

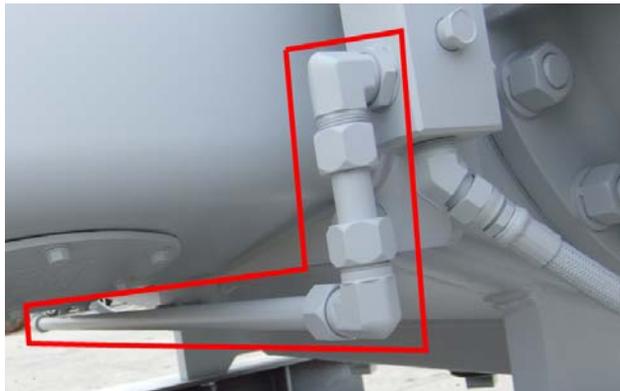
Engineering Bulletin **BLLT1182**

Product: SPM® Destiny™ TWS2500 Frac Pump
Subject: **Power End Lube Assembly, Hose Loop**
Date: June 19, 2012

Weir SPM has put together a hydraulic hose and JIC fitting kit to replace the 1" hard tubing and fittings on the power end lube assembly. Occasionally the compression fittings on the tube can become loose from vibration causing leaks. In an effort to stop a leak, the fitting can be over torqued thus damaging the compression fittings. The new hose assembly replaces the compression fittings with JIC fittings. The hydraulic hose helps absorb the vibration in the line.

The new hose kit part number **2A118617** includes: 2 - 90° elbows (SAE x JIC), 1 - 48" hose, and 2 - Adel clamps. The hose assembly includes MEGA-Crimp® fittings which have a higher tolerance for over-torquing. Please contact your local service center should you have questions.

Line to be replaced:



New hose assembly installed:



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Well Service Valve
& Seat Technologies

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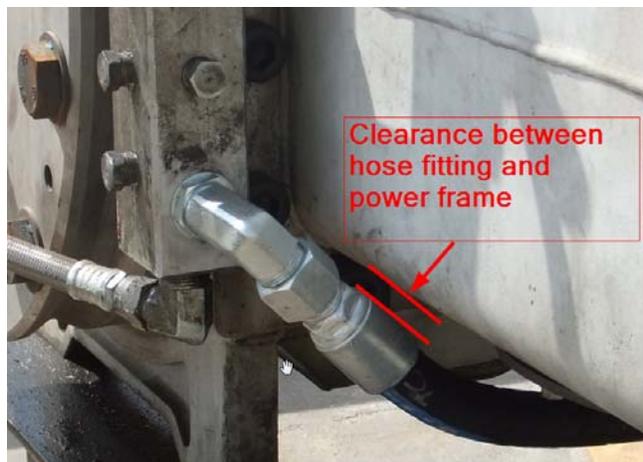


Installation:

1. Remove old tubing from 90° elbow. CAUTION - Make sure a can and drop cloth are underneath the fitting to catch any oil in the tubing. Once tubing line is loose, drain oil into can and dispose of properly.



2. Remove 90° elbow from lube assembly manifold and clean threads on the manifold. Inspect the threads after cleaning and ensure there is no damage.
3. Install the new elbows from kit. Elbows should be Male SAE x Male JIC. Do NOT tighten the SAE fitting into the manifold at this time. Make sure elbow is angled towards the belly of the pump to help with hose installation.
4. Install hose assembly onto both elbows. Make sure there is min. of 1" clearance between the power frame and crimp fitting on the end of the hose by adjusting the elbow orientation and then tightening the nut on the SAE fitting. Torque JIC fitting to 116 – 125 ft-lbs. For field installation use the Flats from Wrench Resistance method and tighten one flat (1/6 of a turn) after wrench resistance.



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5. Install the Adel clamp in the middle of the hose. Remove one bolt from the middle SPM cover plate on the bottom of the power frame, slide clamp around hose, and re-install bolt through Adel clamp and into original hole. Refer to photo below.



6. Pick up the drop cloth and can from step 1, clean up any spills and dispose of any liquids properly, and run the unit to confirm there are no leaks.

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