



ENGINEERING DIVISION

ITEM NO. 450-04-20582/583

CENTRIFUGAL PUMP DATA SHEET.

A.2. NO. 80-701

JOB NO. 15-2-2

Process BDP
Unit Recovery Area (04)
Service Acetic Acid Column Bottoms
Pump Type: ☐ Horizontal ☐ Vertical
☒ Inline ☐ Turbine ☐ Sump
Pump Mfr. Goulds Pumps, Inc.

P. O. No. _____ Req. No. _____
Originator ISR Date 12/15/80
Revised By JSB Rev. No. 1 Date 4-27-81
Size & Type 3996ST 1 1/2x3-8 No. Req. 2

OPERATING CONDITIONS

Liquid Organic Solvent
125 GPM at 43 Ft. Hd. Differential
GPM at _____ Ft. Hd. Differential
NPSH 19.8 Ft. Available at 125 GPM
Shut Off. Ft. Head 61 P.T. °C Opr. 153 Max.
Disch. Press, PSIA 42.0 Sp. Gr. at P.T. 0.678
Suct. Press, PSIA 29.4 Viscosity at P.T. CPS 0.25
Vapor Press. at P.T. PSIA 23.5

CONSTRUCTION

Case Split: Horizontal, ~~XXXXXX~~
Support: ~~XXXXXX~~ ~~XXXXXX~~ ~~XXXXXX~~ Pipeline
Vent: ~~XXXX~~ No. Size ~~---~~ Drain: Yes, ~~XX~~ Size 3/8"
Mech. Seal Flush Tap: Size 1/4"
Nozzles Size Rating Facing Position
Suction 3" 150 lbs. FF Inline
Discharge 1-1/2" 150 lbs. FF Inline
Impeller Type Open
Diameter: Design 7 1/4" Max. 8"
Shaft Sleeve: ~~XXXX~~ No.
Coupling Type Falk Steelflex
Thrust ~~XXXXXX~~ Bearing Lube: ~~XXXX~~ Greased for life
Seal Bypass Tap: Size 1/4"
Stuffing Box Drain: Size 1/2"
a) Flush Gland

MATERIALS

Casing 316 SS Shaft Sleeve -----
Impeller 316 SS Wear Rings -----
Shaft 316 SS Stuffing Box 316 SS
Inner Case Parts 316 SS

SHAFT SEALING Y F 10 1
Mechanical Seal Type Crane Type 8 5 51 8 (316 SS)
Rotating Face Material Carbon (Grade 51)
Stat. Face Material Silicon Carbide
Other Wetted Parts Kalrez 7 316 SS
Packing Type ----- Size & No. Rings -----
Lantern Ring Material ----- Lube -----
Stuffing Box Arrangements: Crane Type 24-SL
b) ☒ External Flush Conn. ☒ Throat Bush.
☐ Suction Flush Loop. ☐ Cyclone Sep.
☐ Discharge Flush Loop ☐ Cooler

PERFORMANCE (By Vendor)

Proposal Curve No. CDS 2418
Hb. Stages 1 Design Eff. 55% BHP 1.67
For Design Impeller:
Max. BHP 1.84 Max. Head-Ft. 61
Max. Req'd. NPSH-Ft. _____ Min. Continuous GPM _____
Rotation Facing Coupling End CW
Water Cooling: NO
Bearings _____ GPM
Stuffing Box _____ GPM
Gland _____ GPM
Max. Allow WP _____ PSIG at °C
Weights: Pump _____ Base _____
Motor, ~~XXXXXX~~

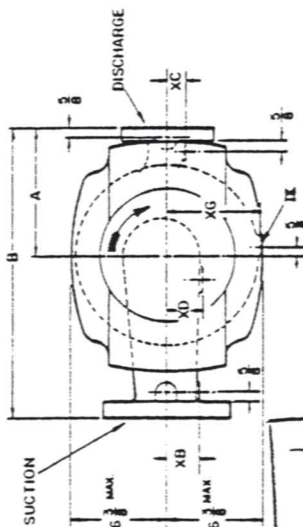
DRIVER

MOTOR Purchased By Vendor
Item No. _____ Mtd. By Vendor
HP * 3 RPM 1750
R and H Spec. No. 22-741
Control Button Mounted at Pump ☒ & Panel Board ☐
~~XXXXXXXXXXXXXXXXXXXX~~
Guard for Drive - Std. No. 99-056
Motor to be high efficiency type.
*This horsepower is required for water runs.

