

	Page
Related Publications	1
Resleeving Identification	1
Resleeving Instructions	2
Rework Dimensions	3
T100 Medium Pressure Sleeve Kit Parts	5

Related Publications

177-999 T100 Series Medium Pressure Installation and Service

Resleeving Instructions

Note: Read and understand these instructions and illustrations before starting resleeving.

Manifold Disassembly

1. Remove the NPT or Flange manifold from the pump following instructions in the pump manual (see Related Publications).
2. Remove all valves, and supporting hardware.

Manifold Cleaning

CAUTION: Make sure not to damage critical surfaces. Thoroughly clean the manifold of all scale and deposits.

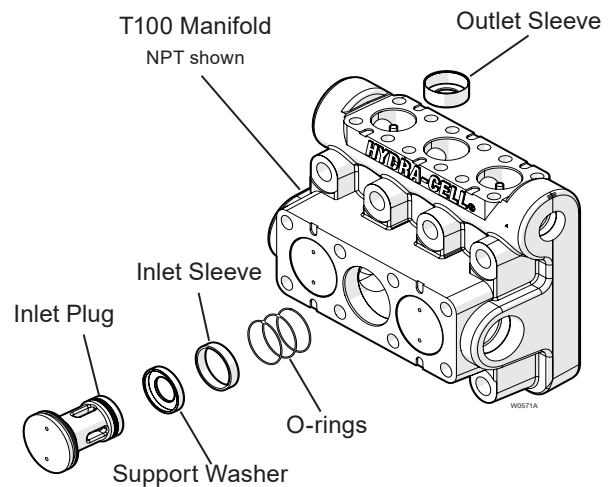
Manifold and Inlet Plug Rework

1. Remachine the NPT or Flange manifold *inlet valve bores*, and *outlet valve bores* as shown in the applicable NPT or Flange manifold drawings on the following pages.
2. Rework the overall length of the *inlet valve support plug* to the length shown in the inlet plug drawing. Pay very close attention to the machining tolerances as they are critical to the successful operation of the pump manifold. Make sure all sharp edges are deburred and prepared for assembly.

Resleeving Kit Installation

1. With the manifold and inlet support plug remachined, prepare the sleeves and the manifold for assembly.
2. The sleeves are a press fit into the newly machined bores and need to be pressed into place. The use of a hydraulic press is highly recommended.

Resleeving Identification



CAUTION: The parts can be pressed in place with the use of the supplied inlet/outlet dowels and a hammer only if great care is taken.

Manifold, Kit, and Tool Conditioning

Note: To ease kit installation the manifold is heated and the tools and kit parts are cooled.

1. Heat the manifold until just to hot to touch. Use a torch or heat gun without damaging the surfaces (for example by melting with a flame).
2. Cool the sleeves, and installation tools in a standard kitchen freezer.

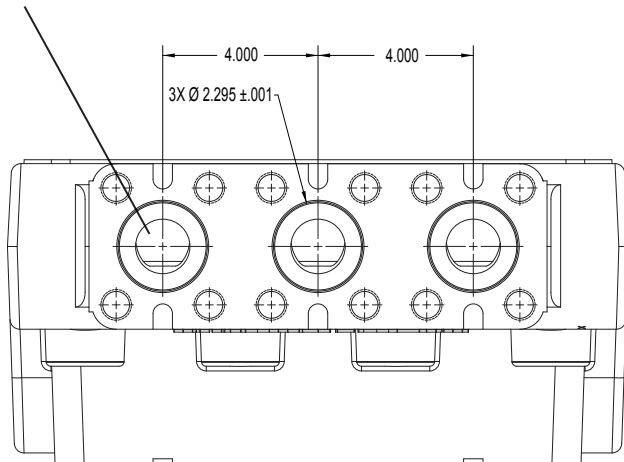
Kit Installation

1. Install inlet sleeves (177-470-01) with o-rings (177-473) and outlet sleeves (177-472-01) in the newly machined manifold bores until they are bottomed out. Make sure the sleeves are at the bottom of the bores before attempting to reassemble the valve assemblies
2. Install the manifold onto the pump following the procedure outlined in the pump manual (see Related Publications).
3. Install the outlet valve assemblies, and outlet plugs.
4. Reassemble the remachined inlet support plugs to the inlet support plate
5. Place the inlet support washer (177-471-01) onto the end of the shortened inlet support plug as shown in the Inlet Support Washer Installation illustration. A small amount of grease should be used to hold the support washer onto the support plug during assembly.
6. Reinstall the inlet valves and support plug assembly.
7. Torque the manifold bolts.

