

WAUKESHA PUMP INSPECTION CHECKLIST

Customer:	Valued Customer
Model#	18-U1
Serial#	123456789
Cust PN:	

Drive: Top: Bottom: _____

Serial Numbers Match? Yes No _____

If No, Explain: _____

Cover Nuts Tight? Yes No _____

Cover Inspection: No visible wear

Rotor Nuts Tight? Yes No _____

Backlash In Spines? Yes _____ No

Rotor Clearances

Back Face:	Top: <u>.000"</u>	Bottom: <u>.001"</u>	Spec: <u>.002"</u>
Rotor to Body	Top: <u>.003"</u>	Bottom: <u>.003"</u>	Spec: <u>.003"</u>
Front Face	Top: <u>.007"</u>	Bottom: <u>.006"</u>	Spec: <u>.005"</u>

Describe Rotor Wear: Slight smearing on rotor wings due to contact with pump body back face

Describe Body Wear: Slight due to metal contact with drive shaft rotor

Shaft Radial Movement:	Top: <u>.003"</u>	Bottom: <u>.000"</u>
Shaft Vertical Movement:	Top: <u>.003"</u>	Bottom: <u>.0015"</u>

Seals worn, Leaking? Yes No _____

Check Shafts for Grooves at Seal Points:

Top:	Yes _____	No <input checked="" type="checkbox"/>
Bottom:	Yes _____	No <input checked="" type="checkbox"/>

Date: _____

Bearings Greased or Dry?

