

**OPERATING INSTRUCTIONS**

**AND**

**MAINTENANCE MANUAL**

**FOR THE**

 **MODEL SPI-1\***

(\*Pump model varies)

**SINGLE POINT INJECTOR**

**Manufactured by**

**HAMMONDS TECHNICAL SERVICES, INC.**

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**Houston TX 77040**

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**August 2017**

# Hammonds Model SPI-1 Manual

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## SPECIAL NOTICE TO USERS

PLEASE READ CAREFULLY BEFORE  
OPERATING EQUIPMENT

Note: the photos in this manual show a vertical flow unit. Your system may be arranged differently. The concepts are the same.

This additive injector system is designed to give consistent dependable performance when operated and maintained according to manufacturer's recommendations. However, being a mechanical device, it is subject to failure from improper installation, wear, human error and operating environments beyond the control of the system. Because of this fact, it is the responsibility of the operator to make certain that:

- A. The system is installed properly.
- B. The system is being operated properly.
- C. The system is actually running during product transfer.
- D. The system is checked after the transfer operation to make certain the proper amount of additive was injected during the operation.

The performing of these checks by the operator eliminates the possibility of product not having the proper additive ratio as required. Therefore, since the manufacturer cannot be present during each transfer operation, the responsibility for checking the performance of the system is that of the operator. Should there be any questions whatsoever, the operator should consult the distributor from whom the unit was purchased.

**Do Not Take Chances.....Do Not Guess.....Be Absolutely Certain That the System Is Installed And Working As It Should.**

**The user/operator carries the final responsibility to make certain the system is operating properly.**



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## INSTALLATION AND PREPARATION FOR STARTUP

The Hammonds Model SPI fluid powered Single Point injector is shipped complete and ready to operate. The system should include appropriate fittings to suit your specific application.



1. Unpack only what is needed. The SPI injector, the "5SF" 5-gallon siphon tube adapter, the stainless braided suction hose,

priming bulb and desiccant dryer cartridge from the case.

2. The SPI injector comes equipped with an integral single point nozzle. When installing the unit, users must ensure that both nozzles (upstream and downstream of the unit) are positively locked to their SPR



connectors. **CAUTION; DO NOT LIFT BY THE INJECTION PUMP! USE THE NOZZLE HANDLES.** With the SPI nozzle crank handle in the closed position, check the strainer coupling quick disconnect device for positive locking. Be sure the nozzle is securely locked to the aircraft by attempting to remove the nozzle with the nozzle crank handle in the open



position. **Any nozzle that can be disconnected from the SPR with the nozzle crank handle in the open position is defective and must be removed from service immediately.**

LIFT BY  
HANDLES  
ONLY!



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- Using a fresh 5-gallon pail of additive, remove the cap from the pail and knock out the center plastic plug. Thread the 5SF into the cap and then re-install this assembly onto the pail as shown in the following photo.



- Remove the yellow rubber caps from the desiccant dryer cartridge and install it onto the rubber tube on the 5SF.
- Remove the dust cap from the outlet end of the 5SF assembly. Remove the dust plug from one end of the suction hose. Couple the suction hose to the 5SF. Be certain that the coupling is fully connected.



- Remove the dust cap from the other end of the suction hose. Remove the dust plug from the injector pump additive inlet on the SPI and fully connect the coupling.
- The suction hose is 10 ft. long so; the pail of additive should be positioned below and as near to the SPI injector as possible.



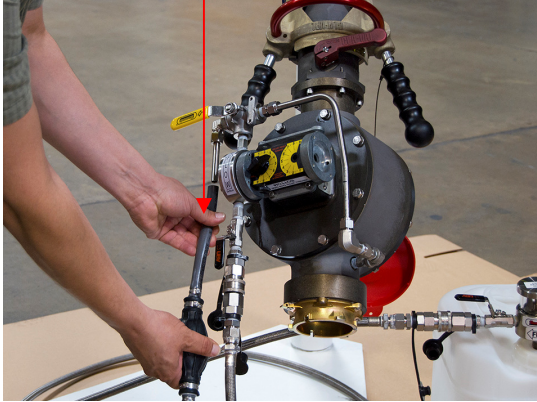
CAUTION; Do not bend the supply hose as it may kink, starving the pump of fluid and causing erratic injection performance. The injector will pull a minimal suction lift.

- Connect the SPR hose nozzle into the inlet end of the SPI. With the SPR nozzle crank handle in the closed position, check the strainer coupling quick disconnect device for positive locking. Prior to pressurizing the hose, be sure the nozzle is securely locked to the SPI by attempting to remove the nozzle with the nozzle crank handle in the open position. Now fueling can begin.

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## START UP

1. If you are attempting start up for the first time, the pump is "dry". Connect the short end of the priming bulb to the bleed port on the pump.



2. Have the open end of the priming bulb hose in a container to catch the fluid.

With the hoses connected properly as described above, simply squeeze the priming bulb a few of times until fluid is drawn through the pump and out the bleed hose.



NOTE:  
Flow  
Arrow

As the system starts, after a brief period of running, you will notice pulses of additive in the sight glass on the 5SF. The injector is now primed and will continue to inject additive as fueling continues and an adequate supply of additive is present.

3. The additive injection process may be monitored by observing this sight glass. After viewing the action of the additive in the sight glass, you will notice changes in volume of injection as the fuel flow rate changes.

## FLOW CONSIDERATIONS

The Hammonds Model SPI requires a minimum of 50 and up to 250 GPM to deliver consistent ratios. This does not mean that the system cannot be used in cases where startup and shutdown fall under the 50 GPM minimum. Check with the factory if you have any questions in the area of performance.



**CAUTION; Do not attempt to use this device without understanding and following proper safety precautions regarding system grounding, fire safety, and special handling for potentially dangerous additives.**

Consult your Engineering Department for their specific instructions. Make certain all personnel involved with this system are thoroughly familiar with safe operating practices.

If no factory-authorized distributor is available, consult the factory directly for assistance.

**HAMMONDS TECHNICAL SERVICES, INC.**  
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## POINT OF INJECTION OF ADDITIVE

Some additives may adversely affect other components in the product handling systems, for example seals in meters, valve seals, aluminum and filter elements to name a few. The Hammonds SPI injector system utilizes a precision rotary vane pump, which does an excellent job of mixing the additive in the product, and does not inject in large slugs. Because of this superior mixing and very small concentration of additive in any one point, many customers feel that this is not a problem. **SOME DO**, and therefore, should use their own judgment as to the effect of these additives. **Hammonds Technical Services, Inc. can only advise you of the possible hazards.** The SPI comes with the injection point directly ahead of the fluid motor for good blending.

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## NORMAL OPERATION

Following initial start up, the system requires very little attention other than making certain that additive levels are maintained. Operators will quickly become accustomed to the performance of the system by observing the 5SF Sight Flow Indicator. On-spec injection will cause a certain response in the Sight Flow Indicator, and with some practice, operators will be able to observe the system at a glance. However, during a busy workload, these visual checks will provide assurance to the operator that the system is functioning.

Good record keeping of additive inventory and use levels compared to fuel handled can give a good indication that additive is on specification. Test such as the refractometer for FSII content should be the final test to verify additive injection ratios.

## PROPER ADDITIVE INJECTION RATIOS

The only true evaluation for proper ratio is the **ASTM D-5006** evaluation for fuel system ice inhibitor (FSII). Contact Hammonds Fuel Additives, Inc. for supply of quality fuel system ice inhibitor and fuel testing procedures.

## DRAINING AND STORAGE OF SPI

After fueling is completed follow these steps in their proper order to drain fuel and additive from the SPI.

1. Disconnect the fuel hose single point nozzle from the SPI inlet.
2. Disconnect the additive supply hose between the 5-gallon pail and the SPI injector. Reinstall the dust plug and dust cap into each end of the hose.
3. Install the dust plug into the injector pump additive inlet and install the dust cap onto the 5SF. These dust plugs and caps are important to protect the coupling ends from damage and to help keep the additive clean.
4. Disconnect the SPI from the fueling port of the aircraft. **BE CAREFUL NOT TO LIFT IT BY THE PUMP TUBING!**
5. Unscrew the 5SF from the cap of the 5-gallon additive pail. If there is enough additive left in the pail, and you need to store it, install a 3/4" NPT pipe plug into the plastic pail cap. Otherwise, dispose of the empty container properly.
6. The SPI and all components may now be returned to their place in the case.

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## **TROUBLE SHOOTING THE SYSTEM**

The following conditions are given as a means of troubleshooting the system. Each condition lists a number of possible causes. In most cases, trouble can be solved by the use of this section. Please read it carefully before attempting repairs or making changes in the system.