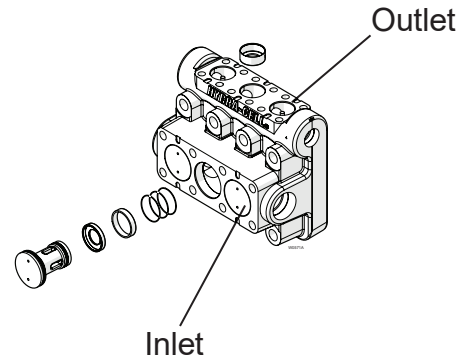
T100 Resleeving Rework Dimensions

NPT Manifold

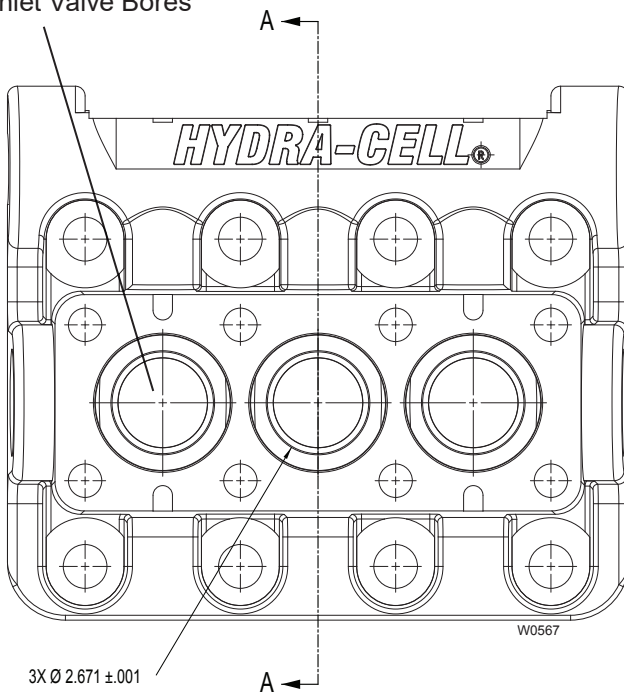
Outlet Valve Bores



Top View

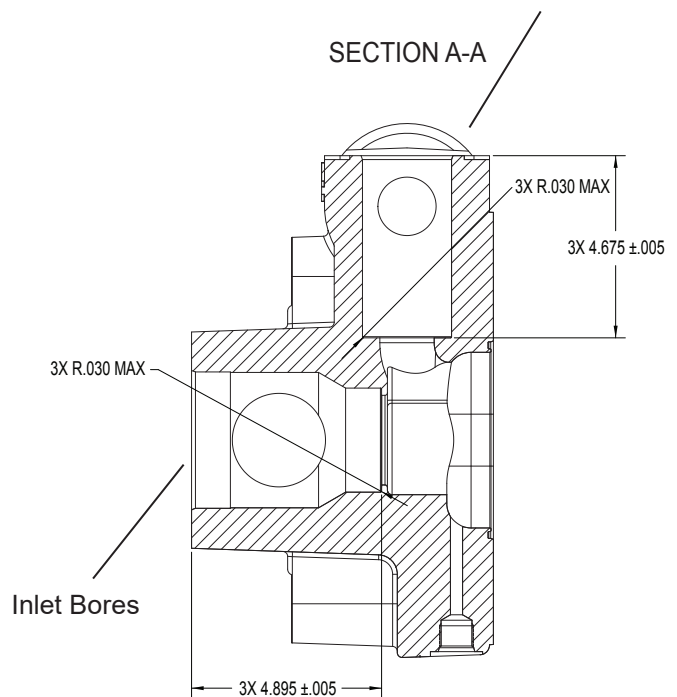


Inlet Valve Bores



Front View

Outlet Bores

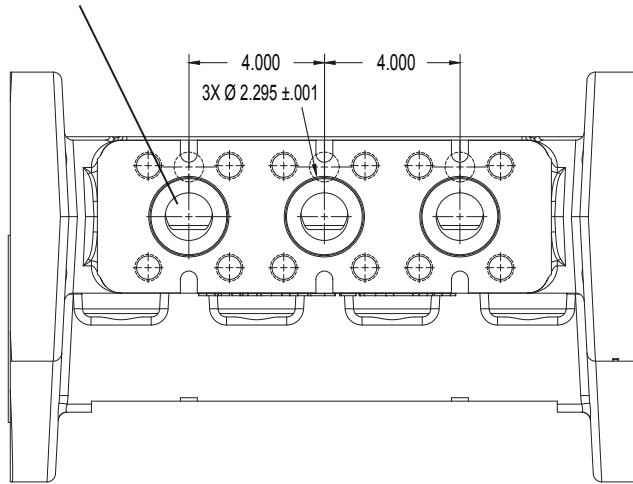


Side View

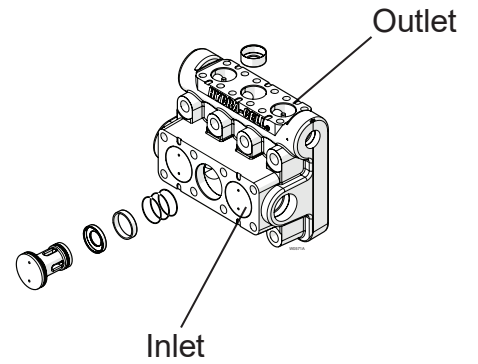
T100 Resleeving Rework Dimensions

Flange Manifold

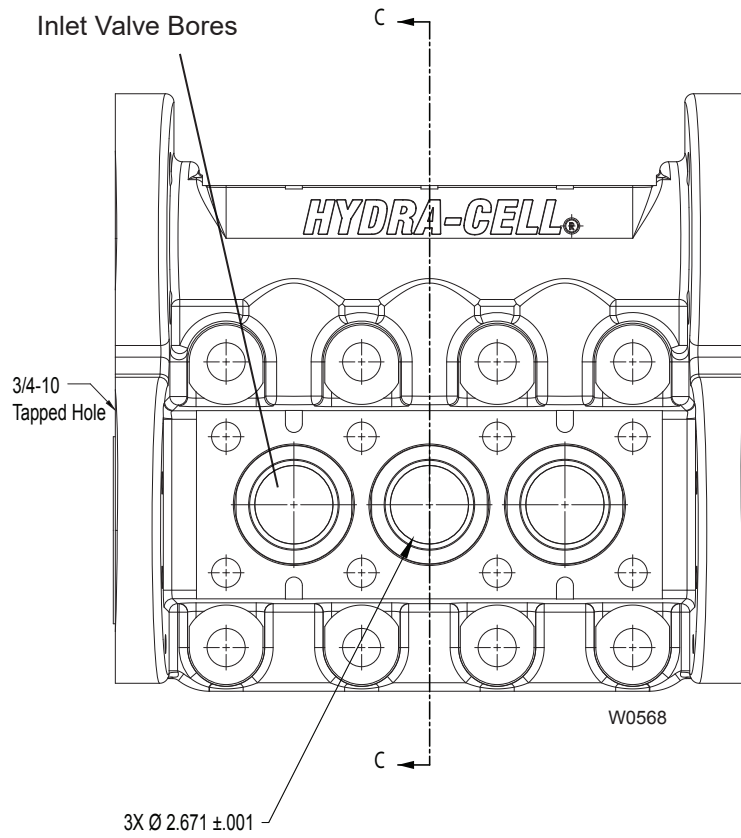
Outlet Valve Bores



Top View

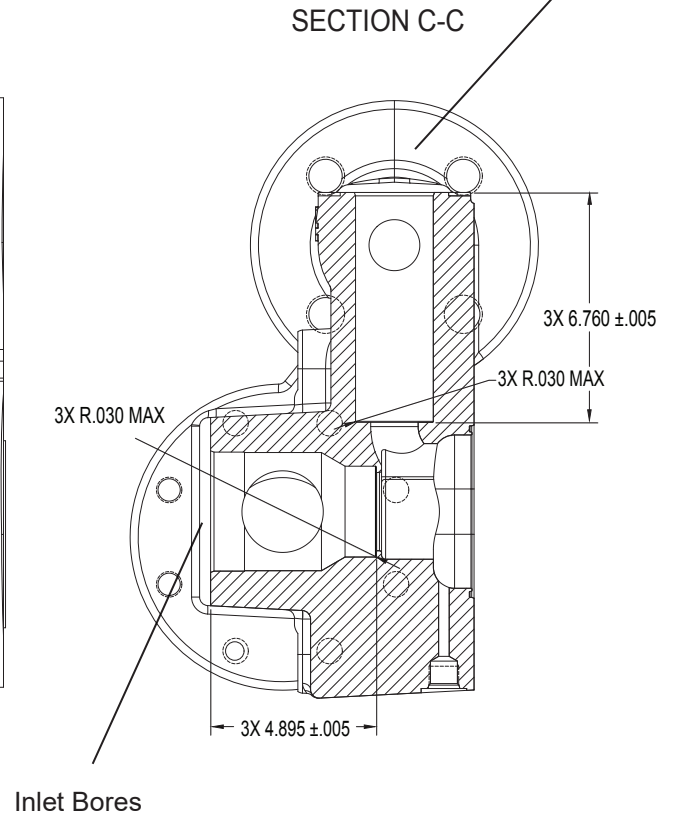