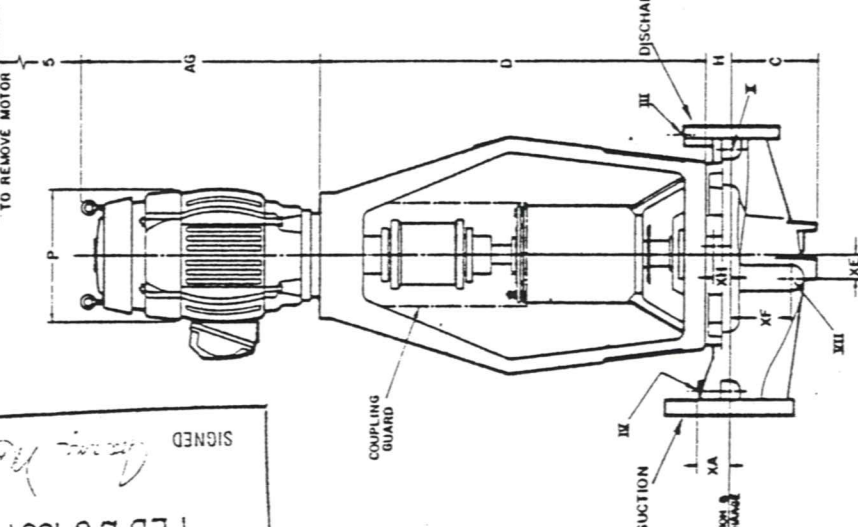
TURBINE Purchased By _____
Item No. _____ Mtd. By _____
HP _____ RPM _____
Mfr. & Type _____
Inlet Steam, PSIG _____ Temp F. _____
Exhaust _____
Steam Rate, FL _____ LB/3HP/HR
Bearings _____ Lube _____
Nozzles Size ASA Rating Facing Position
Inlet _____
Exhaust _____

*Motor Brake Horsepower Shall Not Exceed 90% of Nameplate Horsepower For Impeller Design At Any Point On The Curve.

REMARKS: a) Vendor to provide vent tap on flush gland.
b) Organic solvent flush will be used.
c) Hydrostatically test to manufacturer's standard.



MINIMUM HEADROOM REQUIRED
TO REMOVE MOTOR



Approved for Construction Purposes
GOULDS PUMPS, INC.
SENeca FALLS, N. Y.

FEB 26 1981

SIGNED

DIMENSIONS DETERMINED BY PUMP

DISCH SIZE	SUCT CLASS	A	B	C	H	XA	XB	XC	XD	XE	XF	YG	XH	XJ	XK	XL	XM	XN	XP	WT
1-1/2	2	6	6 3/4	15	4 1/2	2 1/8	2 1/8	1 1/8	1 1/8	1 1/2	2 1/8	4 1/8	1 3/8	3/4	2 5/16	2 5/16	3 13/16	3 13/16	3 9/16	190
1-1/2	3	6	6 3/4	15	5 1/8	2 1/8	2 1/8	1 1/8	1 1/8	1 5/8	3 3/8	4 1/8	1 3/8	3/4	2 5/16	2 5/16	3 13/16	3 13/16	3 9/16	200
2	3	6	7 1/2	17	4 7/8	2 1/8	2 1/8	1 1/8	1 1/8	1 7/8	3 1/2	4 1/8	1 3/8	3/4	2 7/16	2 7/16	3 15/16	3 15/16	3 1/2	205
1-1/2	2	8	8	17	5 1/8	2 1/8	2 1/8	1 1/8	1 1/8	1 1/2	3 1/4	6 1/8	1 3/8	7/8	1 5/16	2 3/16	3 11/16	3 11/16	3 1/2	200
1-1/2	3	8	8 3/8	18 7/8	5 1/2	2 1/8	2 1/8	1 1/8	1 1/8	1 1/2	3 3/8	6 1/8	1 3/8	7/8	2 3/16	2 3/16	3 15/16	3 15/16	3 1/2	210

FLANGE DIMENSIONS

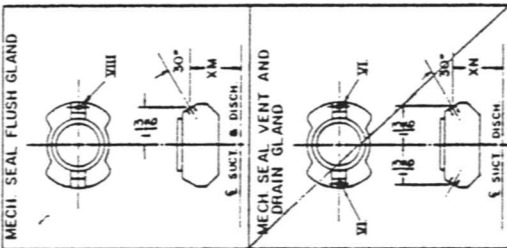
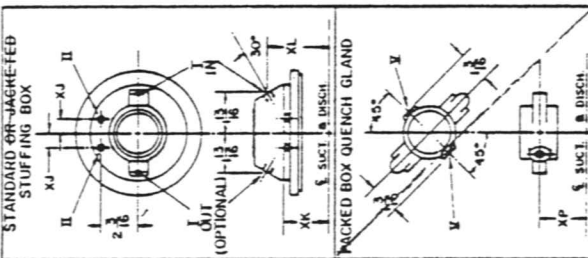
NOM I.D.	O.D.	B.C.	THK.	NO OF HOLES	SIZE OF HOLES
1-1/2	5	3-7/8	11/16	4	5/8
2	6	4-3/4	3/4	4	3/4
3	7-1/2	6	15/16	4	3/4
1-1/2	6-1/8	4-1/2	13/16	4	7/8
2	6-1/2	5	7/8	8	3/4
3	8-1/4	6-5/8	1-1/8	8	7/8

DIMENSIONS DETERMINED BY MOTOR

NEMA FRAME	6" CAS	8" CAS	AG	P	WT
143 TC	17-1/2	18-1/8	12	7	60
145 TC	17-1/2	18-1/8	13	7	65
182 TC	19-1/4	19-7/8	15	9	105
184 TC	19-1/4	19-7/8	16	9	105
213 TC	19-1/4	19-7/8	17	11	185
215 TC	19-1/4	19-7/8	18	11	185
254 TC	19-1/4	19-7/8	21	13	320
256 TC	19-1/4	19-7/8	25	13	320
284 TC	19-1/4	19-7/8	24	15	350
286 TC	19-1/4	19-7/8	25	15	440