### **FLUID MOTOR IS NOT TURNING**

A. Insufficient flow to turn the motor. A minimum flow of about 50 GPM is needed to start the system.

B. A diverter valve is blocked downstream of the system, blocking the fuel flow through the system.

C. A valve is closed upstream of the fluid motor starving the product flow.

D. If the unit has been recently serviced internally, the rotor might be installed backwards. Consult the factory before disassembly.

### **FLUID MOTOR IS TURNING AND PUMP IS RUNNING, BUT WITH NO OUTPUT**

A. The pump is not getting additive. Check all connections in the line between the pump and the pail. Make certain that the quick disconnect couplings are fully coupled.

B. The vent on the pail is not open causing the pump to pull a vacuum. Check to see if the rubber cap has been removed from the dryer cartridge, if so equipped.

C. The injector pump is not priming itself at initial start up. Although the system will operate at 50 GPM, the fueling rate needs to be at least 150 GPM at first to prime the rotary vane pump. This will give the pump the speed it needs to prime itself. After it is primed it will continue to pump.

D. The pump may need to be manually primed. Install the priming bulb as described in the Start Up section. Give the priming bulb a few squeezes until additive flows from the bleed hose. Once a clear, bubble-free, stream of additive is observed, disconnect the priming hose. The pump should continue to inject.

E. The additive pail is empty...don't laugh, it happens.

### **THE INJECTOR IS OPERATING BUT WITH REDUCED OUTPUT**

A. Air leak in suction side of system.

B. Defective tubing or piping on suction side.

C. A leak in threaded connections or quick disconnects - suction side.

F. Check to see that the supply hose is not kinked or crushed, starving the pump.

D. A leak in the 5SF glass seal.

E. Fluid motor vanes are badly worn. This would only be probable after a high number of hours of operation.

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## PREVENTIVE MAINTENANCE

1. Make certain to use only clean, fresh additive that has been stored in a sealed container. Most additives are moisture sensitive. Some will form heavy crystals if allowed to accumulate moisture. These crystals will stop the pump in very short order.
2. Check the additive filter screen (5SF Sight Flow Indicator) at least once a month. More often if there is an indication of possible contamination.
3. Check the system for leaks at every use. This is an extremely important safety procedure, since some additives are flammable, caustic and corrosive.
4. Check for leaks from the seal that is located at the exit point of the injector output shaft in the side plate housing. This should be done at each operation. Leakage at this point usually indicates that the mechanical seal inside the rotor housing is leaking. A leak here will be fuel, and is not only dangerous from a fire standpoint, but will quickly ruin the bearings on the rotor shaft, since all lubricant will be washed away.
5. Check the fittings for leakage around the suction strainer or sight flow indicator, if one is used on the pump. Check this fitting each time the filter is changed or cleaned. Make certain there are no leaks in the suction line. A very small leak will either change the operation of the pump or prevent it from operating all together.
6. Visually check around the pump housing and make certain there is no leaking of additive around the pump fluid end. If there is, check the tightness of the head screws. (40 inch pounds each)
7. Check the grease around the eccentric drive bearing in the pump every 12 months. Use a good quality waterproof grease.
8. It is recommended that the injector diaphragm be changed at least every 12 months. Every 6 months under extreme operating conditions. Doing so will prevent unexpected failures and unscheduled downtime.

Hammonds injectors are very dependable. If installed properly and sized appropriately to the application, they require very little maintenance. Remember; keep the additive clean, and the suction strainer clean. If you have problems with the pump working, it is usually in the suction side of the system (between the injection pump and the additive pail). Suction lines and fittings are notorious for leaking just enough to prevent the system from working. Always check to ensure optimum suction conditions should problems occur.

Remember that a leak in the suction allows air from the outside to be introduced into the system. It does not always mean a visible leak of additive. If the pump loses its prime or output is erratic, chances are good that there are problems in the suction side. Otherwise, if it is working...leave it alone.

## PREVENTATIVE MAINTENANCE SCHEDULE

**NOTE:** It is important to read the section on preventative maintenance. These intervals are general, and may vary according to individual applications and severity of service.

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SERVICE FUNCTION	0-1 HOUR DAILY	1-2 HOUR DAILY
Check additive filter screen	Monthly	Monthly
Check system for additive/fuel leaks	Daily	Daily
Inspect diaphragm or plunger seals	12 Months	6 Months
Replace diaphragm or plunger seals	12 Months	As needed
Check eccentric bearing grease	6 Months	3 Months
Check stroke adjustment parts for looseness	Monthly	Monthly
Replace stroke adjustment parts	24 Months	As needed
Disassemble and inspect fluid motor housing and internal parts	12 Months	8 Months
Check nozzle screen, if equipped	Monthly	Bi-weekly

## DESICCANT DRYER

Your Hammonds additive system may include either a custom additive pail or one of several Sight Flow Indicators. Both custom pails and the 5-SF and 55-SF Sight Flow Indicator come equipped with a desiccant dryer cartridge. These units come in several different sizes.

Most systems come equipped with the standard 3/4" cartridge. This unit is attached to the pail or Sight Flow Indicator via a short length of black rubber hose. The cartridge has a housing constructed of a clear poly material and is filled with a blue colored desiccant crystal. All these units are shipped from the factory with small yellow caps on the ends of the cartridge.

The purpose of all desiccant dryers is simply to remove moisture from the air as the system breathes. All pails or portable sources of additive supply must be vented to atmosphere in order for the injector to operate. If moisture in this venting air is not removed, some additives are either ruined or seriously damaged. Fuel system icing inhibitor (FSII) FIZZY®, for example, is designed to seek out water in a fluid. So, when enough moisture is absorbed into the container, the FIZZY® (FSII) is diluted and at some point will be ruined. Biobor® JF, an anti-fungal material, will form crystals in the presence of moisture and not only perform unsatisfactorily as an additive, but will stop up pumps and lines as well.

The following instructions apply to all desiccant cartridges:

A. Remove the yellow caps when the system is placed into service.

B. Observe the color of the desiccant. The original color is blue. As moisture is absorbed, the color will change to pink. When the cartridge is completely pink, it should either have its contents removed, dried and replaced, or the entire unit replaced.

**C. NOTE:** The contents can be removed from plastic cartridge, placed on a pan and baked at 400°F in a conventional oven until the moisture has been removed. When the color blue returns, the cooled material may be reinstalled into the cartridge and is again ready for service.

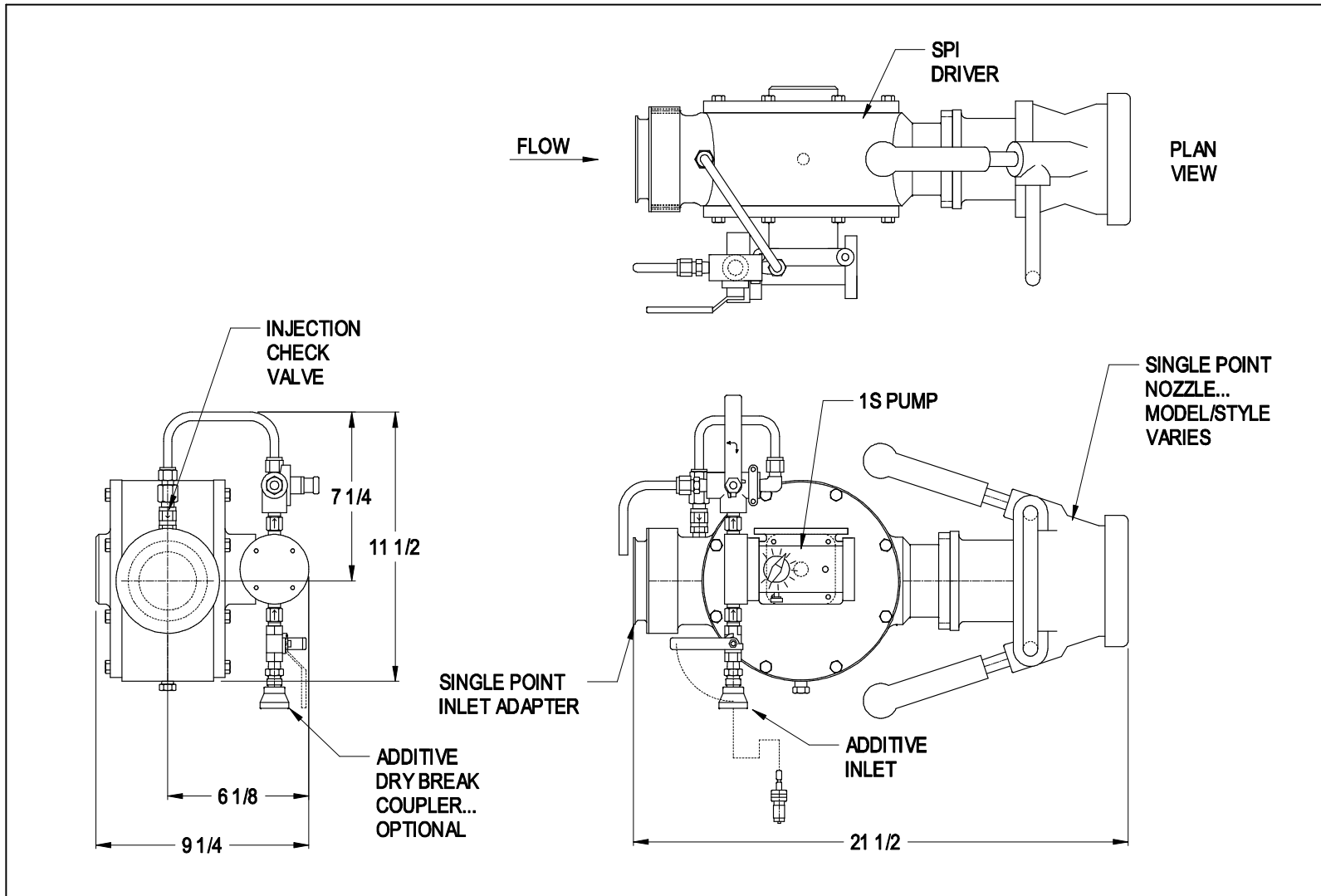
**D. COLOR** change and cartridge life is totally dependent on humidity. The more moist the air, the shorter the life. Keeping it dry is especially important if additive is not consumed rapidly. Check daily and service the dryer cartridge as needed.

