

**Wilfley**  
**Centrifugal Pumps**  
**HD Assembly Guide**

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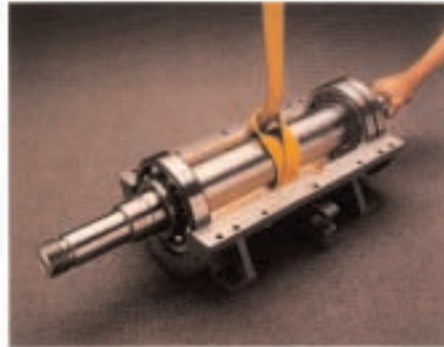
# Wilfley Centrifugal Pumps

Model "HD"

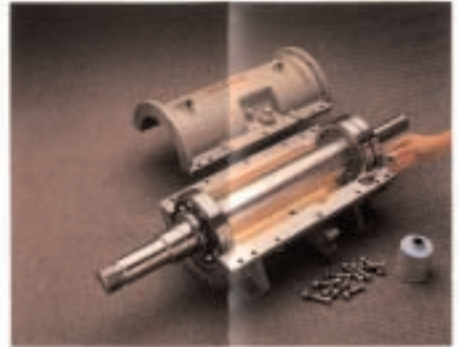
6 x 4 Metal



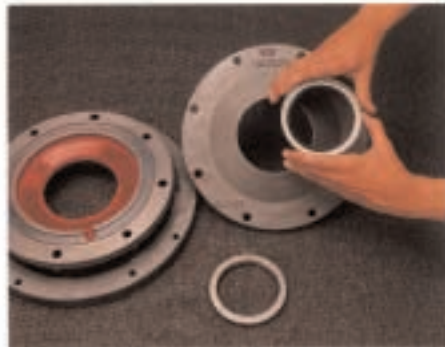
**1.** Install bearings on shaft and lock into place with locknuts and lockwashers.



**2.** Place the shaft assembly in the lower half on the long cylinder.



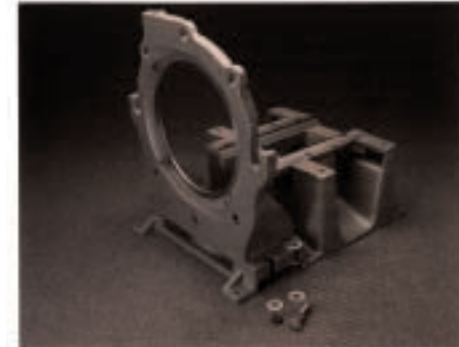
**3.** Coat sealing surfaces of the long cylinder with a liquid gasket material. Securely tighten the two halves of the long cylinder together.



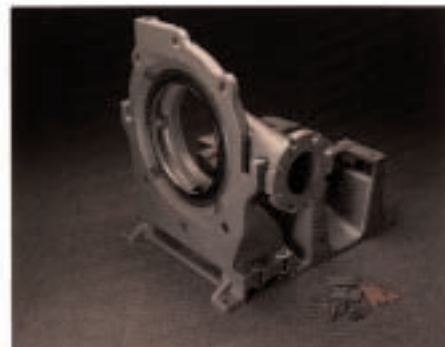
**4.** Place the oil seals in the front and rear bearing caps.



**5.** Install the bearing caps and bearing cap o-rings to the long cylinder.



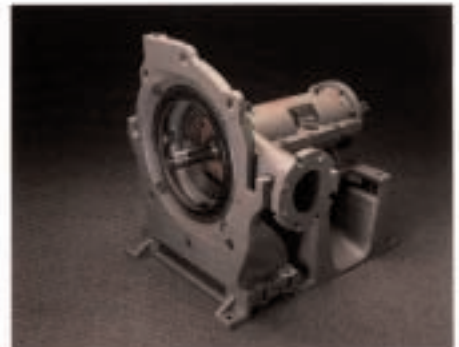
**6.** Securely attach the bracket to the frame.



