No portion of the pump/motor unit shall bear on the sump floor directly or on a sump floor mounted stand.

The column pipe shall be made from glass reinforced polymer (GRP) or stainless steels complying with relevant Sections of this Specification.

B. Pump components shall be metallic with smooth surfaces devoid of blow holes or other casting irregularities.

C. Casings shall be metallic satisfying following criteria as a minimum:

- Strength
- Corrosion resistance
- Abrasive-wear resistance
- Casting and machining properties
- Cost and selection of materials complying with applicable BS EN and ANSI standard

Casings shall be free of any blow holes and sand pockets resulting from imperfect and defective castings. Inner surfaces of casing which are in contact with the fluid shall be ideally shaped to match the streamlines and be finished so that minimum head loss and favourable efficiency could be attained.

All screw or bolt and nut seating in the casing should be machined and the joint face of the pump casing should be sealed by means of flat gasket and bolted together.

D. Impellers shall be metallic non-clog type satisfying following criteria as a minimum:

- Corrosion resistance;
- Abrasive-wear resistance;
- Cavitation resistance;
- High machining properties;
- Low cost and selection of the materials complying with applicable BS EN and ANSI standard.

The impeller vanes design shall be based on manufacture experience to ensure hydraulic balance during all operating conditions.