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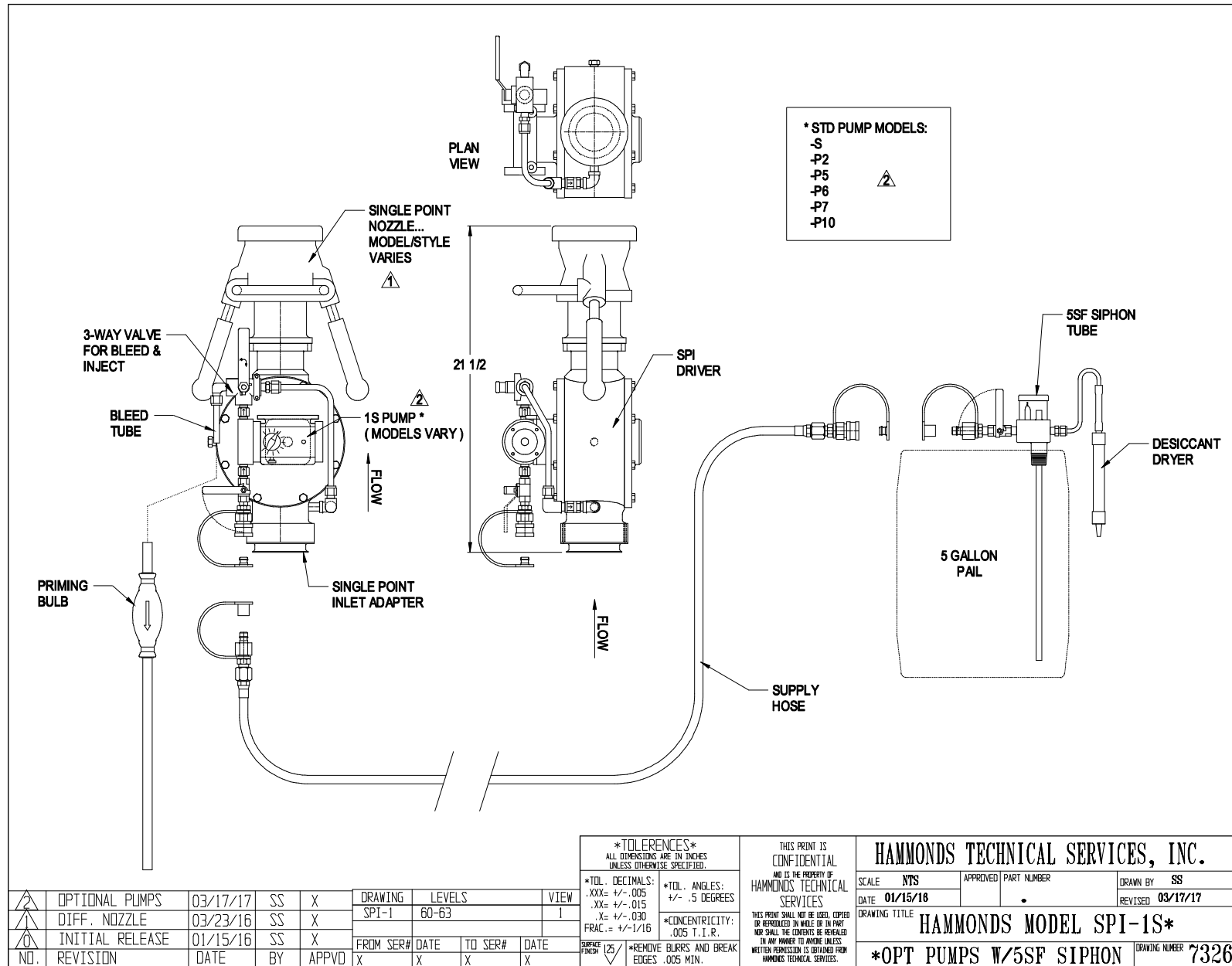
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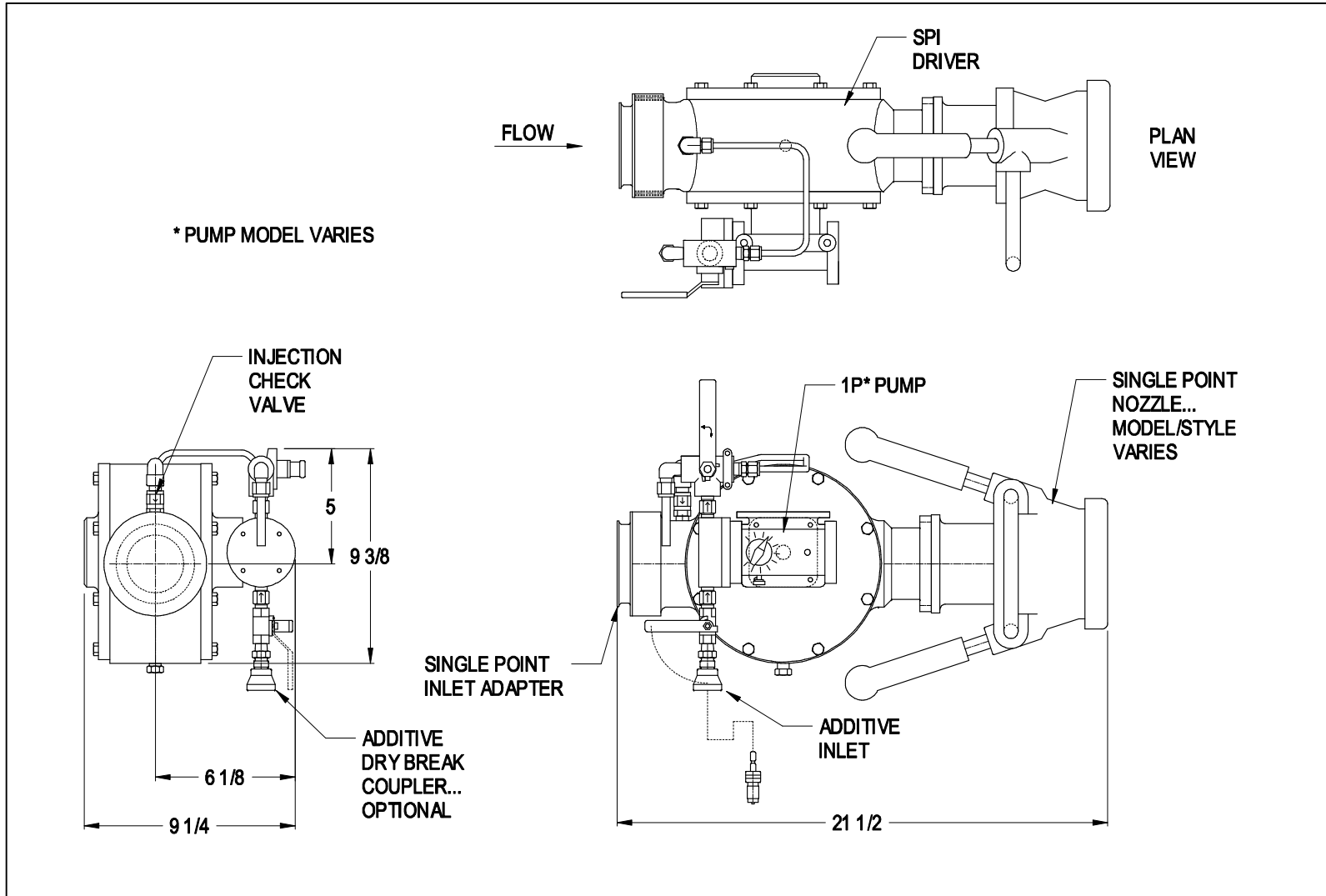


