

## PARTS MANUAL

# Hydra-Cell<sup>®</sup>

## INDUSTRIAL PUMPS

### IMPORTANT

Record your pump model number and serial number here for easy reference:

Model No. \_\_\_\_\_

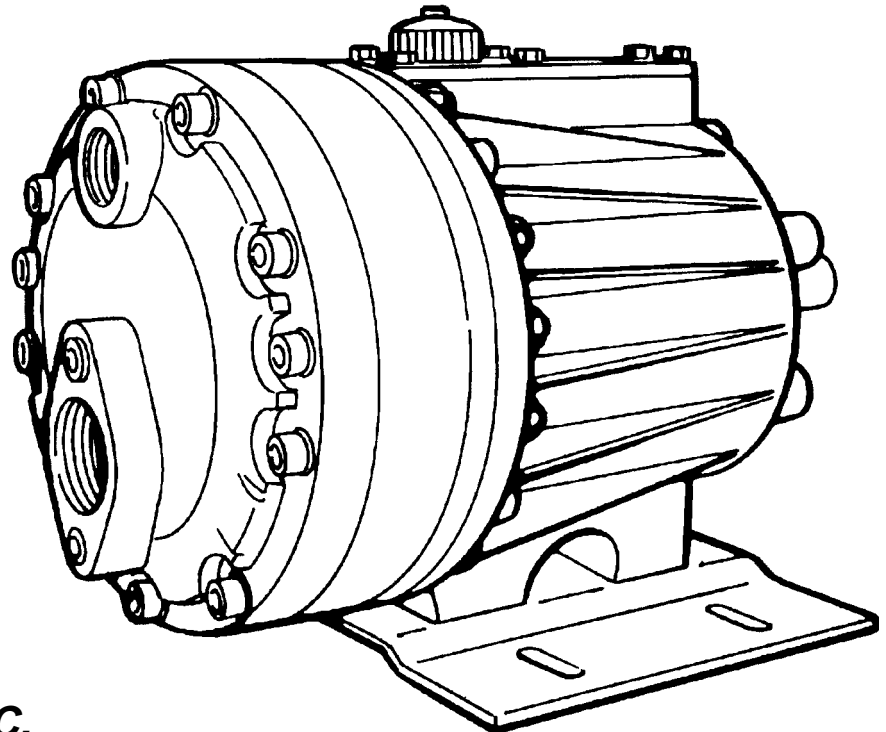
Serial No. \_\_\_\_\_

Date of Purchase \_\_\_\_\_

When ordering parts or making inquiries about this pump, please mention the model and serial numbers.

