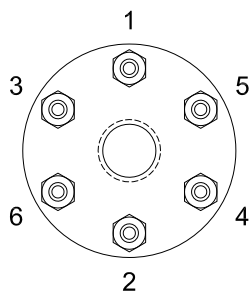


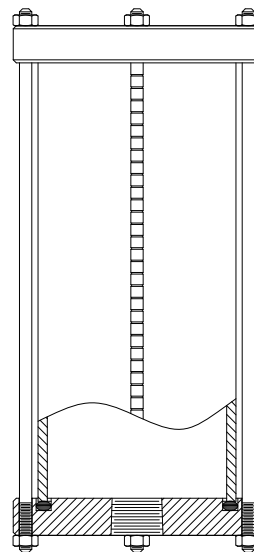
# Kenco Stay Rod Type Pump Setting Gauges (Model 31440) Sight Tube Installation Instructions

1. Take sight tube and carefully insert each end into o-ring groove of each end plate without o-ring in place to ensure that sight tube inside diameter and outside diameter will fit properly in groove. This is important due to the fact that sometimes sight tube is egg-shaped and will not allow for a proper fit. If a clearance problem is suspected, consult factory before attempting to assemble gauge.
2. Thread 1/4"-20UNC hexagon nut onto one end of each stay rod until approximately 1/16" of rod is through nut.
3. Inspect o-ring grooves in end plates to ensure that they are free of foreign materials which might interfere with o-ring seal.
4. Place end plate on a flat surface with o-ring groove side up.
5. Insert o-ring seal into groove in end plate.
6. Wipe off ends of sight tube.
7. Place sight tube on top of o-ring seal in groove ensuring that it is centered as close as possible.
8. Place second o-ring seal on top of exposed end of sight tube centering as close as possible.
9. Carefully place other end plate, o-ring groove side down, on top of sight tube/o-ring centering as close as possible.  
Note: It is very important that sight tube be centered in groove because if edge of sight tube is outside of groove, permanent damage to sight tube will occur.
10. Insert stay rods through holes in upper end plate and into holes in lower end plate.
11. Compress upper end plate down with hand to hold all parts in place and carefully slide gauge slightly past edge of assembly table allowing stay rod to extend beyond bottom surface of lower end plate.
12. While continuing to compress parts together, thread hexagon nut onto lower end of each stay rod until it is hand tight.
13. Carefully rotate gauge and repeat steps 11 and 12 until all stay rods have been installed and are hand tight.
14. Gently tilt assembled gauge over onto table allowing end plates to support sight tube.
15. Closely inspect sight tube to ensure that ends are still centered within o-ring grooves in end plates and carefully adjust its position at this time if necessary.
16. Place wrench on hexagon nut on preassembled end of stay rod.
17. Place wrench on hexagon nut on opposing end of gauge and tighten 1/4 turn. Ensure that you DO NOT tighten hexagon nuts any more than 1/4 turn at a time.
18. Repeat steps 16 and 17 using recommended nut tightening sequence illustrated below to allow even loading on sight tube.  
Note: Tighten hexagon nuts 1/4 turn at a time and only enough to give a positive seal. The maximum recommended torque on hexagon nuts is 10 inch pounds.