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DRAWING SPI-1		LEVELS 87-89		VIEW 1		DATE 06/07/17		SPI-1S		REVISED .	
FROM SER# DATE TO SER# DATE		X X X X		DRAWING TITLE		HAMMONDS MODEL SPI-1S		HORIZ FLOW, FSII		DRAWING NUMBER 7603	
INITIAL RELEASE 06/07/17 SS X		DATE BY APPVD		X X X X		*REMOVE BURRS AND BREAK EDGES .005 MIN.		THIS PRINT SHALL NOT BE USED, COPIED OR REPRODUCED IN WHOLE OR IN PART NOR SHALL THE CONTENTS BE REVEALED IN ANY MANNER TO ANYONE UNLESS WRITTEN PERMISSION IS OBTAINED FROM HAMMONDS TECHNICAL SERVICES.		HAMMONDS MODEL SPI-1S	

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DRAWING: SPI-1		LEVELS: 93-95		VIEW: 1		DATE: 07/19/17		REVISED: .	
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NO. 2		REVISION		DATE		BY		APPVD	
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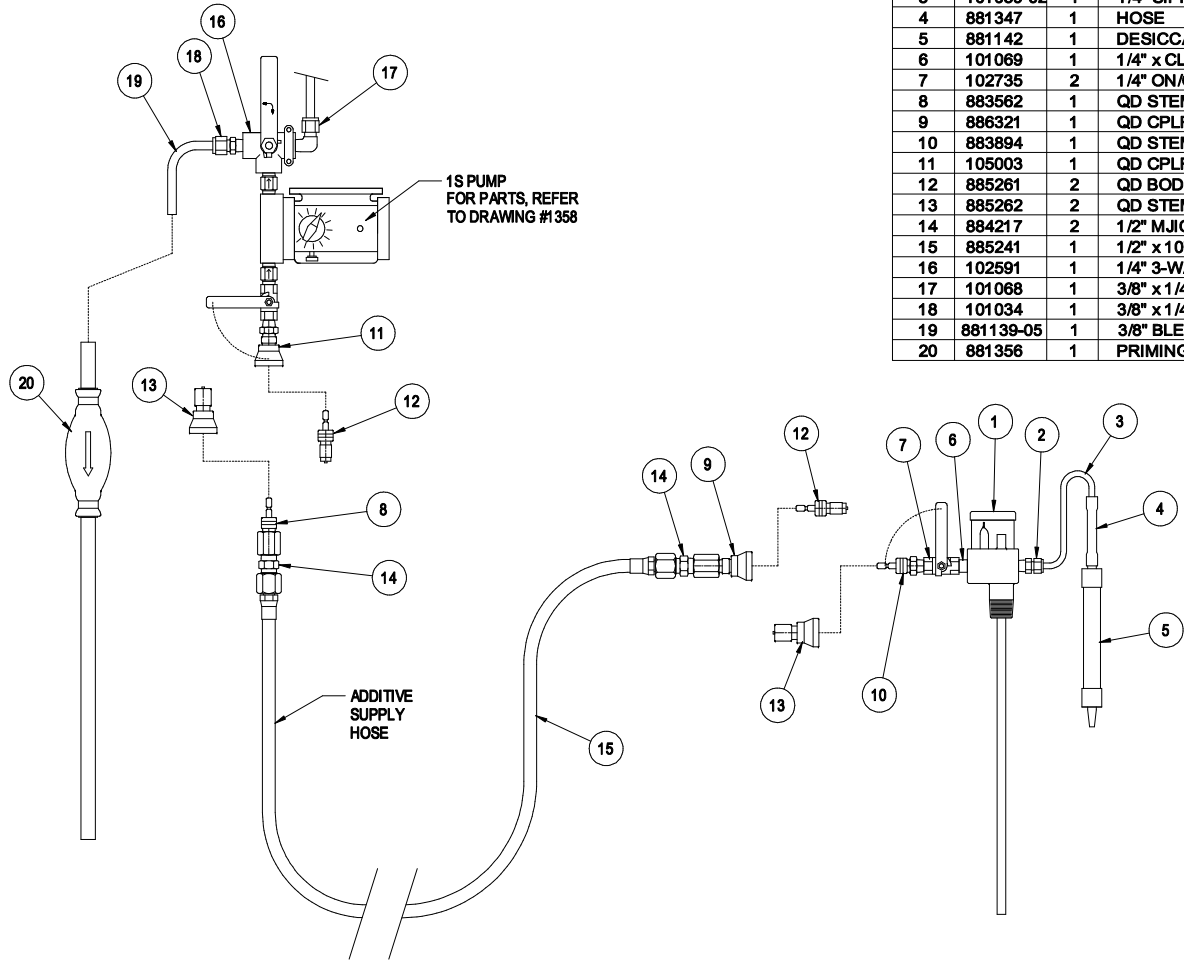
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ITEM	PART NO.	QTY.	DESCRIPTION
1	212117	1	SPI STR. HSG, CLA-VAL NOZ
2	212288	1	ROTOR
3	212304	6	VANE, TEFLON, SOLID
4	212304-1	6	VANE, TEFLON, VENTED
5	881987	1	O-RING, BUTADIENE-ACRYLONITRILE
6	885294	1	O-RING, BUNA-N
7	881975	1	SINGLE POINT RECEPTACLE
8	881980	6	10-24 x 5/8" F H SCREW
9	881291	6	SCREW, 1/4-20 x 1"
10	883529	6	LOCK WASHER, 1/4" HI-COL
11	212557	1	O-RING, VITON
12	885295	1	O-RING, BUNA-N
13	885246	1	NOZZLE SCREEN, 100 MESH
14	885247	1	RETAINING CLIP
15	882667	1	SINGLE POINT NOZZLE
16	882011	1	PUMP PLATE
17	212309	1	BACK PLATE
18	882012	2	WEAR RING
19	212549	1	SHAFT, SPI-ECC
20	212272	1	BEARING, SHIELDED
21	881121	2	INTERNAL SNAP RING
22	212002	1	KEY, 3/16" SQ x 1"
23	141006	1	MECHANICAL SEAL, VITON
24	141048	1	MECHANICAL SEAL, BUNA-N
25	881120	2	BEARING, SEALED
26	881119	3	EXTERNAL SNAP RING
27	881629	1	SPACER
28	881157	1	HD DRIVE BEARING
29	101045	1	EXTERNAL SNAP RING
30	881422	16	HEX BOLT, 5/16-18 x 1"
31	881417	16	LOCK WASHER, 5/16"
32	881910	2	O-RING, VITON
33	881154	2	O-RING, BUNA-N
34	151005	1	PIPE PLUG, 1/4"

NO.	REVISION	DATE	BY	APPVD	FROM SER#	DATE	TO SER#	DATE	VIEW
1	ADDED BUNA-N SEAL	06/07/17	SS	X					
2	ADDED VENTED VANE	06/03/16	SS	X					
3	INITIAL RELEASE	03/31/16	SS	X					
					X	X	X	X	

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DRAWING LEVELS: SPI 28, 87, 89				DRAWING TITLE: SPI DRIVER ASSEMBLY	
STRAIGHT HSG, ECC DRIVE				DRAWING NUMBER: 7359	