**7.** Seat the intake chamber into the bracket. Be sure to attach the drain and vent plugs on either side of the intake chamber.



**8.** Place the gland ring on the intake chamber. Hand tighten only. This part will be removed later to add the gland ring packing.



**9.** Slide the long cylinder onto the frame and through the intake chamber.



**10.** Place the shaft sleeve o-ring in the inner bore of the shaft sleeve.



**11.** Slide the shaft sleeve onto the shaft and tighten with set screws. Set screws must seat properly on the flat area of the shaft.



**12.** Place the die ring holder over the shaft so that it seats flush with the front bearing cap.



**13.** Seat the check valve diaphragm into the groove on the die ring holder. Be sure that the die ring is seated properly.



**14.** Attach the rear die ring to the front bearing cap.



**15.** Slide the expeller onto the shaft and seat against the rear die ring.



**16.** Attach the front die ring to the front bearing cap.



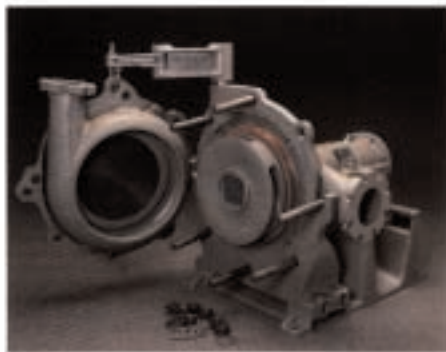
**17.** Place the intake chamber gasket on the intake chamber.



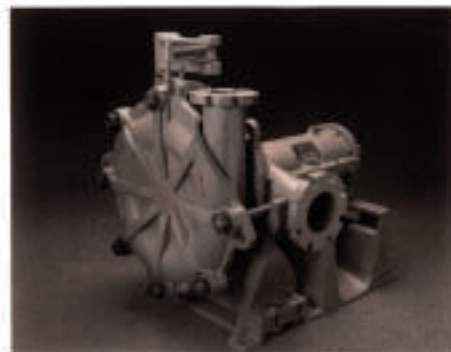
**18.** Place the follower plate onto the intake chamber and attach the follower plate gasket to the follower plate.



**19.** Place the runner on the shaft and secure with the runner bolt.



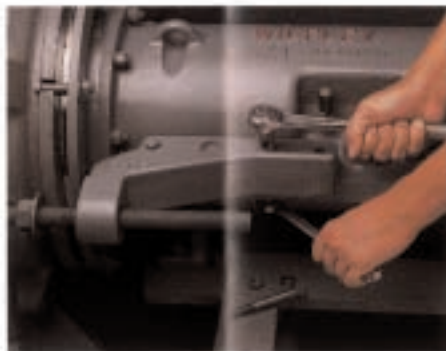
**20.** Place the case shell gasket on the case shell and attach the case liner to the case shell. Attach the case to the crane arm.



**21.** Securely attach the case to the bracket.



**22.** Remove the gland ring and install the gland ring packing. Retighten gland ring in place.



**23.** Attach the draw bolt assembly to the frame. A washer and nut should be on each side of the lobe that extends from the draw bolt bracket.



**24.** Adjust the runner clearance with the draw bolt assembly. Once runner is adjusted properly, securely tighten long cylinder to the frame.



**25.** Before installing pump, be sure the long cylinder has clean oil to lubricate bearings.

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A. R. Wilfley & Sons, Inc.  
P.O. Box 2330/Denver, Colorado 80201  
303-779-1777.

This pictorial guide is to be used only as a general reference to the "HD" Operating Handbook. Photos in this guide relate to the 6 x 4 Metal "HD" Pumps. Parts may not be exactly the same for pumps of other sizes or materials. Refer to the

exceptions as noted in the "HD" Operating Handbook. Before you work on the Model "HD" Pump, please read all instructions and warnings carefully and observe all safety precautions.