## MODEL: G-25

### WITH METALLIC PUMP HEAD



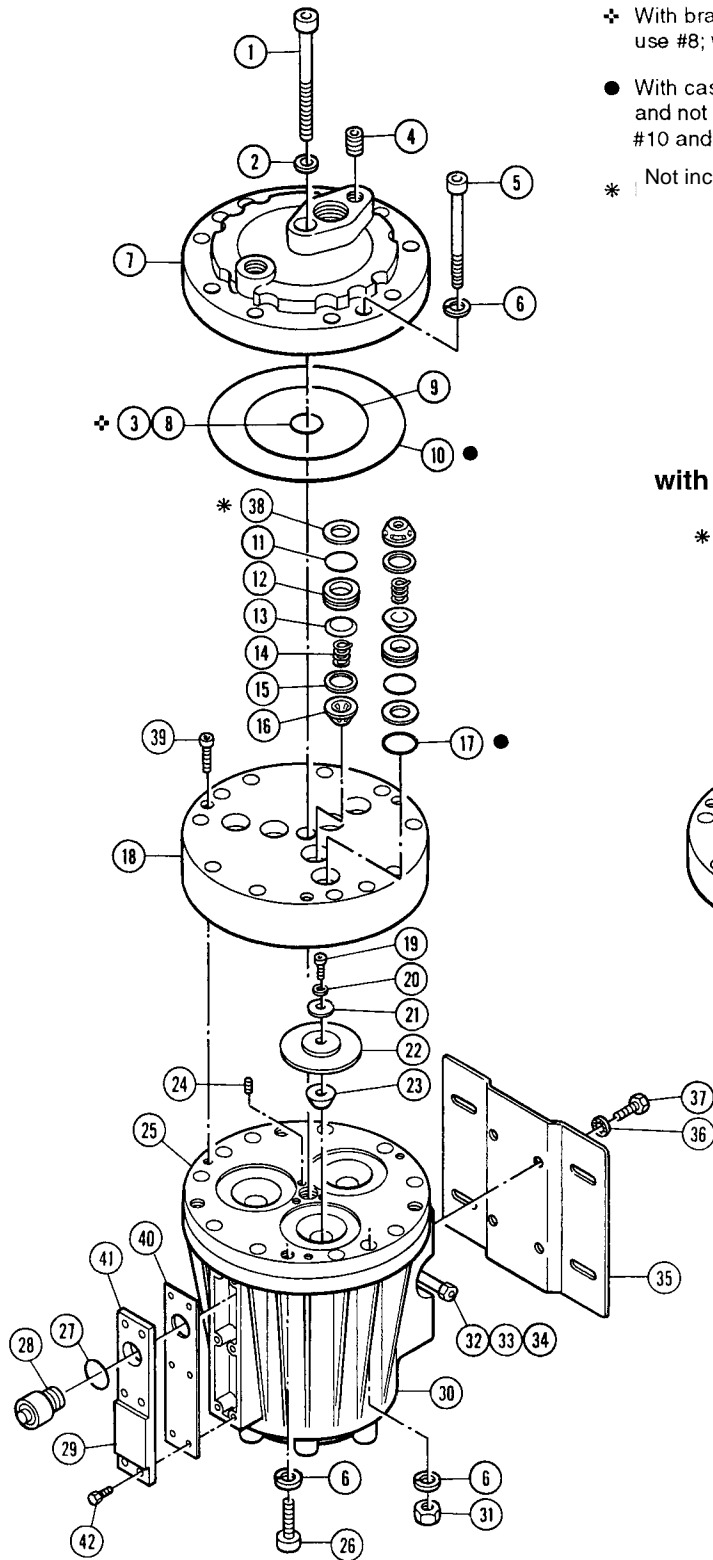
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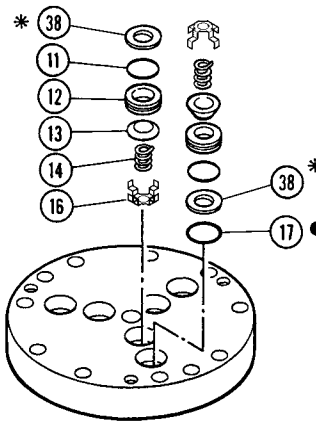
*H-25 Pumps with serial number 103200 and above have metric fasteners and a finned, diecast pump housing as illustrated above (see pages 2-3 for fluid end parts list). Pumps with serial number 103199 and below have a smooth pump housing (see pages 4-5 for fluid end parts list).*

# G-25 Fluid End (with metallic pump head)



- ❖ With brass external-centerbolt models, use #8; with all other models, use #3.
- With cast iron pump heads, use #17 and not #10; with all other heads, use #10 and not #17.
- \* Not included with brass pump heads

## Valve Assemblies with metal spring retainers



Ref #	Part Number	Description	Quantity/ Pump
1	G25-081-2045	Cap Screw, socket head, M12 x 1.25 x 114 mm	1
2	G10-084-2010	Washer, 13 cm, flat	1
3	D25-083-2110	O-ring, centerbolt, Buna <sup>1</sup>	1
	D25-083-2111	O-ring, centerbolt, Viton <sup>1</sup>	1
	D25-083-2112	O-ring, centerbolt, Neoprene <sup>1</sup>	1
	D25-083-2113	O-ring, centerbolt, EPDM <sup>1</sup>	1
	D25-083-2118	O-ring, centerbolt, Teflon <sup>1</sup>	1
4	D25-038-2017	Plug, Hastelloy C	1
	D25-038-2211	Plug, 316 SST	1
5	G25-024-2010	Cap Screw, socket-head, M10 x 1.5 x 120 mm	11
6	G25-048-2010	Washer, split-lock, M10	25
7	D25-004-1010	Manifold, brass	1
	D25-004-1022	Manifold, 316 SST	1
	D25-004-1026	Manifold, cast iron	1
	D25-004-1029	Manifold, nickel alloy, Hastelloy CW12MW	1
8	D10-083-2110	O-ring, center manifold, Buna <sup>1</sup>	1
	D10-083-2111	O-ring, center manifold, Viton <sup>1</sup>	1
	D10-083-2112	O-ring, center manifold, Neoprene <sup>1</sup>	1
	D10-083-2113	O-ring, center manifold, EPDM <sup>1</sup>	1
	D10-083-2118	O-ring, center manifold, Teflon <sup>1</sup>	1