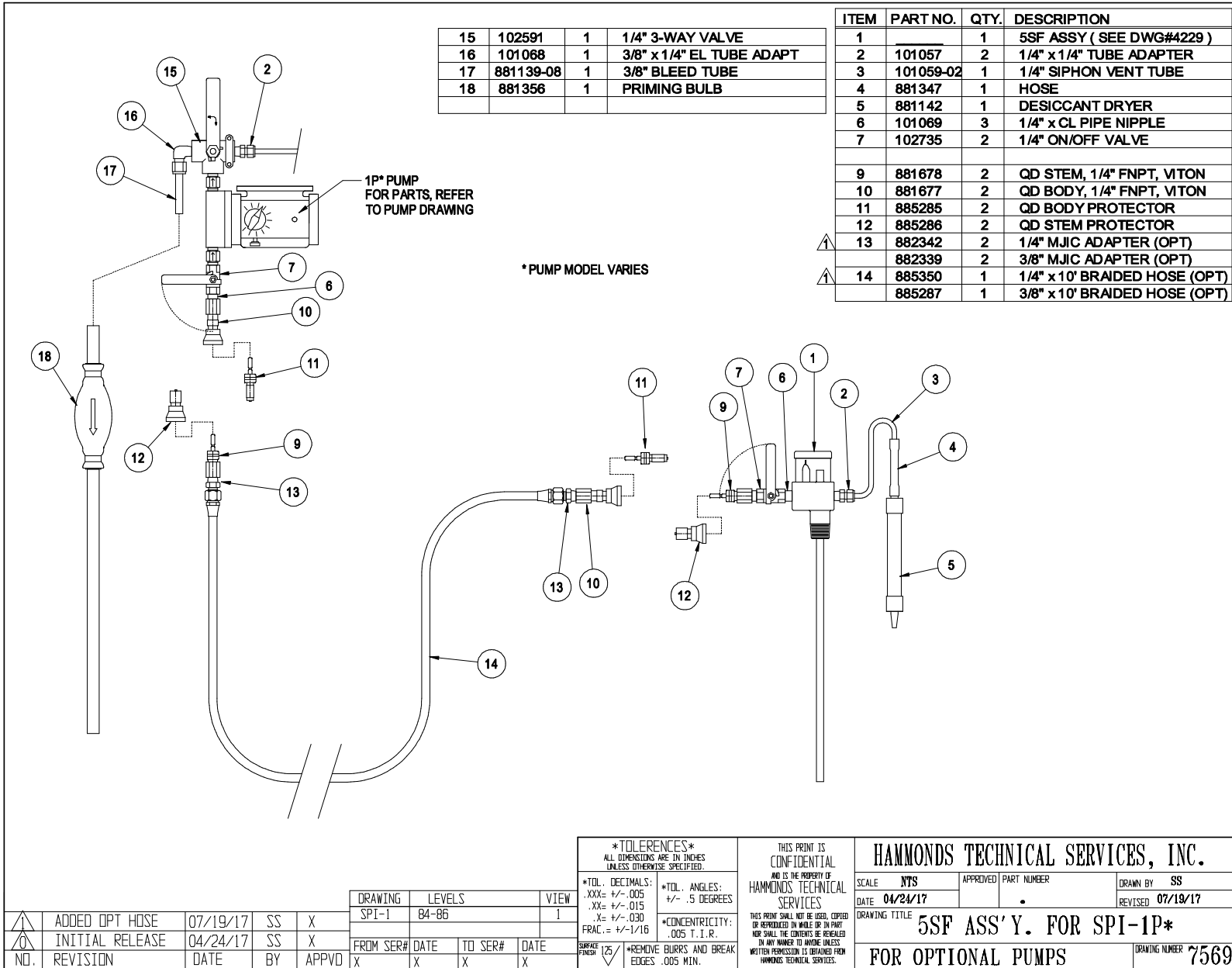
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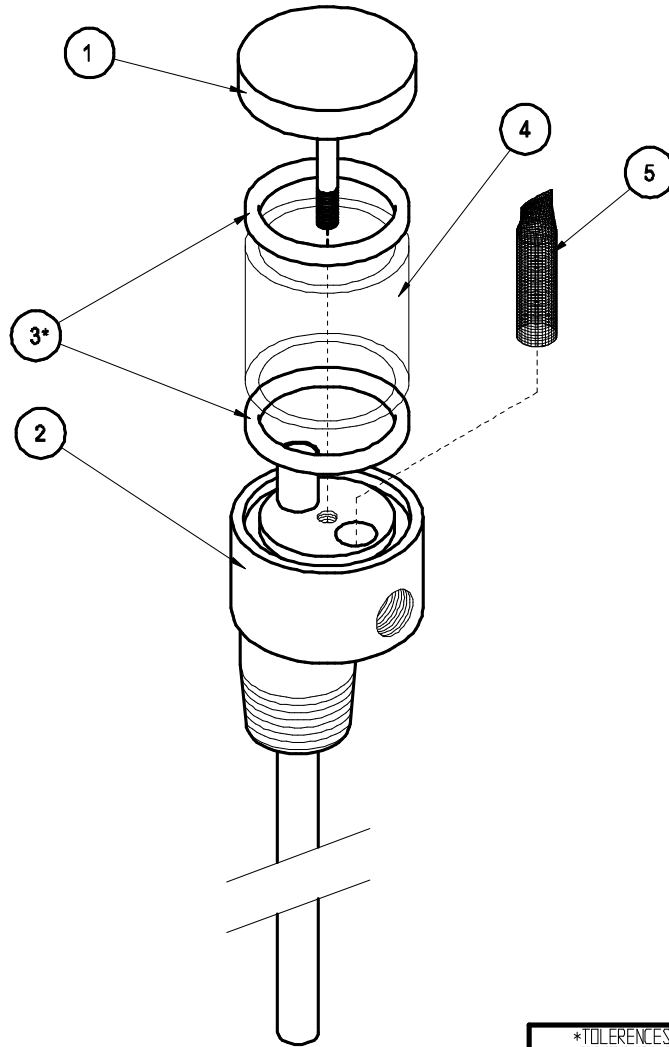
ITEM	PART NO.	QTY.	DESCRIPTION
1		1	5SF ASSY ( SEE DWG#4229 )
2	101057	1	1/4" x 1/4" TUBE ADAPTER
3	101059-02	1	1/4" SIPHON VENT TUBE
4	881347	1	HOSE
5	881142	1	DESICCANT DRYER
6	101069	1	1/4" x CL PIPE NIPPLE
7	102735	2	1/4" ON/OFF VALVE
8	883562	1	QD STEM, 3/8" FNPT, BUNA-N
9	886321	1	QD CPLR, 3/8" FNPT, BUNA-N
10	883894	1	QD STEM, 1/4" MNPT, BUNA-N
11	105003	1	QD CPLR, 1/4" MNPT, BUNA-N
12	885261	2	QD BODY PROTECTOR
13	885262	2	QD STEM PROTECTOR
14	884217	2	1/2" M.JIC X 3/8" MNPT ADAPTER
15	885241	1	1/2" x 10' BRAIDED HOSE
16	102591	1	1/4" 3-WAY VALVE
17	101068	1	3/8" x 1/4" EL TUBE ADAPT
18	101034	1	3/8" x 1/4" TUBE ADAPTER
19	881139-05	1	3/8" BLEED TUBE
20	881356	1	PRIMING BULB

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	INITIAL RELEASE	06/07/17	SS	X	

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ITEM	PART NO.	QTY.	DESCRIPTION
1	152074	1	CAP, ASS'Y.
2	152084	1	BODY, ASS'Y. 5SF
3	151002	2	O-RING, BUNA
4	151001	1	GLASS
5	152002	1	FILTER ELEMENT
* 3	151007	2	O-RING, VITON (OPT)
* 3	151027	2	O-RING, NEOPRENE (OPT)

\* NOTE: THIS COMPONENT IS PART  
OF VARIOUS ASSEMBLIES

△ INITIAL RELEASE 10/11/01 SS X NO. REVISION DATE BY APPVD		DRAWING 0159 LEVELS 7,B VIEW 1		*TOLERANCES* ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.		THIS PRINT IS CONFIDENTIAL AND IS THE PROPERTY OF HAMMONDS TECHNICAL SERVICES		HAMMONDS TECHNICAL SERVICES, INC.	
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ITEM	PART NO.	QTY.	DESCRIPTION
1	101014	1	POWER FRAME
2	101016	1	DIAPHRAGM, S
	101455	1	DIAPHRAGM, S, VITON (OPTION)
3	102001	1	FLUID END, S
4	882949	8	LOCK WASHER, #10
5	101037	4	SCREW, 10-32 x 1 1/2"
6	101842	1	CROSSHEAD GUIDE
7	101007	2	RETURN SPRING
8	101006	1	CROSSHEAD
9	101152	2	SLIDE BEARING
10	101005	1	STROKE ADJUSTMENT CAM
11	101003	1	CAM GUIDE
12	101001	1	STROKE ADJUSTMENT KNOB
13	101002	1	POWER FRAME COVER
14	101004	1	LOCK SCREW
15	101009	4	SCREW, 8-32 x 3/8"
16	881086	4	LOCKWASHER, #6
17	101010	4	SCREW, 6-32 x 3/8"
18	881089	4	SCREW, 10-32 x 3/4"
18A	881660	4	SCREW, 10-32 x 2 1/4" (OPT)
19	102463	2	CHECK VALVE, AFLAS, STD.
	102464	2	CHECK VALVE, VITON (OPT)
	102642	2	CHECK VALVE, KALREZ (OPT)
20	882911	1	CHECK VALVE, 5 PSI, AFLAS (STD.)
	101576	1	CHECK VALVE, 5 PSI, VITON (OPT.)
	102643	1	CHECK VALVE, 5 PSI, KALREZ (OPT.)
21	101088	1	3/8 x 1/4 FNPT TUBE ADAPT.

