46	70-02355	5	MAGNET, POWER END