

**PARTS MANUAL**

# Hydra-Cell<sup>®</sup>

## INDUSTRIAL PUMPS

**IMPORTANT**

Record your pump model number and serial number here for easy reference:

Model No. \_\_\_\_\_

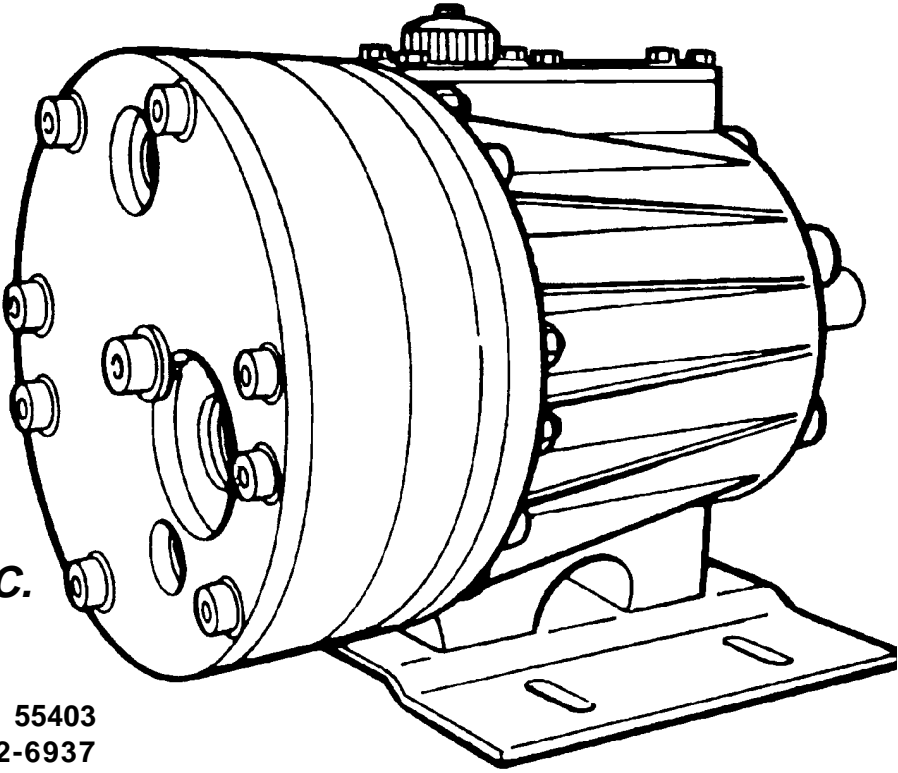
Serial No. \_\_\_\_\_

Date of Purchase \_\_\_\_\_

When ordering parts or making inquiries about this pump, please mention the model and serial numbers.

### **MODEL: H-25**

**WITH NON-METALLIC PUMP HEAD**



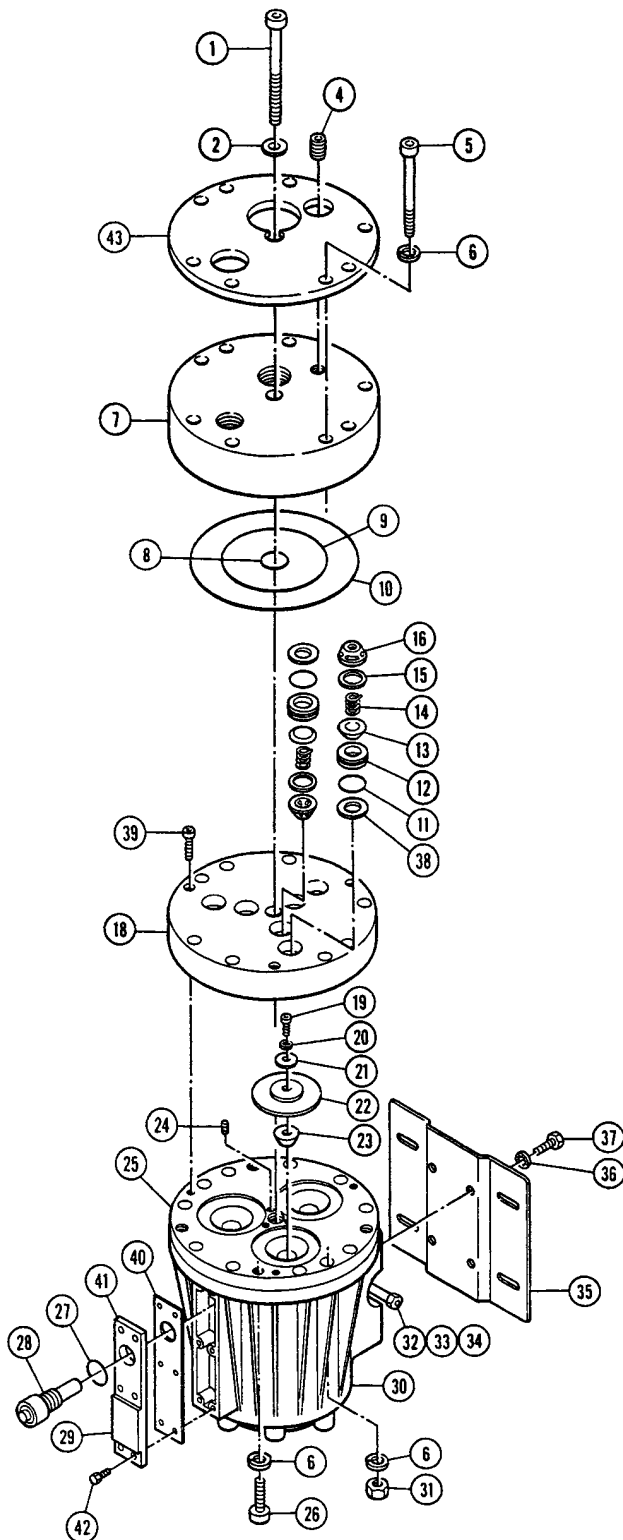
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# H-25 Fluid End