NEW CHECK VALVES	03/15/04	SS			
SOFT SEAT CHK VLV	09/03/02	SS			
WAS #101008	08/99	SS			
ADDED INJ CHK VLV	01/06/98	SS			
NO. REVISION	DATE	BY			

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*TOL. DECIMALS:	.XXX= +/- .005	*TOL. ANGLES:	+/- .5 DEGREES
	.XX= +/- .015		*CONCENTRICITY:
	.X= +/- .030		.005 T.I.R.
*REMOVE BURRS AND BREAK EDGES .005 MIN.		DATE: 10/15/91	

HAMMONDS TECHNICAL SERVICES, INC.			
SCALE: NTS	APPROVED BY:	DRAWN BY: SS	REVISED: 03/15/04
DATE: 10/15/91		DRAWING TITLE: HAMMONDS 1S PUMP ASSEMBLY	
			DRAWING NUMBER: 1358

# Hammonds Model SPI-1 Manual

**1**

**2**

**3**

**\* WARNING... FAILURE TO TORQUE SCREWS PROPERLY TO 40 IN. LBS. WILL REDUCE PUMP HEAD PERFORMANCE, RESULTING IN INSUFFICIENT INJECTION RATIO.**

**11 REINSTALL SCREWS, TAKING EACH ONE DOWN BY HAND UNTIL IT STOPS. TIGHTEN SCREWS TO 40 IN. LBS. \* IN THE ORDER SHOWN BELOW. TORQUE EACH SCREW IN THE PATTERN, THEN REPEAT THE TORQUE SEQUENCE ONLY ONCE!**

**12 ROTATE DIAL COUNTER CLOCKWISE ENOUGH TO INSTALL DRIVE BEARING. INSTALL SNAP RING.**

**13 REMOVE DIAL KNOB. REINSTALL PLASTIC COVER. REINSTALL DIAL KNOB AND POSITION IT ON ORIGINAL % SETTING. INSTALL LOCK SCREW, LOCK DIAL IN PLACE.**

**NOTE: AFTER THIS PROCEDURE IS COMPLETE, YOU MUST RECALIBRATE THE INJECTOR TO YOUR SPECIFICATIONS.**

**WARNING! FAILURE TO FOLLOW THIS PROCEDURE WILL RESULT IN DIAPHRAGM DEFORMATION AND PREMATURE FAILURE.**

**HAMMONDS TECHNICAL SERVICES, INC.**

SCALE	NTS	APPROVED BY:	DRAWN BY
DATE	2/11/92		REVISED 4/10/92
DRAWING TITLE		<b>"S" DIAPHRAGM REPLACEMENT</b>	
			DRAWING NUMBER <b>1459</b>

FOR TECHNICAL ASSISTANCE CALL  
HAMMONDS TECHNICAL SERVICES  
(281) 999-2900

# Hammonds Model SPI-1 Manual

ITEM	PART NO.	QTY.	DESCRIPTION
1	101014	1	POWER FRAME
2	102266	1	PLUNGER, P2
3	102267	1	FLUID END, P2
4	882949	8	LOCK WASHER, #10 INT. TOOTH
5	881780	4	SCREW, 10-32 x 2 3/4"
6	101842	1	CROSSHEAD GUIDE
7	101007	2	RETURN SPRING
8	101006	1	CROSSHEAD
9	101152	2	SLIDE BEARING
10	101005	1	STROKE ADJUSTMENT CAM
11	101003	1	CAM GUIDE
12	101001	1	STROKE ADJUSTMENT KNOB
13	101002	1	POWER FRAME COVER
14	101004	1	LOCK SCREW
15	101009	4	SCREW, 8-32 x 3/8"
16	881086	4	LOCKWASHER, #6
17	101010	4	SCREW, 6-32 x 3/8"
18	881089	4	SCREW, 10-32 x 3/4"
* 18A	881660	4	SCREW, 10-32 x 2 1/4" (OPTION)
19	102783	2	CHECK VALVE, 1/8", VITON
20	102269	1	O-RING, AFLAS
* 20A	102270	1	O-RING, VITON (OPTION)
21	102268	1	SEAL HOUSING, P2
22	881024	1	SEAL, LIP
23	881045	1	SETSCREW, 1/4-20 x 1"
24	882911	1	CHECK VALVE, 5 PSI, AFLAS
	101576	1	CHECK VALVE, 5 PSI, VITON (OPTION)
25	101058	1	1/4 x 1/4 FNPT TUBE ADAPT.

NO.	REVISION	DATE	BY	APPVD	FROM SER#	DATE	TO SER#	DATE
△	WAS #102463	02/20/08	SS	X				
▲	WAS #101933	03/15/04	SS	X				

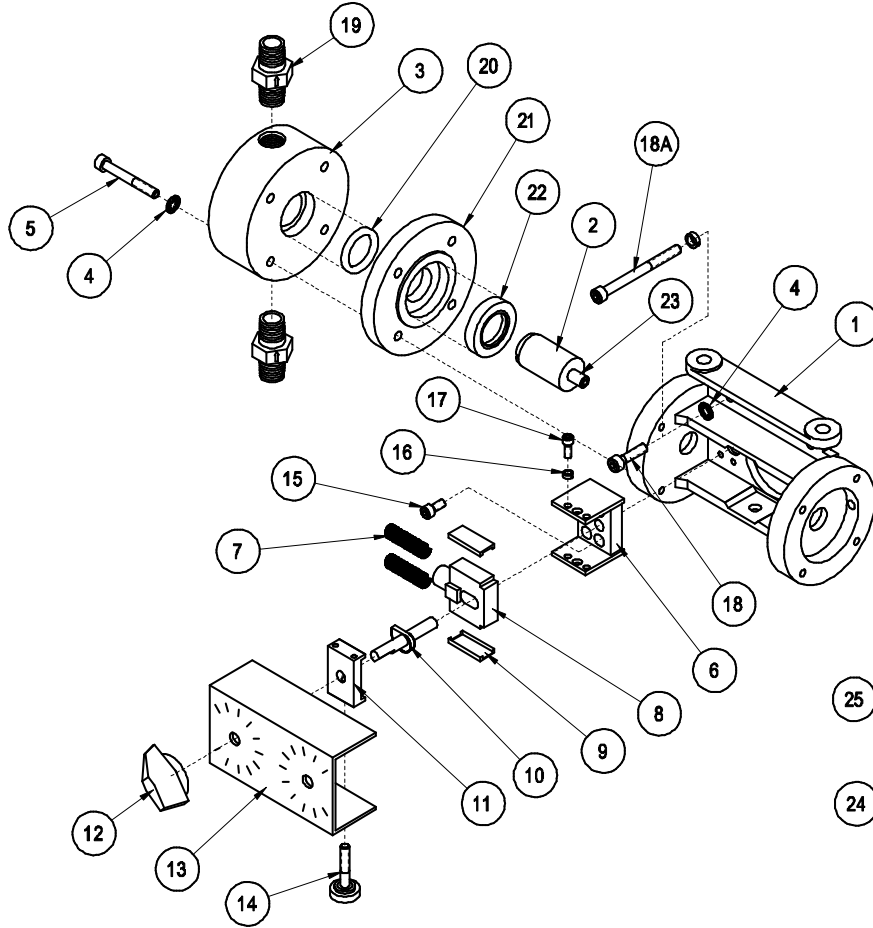
  

DRAWING		LEVELS	
INJECTOR	10, 12, 14, 16, 18, 20, 24, 28,		
	30, 39-41, 89, 90, 202-205		
FROM SER#	DATE	TO SER#	DATE
X	X	X	X

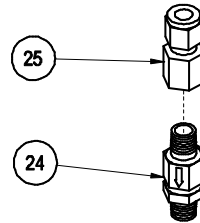
  

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SURFACE FINISH 125 ✓ REMOVE BURRS AND BREAK EDGES .005 MIN.		APPROVED		PART NUMBER	DRAWN BY SS
		DATE 06/20/95		REVISED	02/20/08
		DRAWING TITLE		HAMMONDS 1P2 PUMP	
				DRAWING NUMBER 4567	

