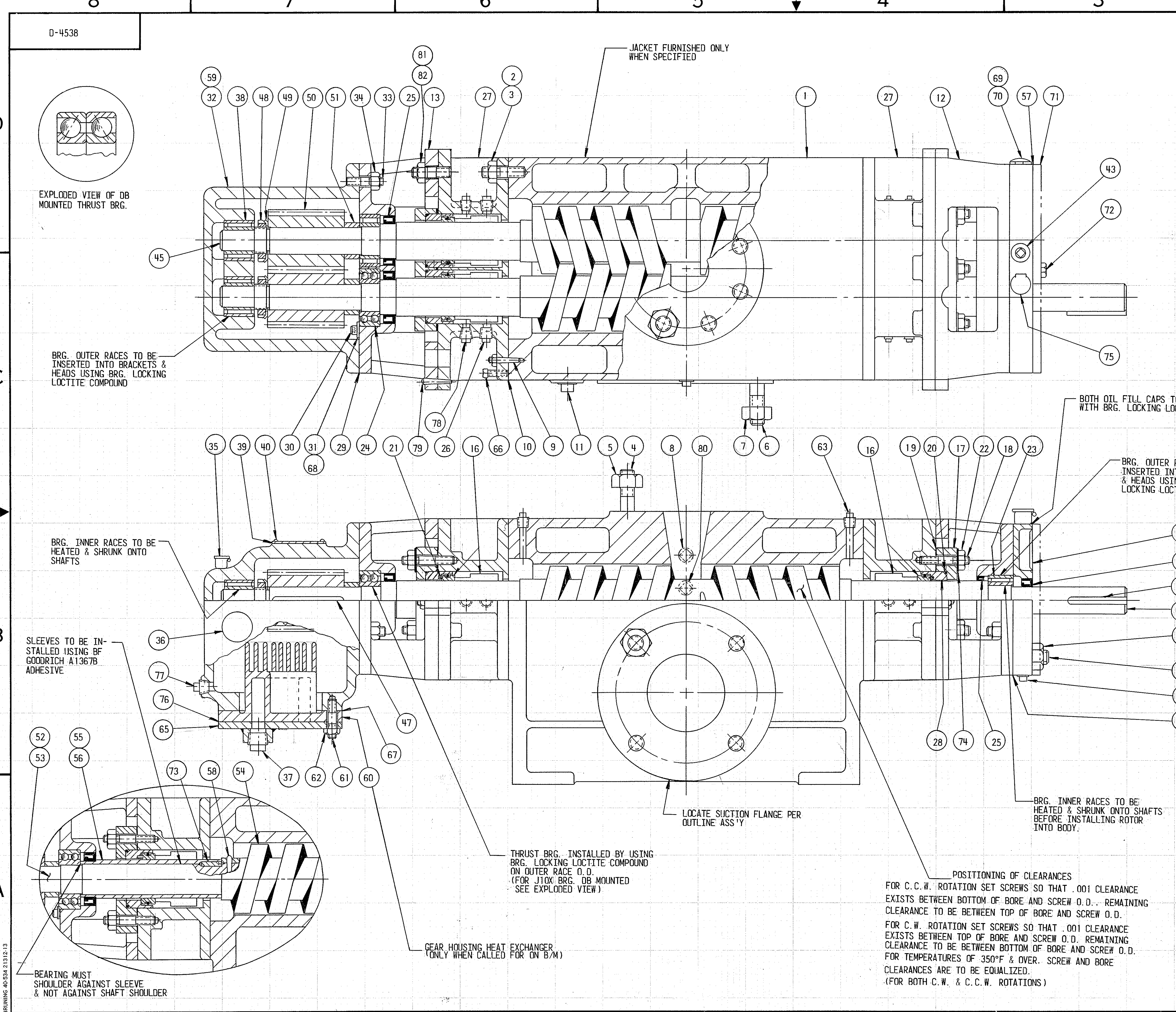


D-4538

REVISIONS		DATE	APPROVED	MICRO FILM
ZONE	LTR	DESCRIPTION		
A		PC. NO'S. 81 & 82 WERE PC NO'S. 2 & 3 T.T.	2/29/84	EMS
B		BOTTOM L.H. VIEW PC. 21 WAS IN PC. 28 & 17	3/16/84	EMS



FRONT BRACKET ASSEMBLY - J-30X & J-60X
 FRONT HEAD 002B0393 MUST FIT FRONT BRG. BRKT. OF BOTH J-20X & J-30X. ON THE J-30X. NOTE THAT STUDS ON FRONT FACE OF BRACKET ARE ORIENTED CLOSER TO ONE END OF THE BRACKET FLANGE. ASSEMBLE J-30X FRONT BRACKET WITH STUDS OFFSET TOWARD LONG SHAFT SIDE. THE FRONT BRACKET FOR THE J20X CAN BE MOUNTED EITHER WAY SINCE THERE IS NO OFFSET.
 FRONT HEAD 002B0395 MUST FIT FRONT BRKT. OF BOTH J-50X & J-60X. THE J-60X FRONT BRACKET MUST BE ASSEMBLED WITH STUDS OFFSET TOWARD LONG SHAFT SIDE. THE FRONT BRACKET FOR THE J-50X CAN BE MOUNTED EITHER WAY.

POSITIONING OF CLEARANCES
 FOR C.C.W. ROTATION SET SCREWS SO THAT .001 CLEARANCE EXISTS BETWEEN BOTTOM OF BORE AND SCREW O.D. REMAINING CLEARANCE TO BE BETWEEN TOP OF BORE AND SCREW O.D.
 FOR C.W. ROTATION SET SCREWS SO THAT .001 CLEARANCE EXISTS BETWEEN TOP OF BORE AND SCREW O.D. REMAINING CLEARANCE TO BE BETWEEN BOTTOM OF BORE AND SCREW O.D.
 FOR TEMPERATURES OF 350°F & OVER. SCREW AND BORE CLEARANCES ARE TO BE EQUALIZED.
 (FOR BOTH C.W. & C.C.W. ROTATIONS)

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES FRACTIONS- DECIMALS- ANGLES-	CONTRACT NO.	WARREN PUMPS DIV. HOUDAILLE INDUSTRIES, INC. WARREN, MASS. 01083	
	CHECKED <i>EMS</i> 11/9/83	DATE	5/30/90
	DRAWN <i>D.T.</i> 10/30/83	APPROVED	
	APPROVED		
	SIZE	CODE IDENT NO.	DWG. NO.
	D	63857	D-4538
SCALE: NTS	SHEET		10F 1 SHEETS