

**VIKING  
PUMP****TECHNICAL SERVICE MANUAL****INSTALLATION, START UP, TROUBLESHOOTING,  
PREVENTATIVE MAINTENANCE, DO'S & DON'TS**

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**INSTALLATION  
GENERAL COMMENTS**

Before installation is started, a few items of a general nature should be considered.

- Location** - always locate the pump as close as possible to the supply of liquid to be pumped. Locate it below the liquid supply if at all practical. Viking pumps are self priming but the better the suction conditions the better the performance.
- Accessibility** - the pump should be located where it is accessible for inspection, maintenance, and repair. For large pumps, allow room to remove the rotor and shaft without removing the pump from the base.
- Port Arrangement** - since the pumps have different port arrangements depending on the model, port location should be checked before starting the installation. The ports may be upright, opposite or at right angles to each other, see **Figure 1**. The right angle ports are normally right-hand, see **Figure 2**; some models are available with left-hand arrangements; still other models are available with the right angle ports located in any one of eight positions including right-hand and left-hand.

**FIGURE 1****FIGURE 2**

- Suction/Discharge** - shaft rotation will determine which port is suction and which is discharge. A look at **Figure 3** will show how rotation determines which port is which; as the pumping elements (gears) come out of mesh, point "A" on **Figure 3**, liquid is drawn into the suction port; as the gears come into mesh, point "B", the liquid is forced out the discharge port.

Reversing the rotation reverses the flow through the pump. When determining shaft rotation, always look from the shaft end of the pump. Unless otherwise specified, rotation is assumed to be clockwise (CW), which makes the suction port on the right side of the pump. The idler pin, which is offset in the pump head, should be properly positioned toward and an equal distance between the port connections.

**FIGURE 3**

- Pressure Protection** - Viking pumps are positive displacement. This means that when the pump is rotated, liquid will be delivered to the discharge side of the pump. If there is no place for this liquid to go - discharge line is blocked or closed - pressure can build up until the motor stalls, the drive equipment fails, a pump part breaks or ruptures, or the piping bursts. Because of this, some forms of pressure protection must be used with a positive displacement pump. This may be a relief valve mounted directly on the pump, an inline relief valve, a torque limiting device or a rupture disk.

**FIGURE 4****CUTAWAY OF VIKING INTERNAL PRESSURE RELIEF VALVE**

The pressure relief valve mounted on most Viking pumps and most in-line valves are of the spring loaded poppet design. See **Figure 4**. The spring (A) holds poppet (B) against the seat in the valve body (C) with a given force determined by the spring size and by how tightly it is compressed by the adjusting screw (D). The pump discharge pressure pushes against the underside of the poppet at point (E). When the force exerted by the liquid under the poppet exceeds that exerted by the spring, the poppet lifts and liquid starts to flow through the valve. As the discharge pressure builds up, more and more of the liquid flows through until a pressure is reached at which all of the liquid being pumped is going through the valve. This pressure is the relief valve setting.

# Viking Service Manual

**JR Anderson**



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