OPTIONS FURNISHED WHEN CHECKED

STUFFING BOX COVER	☒ STANDARD ☐ JACKETS
STUFFING BOX SEALING	☐ PACKING WITH QUENCH GLAND ☒ MECHANICAL SEAL WITH FLUSH GLAND ☐ MECHANICAL SEAL WITH VENT AND DRAIN ☐ MECHANICAL SEAL WITH PLAIN GLAND
COUPLING GUARD	☒ BY GOULDS ☐ BY OTHERS



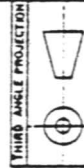
SIZE	QTY	PURPOSE	FURNISHED YES NO
I 1/4	1	LANTERN RING OR MECH SEAL FLUSH	X
II 1/4	2	STUFFING BOX JACKET CONNECTIONS	X
III 1/4	1	DISCHARGE GAGE CONNECTION	X
IV 1/4	1	SUCTION GAGE CONNECTION	X
V 1/4	2	QUENCH CONN FOR PACKED BOX	X
VI 1/4	2	VENT AND DRAIN FOR MECH SEAL	X
VII 1/4	1	CASING DRAIN ☒ 3/8 ☐ 1/2	X
VIII 1/4	1	FLUSH CONN FOR MECH SEAL	X
IX 1/2	1	STUFFING BOX DRAIN	X
X 1/4	1	SEAL BYPASS CONNECTION	X

▲ MOTORS MAY BE SUPPLIED WITH "V"
DESIGNATION. THIS DESIGNATION DOES
NOT AFFECT DIMENSIONS OR MOUNTING.

NOTES:
DRAWING IS NOT TO SCALE.
ALL DIMENSIONS ARE IN INCHES.
WEIGHTS ARE APPROXIMATE.

GOULDS PUMPS INC., SENECA FALLS, N. Y., U.S.A.

GOULDS SERIAL NO. 719C866-1-2
CUSTOMER: ROHM & HAAS CORPORATION
CUSTOMER P.O. NO. PLS-1049
ITEM NO. 450-04-20582/583
SERVICE: ACETIC ACID COLUMN BOTTOMS



113-64

ENG. FORM NO 1364
DATE: 6-20-80 KWE, DRH

DWG. NO.