**Note: Contact factory for pumps with Serial Numbers 103199 or below.**

# G-25 Fluid End (with metallic pump head)

Ref #	Part Number	Description	Quantity/ Pump
9	D25-073-2110	O-ring, inner manifold, Buna	1
	D25-073-2111	O-ring, inner manifold, Viton	1
	D25-073-2112	O-ring, inner manifold, Neoprene	1
	D25-073-2113	O-ring, inner manifold EPDM	1
	D25-073-2118	O-ring, inner manifold, Teflon	1
10	D25-097-2110	O-ring, outer manifold, Buna <sup>2</sup>	1
	D25-097-2111	O-ring, outer manifold, Viton <sup>2</sup>	1
	D25-097-2112	O-ring, outer manifold Neoprene <sup>2</sup>	1
	D25-097-2113	O-ring, outer manifold EPDM <sup>2</sup>	1
	D25-097-2118	O-ring, outer manifold, Teflon <sup>2</sup>	1
11	D25-035-2110	O-ring, valve seat, Buna	6
	D25-035-2111	O-ring, valve seat, Viton	6
	D25-035-2112	O-ring, valve seat, Neoprene	6
	D25-035-2113	O-ring, valve seat, EPDM	6
	D25-035-2118	O-ring valve seat, Teflon	6
12	D25-020-1010	Valve Seat, 17-4 HT SST	6
	D25-020-1012	Valve Seat, Nitronic 50	6
	D25-020-1016	Valve Seat, tungsten carbide	6
	D25-020-1017	Valve Seat, Hastelloy C	6
	D25-020-3300	Valve Seat, ceramic	6
13	D25-021-1010	Valve, 17-7 HT SST, stamped	6
	D25-021-1011	Valve, Nitronic 50	6
	D25-021-1015	Valve, 17-4 HT SST, machined	6
	D25-021-1016	Valve, tungsten carbide	6
	D25-021-1017	Valve, Hastelloy C	6
	D25-021-3300	Valve, ceramic	6
14	D25-022-3110	Valve Spring, 17-7 HT SST	6
	D25-022-3114	Valve Spring, Elgiloy	6
	D25-022-3115	Valve Spring, Hastelloy C	6
15	D25-092-2110	Tetra Seal, Buna	6
	D25-092-2111	Tetra Seal, Viton	6
	D25-092-2112	Tetra Seal, Neoprene	6
	D25-092-2113	Tetra Seal, EPDM	6
	D25-092-2118	O-ring, Teflon (not a "Tetra Seal")	6
16	D25-023-1010	Retainer, valve spring, 17-7 HT SST	6
	D25-023-1017	Retainer, valve spring, Hastelloy C	6
	D25-023-2310	Retainer, valve spring, Celcon	6
	D25-023-2316	Retainer, valve spring, Nylon	6
	D25-023-2317	Retainer, valve spring, polypropylene	6
	D25-023-2318	Retainer, valve spring, Kynar	6
17	D25-074-2110	O-ring, outlet valve, Buna <sup>2</sup>	3
	D25-074-2111	O-ring, outlet valve, Viton <sup>2</sup>	3
	D25-074-2112	O-ring, outlet valve, Neoprene <sup>2</sup>	3
	D25-074-2113	O-ring, outlet valve, EPDM <sup>2</sup>	3
	D25-074-2118	O-ring, outlet valve, Teflon <sup>2</sup>	3
18	D25-003-1010	Valve Plate, brass	1
	D25-003-1012	Valve Plate, 316 SST	1
	D25-003-1016	Valve Plate, cast iron	1
	D25-003-1029	Valve Plate, nickel alloy C series	1
19	D25-030-2010	Screw, flat-head, 5/8", 316 SST	3
	D25-030-2011	Screw, flat-head, 5/8", Hastelloy C	3
20	D25-047-2110	O-ring, follower, Buna	3
	D25-047-2111	O-ring, follower, Viton	3
	D25-047-2112	O-ring, follower, Neoprene	3
	D25-047-2113	O-ring, follower, EPDM	3
	D25-047-2118	O-ring, follower, Teflon	3
21	D25-017-1010	Follower, 316 SST	3
	D25-017-1011	Follower, Hastelloy C	3

