Please read and save this Repair Parts Manual. Read this manual and the General Operating Instructions carefully before attempting to assemble, install, operate or maintain the product described. Protect yourself and others by observing all safety information. The Safety Instructions are contained in the General Operating Instructions. Failure to comply with the safety instructions accompanying this product could result in personal injury and/or property damage! Retain instructions for future reference. AMT reserves the right to discontinue any model or change specifications at any time without incurring any obligation.

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Periodic maintenance and inspection is required on all pumps to ensure proper operation. Unit must be clear of debris and sediment. Inspect for leaks and loose bolts. Failure to do so voids warranty

1-Inch Dewatering Pumps

Refer to pump manual 1808-634-00 for General Operating and Safety Instructions.

DESCRIPTION

1" dewatering pumps are 4-cycle engine driven, self-priming to 15 ft. lift and portable. Clog resistant impeller is capable of handling solids up to ¼" diameter. Shaft seal has stainless steel components, Buna N elastomers, carbon head and ceramic seat. Handles liquids from 40° to 180° F (4° to 82° C). For use with nonflammable, non-abrasive liquids compatible with pump component materials.

MAINTENANCE

AWARNING

To prevent accidental starting always remove the spark plug, or disconnect and ground the spark plug wire before attempting to service or remove any component.

MECHANICAL SEAL REPLACEMENT

Refer to Figures 1 and 2

IMPORTANT: Always replace the seal seat (Ref. No. 4) and seal head (Ref. No. 5) to ensure proper mating of mechanical seal components!

- Unthread cap screws (Ref. No. 9). Remove casing (Ref. No. 11) and seal (Ref. No. 10) from adapter (Ref. No. 3).
- Unscrew impeller (Ref. No. 8) from the engine shaft and remove the impeller shims (Ref. No. 7).

NOTE: To keep the shaft from turning, remove the shroud from engine and hold the flywheel in place.

- 3. Slide shaft sleeve and seal head from the engine shaft.
- 4. Unthread cap screws (Ref. No. 2) from engine mounting
- 5. Push seal seat from the adapter recess with a screwdriver.
- 6. Clean the adapter recess before inserting a new seal seat.
- Carefully wipe the ceramic surface of the new seal seat with a clean cloth.
- Wet the rubber portion of the seal with a light coating of soapy water.
- 9. Press the new seal seat squarely into cavity in the adapter. If the seal seat does not press squarely into the cavity, it can be adjusted in place by pushing on it with the end of a piece of pipe. Always use a piece of cardboard between the pipe and the seal seat to avoid scratching the seal seat. (This is a lapped surface and must be handled very carefully.
- After the seal seat is in place, ensure that it is clean and has not been marred.
- 11. Using a clean cloth, wipe the shaft and make certain that it is perfectly clean.
- 12. Secure the adapter on the engine mounting face.

A CAUTION

Tighten cap screws EVENLY to avoid cocking rabbet on engine mounting.

13. Apply a light coating of soapy water to the inside rubber portion of seal head and slide onto the shaft sleeve. Slip the shaft sleeve with seal head onto the engine shaft.

A CAUTION

Do not touch or wipe the face of the carbon (black) part of the seal cartridge.

- 14. Replace impeller shims.
- Screw impeller back in place, tightening until it is against the shoulder
- 16. Install seal and remount the pump casing on adapter.

SHIM ADJUSTMENT

 When installing a replacement engine, adapter, impeller, shaft sleeve, volute or casing, it may be necessary to vary the number of impeller shims (Ref. No. 7) that will be required. This is easily done by adding one shim more than was removed and reassembling the pump as described in MECHANICAL SEAL REPLACEMENT section.

NOTE: When adding or removing shims, it is best to proceed with a 0.010" increment each time. Remove spark plug wire from engine and ground. While tightening the unit together, turn the shaft (by pulling on the recoil starter, etc.); feel for the shaft seizing. If shaft begins to seize before the fasteners are completely tight, disassemble the pump and remove one shim and repeat assembly.

- Once having added one shim more than original, ensure that the volute (Ref. No. 11) and adapter (Ref. No. 3) are firmly fitted (check fasteners Ref. Nos. 2 & 9). When engine turns freely, add shims until it does strike, then remove a 0.010" shim. This should allow the proper clearance.
- 3. Proper running clearance for the impeller should be as close as possible to volute without striking; maximum clearance is 1/32" (0.032").
- 4. Follow the above procedure until proper clearance is obtained. This will ensure maximum performance.