113-64

REV. 1

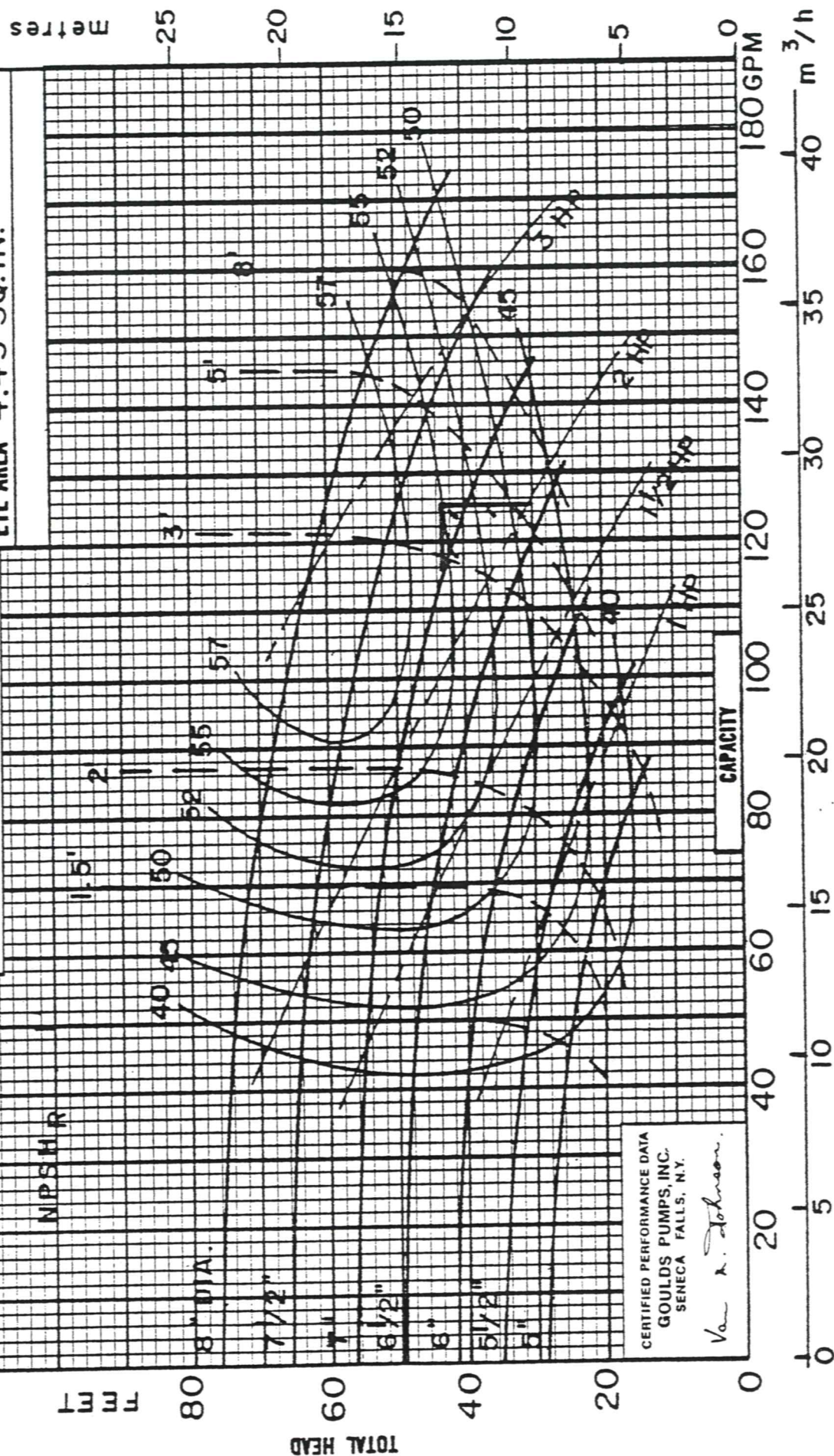
REV. DATE

GOULDS PUMPS, INC.
SENECA FALLS, NEW YORK 14448

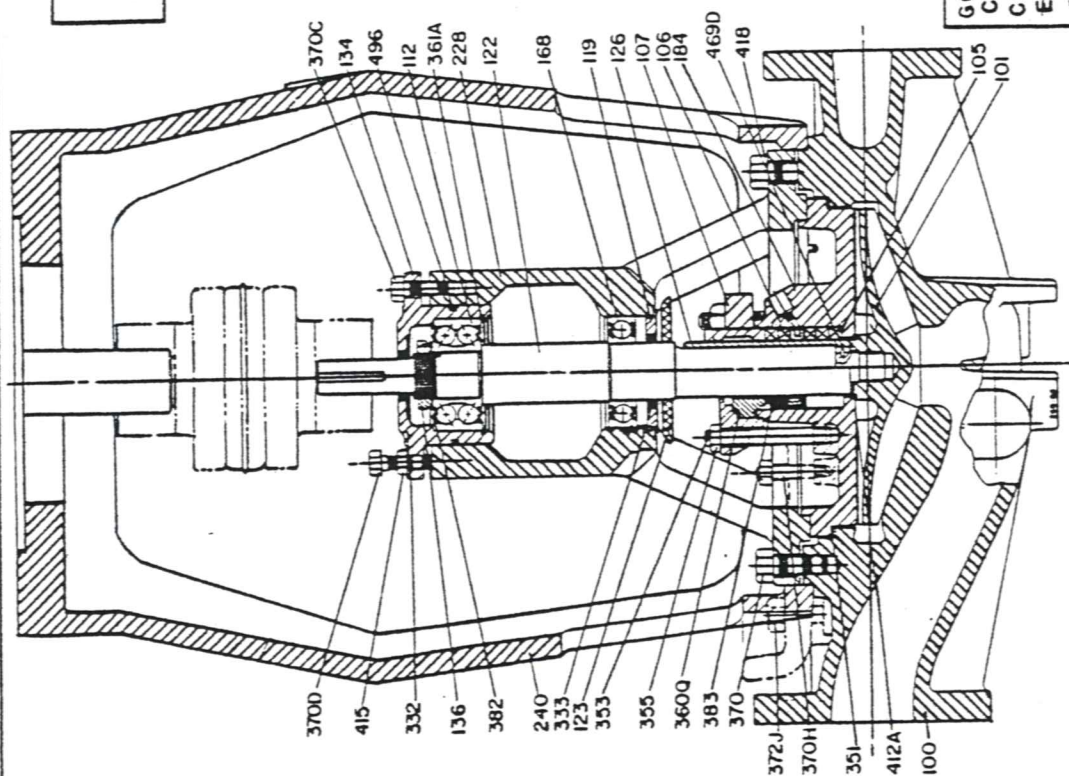
CENTRIFUGAL PUMP CHARACTERISTICS

	RPM	1750	CDS	2418
1	100	100	100	100
2	100	100	100	100
3	100	100	100	100
4	100	100	100	100
5	100	100	100	100
6	100	100	100	100
7	100	100	100	100
8	100	100	100	100
9	100	100	100	100
10	100	100	100	100
11	100	100	100	100
12	100	100	100	100
13	100	100	100	100
14	100	100	100	100
15	100	100	100	100
16	100	100	100	100
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71	100	100	100	100
72	100	100	100	100
73	100	100	100	100
74	100	100	100	100
75	100	100	100	100
76	100	100	100	100
77	100	100	100	100
78	100	100	100	100
79	100	100	100	100
80	1			

MODEL	3996 ST	7 1/4" IMP. DIA.
SIZE	1 1/2 x 3-8	
IMP. DWG.	76780	76794
PATTERN	56091	56209
EYE AREA	4.43 SQ. IN.	