**MODEL H-25  
WITH NONMETALLIC  
PUMP HEAD**



Ref #	Part Number	Description	Quantity/ Pump
1	G25-081-2017	Cap Screw, socket head, M12 x 1.25 x 130mm .....	1
2	G10-084-1010	Washer, 13 cm, flat .....	1
4	D25-038-2017	Plug, Hastelloy C .....	1
	D25-038-2211	Plug, 316 SST .....	1
5	G25-024-2017	Cap Screw, socket-head, M10 x 1.5 x 170 mm .....	8
6	G25-048-2010	Washer, split-lock, M10 .....	16
7	D25-004-1054	Manifold, polypropylene .....	1
	D25-004-1055	Manifold, Celcon .....	1
	D25-004-1056	Manifold, Teflon .....	1
	D25-004-1057	Manifold, Kynar .....	1
8	D10-083-2110	O-ring, center manifold, Buna .....	1
	D10-083-2111	O-ring, center manifold, Viton .....	1
	D10-083-2112	O-ring, center manifold, Neoprene ....	1
	D10-083-2113	O-ring, center manifold, EPDM .....	1
9	D25-073-2110	O-ring, manifold, Buna .....	1
	D25-073-2111	O-ring, manifold, Viton .....	1
	D25-073-2112	O-ring, manifold, Neoprene .....	1
	D25-073-2113	O-ring, manifold, EPDM .....	1
10	D25-109-2110	O-ring, outer manifold, Buna .....	1
	D25-109-2111	O-ring, outer manifold, Viton .....	1
	D25-109-2112	O-ring, outer manifold, Neoprene .....	1
	D25-109-2113	O-ring, outer manifold, EPDM .....	1
11	D25-035-2110	O-ring, valve seat, Buna .....	6
	D25-035-2111	O-ring, valve seat, Viton .....	6
	D25-035-2112	O-ring, valve seat, Neoprene .....	6
	D25-035-2113	O-ring, valve seat, EPDM .....	6
12	D25-020-1010	Valve Seat, 17-4 HT SST .....	6
	D25-020-1012	Valve Seat, Nitronic 50 .....	6
	D25-020-1017	Valve Seat, Hastelloy C .....	6
	D25-020-3300	Valve Seat, ceramic .....	6
13	D25-021-1010	Valve, 17-7 HT SST. stamped .....	6
	D25-021-1011	Valve, Nitronic 50 .....	6
	D25-021-1015	Valve, 17-4 HT SST, machined .....	6
	D25-021-1017	Valve, Hastelloy C .....	6
	D25-021-3300	Valve, ceramic .....	6
14	D25-022-3110	Valve Spring, 17-7 HT SST .....	6
	D25-022-3114	Valve Spring, Elgiloy .....	6
	D25-022-3115	Valve Spring, Hastelloy C .....	6
15	D25-092-2110	Tetra Seal, Buna .....	6
	D25-092-2111	Tetra Seal, Viton .....	6
	D25-092-2112	Tetra Seal, Neoprene .....	6
	D25-092-2113	Tetra Seal, EPDM .....	6
16	D25-023-2310	Retainer, valve spring, Celcon .....	6
	D25-023-2316	Retainer, valve spring, Nylon .....	6
	D25-023-2317	Retainer, valve spring, polypropylene	6
	D25-023-2318	Retainer, valve spring, Kynar .....	6

