



TECHNICAL SERVICE BULLETIN

Bulletin Number: DC- 2256

Date: 7/7/2009

**Affected Model(s): 3" and 4.25"-PMV Fluid/Oil Pumps
Bare Pumps-V305000000/5:1 Ratio
V406000000/6:1 Ratio
V410000000/10:1 Ratio
(See **Attachment 1** for Listing of Affected Models)**

Subject: Pump Tube Loosening from Outlet Body

A few reports have been received regarding Lincoln's PMV fluid/oil pump outlet bodies and tubes "loosening", or "separating". A thorough investigation revealed variations in the torque where the two parts thread together. All Lincoln's inventory has been pulled and tightened to the correct torque specification. Two to three drops of Loctite 242 Blue was added to the threads to secure the torque setting. Remember to reinforce the fact that there have been hundreds of PMV fluid pumps in service with no problems. The first ones are now starting their third year on the job. This issue has been limited to a manufacturing run where equipment malfunctions lead to false torque settings. A procedure was added to validate the settings with a mechanical torque meter to prevent this from happening on subsequent production runs.

The torque problem was isolated to pumps that were produced prior to December, 2008. They will be identified with our date code of **ME/XT (12/08) or earlier**. A blue stamp on the shipping carton identifies pumps from these date codes that have been checked and tightened to specification with Loctite 242. Pumps with a manufacturing date code **after ME/XT (12/08)**, or those with the blue dot stamp on the carton have the correct torque and Loctite applied. Please see **FIG. 1** for details of the "MERCHANTSX" date code system used for the PMV pumps. The date code is located on the upper flange of the outlet casting (**see Fig. 2**). Contact us if you have trouble identifying the date code on your pumps.

All inventories that you or your customers may have, as well as any installed PMV fluid/oil pumps need to be checked. Any pumps with a date code of ME/XT or earlier or those that do not have the blue dot stamp on the box should have the torque adjusted and also must have 2-3 drops of Loctite 242 Blue added at the same time. The correct tube to outlet body torques setting is 160 ft. lbs. A wide torque tolerance is designed in, but testing has shown any pump tightened to less than 80 ft. lbs. would begin to loosen

or pull apart during normal use (threads on the outlet body became distorted and by the time the issue was recognized could not be retightened to the proper torque settings).

If you find pumps that have separated and allowed to run for an extended period of time it will be necessary to replace the entire bare pump. Warranty will be paid for your efforts to review, rework, or even replace any leaking pumps in the field that include a date code identified as being prior to December, 2008 (ME/XT).

Again, due to the nature of this issue we must insist that you act on these repairs immediately. Failure to take action while the repair is this simple can affect future warranty coverage when the repair can become more complicated. Lincoln has solved this manufacturing issue and all pumps being shipped today are perfect. We are counting on you to catch and repair all pumps that fall into this date code ranges immediately so our customers can continue to be thrilled with the performance of this pump family. Please use your best judgment in determining how you handle any suspect pumps with your customer base.

As always, if you have questions or concerns, please do not hesitate to call Lincoln Technical Services at 314/679-4200, Ext. 4782 or fax us at 314/679-HELP (4357).

Regards,

Barry Frankum

MERCHANTSX Date Code System

Alpha	M	E	R	C	H	A	N	T	S	X
Numeric	1	2	3	4	5	6	7	8	9	0

Example: MM/XN =November, 2007 or 11/07

1=M 1=M / 0=X 7=N

Fig. 1

Instructions for checking torque and adding Loctite 242-

--Check date code

- a. On cartons for stock pumps-

b. On pump for installed units- Check for leakage or seepage between outlet casting and pump tube (see Fig.2)

--a. On stock pumps place in vise and loosen the pump tube 5 or 6 turns. Clean the threads with Loctite Prep or another cleaning solution. Dry the threads off. Add 2 to 3 drops of Loctite 242 Blue. Let it cure a couple minutes and re-tighten to 160 ft. lbs.

--b. On installed pumps, if they are leaking or seeping oil or not: take pressure off of pump, loosen the tube 4 or 5 turns. Clean off the threads on the tube with Loctite thread prep or another cleaning solution. Dry threads off completely. Add 2 or 3 drops of Loctite 242 Blue. Let it cure a couple minutes and re-tighten to 160 ft. lbs.

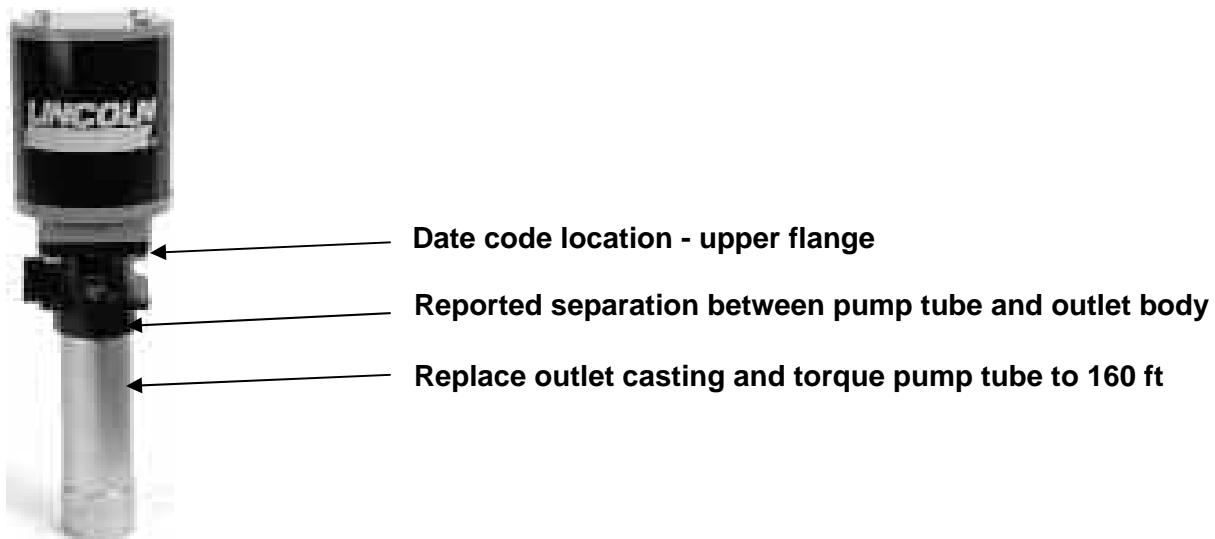


Fig. 2

Attachment 1

Affected Fluid/Oil PMV Pumps-

3 inch-5:1-

V30500000
V30500SSU
V305055BB
V305016DC
V305275BB
V30500SWM
V305055LT

4.25 inch-

V406000000
V40600SSU-6:1
V40600SWM-6:1

V410000000
V41000SSU-10:1
V410055DC-10:1
V410055BB-10:1
V41000SWM-10:1
V410055LB-10:1
V410055LT-10:1