



REV	DATE	DESCRIPTION	BY	CHK	APP
1		ISSUE FOR PRODUCTION			
2		REVISED TO ADD DIMENSIONS			
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NOTES: UNLESS OTHERWISE SPECIFIED

- ① ② ③ ④ △ PARTS LISTED BELOW ARE NOT ASSEMBLED BY JABSCO BUT SHIPPED IN SEPARATE CONTAINERS.
- PLACE O-RINGS, ITEM 21, AND ITEM 22, (QTY 3) IN POLYBAG 42847-0000.
- PLACE SCREWS, ITEM 29 AND WASHERS, ITEM 37, (QTY 6) IN POLYBAG 42845-0000.
- PLACE ADAPTOR, ITEM 11 AND TWO POLYBAGS, ABOVE, IN CARTON 18002-0000.
- △ LUBRICATE I.D. OF CAM RING, (ITEM 7), WITH DOW CORNING 111 COMPOUND.
- △ TAPE SPLINE FOR SHIPMENT.
- △ STAMP CUMMINS MODEL NO. ON NAMEPLATE.
- △ STAMP SERIAL NO. ON NAMEPLATE AS FOLLOWS:
 MONTH OF BUILD XX XX XX
 YEAR OF BUILD XX XX
 QUANTITY IN WORK ORDER
 SEQUENTIAL NUMBERING OF PUMPS PER WORK ORDER (01, 02, 03, ...ETC)
 EXAMPLE: 099650-07
 BUILD DATE: SEPT 1996
 QUANTITY IN WORK ORDER: 30
 SERIAL NO.: 07
- 8. DIMENSIONS IN [] ARE IN INCHES.
- △ TORQUE CASTLE NUT, ITEM 34, TO 120 FT-LBS (163 N-M) MIN. THEN INCREASE TORQUE TO MATCH HOLE IN SHAFT WITH SLOT IN NUT. DO NOT BACK OFF NUT TO ALIGN HOLE.
- ⑤ △ STAMP JABSCO MODEL NO. ON NAMEPLATE.

TORQUE REQUIREMENTS

ITEM	REQUIRED TORQUE
27, 28, 29 & 30	40.7-46.1 N-M [30-34 FT-LBS]
31	10.2-11.3 N-M [90-100 IN-LBS]
32	6.8-7.9 N-M [60-70 IN-LBS]
34	SEE NOTE △

4. REVISED 8-7-98
 C.E. SABEL 8-13-98
 E.A. NICK 8-17-98

VORTEX ENGINE COOLING PUMP
 CUMMINS
 15780-0000
 CUM 094-078