# H-25 Fluid End

Ref #	Part Number	Description	Quantity/ Pump
18	D25-003-1054	Valve Plate, polypropylene .....	1
	D25-003-1055	Valve Plate, Celcon .....	1
	D25-003-1056	Valve Plate, Teflon .....	1
	D25-003-1057	Valve Plate, Kynar .....	1
19	D25-030-2010	Screw, flat-head mach., 5/8", 316 SST .....	3
	D25-030-2011	Screw, flat-head mach., 5/8", Hastelloy C .....	3
20	D25-047-2110	O-ring, follower, Buna .....	3
	D25-047-2111	O-ring, follower, Viton .....	3
	D25-047-2112	O-ring, follower, Neoprene .....	3
	D25-047-2113	O-ring, follower, EPDM .....	3
21	D25-017-1010	Follower, 316 SST .....	3
	D25-017-1011	Follower, Hastelloy C .....	3
22	D25-018-2310	Diaphragm, Buna-N .....	3
	D25-018-2311	Diaphragm, Viton .....	3
	D25-018-2312	Diaphragm, Neoprene .....	3
	D25-018-2313	Diaphragm, EPDM .....	3
	D25-018-2315	Diaphragm, Viton-XT .....	3
	D25-018-2320	Diaphragm, Buna-N-XS .....	3
23	D25-016-1010	Plunger .....	3
24	G25-082-2010	Set Screw, M6 x 1 x 16mm .....	3
25	G25-002-1010	Cylinder Casting .....	1
	G25-002-1210	Cylinder Casting Assembly, Buna <sup>1</sup> .....	—
26	G10-087-2020	Cap Screw, socket-hd, M10 x 1.5 x 30 mm .....	4
27	D10-080-2110	O-ring, oil fill, Buna .....	1
	D10-080-2111	O-ring, oil fill, Viton .....	1
28	D10-039-1210	Cap, oil fill ( includes breather ) .....	1
29	D10-040-2410	Name Plate .....	1
30	G25-001-1218	Pump Housing Assembly <sup>2</sup> .....	— <sup>0</sup>
	G25-001-1228	Pump Housing <sup>2</sup> .....	1

Ref #	Part Number	Description	Quantity/ Pump
31	G10-028-2010	Nut, hex, M10 .....	8
32	D25-076-2210	Elbow, 3/8" .....	1
33	D25-077-2210	Pipe, 3/8" .....	1
34	D25-078-2210	Cap, 3/8" .....	1
35	D25-025-1010	Base .....	1
36	G25-054-2010	Washer, shakeproof, M10 .....	4
37	G10-029-2010	Cap Screw, hex-hd, M10 x 1.5 x 25 mm .....	4
38	D25-125-2310	Washer, dampening, Celcon .....	6
	D25-125-2316	Washer, dampening, Nylon .....	6
	D25-125-2317	Washer, dampening, polypropylene ..	6
	D25-125-2318	Washer, dampening, Kynar .....	6
39	G25-088-2010	Cap Screw, socket-hd, M6 x 1x 45 mm .....	3
40	G25-106-2318	Gasket, cover .....	1
41	H25-105-1018	Cover, housing .....	1
42	G25-090-2010	Cap Screw, hex-head .....	6
43	D25-100-1011	Support, manifold .....	1

<sup>1</sup> Cylinder Casting Assembly includes casting (25), bearing cup, adjusting plate (61), O-ring (60), and set screws (24).

<sup>2</sup> Pump Housing Assembly includes housing (30), drain plug (32, 33, 34), and bearing cup. Pump Housing includes gasket (40), cover (41), and screws (42).



# H-25 Hydraulic End

Ref #	Part Number	Description	Quantity/ Pump
50	D25-019-3111	Spring, piston return .....	3
51	D25-042-1010	Retainer, spring .....	3
52	D25-046-2110	O-ring, valve cylinder, Buna .....	9
53	D25-045-3110	Spring, sleeve valve .....	3
54	D25-044-1010	Valve Plunger .....	3
55	D25-043-1010	Cylinder, valve .....	3
56	D25-034-2110	O-ring, Buna .....	6
57	D25-041-1010	Washer, ball retainer .....	3
58	D25-015-3010	Ball, 1/4" <sup>1</sup> .....	12
59	D25-014-1209	Piston, with foot and retainer .....	3
	D25-014-1210	Piston Assembly, Buna <sup>2</sup> .....	-
60	D25-075-2110	O-ring, bearing adjusting plate, Buna	1
61	D25-012-1010	Bearing Adjusting Plate .....	1
62	H25-007-1210	Cam Assembly <sup>3</sup> , 20 GPM @ 1050 RPM .....	1
	H25-007-1212	Cam Assembly <sup>3</sup> , 12 GPM @ 1200 RPM .....	1
	H25-007-1213	Cam Assembly <sup>3</sup> , 16 GPM @ 1200 RPM .....	1
	H25-007-1214	Cam Assembly <sup>3</sup> , 20 GPM @ 1200 RPM .....	1
63	D25-085-2210	Key, shaft .....	1
64	H25-031-2112	Seal, Buna, 1-1/8" .....	2
65	H25-037-2110	O-ring, pump housing, Buna, Ser. No. 100403 & above .....	1
	D25-037-2110	O-ring, pump housing, Buna, Ser. No. 100402 & below .....	1
-	D25-111-2400	Label, caution .....	1