MODEL 3996 ST
GREASE FOR LIFE



ITEM NO	NO REQ PER PUMP	PART NAME	MATERIAL
100	1	CASING	3/4 SS
101	1	IMPELLER	3/4 SS
103	1	LAUTERB-RH6	TEFLON
106	156	STUFFING BOX PACKING	ASBESTOS
107	1	GLAND 58	316 SS
112	1	BALL BRG - OTBD	STEEL
119	1	BRG END COVER INBD	STEEL
122	1	SHAFT	3/4 SS
123	1	DEFLECTOR	NYLON
126	1	SHAFT-SLEEVE	CAST IRON
134	1	BRG HOUSING	STEEL
136	1	BRG LK NUT	STEEL
168	1	BALL BRG INBD	STEEL
184	1	STUFF BOX COVER	3/4 SS
228	1	FRAME SUPPORT	CAST IRON
240	1	MOTOR SEAL	STEEL
332	1	GREASE SEAL	STEEL
333	1	GREASE SEAL	STEEL
351	1	GASKET, CASE	ASBESTOS
353	2, 4	GLAND STUD	304 SS
355	2, 4	HEX NUT GLAND STUD	316 SS
360Q	1	GASKET, MECH SEAL	ASBESTOS
361A	1	RTNG RING, BRG HSG	STEEL
370	4, 8	H CAP SCREW, FR - CASE	304 SS
370C	6	H TAP BOLT, BRG HSG	STEEL
370D	3	H TAP BOLT, IMPLR ADJ	STEEL
370H	2	STUD - COVER TO ADPTR	STEEL
372J	2	MOTOR SPRT TO CASING	STEEL
382	1	BRG LK WASHER	STEEL
383Q	1	MECH SEAL	CRANE
412A	1	O-RING, IMPLR	TEFLON
415	3	JAM NUT - BRG HSG	STEEL
418	2	H CAP SCREW - FR. JACK	STEEL
469D	1	ROLL PIN, 5FT SILV	410 SS
496	1	O-RING, BRG HSG	BUNA-N

● MECH SEAL ONLY

OR BY	I.Q.	VAJ	CAD BY	APPROVED	DATE	9-16-76	BLANKING	DATE	7/19/86	REV	0
 GOULDS PUMPS, INC. SUITE 4, FALLS VIEW, NEW JERSEY											
NONE M A I L											

GOULDS SERIAL NO. 719C866-1-2
 CUSTOMER ROHM & HAAS BAYPORT, INC.
 CUSTOMER P. O. NO. P15-11049
 EQUIP-OR ITEM NO. 450-04-20582/583
 SERVICE ACETIC ACID COLUMN BOTTOMS

SP-CF-45721-1

DWG. No.

REV

PRINT IS PROPERTY OF CRANE PACKING CO. SUBJECT TO RETURN UPON DEMAND. TITLE TO SAME NEVER SOLD OR TRANSFERRED FOR ANY REASON ALL RIGHTS TO INVENTION RESERVED

CRANE PACKING COMPANY
6400 W. OAKTON ST.
MORTON GROVE, ILL.

TYPE -8IT 3116

1.375 D. SHAFT SEAL

FOR MODEL 3196 "ST"

GOULDS PUMPS INC.

SENECA FALLS, N.Y.

STD APP

DR APP

DR RE

APP 3-2-81

APP 2/25/81

SCALE NONE

FOR DIMENSIONAL DWG. SEE # CF-SP-45721

OPERATING CONDITIONS:

LIQUID: ORGANIC ACID/SOLVENT SOLUTION

SP. GR: .678

TEMP: 308°F

PRESS. SUCT.:

SPEED: 1750 R.P.M.

PRESS. DISCH.:

UNIT REF:

CUST. P.O. # F04369/MS27319 P.O.# 015-11049

PROJ. # ROHM & HAAS, BRISTOL, PA.

ITEM # 450-04-20582/583

EQUIP. #

PUMP SERIAL # 719C866-1-2

PUMP MODEL 3196 "ST"

PUMP STUFFING BOX #

SHOP ORDER # 719866

B/P REF.:

DWG. #CF-SP-36029 REV.C DTD.3/21/77 BY C.P.CO.

REC. SPARE PARTS

MATERIAL

QUAN. +

PART NAME

MATL. CODE

PART NUMBER

OPERATING CONDITIONS:

LIQUID: ORGANIC ACID/SOLVENT SOLUTION

SP. GR: .678

TEMP: 308°F

PRESS. SUCT.:

SPEED: 1750 R.P.M.