Ref #	Part Number	Description	Quantity/ Pump
22	D25-018-2312	Diaphragm, Neoprene	3
	D25-018-2313	Diaphragm, EPDM	3
	D25-018-2315	Diaphragm, Viton-XT	3
	D25-018-2318	Diaphragm, Teflon	3
	D25-018-2320	Diaphragm, Buna-N-XS	3
23	D25-016-1010	Plunger	3
24	G25-082-2010	Set Screw, M6 x 1 x 16 mm	3
25	G25-002-1010	Cylinder Housing	1
	G25-002-1210	Cylinder Housing Assembly <sup>3</sup>	–
	K25-002-1020	Cylinder Housing, Kel-Cell	1
	K25-002-1220	Cylinder Housing Assembly, Kel-Cell <sup>3</sup>	–
	26	G10-087-2010	Cap Screw, socket-hd, M10 x 1.5 x 30 mm
27	D10-080-2110	O-ring, oil fill, Buna	1
28	D03-039-1210	Cap, oil fill (includes breather and O-ring)	1
29	D10-040-2410	Name Plate	1
30	G25-001-1218	Pump Housing Assembly <sup>4</sup>	–
	G25-001-1228	Pump Housing <sup>4</sup>	1
31	G10-028-2010	Nut, hex, M10	10
32	D25-076-2210	Elbow, 3/8"	1
33	D25-077-2210	Pipe, 3/8"	1
34	D25-078-2210	Cap, 3/8"	1
35	D25-025-1010	Base	1
36	G25-054-2010	Washer, shakeproof, M10	4
37	G10-029-2010	Cap Screw, hex-hd, M10 x 1.5 x 25 mm	4
38	D25-125-1011	Washer, dampening, 316 SST <sup>5</sup>	6
	D25-125-1017	Washer, dampening, Hastelloy C <sup>5</sup>	6
	D25-125-2310	Washer, dampening, Celcon (Delrin) <sup>5</sup>	6
	D25-125-2316	Washer, dampening, Nylon <sup>5</sup>	6
	D25-125-2317	Washer, dampening, polypropylene <sup>5</sup>	6
	D25-125-2318	Washer, dampening, Kynar <sup>5</sup>	6
39	G25-088-2010	Cap Screw, socket-hd, M6 x 1 x 45 mm	3
40	G25-106-2318	Gasket, cover	1
41	H25-105-1018	Cover, housing	1
42	G25-090-2010	Cap Screw, hex-head	6

<sup>1</sup> With brass external-centerbolt models, use Ref #8; with all other models, use Ref #3.