# Hammonds Model SPI-1 Manual



ITEM	PART NO.	QTY.	DESCRIPTION
1	101014	1	POWER FRAME
2	102339	1	PLUNGER, P5
3	102340	1	FLUID END, P5
4	882949	8	LOCK WASHER, #10 INT. TOOTH
5	881317	4	SCREW, 10-32 x 2"
6	101842	1	CROSSHEAD GUIDE
7	101007	2	RETURN SPRING
8	101006	1	CROSSHEAD
9	101152	2	SLIDE BEARING
10	101005	1	STROKE ADJUSTMENT CAM
11	101003	1	CAM GUIDE
12	101001	1	STROKE ADJUSTMENT KNOB
13	101002	1	POWER FRAME COVER
14	101004	1	LOCK SCREW
15	101009	4	SCREW, 8-32 x 3/8"
16	881086	4	LOCKWASHER, #6
17	101010	4	SCREW, 6-32 x 3/8"
18	881089	4	SCREW, 10-32 x 3/4"
18A	881660	4	SCREW, 10-32 x 2 1/4" (OPTION)
▲1	19	102463	2 CHECK VALVE, AFLAS, STD.
		102464	2 CHECK VALVE, VITON (OPTION)
▲3		102642	2 CHECK VALVE, KALREZ (OPTION)
	20	101856	1 O-RING, AFLAS
		101857	1 O-RING, VITON (OPTION)
▲3		103514	1 O-RING, KALREZ (OPTION)
	21	102341	1 SEAL HOUSING, P5
	22	881079	1 SEAL LIP
▲2	23	881045	1 SETSCREW, 1/4-20 x 1" (PART OF #2)
	24	882911	1 CHECK VALVE, 5 PSI, AFLAS
▲3		101576	1 CHECK VALVE, 5 PSI, VITON (OPT)
		102643	1 CHECK VALVE, 5 PSI, KALREZ (OPT)
25	101088	1	3/8 x 1/4 FNPT TUBE ADAPT.



▲3	ADDED KALREZ OPT	06/25/09	SS		
▲2	WAS #101671	03/15/04	SS		
▲1	WAS #101933	03/15/04	SS		
NO.	REVISION	DATE	BY	APVD	

DRAWING	LEVELS				
INJECTOR	10, 12, 14, 16, 18, 20, 24, 28, 30				
FROM SER#	39-41, 89-93, 95-97, 99, 118, 119				
DATE		TO SER#		DATE	
X		X		X	

**\*TOLERANCES\***  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.

\*TOL. DECIMALS:  
.XXX= +/- .005  
.XX= +/- .015  
.X= +/- .030  
FRAC. = 1/-1/16

\*TOL. ANGLES:  
+/- .5 DEGREES

\*CONCENTRICITY:  
.005 T.I.R.

SURFACE FINISH: 125/32  
\*REMOVE BURRS AND BREAK EDGES .005 MIN.

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<b>HAMMONDS TECHNICAL SERVICES, INC.</b>			
SCALE	NPS	APPROVED PART NUMBER	DRAWN BY SS
DATE	10/07/99		REVISED 06/25/09
DRAWING TITLE			DRAWING NUMBER
HAMMONDS 1P5 PUMP			3836

# Hammonds Model SPI-1 Manual

ITEM	PART NO.	QTY.	DESCRIPTION
1	101014	1	POWER FRAME
2	102137	1	PLUNGER, P6
3	102138	1	FLUID END, P6
4	882949	8	LOCK WASHER, #10 INT. TOOTH
5	881317	4	SCREW, 10-32 x 2"
6	101842	1	CROSSHEAD GUIDE
7	101007	2	RETURN SPRING
8	101006	1	CROSSHEAD
9	101152	2	SLIDE BEARING
10	101005	1	STROKE ADJUSTMENT CAM
11	101003	1	CAM GUIDE
12	101001	1	STROKE ADJUSTMENT KNOB
13	101002	1	POWER FRAME COVER
14	101004	1	LOCK SCREW
15	101009	4	SCREW, 8-32 x 3/8"
16	881086	4	LOCKWASHER, #6
17	101010	4	SCREW, 6-32 x 3/8"
18	881089	4	SCREW, 10-32 x 3/4"
* 18A	881660	4	SCREW, 10-32 x 2 1/4" (OPTION)
* 19	102463	2	CHECK VALVE, AFLAS, STD.
* 19	102464	2	CHECK VALVE, VITON (OPT)
20	101491	1	O-RING, AFLAS
* 20	101417	1	O-RING, VITON (OPTION)
21	102139	1	SEAL HOUSING
22	881024	1	SEAL, LIP
23	881045	1	SETScrew, 1/4-20 x 1"
24	882911	1	CHECK VALVE, 5 PSI, AFLAS, STD.
24	101576	1	CHECK VALVE, 5 PSI, VITON, (OPT)
25	101088	1	3/8 x 1/4 FNPT TUBE ADAPT.

NEW CHECK VALVES	03/15/04	SS
WAS #102263	09/03/02	SS
NO. REVISION	DATE	BY

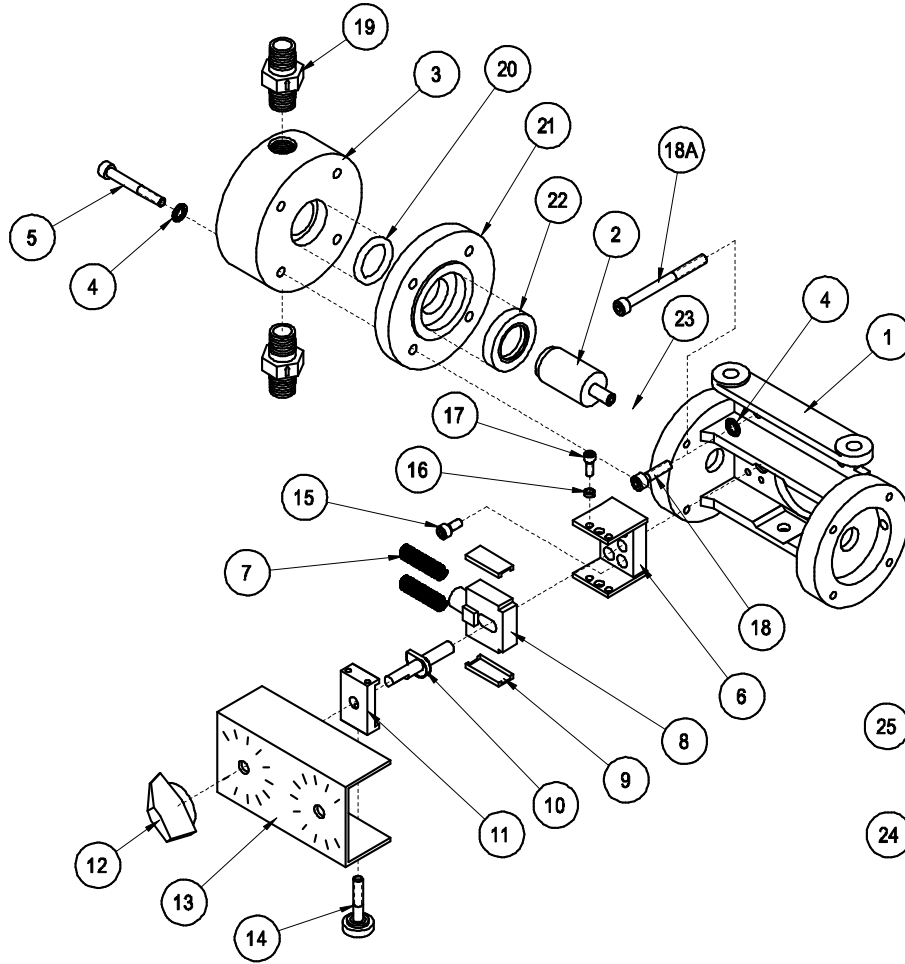
DRAWING		LEVELS		VIEW
INJECTOR	10, 12, 14, 16, 18, 20, 24, 28, 30	39-41, 89-93, 95-97, 99, 113, 114	7	
FROM SER#	DATE	TO SER#	DATE	
X	X	X	X	

*TOLERANCES*	
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.	
*TOL. DECIMALS:	*TOL. ANGLES:
.XXX= +/- .005	+/- .5 DEGREES
.XX= +/- .015	
.X= +/- .030	
*CONCENTRICITY:	
.005 T.I.R.	
*REMOVE BURRS AND BREAK EDGES .005 MIN.	