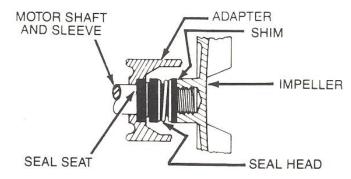


Figure 1- Mechanical Seal Replacement

1-Inch Dewatering Pumps

For Repair Parts contact dealer where pump was purchased.

Please provide following information:

-Model Number

-Serial Number (if any)

Part description and number as shown in parts list

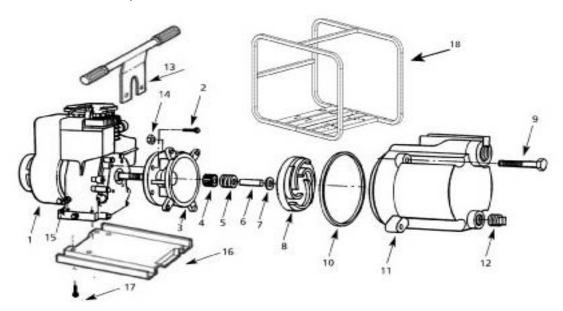


Figure 2 - Repair Parts Illustration

Repair Parts List

Ref.		Part Number for	Models:		
No.	Description	1G4XA	1G4XAR	1G4XHR	Qty.
1	Engine	1630-008-00	1630-008-00	1630-005-00	1
2	Fastener	*	*	*	4
3	Adapter	2850-030-95	2850-030-95	2850-030-95	1
	(includes Ref. No. 6)				
4&5	Shaft Seal Assembly – Buna N	1640-162-90	1640-162-90	1640-162-90	1
	Shaft Seal Assembly - Viton	1640-162-91	1640-162-91	1640-162-91	1
6	Shaft Sleeve	1483-140-09	1483-140-09	1483-140-09	1
7	Impeller Shim Package	1658-000-90	1658-000-90	1658-000-90	1
8	Impeller	2890-010-00	2890-010-00	2890-010-00	1
9	Fastener	*	*	*	4
10	Casing Seal – Buna N	1531-000-00	1531-000-00	1531-000-00	1
	Casing Seal – Viton	1532-000-00	1532-000-00	1532-000-00	1
11	Casing	2850-004-96	2850-004-96	2850-004-96	1
	(includes Ref. Nos. 9, 12, & 14)				
12	½" NPT Pipe Plug	*	*	*	1
13	Carry Handle	1549-006-Z0	N/A	N/A	1
14	Fastener	*	*	*	4
15	Fastener	*	*	*	4
16	Base	4220-100-00	N/A	N/A	1
17	Fastener	*	*	*	4
18	Frame w/ Hardware Kit	N/A	2760-104-K0	2760-104-K0	1
\triangle	1" NPT Hose Adapter Kit	1696-073-00	1696-073-00	1696-073-00	1
(*)	Standard Hardware Item, Available Locally				

(*) Standard Hardware Item, Available Locally

 (\triangle) Not Shown



AMT Pump Company (herein "AMT") 400 Spring Street Royersford, PA 19468 Phone: (610) 948-3800 Fax: (610) 948-5300 www.amtpump.com



General Information

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MINIMUM ORDER: We appreciate your order, however, all orders are subject to a minimum \$35.00 net invoice charge (excluding freight). This applies to all pump and parts purchase orders.

PRICES: Prices are subject to change without notice. All orders accepted are subject to prices in effect at time of shipment.

PAYMENT TERMS: Terms, upon establishment of credit, are Net 30 days. Past due accounts may be subject to a service charge of 1.5% per month. Domestic or assignable letter of credit is required for all export trade.

PAST DUE ACCOUNTS: AMT reserves the right to withhold open account shipments on any past due account. Invoices are considered past due after thirty (30) days. In the interest of sound business, all orders are subject to approval of the Credit Department.

SHIPPING INSTRUCTIONS: All shipments will be made F.O.B. the factory. Where instructions for shipment do not appear on the order, the shipment will be made according to our best judgment. Full risk of loss (including transportation delays and losses) shall pass to the customer upon delivery of the products to the carrier at the F.O.B. point. When loss or delay occurs, primary responsibility for tracing rests with the customer. When there is LOSS or APPARENT VISIBLE DAMAGE to a shipment, when tendered for delivery, *DO NOT* give the carrier a clear receipt. Note such damage on the carrier's delivery receipt and HAVE THE DRIVER SIGN THE RECEIPT.