Top: Greased: _____ Dry: x

Bottom: Greased: _____ Dry: x

Drain Oil and Describe Consistency: Cloudy

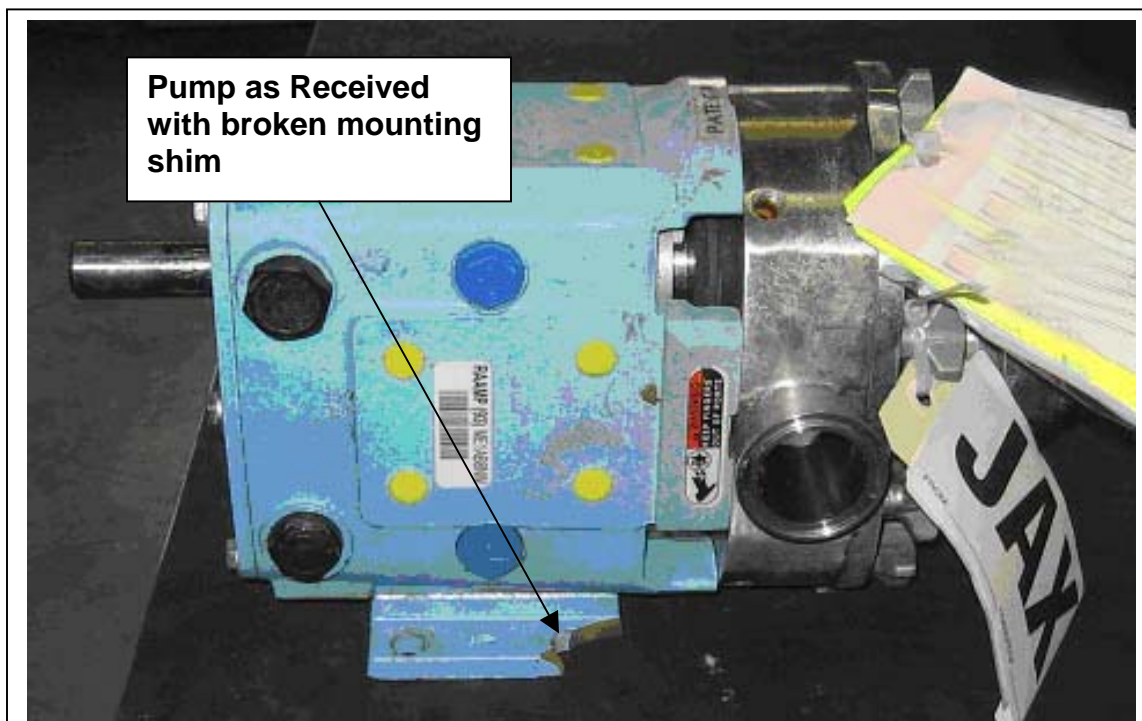
Backlash in Gears? Yes _____ No x

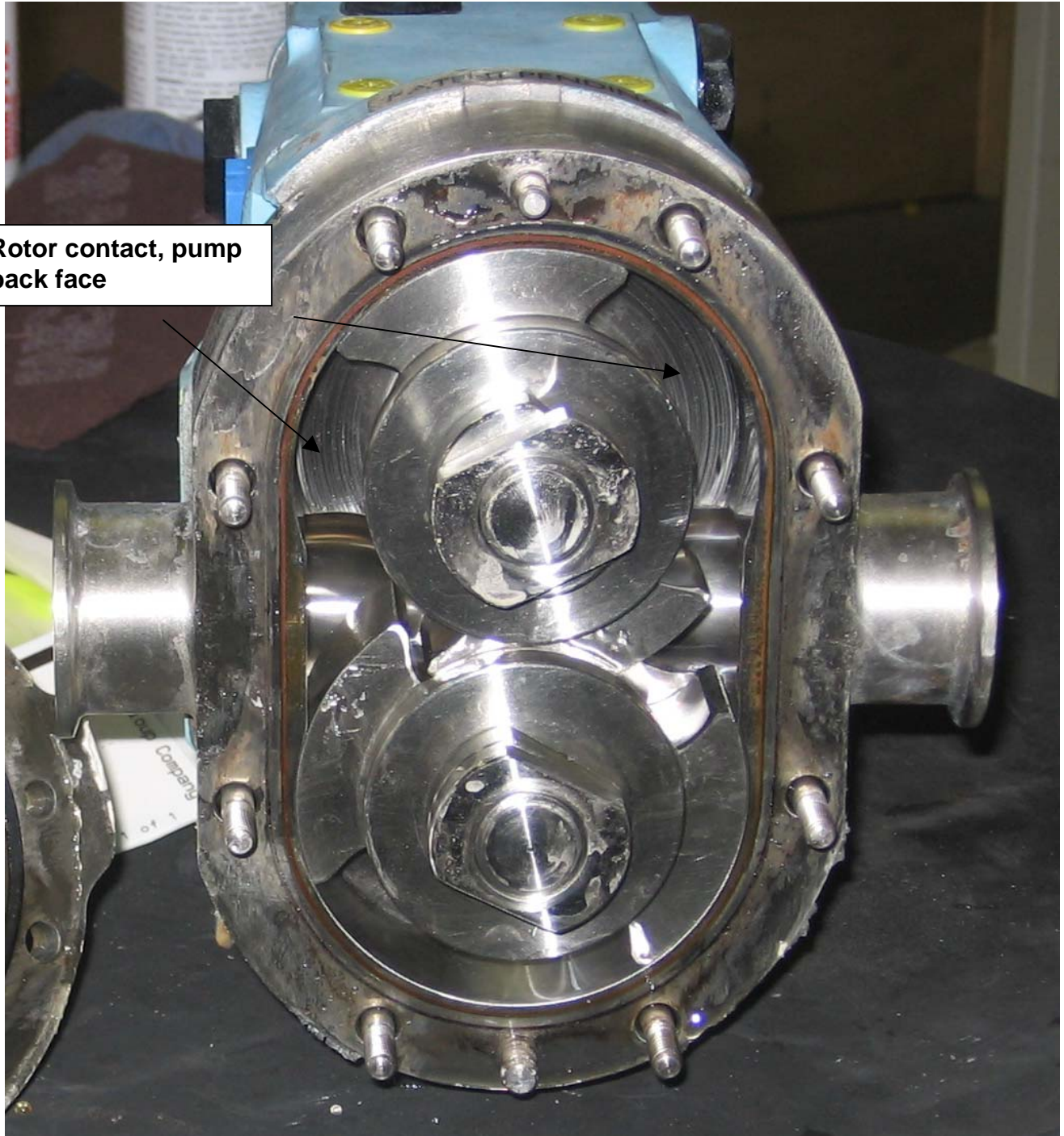
Describe Housing Cavity Contents: Little grease at rear bearing area

Overall Evaluation:

Upon receipt of this pump we observed a broken corner on the mounting shim. We also observed the pump is seized and will not operate. No cover wear visible on the inside cover. A check of tolerances showed the drive shaft (upper shaft) to be out of spec on both the front face and back face clearances. Removal of the rotors showed metal contact on the back face of the upper pump rotor area and on the rotor wings. Both contact areas are slight and can be cleaned up. A check of shaft deflection showed the bearing on the drive shaft was worn and was the cause of the metal contact.

The failure of the bearing was the lack of grease. These pumps should be greased every 250 hours of operation. This pump appears to have the original grease applied during assembly. Had the pump been greased as recommended there would be grease in the center gear case, and there is none.





Rotor contact, pump back face



Lack of fresh grease

Evaluated By:	Certified Technician
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