PRESS. DISCH.:

ITEM	QUAN.	PART NAME	MATL. CODE	PART NUMBER	MATERIAL	REC. SPARE PARTS
1	1	MATING RING	9220	430	SIL. CARD.	X
2	1	O-RING	3765	0000	KALREZ	X
3	1	PRIMARY RING	9051	020	CARBON	X
4	1	O-RING	3765	0000	KALREZ	X
5	1	RETAINER	0550	1375	316 SS	
6	12	SPRING		2077	316 SS	X
7	1	DISC	0550	1375	316 SS	
8	1	SNAP RING	0550	119	316 SS	
9	4	SET SCREW	0550	8-32x1/4 LG. 1108-3204-000	316 SS	X
10	1	PRIM. RING	7510	1375	GL. FILLED CHEMLON	X
11	3	SPRING		3035	316 SS	X
12	1	RETAINER	0550	1375	316 SS	
13	1	SET SCREW	0550	10-24x1/4 LG. 1110-2404-000	316 SS	X
14		SLEEVE		BY CUST.		
15		GASKET		BY CUST.	ASBESTOS	
16		GLAND PLATE		BY CUST.	316 SS	

SEAL ASSY. NO. A8T-1375-231

BUSH. ASSY. NO. A24-1375-010

MATING RING ASSY. NO.

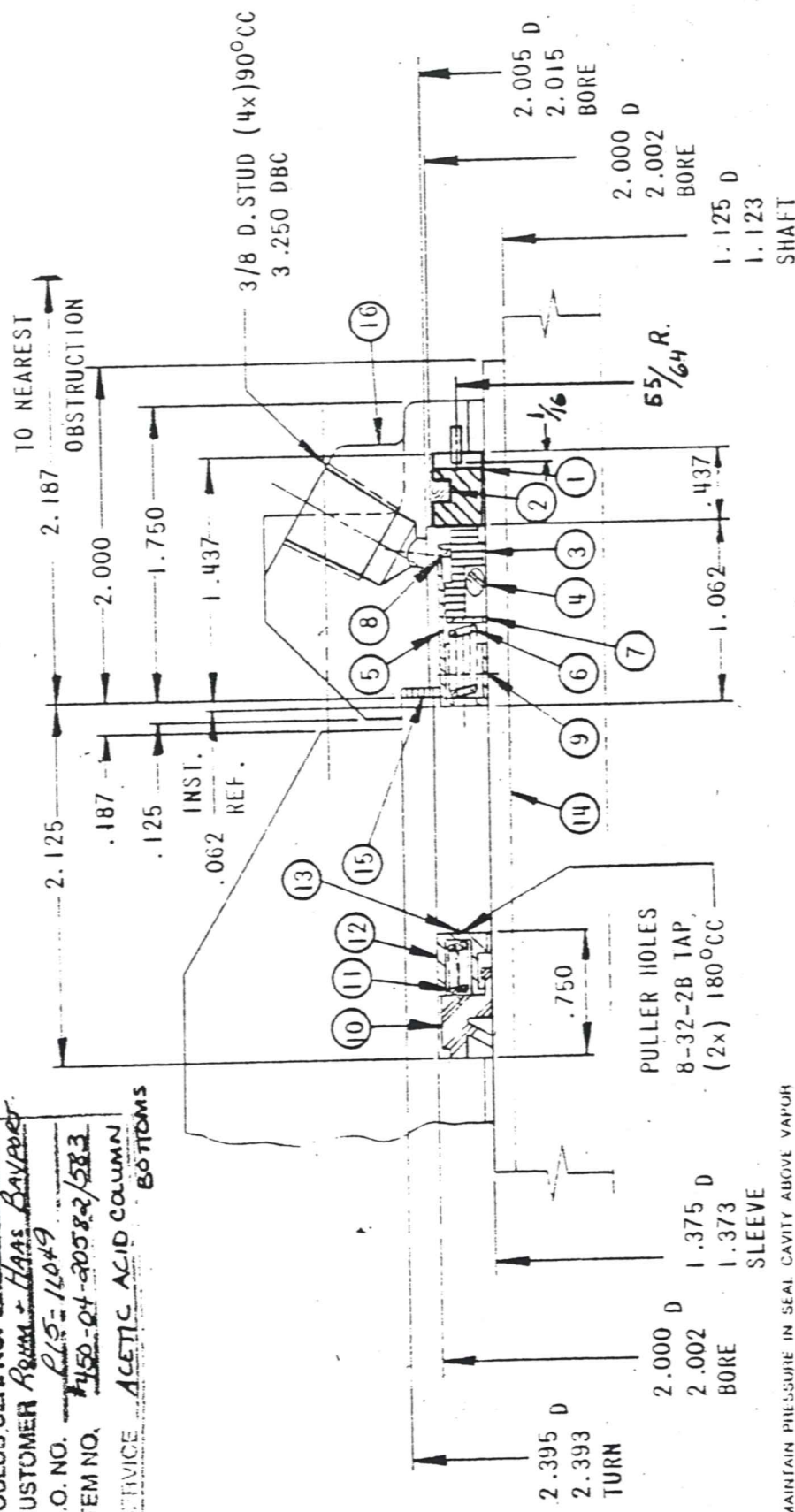
*PART OF ASSEMBLY
+ SPECIAL PART

CODE: X5F51081 (316)

VI-1/

DWG. No		CF-SP-45721		REV		PRINT IS PROPERTY OF CRANE PACKING CO. SUBJECT TO RETURN UPON DEMAND TITLE TO SAME NEVER SOLD OR TRANSFERRED FOR ANY REASON. ALL RIGHTS TO INVENTION RESERVED		STD APP DR APP JAL RE CH 3-10-81 APP 3-10-81 10-3-10-81 SCALE 1:1		TYPE-8-11 1.375 D. SHAFT SEAL FOR MODEL 3196 "S1" GOULDS PUMPS, INC. SENECA FALLS, N.Y.	
6400 W. OAKTON ST. MORTON GROVE, ILL.		CRANE PACKING COMPANY		FOR BILL OF MAT. SEE #		SP-CF-45721					