Inlet Valve Bores



Front View

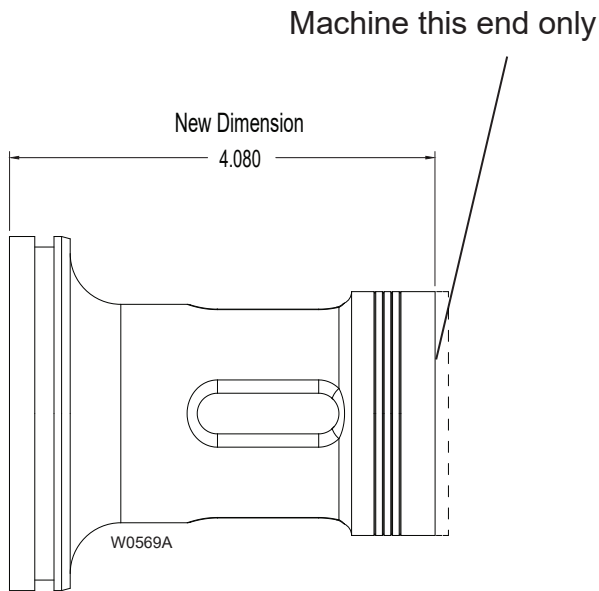
Outlet Bores



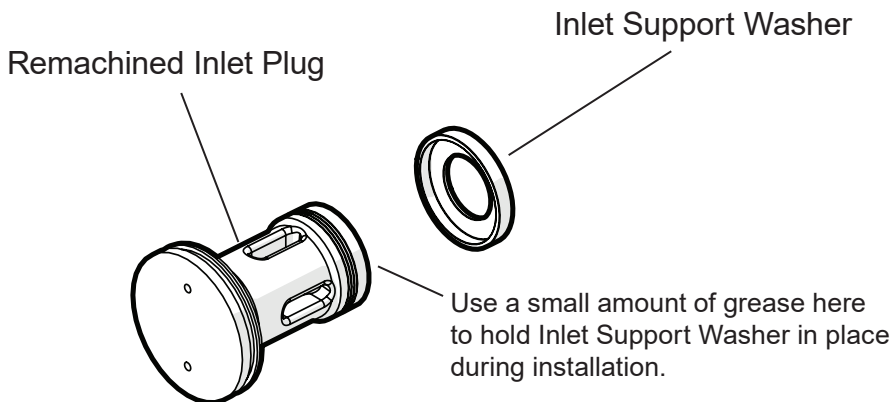
Side View

T100 Resleeving Rework Dimensions

Inlet Plug



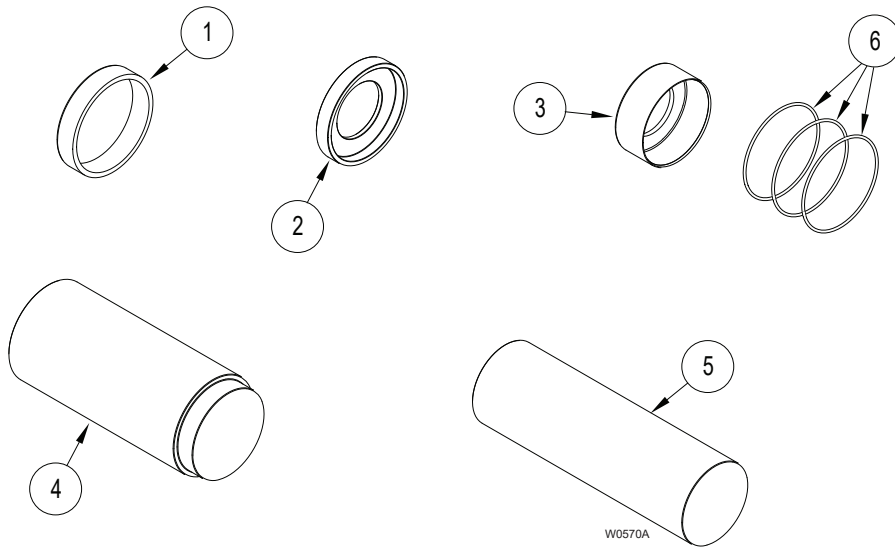
Inlet Support Washer Installation



T100 Manifold Resleeving

T100 Medium Pressure Sleeve Kit Parts

The T100 Medium Pressure Sleeve Kit contains the parts and tools illustrated below. These parts and tools are used to resleeve T100 Series Medium Pressure Hydra-Cell Pumps.



Ref. No.	Part No.	Part/Tool Description	Quantity/Kit
1	177-470-01	Sleeve, Inlet, 316 SST.....	3
	177-470-02	Sleeve, Inlet, 17-4 SST.....	3
2	177-471-01	Support washer, 316 SST	3
	177-471-02	Support washer, 17-4 SST	3
3	177-472-01	Sleeve, Outlet, 316 SST	3
	177-472-02	Sleeve, Outlet, 17-4 SST	3
4	177-815	Dowel, Inlet sleeve installation	1
5	177-816	Dowel, Outlet sleeve installation	1
6	177-473-01	O-ring, Buna-N.....	9
	177-473-02	O-ring, FKM	9

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