## Recommended Nut Tightening Sequence



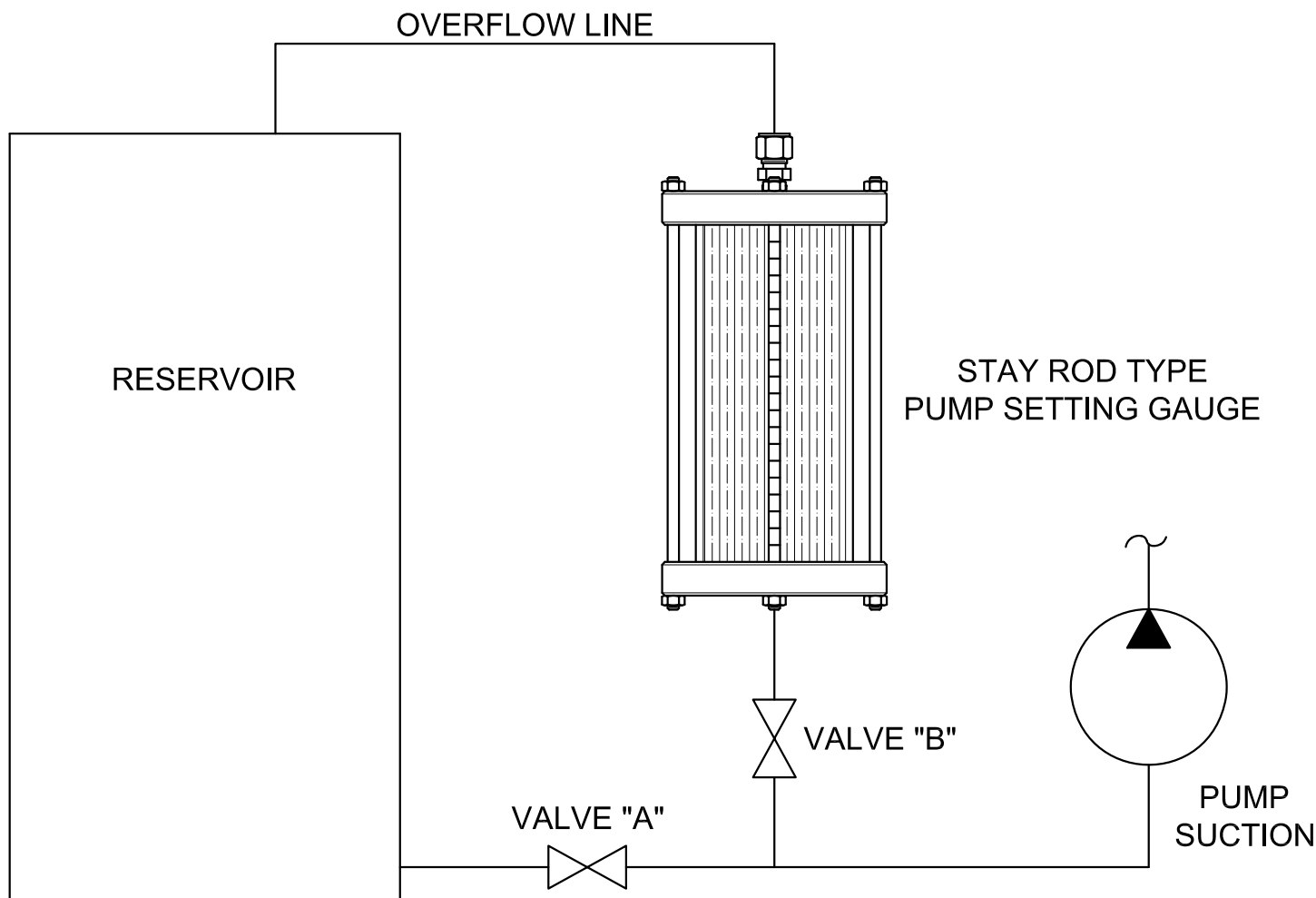
Maximum  
Recommended  
Torque:  
10 inch pounds



Typical Gauge Assembly



# 30,000 SERIES STAY ROD TYPE PUMP SETTING GAUGE INSTALLATION AND OPERATING INSTRUCTIONS



Install pipe fittings into gauge by rigidly clamping the END PLATE that is to have piping installed. Tighten the pipe fittings into the threaded connection of this END PLATE. GLASS SIGHT TUBE will BREAK if the END PLATE is not HELD RIGIDLY to eliminate any TWISTING.

**GAUGE MUST BE INSTALLED SO GRAVITY WILL FILL THE GAUGE.**

To check pumping rate, open VALVE "B" to fill the pump setting gauge. When the gauge is filled, close VALVE "A" for one minute, and note the level in the gauge at the beginning of the test and at the end of the test. Count the number of marks on the rate scale that the level dropped. This is the pump rate.



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