PRODUCT REVISIONS: AMT reserves the right to discontinue, change or improve its products or any portions thereof without being obligated to provide such a change or improvement for units sold and/or shipped prior to such a change or improvement.

LEAD TIME: Products designated "Quick Ship Product", also referred to as "QSP" will normally be shipped within 24 hours of receipt of a non-cancellable purchase order. Only limited quantities of "QSP" pumps are available.

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ALL purchase orders must be submitted via hard copy sent to AMT customer service department by fax, EDI or e-mail.

RETURN GOODS POLICY: Goods shall not be returned without a return goods authorization number (RGA) issued by AMT customer service. The RGA number must be listed on the packing list. Only current model and part numbers with a valid date code may be returned (within one year from date of purchase). A 20% restocking and packaging charge will apply to all returns. All shipping charges must be pre-paid. No exceptions.

ORDER CHANGES BY CUSTOMER: Orders in process may not be changed except with written consent and may be subject to special charges.

12 Month Limited Warranty

EXTENT AND DURATION OF LIMITED WARRANTY

Coverage: AMT Pump Company (herein "AMT") or IPT Pumps by Gorman-Rupp (herein "IPT") or Gorman-Rupp Industries Division of the The Gorman-Rupp Company, Patterson, or the Gorman-Rupp Company (herein referred to as "G-R Unit) each individually warrants that its products and parts shall be free from defects in material and workmanship for twelve (12) months from the date of purchase by the original end user when installation is made and maintenance is performed in accordance with G-R Unit's recommendations. Wear and tear resulting from use and items normally consumed in use are not covered.

EXCEPTIONS

(A) This Limited Warranty shall not apply to mechanical seals in AMT or IPT pumps and the following products and parts: engines, motors, trade accessories and all other products, components, parts and materials not manufactured by the G-R Units. These items may, however, be covered by the warranties of their respective manufacturers. (B) This warranty does not extend to or apply to any unit which has been repaired or altered at any place other than by a G-R Unit, or by persons not expressly approved by a G-R Unit to make repairs or alterations, nor to any unit the serial number, model number or identification of which has been removed, defaced or altered. (C) This warranty does not extend to any product manufactured by a G-R Unit, which has been subjected to mis-use, neglect, accident, improper installation, or use in violation of instructions furnished by a G-R Unit. (D) Pump Kits: This warranty does not extend to any product sold by a G-R Unit unassembled as a Pump Kit. Pump Kits are warranted against defects in material and workmanship for 60 days from the date of shipment from a G-R Unit. Any Pump Kit parts deemed defective by a G-R Unit will be replaced free of charge within 60 days of shipment. Pump Kits are not returnable for credit.

LIMITATIONS

THE G-R UNITS' SOLE AND EXCLUSIVE WARRANTY WITH RESPECT TO THEIR PRODUCTS AND PARTS IS THIS LIMITED WARRANTY. THIS LIMITED WARRANTY IS IN LIEU OF ALL OTHER EXPRESS AND/OR IMPLIED WARRANTIES, INCLUDING IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSE.

EXCLUSIVE REMEDY AND DAMAGES

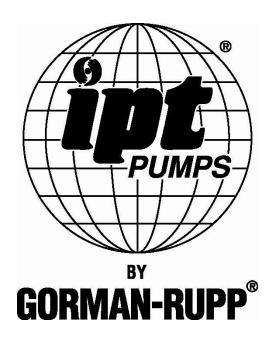
The sole and exclusive remedy for breach of this Warranty by a G-R Unit and the entire extent of its liability for such breach or for damages arising from the use of the products and parts covered under this Limited Warranty, shall be as follows:

- Repair or Replacement: If inspection shows that any G-R Unit product
 or part covered under this Limited Warranty is defective in materials or
 workmanship, the G-R Unit shall repair or replace the defective or nonconforming product or part without charge, whichever the G-R Unit
 chooses. You must have properly maintained and used the product or
 part claimed to be defective in accordance with the maintenance
 schedule or manual, which comes with the product. No allowance will
 be made for labor, installation, removal, transportation or other charges
 incurred by you in connection with such repair or replacement.
- 2. To obtain the above remedy:
 - A. Immediately notify the G-R Unit upon discovery of the claimed defect in materials or workmanship and provide the serial number or date code of the product and/or part(s) or provide the G-R Unit with the invoice or bill of sale referencing the product by no later than the expiration date of the warranty period.
 - B. The G-R Unit will advise whether inspection will be necessary and how whether repair or replacement will be made. If inspection by the G-R Unit is necessary, the pump or defective part must be sent freight pre-paid to the G-R Unit. Return shipment will be F.O.B. the G-R Unit's plant.
 - C. Return Goods Authorization Requirement: No product will be accepted for return or replacement without the prior written authorization of the G-R Unit. Upon such authorization, and in accordance with instructions from the G-R Unit, the product will be returned to the G-R Unit, shipping charges prepaid by the Buyer.
- 3. Damages: The G-R Unit's liability for damages for breach of this Limited Warranty shall not exceed the amount of the purchase price of the product or part(s) in respect to which Such damages are claimed. IN NO EVENT SHALL THE G-R UNITS BE LIABLE FOR INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES FOR BREACH OF THIS LIMITED WARRANTY.

Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you. This Limited Warranty gives you specific legal rights, and you may also have other rights, which vary from state to state.



A Gorman-Rupp Company



www.amtpump.com

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Periodic maintenance and inspection is required on all pumps to ensure proper operation. Unit must be clear of debris and sediment. Inspect for leaks and loose bolts. Failure to do so voids warranty.

Aluminum General Purpose Pumps

Refer to pump manual 1808-633-00 for General Operating and Safety Instructions.



DESCRIPTION

These pumps are engine driven, self-priming (to 20 ft. lift), portable units. Clog resistant impeller is capable of handling solids up to 1/4" diameter (2"=3/16" & 3"=1/4"). For use with non-flammable, non-abrasive liquids compatible with pump component materials.

MAINTENANCE

AWARNING

To prevent accidental starting, always remove spark plug or disconnect and ground spark plug wire before attempting to service or remove any component.

MECHANICAL SEAL REPLACEMENT

Refer to figures 1, 2 and 3.

IMPORTANT: Always replace both seal seat and seal head (Ref. No. 9) to ensure proper mating of components!

- Unthread fasteners (Ref. No. 15) and remove casing (Ref. No. 13) and casing seal (Ref. No. 11).
- 2. Remove volute (Ref. No. 10).
- Unscrew impeller fastener (Ref. No. 8) from motor shaft (fastener unscrews CCW looking at motor shaft).

NOTE: To prevent shaft from turning, remove shroud from engine and hold the flywheel in place.

- Remove keyed impeller (Ref. No. 7) from motor shaft. Remove shims (Ref. No. 6) DO NOT LOSE SHIMS.
- 5. Pry seal seat from recess of impeller.
- 6. Remove the adapter (Ref. No. 2) by unthreading fasteners (Ref. No. 4).
- 7. Press seal head from rear of adapter.
- Clean adapter and impeller seal recesses and motor shaft. Make certain all surfaces are perfectly clean before installing new seal parts.

A CAUTION

Handle seal parts with extreme caution and keep them clean. Do not touch polished seal faces with your hands. Do not apply lubricants on seal faces. This could cause a leak or premature seal failure.

- Apply a light coat of sealing compound to new seal head (See Figure 1)
 and press it into adapter recess using proper size tube or installation tool
 (see Figure 2). DO NOT press on carbon face. Install using flange only.
- 10. Slide adapter onto motor mounting face. Attach with fasteners.
- 11. Press new seal seat squarely into impeller recess. Avoid scratching polished surface.

NOTE: Use a soft, clean piece of cloth on seal seat face when installing to prevent marring.

- Replace any shim washers which may have been removed in disassembly (see SHIM ADJUSTMENT). Using key, put the impeller back in place.
- 13. Install and tighten impeller screw.
- 14. Reinstall volute and remount casing with fasteners.

NOTE: Volute gets placed inside casing before mouniting casing to adapter.

NOTE: Always flush pump thoroughly before use so as not to contaminate liquid being pumped. If impeller is replaced, seal assembly should also be replaced as seal is usually damaged in disassembly.

SHIM ADJUSTMENT

When installing a replacement impeller, it may be necessary to vary number of shims that will be required. This is done by adding 0.010" shim more than was removed and reassembling pump as follows:

IMPORTANT: When clearance between impeller and volute exceeds 1/16" at face of impeller or 1/8" on outside diameter of impeller, it may be necessary to take corrective action.

- Ensure that casing is snugly in place and check shaft to make sure it is turning freely. If it turns freely, check to ensure that adapter and casing are seated firmly, compressing gasket where they meet. If they are not seated, tighten fasteners and recheck shaft for free turning. Tighten carefully, turning shaft while tightening. If shaft seizes before fasteners are completely tight, disassembly pump, remove one shim and repeat reassembly.
- If at any time during shim adjustment shaft does not turn free, or a metalto-metal rubbing can be heard or felt when turning shaft, repeat SHIM ADJUSTMENT procedure.