<sup>1</sup> Pump serial numbers 90380 and lower many have two balls per piston.

<sup>2</sup> Piston Assembly includes cylinder, foot, valve plunger, O-rings, spring reatiner, and springs (50-59).

<sup>3</sup> Cam Assembly includes cam, shaft, wobble plate and bearings. It is only available as an assembly.

# H-25 Series Replacement Parts Kits

## Ordering Information

A complete H-25 Replacement Parts Kit contains 11 digits including 7 customer-specified material options: for example D12K52GHHEP

1 H 2 2 3 5 4 5 6 7 8 9 10 11

### 4 Kit Designator

- K** Complete Fluid End Kit
- D** Diaphragm Kit
- V** Valve Kit (diaphragm not included)

### 6 Pump Head Type

- 2** Metallic
- 5** Non-metallic

### 7 Diaphragm & O-ring Material

- E** EPDM
- G** Viton®-XT
- J** Teflon® (used with metallic heads only)
- N** Buna-N
- P** Neoprene
- T** Buna-N-XS
- V** Viton®

### 8 Valve Seat Material

- C** Ceramic
- H** 17-4 PH Stainless Steel
- S** 316 Stainless Steel
- N** Nitronic 50
- X** Not included in Diaphragm Kit

### 9 Valve Material

- C** Ceramic
- F** 17-4 PH Stainless Steel (machined)
- H** 17-7 PH Stainless Steel (stamped)
- N** Nitronic 50
- T** Hastelloy® C
- X** Not included in Diaphragm Kit

### 10 Valve Springs

- E** Elgiloy®
- H** 17-7 PH Stainless Steel
- T** Hastelloy® C
- X** Not included in Diaphragm Kit

### 11 Valve Spring Retainers

- C** Celcon
- H** 17-7 PH Stainless Steel (used with metallic heads only)
- M** Kynar®
- P** Polypropylene
- T** Hastelloy® C (used with metallic heads only)
- Y** Nylon (Zytel)
- X** Not included in Diaphragm Kit

## Kit Contents

Part Number*	Description	Qty	Kit Designator		
			K	D	V
<b>D25-018-</b> ___	Diaphragm	3	•	•	
<b>D25-047-</b> ___	O-ring, follower	3	•	•	
<b>D25-074-</b> ___	O-ring, outlet valve <sup>1</sup>	3	•	•	•
<b>D25-097-</b> ___ or					
<b>D25-109-</b> ___	O-ring, outer manifold <sup>2</sup>	1	•	•	•
<b>D25-073-</b> ___	O-ring, inner manifold	1	•	•	•
<b>D10-083-</b> ___	O-ring, center manifold <sup>3</sup>	1	•	•	•
<b>D25-083-</b> ___	O-ring, center bolt <sup>4</sup>	1	•	•	•
<b>D25-035-</b> ___	O-ring, valve seat	6	•		•
<b>D25-020-</b> ___	Valve seat	6	•		•
<b>D25-021-</b> ___	Valve	6	•		•
<b>D25-022-</b> ___	Valve spring	6	•		•
<b>D25-092-</b> ___	Tetra seal <sup>5</sup>	6	•		•
<b>D25-023-</b> ___	Retainer, valve spring	6	•		•
<b>D25-125-</b> ___	Washer, dampening <sup>6</sup>	6	•		•
<b>A01-113-3400</b>	Threadlocker	1	•	•	

\* Last four digits of part numbers with \_\_\_ refer to specific material of construction.

<sup>1</sup> D25-074 is provided with metallic heads only.

<sup>2</sup> D25-097 is provided with metallic heads; D25-109 is provided with non-metallic heads

<sup>3</sup> D10-083 is provided with non-metallic heads and metallic head models with brass external centerbolt.

<sup>4</sup> D25-083 is provided with metallic heads only.

<sup>5</sup> Tetra seal is provided with non-metallic spring retainers only.

<sup>6</sup> Dampening washer is provided for non-metallic heads only.



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