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<b>HAMMONDS TECHNICAL SERVICES, INC.</b>			
SCALE	NTS	APPROVED BY:	DRAWN BY
DATE	09/22/92		SS
DRAWING TITLE		REVISED	
<b>HAMMONDS 1P6 PUMP</b>		03/15/04	
			DRAWING NUMBER
			<b>1687</b>

# Hammonds Model SPI-1 Manual



ITEM	PART NO.	QTY.	DESCRIPTION
1	101014	1	POWER FRAME
2	102192	1	PLUNGER, P7
3	102193	1	FLUID END, P7
4	882949	8	LOCK WASHER, #10 INT. TOOTH
5	881317	4	SCREW, 10-32 x 2"
6	101842	1	CROSSHEAD GUIDE
7	101007	2	RETURN SPRING
8	101006	1	CROSSHEAD
9	101152	2	SLIDE BEARING
10	101005	1	STROKE ADJUSTMENT CAM
11	101003	1	CAM GUIDE
12	101001	1	STROKE ADJUSTMENT KNOB
13	101002	1	POWER FRAME COVER
14	101004	1	LOCK SCREW
15	101009	4	SCREW, 8-32 x 3/8"
16	881086	4	LOCKWASHER, #6
17	101010	4	SCREW, 6-32 x 3/8"
18	881089	4	SCREW, 10-32 x 3/4"
18A	881660	4	SCREW, 10-32 x 2 1/4" (OPTION)
19	102463	2	CHECK VALVE, AFLAS
	102464	2	CHECK VALVE, VITON (OPTION)
	102842	2	CHECK VALVE, KALREZ (OPTION)
20	101490	1	O-RING, AFLAS
	101226	1	O-RING, VITON (OPTION)
	101754	1	O-RING, KALREZ (OPTION)
21	102194	1	SEAL HOUSING
22	881765	1	SEAL, LIP
23	881045	1	SETSCREW, 1/4-20 x 1"
24	882911	1	CHECK VALVE, 5 PSI, AFLAS, STD.
	101576	1	CHECK VALVE, 5 PSI, VITON, (OPT)
	102843	1	CHECK VALVE, 5 PSI, KALREZ, (OPT)
25	101088	1	3/8 x 1/4 FNPT TUBE ADAPT.

6	ADDED PART NOS.	01/21/14	SS
5	WAS #101671	03/15/04	SS
4	WAS #101933	03/15/04	SS
3	WAS #102263	09/03/02	SS
2	WAS #101008	08/99	SS
1	ADDED INJ CHK VLV	01/06/98	SS
NO.	REVISION	DATE	BY

DRAWING	LEVELS	VIEW
INJECTOR	10, 12, 14, 16, 18, 20, 24, 28, 30	1
	39-41, 89-93, 95-97, 99, 110, 111	
FROM SER#	DATE	TO SER#
X	X	X

**\*TOLERANCES\***  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.

\*TOL. DECIMALS:  
.XXX = +/- .005  
.XX = +/- .015  
.X = +/- .030  
FRAC. = +/- 1/16

\*TOL. ANGLES:  
+/- .5 DEGREES

\*CONCENTRICITY:  
.005 T.I.R.

BRAZE FINISH 125

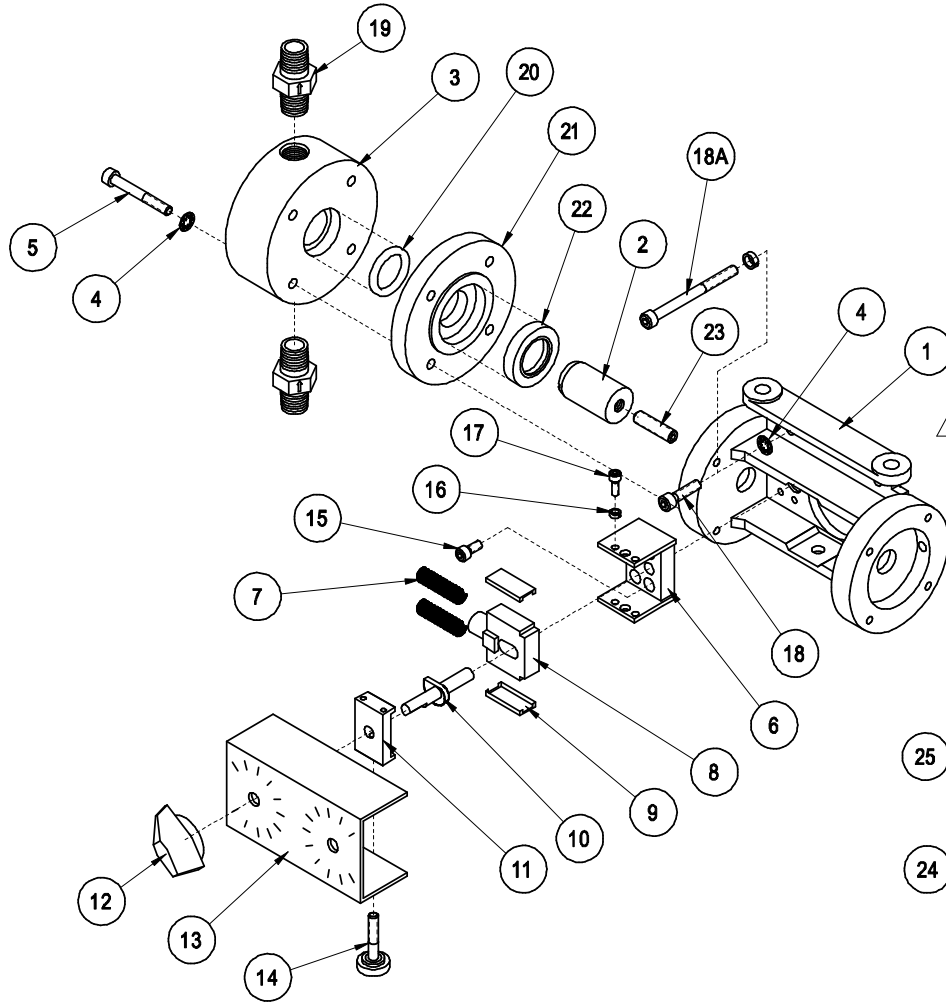
\*REMOVE BURRS AND BREAK EDGES .005 MIN.

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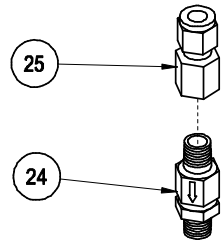
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HAMMONDS TECHNICAL SERVICES, INC.			
SCALE: NPS	APPROVED PART NUMBER	DRAWN BY: SS	
DATE: 05/11/93		REVISED: 01/21/14	
DRAWING TITLE: HAMMONDS 1P7 PUMP ASSEMBLY			
			DRAWING NUMBER: 1911

# Hammonds Model SPI-1 Manual



ITEM	PART NO.	QTY.	DESCRIPTION
1	101014	1	POWER FRAME
2	102224	1	PLUNGER, P10
3	102225	1	FLUID END, P10
4	882949	8	LOCK WASHER, #10 INT. TOOTH
5	881317	4	SCREW, 10-32 x 2"
6	101842	1	CROSSHEAD GUIDE
7	101007	2	RETURN SPRING
8	101006	1	CROSSHEAD
9	101152	2	SLIDE BEARING
10	101005	1	STROKE ADJUSTMENT CAM
11	101003	1	CAM GUIDE
12	101001	1	STROKE ADJUSTMENT KNOB
13	101002	1	POWER FRAME COVER
14	101004	1	LOCK SCREW
15	101009	4	SCREW, 8-32 x 3/8"
16	881086	4	LOCKWASHER, #6
17	101010	4	SCREW, 6-32 x 3/8"
18	881089	4	SCREW, 10-32 x 3/4"
18A	881860	4	SCREW, 10-32 x 2 1/4" (OPTION)
19	102463	2	CHECK VALVE, AFLAS, STD.
	102464	2	CHECK VALVE, VITON, ( OPTION )
20	101537	1	O-RING, AFLAS
	101839	1	O-RING, VITON (OPTION)
	101883	1	O-RING, EPDM (OPTION)
21	102226	1	SEAL HOUSING
22	881908	1	SEAL, LIP
23	881045	1	SETSCREW, 1/4-20 x 1"
24	882911	1	CHECK VALVE, 5 PSI, AFLAS, STD.
	101576	1	CHECK VALVE, 5 PSI, VITON (OPT)
25	101088	1	3/8 x 1/4 FNPT TUBE ADAPT.



NO.	REVISION	DATE	BY	APPVD
1	WAS #101671	03/15/04	SS	X
2	WAS #101933	03/15/04	SS	X
3	WAS #102263	09/03/02	SS	X
4	WAS #101008	08/99	SS	X

FROM SER#	DATE	TO SER#	DATE

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.XXX= +/- .005  
.XX= +/- .015  
.X= +/- .030  
FRAC. = +/- 1/16

\*TOL. ANGLES:  
+/- .5 DEGREES

\*CONCENTRICITY:  
.005 T.I.R.

\*REMOVE BURRS AND BREAK EDGES .005 MIN.

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**HAMMONDS TECHNICAL SERVICES, INC.**

SCALE: NPS	APPROVED: PART NUMBER	DRAWN BY: SS
DATE: 09/23/93		REVISED: 03/15/04
DRAWING TITLE: <b>HAMMONDS 1P10 PUMP</b>		DRAWING NUMBER: <b>2668</b>