NOTE: Impeller must be as close as possible to volute in order to perform properly and retain suction capabilities.

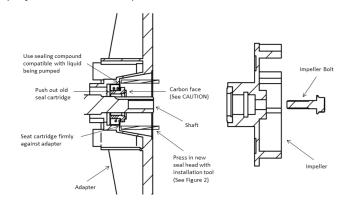


Figure 1 - Mechanical Seal Replacement

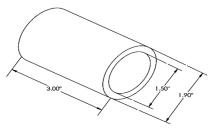


Figure 2 - Seal Installation Tool (Ref. No. 31)

Aluminum General Purpose Pumps

For Repair Parts contact dealer where pump was purchased.

Please provide following information:

- -Model Number
- -Serial Number (if any)

Part description and number as shown in parts list

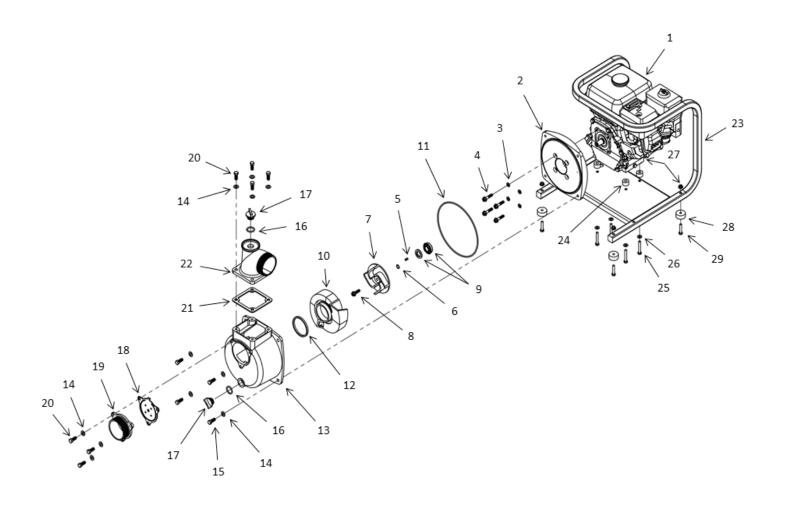


Figure 3 - Repair Parts Illustrations

Repair Parts List

_	Faits List			
Ref	Description		nber for Models	<u> </u>
No.	Description	GCW2	GCW3	Qty
1	Engine	1639-040-00	1639-040-00	1
2	Adapter Kit	GCW2-030-96	GCW3-030-96	1
	(includes Ref. Nos. 2, 3 and 4)	lead or/Daf O	local codD of O	4
3	Flat Washer	Incl. w/Ref. 2	Incl. w/Ref. 2	4
4	Adapter Bolt	Incl. w/Ref. 2	Incl. w/Ref. 2	4
5	Impeller Key	Incl. w/Ref. 7	Incl. w/Ref. 7	1
6	Impeller Shims	Incl. w/Ref. 7	Incl. w/Ref. 7	1
7	Impeller Kit	GCW2-010-95	GCW3-010-95	1
	(includes Ref. Nos. 5, 6, 7 and 8)			
8	Impeller Bolt	Incl. w/Ref. 7	Incl. w/Ref. 7	1
9	Mechanial Seal Kit	GCW2-301-90	GCW2-301-90	1
	(includes Ref. Nos. 9 and 31)			
10	Volute	GCW2-150-95	GCW3-150-95	1
11	Casing O-Ring	Incl. w/Ref. KIT	Incl. w/Ref. KIT	1
12	Volute Gasket	Incl. w/Ref. KIT	Incl. w/Ref. KIT	1
13	Casing Kit	GCW2-001-96	GCW3-001-96	1
	(includes Ref. Nos. 13, 14 and 15)			
14	Washers	Incl. w/Ref. 13, 19 and 22	Incl. w/Ref. 13, 19 and 22	11
15	Casing Bolt	Incl. w/Ref. 13	Incl. w/Ref. 13	4
16	Plug O-Ring	Incl. w/Ref. KIT	Incl. w/Ref. KIT	2
17	Plug	Incl. w/Ref. KIT	Incl. w/Ref. KIT	2
18	Flapper Valve	Incl. w/Ref. KIT	Incl. w/Ref. KIT	1
19	Suction Flange Kit NPT	GCW2-050-96	GCW3-050-96	1
	Suction Flange Kit BSP	GCW2-052-96	GCW3-052-96	1
	(includes Ref. Nos. 14, 19 and 20)			
20	Flange Bolt	Incl. w/Ref. 19 and 22	Incl. w/Ref. 19 and 22	7
21	Discharge Gasket	Incl. w/Ref. KIT	Incl. w/Ref. KIT	1
22	Discharge Flange Kit NPT	GCW2-080-96	GCW3-080-96	1
	Discharge Flange Kit BSP	GCW2-082-96	GCW3-082-96	1
	(includes Ref. Nos. 14, 20, and 22)			
23	Frame Kit	2760-104-K0	2760-104-K0	1
	(includes Ref. Nos. 23, 27, 28 and 29)			
24	Engine Mounting Hardware Kit	C403-420-92	C403-420-92	4
	(includes Ref. Nos. 24, 25, 26 and 27)			
25	Engine Bolts	Incl. w/Ref. 24	Incl. w/Ref. 24	4
26	Washers	Incl. w/Ref. 24	Incl. w/Ref. 24	4
27	Hex Nuts	Incl. w/Ref. 23 and 24	Incl. w/Ref. 23 and 24	8
28	Rubber Feet	Incl. w/Ref. 23	Incl. w/Ref. 23	4
29	Rubber Feet Bolts	Incl. w/Ref. 23	Incl. w/Ref. 23	4
30	Suction Strainer (not shown)	GCW2-170-90	GCW3-170-90	1
31	Seal Installation Tool (not shown, See Figure 2)	Incl. w/Ref. 9	Incl. w/Ref. 9	1
KIT	Gasket/O-Ring Kit	GCW2-300-90	GCW3-300-90	1
	(includes Ref. Nos. 11, 12, 16, 17, 18 and 21)			
****	(includes Ref. Nos. 11, 12, 16, 17, 18 and 21) Raising blocks not necessary for 2" Pump			_