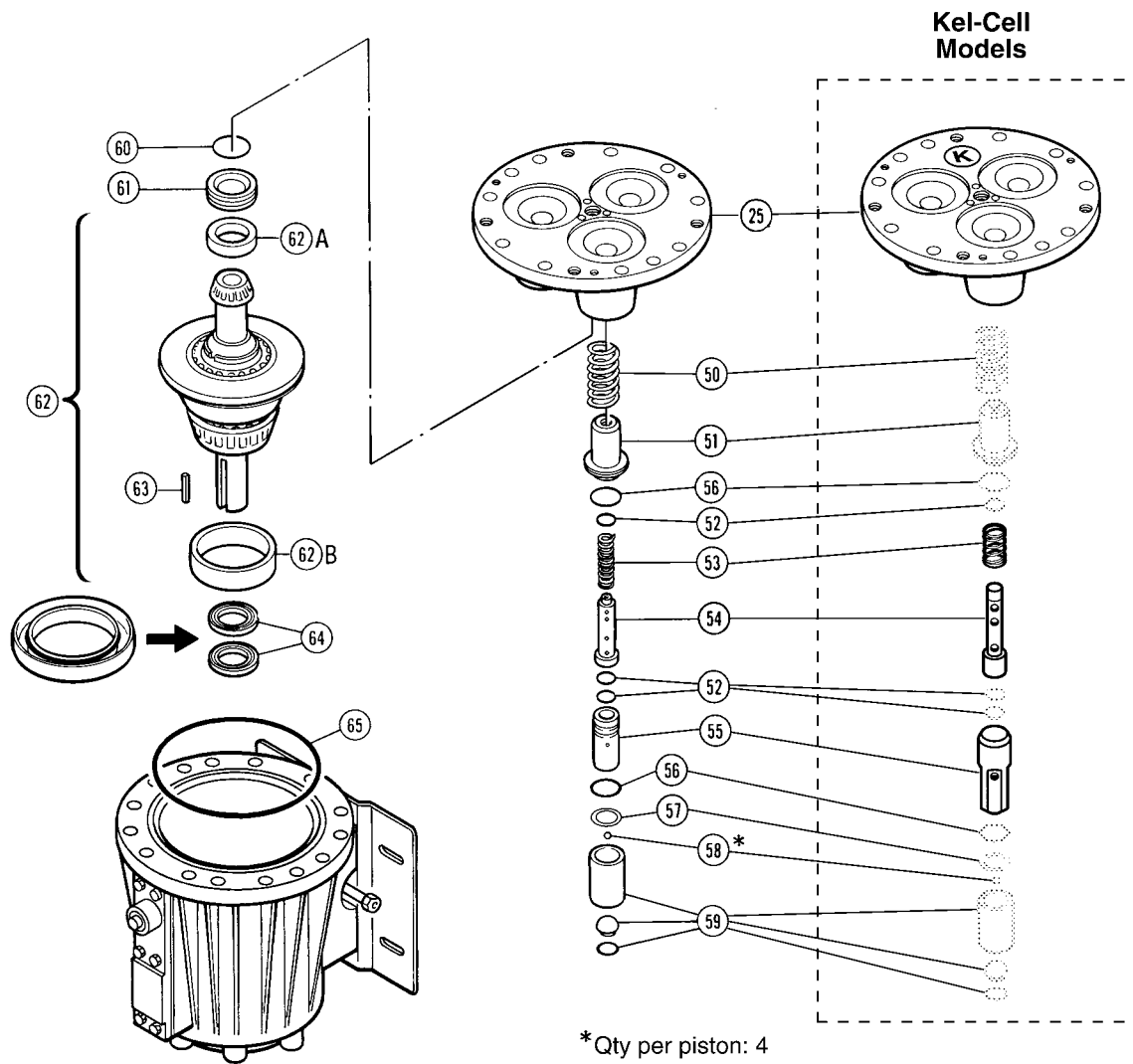
<sup>2</sup> With cast iron pump heads, use Ref #17 and not Ref #10; with all other models, use Ref #10 and not Ref # 17.

<sup>3</sup> Cylinder Housing Assembly includes housing (25), bearing adjusting plate (61), O-ring (60), screws (24), and bearing cup (62A).

<sup>4</sup> Pump Housing Assembly includes housing (30), gasket (40), cover (41), screws (42), oil drain (32, 33, 34), and bearing cup (62B).

<sup>5</sup> Not required on all pumps.

# G-25 Hydraulic End (with metallic pump head)



# G-25 Hydraulic End (with metallic pump head)

Ref #	Part Number	Description	Quantity/ Pump
50	D25-019-3111	Spring, piston return .....	3
51	D25-042-1010	Retainer, piston return spring .....	3
52	D25-046-2110	O-ring, valve cylinder, Buna .....	9
53	D25-045-3110	Spring, sleeve valve .....	3
	K25-045-3110	Spring, sleeve valve, Kel-Cell .....	3
54	D25-044-1010	Valve Plunger .....	3
	K25-044-1010	Valve Plunger, Kel-Cell .....	3
55	D25-043-1010	Cylinder, valve .....	3
	K25-043-1010	Cylinder, valve, Kel-Cell .....	3
56	D25-034-2110	O-ring, Buna .....	6
57	D25-041-1010	Washer, ball retainer .....	3
58	D25-015-3010	Ball, 1/4" .....	12
59	D25-014-1209	Piston, with foot and retainer .....	3
	D25-014-1210	Piston Assembly <sup>1</sup> .....	–
	K25-014-1210	Piston Assembly, Kel-Cell <sup>1</sup> .....	–
60	D25-075-2110	O-ring, bearing adjusting plate, Buna	1
61	D25-012-1010	Bearing Adjusting Plate .....	1
62	H25-007-1210	(X) Cam Assembly, 76 lpm @ 1050 RPM <sup>2</sup> .....	1
	H25-007-1212	(I) Cam Assembly, 44 lpm @ 1150 RPM <sup>2</sup> .....	1
	H25-007-1213	(S) Cam Assembly, 59 lpm @ 1150 RPM <sup>2</sup> .....	1
	H25-007-1214	(E) Cam Assembly, 77 lpm @ 1150 RPM <sup>2</sup> .....	1
63	D25-085-2210	Key, shaft .....	1
64	H25-031-2112	Seal, Buna, 1-1/8" .....	2
65	H25-037-2110	O-ring, pump housing, Buna, Ser. No. 100403 & above .....	1
–	D25-111-2400	Label, caution .....	1

