

## Pump Bushing

### 120001

1 Pump Bushing

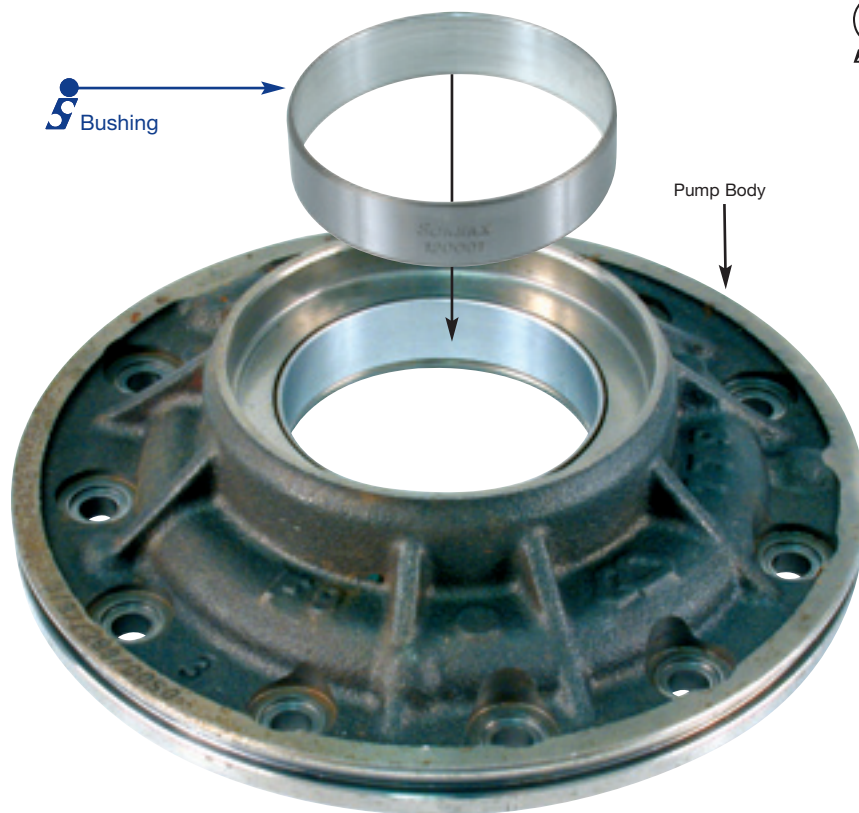
### 120001A

1 Pump Bushing,  
Finish-in-Place



 Bushing

Pump Body



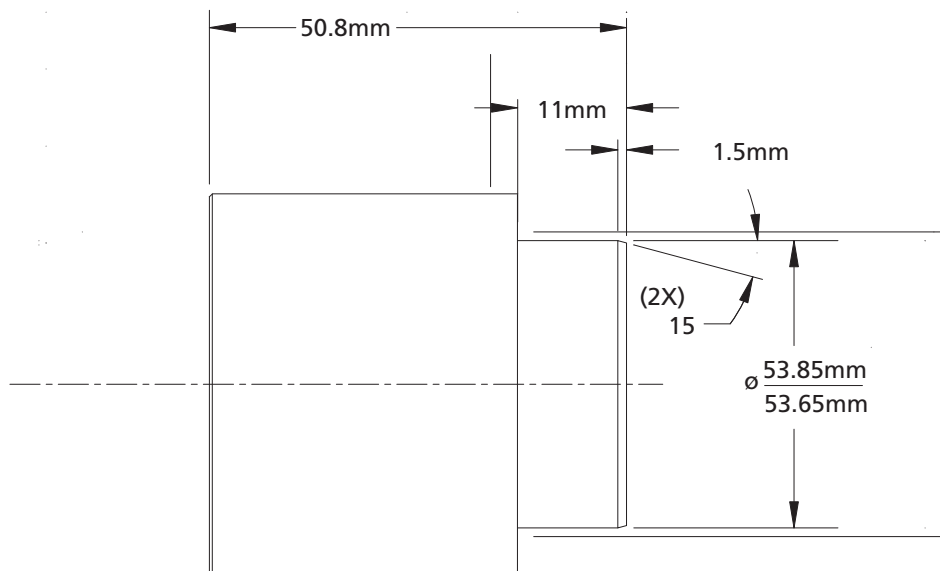
PART NUMBERS 120001, 120001A

### Machining Instructions for finish-in-place bushing

#### Tools Required

- Arbor press
- Shouldered arbor
- Lathe with a 3-jaw chuck that will open up to 152.4mm in diameter
- Magnetic indicator stand
- One-tenth indicator
- Carbide tipped boring bar
- Go/No Go plug gauge - A Go/No Go gauge should be made to the following specifications: (Go Diameter 54.465mm/No Go Diameter 54.485mm)

A shouldered arbor should be made to the specifications shown below:



#### Procedure

1. Remove seal from housing. Bushing must be removed toward seal pocket. Avoid damaging cavity bottom shoulder and bore surface.
2. Use the arbor press and shouldered arbor to install the replacement bushing. Press to shoulder in pump cavity.

**When installing direct replacement bushing, complete by installing seal.**

#### For finish-in-place bushing

3. Clamp on large O.D., being careful not to mark the surface, and indicate the I.D. of the seal bore where the seal is pressed into. This must run within 0.0127mm T.I.R.

**Note:** Pump housings should be clamped on the large diameter where the o-ring seal is. This diameter runs true with the I.D. where the bushing is pressed.

4. Bore the bushing I.D. to a size of 54.46/54.48mm; finish should be 0.4/0.8 micrometers surface finish or better. Verify with Go/No Go gauge.
5. Install seal.