GOULDS SER. NO. 712C-806-1-2
 CUSTOMER Rem - Haas Bayview
 P.O. NO. RLS-11049
 ITEM NO. 450-04-20582/583
 SERVICE ACETIC ACID COLUMN
 BOTTOMS



- ☒ 4 MAINTAIN PRESSURE IN SEAL CAVITY ABOVE VAPOR POINT DURING OPERATION.
- ☒ 3 BEFORE INSTALLING SEAL LUBRICATE ITEM # 2&4
- ☒ 2 VENT GAS ENTRAPMENT BEFORE STARTUP
- ☒ 1 CLEAN SEAL FACES BEFORE FINAL ASSEMBLY
- ☐ 6 CIRCULATE SUITABLE LIQUID (INLET AT BOTTOM. OUTLET AT TOP), AT
- ☐ 5 GLAND MUST BE IN CONTACT WITH HOUSING. DO NOT OVERSTRESS

IMPORTANT NOTES: ☒ IF REQUIRED

DWG. No. CF-SP-45721

RELIANCE

ELECTRIC COMPANY

MOTOR DIVISION, CLEVELAND, OHIO 44117, U.S.A.

DATA TRANSMITTAL AND CERTIFICATION

REFER TO THIS NUMBER
IN ALL CORRESPONDENCE

OLD
TO:

GOULDS-ENG PRODUCTS DIV
240 FALL
SENECA FALLS N Y

13148

SHIP
TO:

GOULDS PUMPS INC
240 FALL ST
SENECA FALLS, N.Y.

ATA
SOURCE

TRANSMITTAL AND CERTIFICATION ISSUED BY: E. J. O'Brien
ASHTABULA PLANT
4200 BENEFIT ROAD
ASHTABULA, OHIO 44004

DATE APR 29 81

CK BY

G. R. Kilborn

DATE APR 29 81

DATE PRINTED: 03/23/81

OTOR
OR
GEN.
ATA

ITEM 2-3	USED FOR CENTR. PUMP	USERS PLANT				MOTOR OR GEN. D/S: 602531-924
QTY. 2	FRAME L 182TC	3	HP 1.15	SERV. FA PB	TYPE 1755	C BOX D/S
PH/HZ/VOLTS-WINDING SEE BELOW	DUTY CONT	ENCLOSURE TEFC-XT	AMB./INSL. 40 F		PWR. CODE	MOTOR OR GEN. C/D:
BEARINGS BALL	MOUNTING & METHOD OF DRIVE W-6 /CPLD	RAILS OR BASE	MODEL NUMBER		REDUCER OR AUX. D/S:	
ROTAT FROM OPP. DR. END CW	D-C FIELD EXCITATION		DOUBLE SHAFT EXTEN.		BRAKE OR AUX. D/S:	
REDUCER STYLE	CLASS	FRAME	RATIO	OUTPUT RPM	ASSEMBLY	BLOWER MOTOR PH/HZ/VOLTS/HP
BRAKE TYPE	SIZE	RATING FT/LB	DUTY	P.O.		

DATA
FOR
CON-
TROL

D-C MOTOR ARMATURE CURRENT: _____ AMPS
FIELD CHARACTERISTICS PER CURVE:
F₁-F₂ _____ MAX. AMPS _____ RPM
F₁₁-F₂₂ _____ MAX. AMPS _____ RPM
F₃-F₄ _____ MAX. AMPS _____ RPM

A-C MOTOR INFORMATION FOR
SELECTION OF STARTER HEATERS:
CODE: K LOCKED AMPS: _____
F.L. CURRENT: 7.6/3.8 AMPS.

IPCL.
IN-
TAL-
LA-
TION
EAT.
AND
MISC.
DATA

ADDITIONAL MOTOR OR GEN DATA:
PHASE: 3 HERTZ: 60 VOLTS: 230/ 460
LD LOC - STD
FR CONST RB

SPECIAL MARKS:
719866

SPECIAL FEATURES:
"ENERGY EFFICIENT" XE
90 C-RISE AT 1.15 S.F.
WITH DRIP CVR
NORMAL THRUST
NEMA NOM EFF 88.5

GOULDS SER. NO. _____
CUSTOMER _____
P.O. NO. _____
ITEM NO. 450-04-20582/583
SERVICE _____

CERTIFIED DRAWINGS & DATA:

JATE: MOD.NO:
DATE: MOD.NO:
DATE: MOD.NO:

