

3K BS-PCDP

“BS” Pollution Control Double Packed Stuffing Box Assembly Procedures

Starting with the PCDP base, make sure that all mating surface areas are clear and clean of any debris include the following locations:

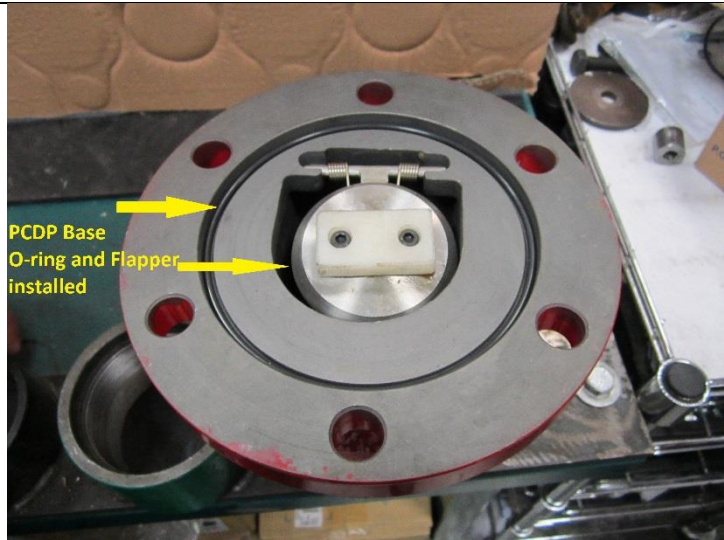
- Mating flange area
- O-ring groove
- Flapper assemble channel



Once all surface areas stated above are clean the next step is to assemble the following items:

- Lightly grease and insert o-ring into groove
- Insert flapper valve assemble
NOTE: Make sure that the white wear pad is facing UP

Finally, recheck all surface areas stated in first step to ensure cleanliness and debris free.



Now you are ready to install the PCDP spool. Before installing the spool, complete the following:

- Make sure spool and base mating areas are free of any debris.
- Slightly grease and insert O-ring into bottom of spool.

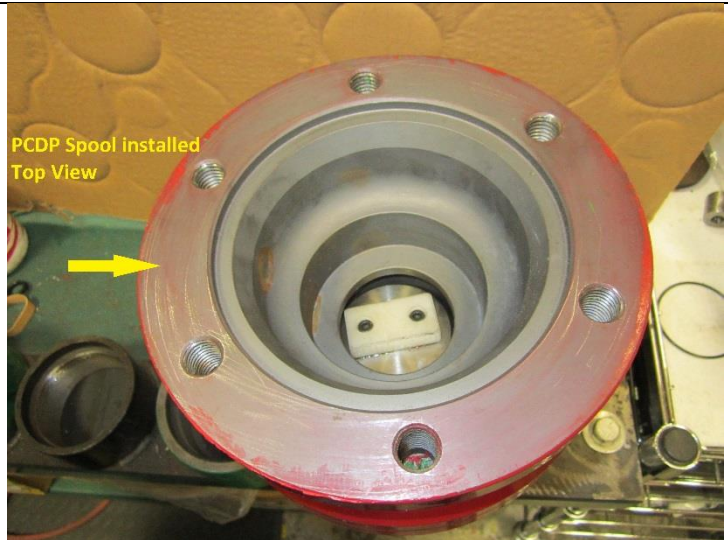


Once you have complete the above steps and aligned bolt holes, you are now ready to begin installing the following:

- 5/8" X 2" bolts (6 per)
NOTE: As you begin to tighten the bolts, make sure that you tighten in a flange fashion by alternating sides. Tighten bolt on one side, then bolt on the opposite side. DO NOT tighten in a row around the flange, this could cause a failure in sealing between the mating components.

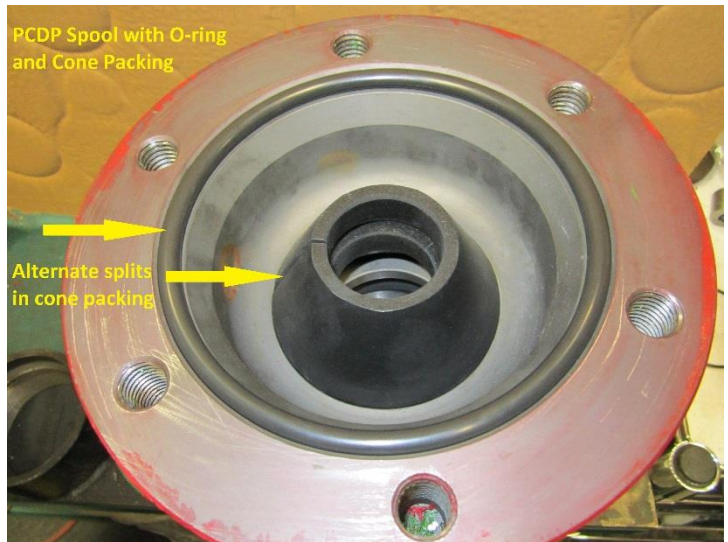


Once PCDP spool is installed you are ready to begin preparing for the body. Make sure once again to thoroughly clean flange mating area and o-ring groove of any debris to ensure a proper seal between the spool and body.