<sup>1</sup> Piston Assembly includes cylinder, foot, valve plunger, O-rings, spring retainer, and springs (50-59).

<sup>2</sup> Cam Assembly includes cam, shaft, wobble plate, bearings, and cups. It is only available as an assembly.

# G-25 Series Replacement Parts Kits (with metallic pump head)

ORDERING INFORMATION: A Replacement Parts Kit contains 11 digits corresponding to customer-specified design options.

1	2	3	4	5	6	7	8	9	10	11
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Digit	Order Code	Description
<b>1-3</b>		<b>Pump Configuration</b>
	G25	For all G-25 Pumps
<b>4</b>		<b>Kit Designator</b>
	K	Complete Fluid End Kit
	D	Diaphragm Kit
	V	Valve Kit (diaphragm not included)
<b>5-6</b>		<b>Pump Head Version</b>
	52	Metallic Pump Head Version
<b>7</b>		<b>Diaphragm &amp; O-ring Material</b>
	E	EPDM
	G	Viton-XT
	J	Teflon®
	P	Neoprene
	T	Buna-N-XS
<b>8</b>		<b>Valve Seat Material</b>
	C	Ceramic
	D	Tungsten Carbide
	H	17-4 PH Stainless Steel
	N	Nitronic 50
	T	Hastelloy® C
	X	Not included in Diaphragm Kit
<b>9</b>		<b>Valve Material</b>
	C	Ceramic
	D	Tungsten Carbide
	F	17-7 PH Stainless Steel – Machined
	H	17-7 PH Stainless Steel – Stamped
	N	Nitronic 50
	T	Hastelloy® C
	X	Not included in Diaphragm Kit
<b>10</b>		<b>Valve Springs</b>
	E	Elgiloy®
	H	17-7 PH Stainless Steel
	T	Hastelloy® C
	X	Not included in Diaphragm Kit
<b>11</b>		<b>Valve Spring Retainers</b>
	C	Celcon
	H	17-7 PH Stainless Steel
	M	Kynar®
	P	Polypropylene
	T	Hastelloy® C
	Y	Nylon (Zytel)
	X	Not included in Diaphragm Kit

## Kit Contents

Part Number*	Description	Qty	Kit Designator		
			K	D	V
D25-018-__	Diaphragm	3	•	•	
D25-047-__	O-ring, follower	3	•	•	
D25-074-__	O-ring, outlet valve	3	•	•	•
D25-097-__	O-ring, outer manifold	1	•	•	•
D25-073-__	O-ring, inner manifold	1	•	•	•
D10-083-__	O-ring, center manifold <sup>1</sup>	1	•	•	•
D25-083-__	O-ring, center bolt <sup>2</sup>	1	•	•	•
D25-035-__	O-ring, valve seat	6	•		•
D25-020-__	Valve seat	6	•		•
D25-021-__	Valve	6	•		•
D25-022-__	Valve spring	6	•		•
D25-092-__	Tetra seal <sup>3</sup>	6	•		•
D25-023-__	Retainer, valve spring	6	•		•
A01-113-3400	Threadlocker	1	•	•	

\* Last four digits of part numbers with \_\_\_\_ refer to specific material of construction.

<sup>1</sup> D10-083 is provided for brass head only.

<sup>2</sup> D25-083 is provided for head other than brass.

<sup>3</sup> Not included with metal spring retainers.



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