1 CERT D/S TO CUST
ATTN JOANNE MOLL
1 CC OF ALL PAPERWORK to 24201

DUTY MASTER ALTERNATING CURRENT MOTORS

SQUIRREL-CAGE INDUCTION

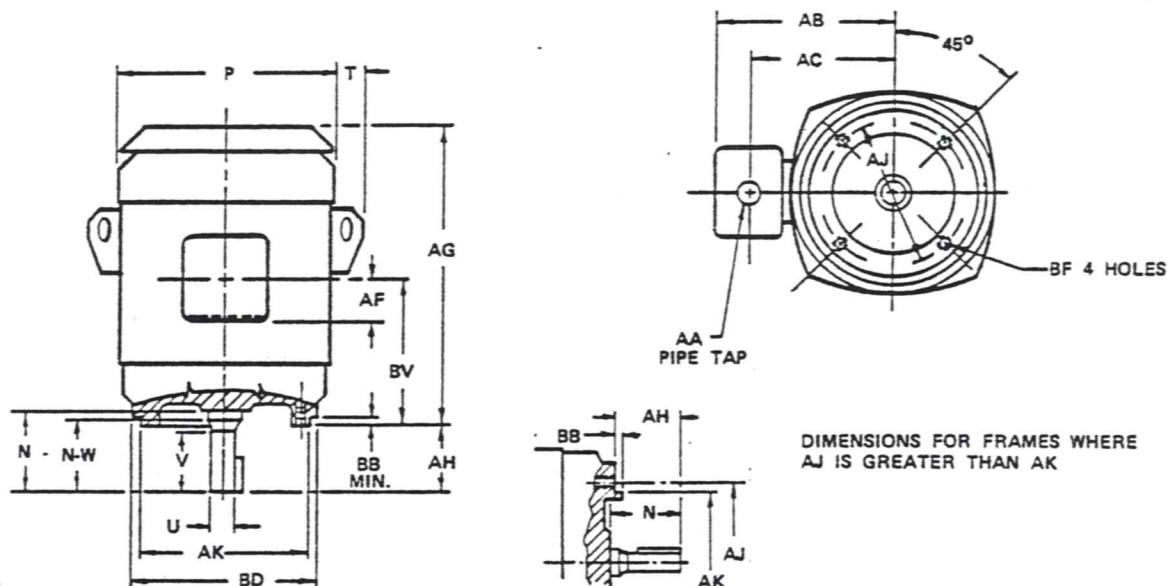
ENCLOSURE: TOTALLY ENCLOSED

COOLING: FAN COOLED

MOUNTING: FOOTLESS, NEMA "C" FACE
VERTICAL SHAFT DOWN

CONSTRUCTION: CAST IRON

FRAMES 180TC THRU 210TC



DIMENSIONS FOR FRAMES WHERE
AJ IS GREATER THAN AK

DIMENSIONS ARE IN INCHES, SEE SHEET 2 FOR DIMENSIONS IN MILLIMETERS

FRAME SIZE	AG		BV		AH	N	N-W	P	T	U(2)	V	AJ	AK(3)	BB	BD	CONDUIT BOX				BF	TAP DEPTH (MIN)	B.E. SQ	KEY LGTH	WT. LBS
	STD	LG(4)	STD	LG(4)												AA	AB	AC	AF					
182TC-L182TC	14.81	16.31	5.88	6.62	2.62	2.94	2.75	9.50	1.44	1.1250	2.50	7.25	8.500	.25	9.00	3/4	7.25	5.75	1.94	1/2-13	.75	.250	1.75	70
184TC-L184TC	15.81	17.31	6.38	7.12	2.62	2.94	2.75	9.50	1.44	1.1250	2.50	7.25	8.500	.25	9.00	3/4	7.25	5.75	1.94	1/2-13	.75	.250	1.75	89
213TC	18.31		7.25		3.12	3.56	3.38	10.50	1.44	1.3750	3.12	7.25	8.500	.25	9.00	1	9.12	7.12	2.50	1/2-13	.75	.312	2.38	120
215TC-L215TC	20.56	21.44	8.00	8.44	3.12	3.56	3.38	10.50	1.44	1.3750	3.12	7.25	8.500	.25	9.00	1	9.12	7.12	2.50	1/2-13	.75	.312	2.38	141

(1)

(1) SPECIAL DIMENSIONS APPLYING TO THIS ORDER ON THIS LINE.

(2) "U" VARIES +.0000, -.0005.

(3) "AK" VARIES +.000, -.003.

FACE RUNOUT AND ECCENTRICITY .004 MAX. T.I.R.
IF MOUNTING CLEARANCE DETAILS ARE REQUIRED,
CONSULT FACTORY.

(4) FRAMES PREFIXED BY "L"

GOULDS SER. NO. 719C866-1-2
CUSTOMER ROHM & HAAS CORPORATION
P.O. NO. P15-11049
ITEM NO. 450-04-20582/583
SERVICE ACETIC ACID COLUMN BOTTOMS

FRAME- TYPE- CERTIFIED FOR-
ORDER- ITEM- HP- RPM- PH- HZ- VOLTS-
RELIANCE SALES ORDER- APPROVED BY- DATE-

**RELIANCE
ELECTRIC**
CLEVELAND, OHIO 44117 U.S.A.

DR. BY R.L. BROWN
CK. BY J.E. BROWN
APP. BY M. BROWN
DATE 4-22-77

**DIMENSION
SHEET**
SHEET 1 OF 2

602531-924
ISSUE DATE SEPTEMBER 25, 1979