^{****} Raising blocks not necessary for 2" Pump



AMT Pump Company (herein "AMT") 400 Spring Street Royersford, PA 19468 Phone: (610) 948-3800 Fax: (610) 948-5300 www.amtpump.com



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LIMITATIONS

THE G-R UNITS' SOLE AND EXCLUSIVE WARRANTY WITH RESPECT TO THEIR PROD-UCTS AND PARTS IS THIS LIMITED WARRANTY. THIS LIMITED WARRANTY IS IN LIEU OF ALL OTHER EXPRESS AND/OR IMPLIED WARRANTIES, INCLUDING IMPLIED WAR-RANTIES OF MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSE.

EXCLUSIVE REMEDY AND DAMAGES

The sole and exclusive remedy for breach of this Warranty by a G-R Unit and the entire extent of its liability for such breach or for damages arising from the use of the products and parts covered under this Limited Warranty, shall be as follows:

- Repair or Replacement: If inspection shows that any G-R Unit product or part covered under this Limited Warranty is defective in materials or workmanship, the G-R Unit shall repair or replace the defective or nonconforming product or part without charge, whichever the G-R Unit chooses. You must have properly maintained and used the product or part claimed to be defective in accordance with the maintenance schedule or manual, which comes with the product. No allowance will be made for labor, installation, removal, transportation or other charges incurred by you in connection with such repair or replacement.
- 2. To obtain the above remedy:
 - A. Immediately notify the G-R Unit upon discovery of the claimed defect in materials or workmanship and provide the serial number or date code of the product and/or part(s) or provide the G-R Unit with the invoice or bill of sale referencing the product by no later than the expiration date of the warranty period.
 - B. The G-R Unit will advise whether inspection will be necessary and how whether repair or replacement will be made. If inspection by the G-R Unit is necessary, the pump or defective part must be sent freight pre-paid to the G-R Unit. Return shipment will be F.O.B. the G-R Unit's plant.
 - C. Return Goods Authorization Requirement: No product will be accepted for return or replacement without the prior written authorization of the G-R Unit. Upon such authorization, and in accordance with instructions from the G-R Unit, the product will be returned to the G-R Unit, shipping charges prepaid by the Buyer.
- 3. Damages: The G-R Unit's liability for damages for breach of this Limited Warranty shall not exceed the amount of the purchase price of the product or part(s) in respect to which Such damages are claimed. IN NO EVENT SHALL THE G-R UNITS BE LIABLE FOR INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES FOR BREACH OF THIS LIMITED WARRANTY.

Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you. This Limited Warranty gives you specific legal rights, and you may also have other rights, which vary from state to state.