



Gear Pump Assembly

Optimum conditions would be to pump 90° to 95° through 1-1/2" or larger pipe with few or no right angles and as short as possible. Keep proper tension on the belt at all times. Keep all connections air tight and keep the packing in the pump shaft in good condition to reduce the possibility of pulling air through a loose connection. For the easiest pumping, keep pump as low and as close to honey source as possible. This pump contains carbon bearings which do not require lubrication.

1. All pipe threads should be coated with regular joint compound to ensure they are liquid tight. Never use white lead paint on pipe threads.
2. Screw in a 1" pipe nipple into each pipe opening of the pump, making sure not to over tighten to hit the gears. Insert a 1-1/2" reducing coupling and precede in both directions with the 1-1/2" flexible hose. This will reduce the friction in the pipe and increase the capacity of the pump and make the pump run easier.
3. Install a 1/2 HP heavy duty 1725 RPM motor with overload protection on this base. Use a 1-1/2" OD V-pulley on the motor with a 1/2" x 42" V-Belt. *Note: If pumping cold honey, use a 3/4 HP motor.*
4. Install the motor pulley with the hub toward the motor, tightening the set-screw in the key-way. Install the pump pulley with the hub away from the pump. Install the set-screw on the shaft flat.
5. It is desirable to install a sump tank in front of the pump with an automatic float switch arrangement to control the operation of the motor when the tank is either full or near empty. If the honey pump is allowed to run without a full supply of honey, could cause bubbles in the honey. A water jacketed sump is preferred because warm honey is faster and easier to pump and foreign matter will rise to the top of the tank to be skimmed off. If a sump tank is not used, the risk of a piece of wood jamming the gears could result.
6. At the end of each season, or prior to long periods of non-use, drain the contents from the pipe line and pump at least 5 gallons of boiling water through the line to clean. Drain the pump and line, dry and store.
7. If the pump and line should become clogged with granulated honey, dismantle the pipe line and submerge in a drum of boiling water. It may be necessary to reverse the ends of the pipe. Also, put the pump into the boiling water to allow the honey to dissolve.