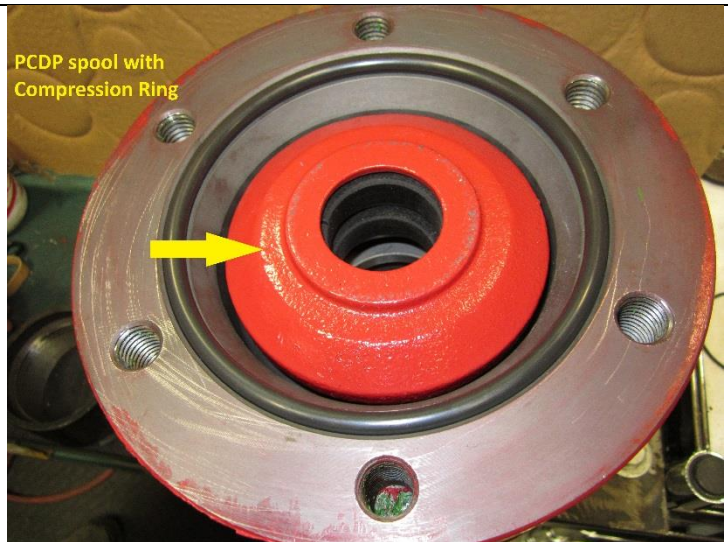


Once all areas mentioned above are cleaned and prepped, you are ready to install the following:

- Lightly grease and install PCDP spool top O-ring
- Thoroughly grease the 2 bottom cleaner cones and **make sure** to alternate splits
NOTE: Make sure that **proper rubber and size cones** are being used per customer request (IE. HSN, Brass Filled, High Temp, Teflon, Etc.)
- The cones should fit snugly inside the machined cavity.



The next step is to install the PCDP spool compression ring. Once again, **make sure** that the proper size compression ring is installed according to customer order.



Now you are ready to install the 3K body. Once again, make sure surface flange area top of spool and bottom of Body are clean and free of any debris before mating together.

Set body onto spool top and align bolt holes. Add the 5/8" X 1-3/4" bolts (6 per).

NOTE: As you begin to tighten the bolts, make sure that you tighten in a flange fashion by alternating sides. Tighten bolt on one side, then bolt on the opposite side. DO NOT tighten in a row around the flange, this could cause a failure in sealing between the mating components.

You have now completed the following components:

- PCDP Base
- Spool w/ Flapper Assembly
- 3K BS-DPSB Body



You are now ready to begin installing the packing. Make sure to follow these steps in order to ensure a proper seal between stuffing box and polished rod.

- First, Install the lower Dome brass packing ring follower

NOTE: make sure to install properly. The size of the brass ring should be stenciled and facing **DOWN** for proper installation.



Next, install 3 pieces of dome packing. NOTE: First, make sure you are installing the **proper size and rubber compound** according to customer order.

Make sure to stagger the splits on the packing to avoid a leak path. Alternate sides of splits to ensure proper installation. In addition, make sure to thoroughly grease the packing before installing.



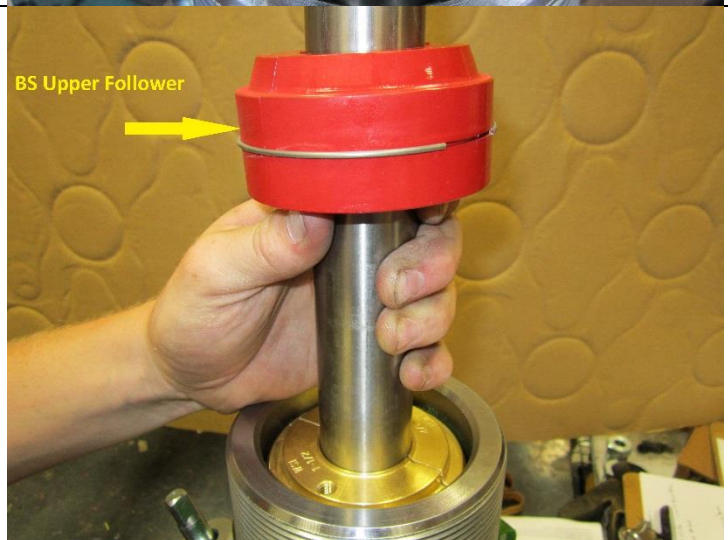
Once dome packing is installed and firmly seated on lower follower, you are ready to install the top dome brass packing ring follower.

NOTE: make sure to install properly. The size of the brass ring should be stenciled and facing **UPWARD** for proper installation



Finally, once you have installed the top dome brass packing ring follower and firmly seated on top of dome packing, you are ready to install the BS upper follower. The Upper follower is a 2 piece design and a retainer ring is used to hold 2 halves together for easier replacement when necessary.

NOTE: install BS upper follower with small upset beveled lip facing up as shown in the side picture. Make sure the BS upper follower is **proper size** per customer order specifications.



Once you have installed the BS upper follower make sure that it is seated firmly onto the top brass follower. At this point you have finished installing all internal components of the 3K BS-PCDP stuffing box.



Finally, add the 3K steel top cap to the BS-PCDP. DO NOT over tighten top cap. Once the cap touches the top follower do not tighten anymore. Tightening anymore will start to compress packing prematurely. You have completed the assembly.

You may wish to recheck all bolts for tightness as well as inspect ram screws and port screws prior to shipping.

