



## Southwest FB1600 pump fluid end

|         |  |  |   |
|---------|--|--|---|
| 8490-2A | FLUID END ASSEMBLY: (CONSISTS OF ITEMS: 3,4,17,18,19,20,21,22,23,24,25,26,27,28,29,30,31, 34,35,36,39) | 3  |   |
| 1       | 6390YXX  | LINER (REFER TO GUIDE TO ORDERING CHART ON PG. 6 FOR TYPE (Y) AND FOR SIZE (XX)) | 3 |
| 2       | AJO-428S   | LINER SEAL (REFER TO GUIDE TO ORDERING CHART ON PG. 6 FOR TYPE AND SIZE (XX))    | 3 |
| 3       | 8490-3   | LINER WEARPLATE  | 3 |
| 4       | 2988   | WEARPLATE AND MODULE SEAL  | 6 |
| 5       | XX-BYY   | PISTON REFER TO GUIDE TO ORDERING CHART ON PG. 6 FOR SIZE (XX) AND FOR TYPE (YY) | 3 |
| 5A      | 2932   | PISTON BUSHING (FROM 1-5/8" TO 1-1/2" STRAIGHT BORE)                             | 3 |
| 6       | 568-225  | PISTON SEAL  | 3 |
| 7       | 6278-25  | PISTON ROD (WITH ELASTIC STOP NUT) *TORQUE TO 1000 FT.LBS                        | 3 |
| 8       | API-4 ESN  | PISTON ROD NUT   | 3 |
| 9       | 1290-2   | PISTON ROD CONNECTING STUD   | 3 |
| 10      | 6284-1   | SUB ROD  | 3 |
| 11      | 6274-CWY   | ROD CLAMP (WITH WATER JACKET)  | 3 |
| 11A     | 1200H30  | HOSE (1/2" X 30" WITH 1/2" MALE X 3/8" MALE CONNECTIONS)                         | 3 |

|         |   |  |    |
|---------|---|--|----|
| 11B     | 1286-CWYFP14  | PIPE (1/2" X 14" GALVANIZED AND THREADED ON ONE END)                         | 3  |
| 11C     | 4020-29   | BOLT (5/8" X 8" GRADE 8 BOLT WITH LOCK NUT AND WASHER) *TORQUE TO 150 FT.LBS | 6  |
| 12      | 1200G74   | PONY ROD   | 3  |
| 13      | SEE PAGE 6  | VALVE COMPLETE   | 6  |
| 14      | SEE PAGE 6  | VALVE INSERT   | 6  |
| 15      | SEE PAGE 6  | VALVE SPRING   | 6  |
| 16      | SEE PAGE 6  | SEAT   | 6  |
| HP-1700 | HYDRAULIC SEAT PULLER KIT COMPLETE (REFER TO TOOLS SECTION OF CATALOG FOR DETAILS.) |  |    |
| 4475-2A | SOUTHWEST HP QUICK-CHANGE VALVE COVER ASSEMBLY: (CONSIST OF ITEMS NO. 17-24)        |  | 6  |
| 17      | 4475  | THREADED FLANGE  | 6  |
| 18      | 4575  | SCREW GLAND  | 6  |
| 19      | 4675-2A   | PLUG (COMPLETE WITH VALVE GUIDE; SCREWS; AND BUSHING)                        | 6  |
| 20      | P-129   | HP VALVE COVER PLUG SEAL   | 6  |
| 21      | 4775-2R   | VALVE GUIDE (complete with bushing #4700-I)                                  | 6  |
| 22      | 4700-I  | VALVE GUIDE BUSHING  | 6  |
| 23      | 4016-99   | VALVE GUIDE SCREW  | 12 |
| 24      | 4015-2  | VALVE COVER STUD (WITH 1-1/4" HEAVY HEX NUT) * TORQUE TO 1350 FT.LBS         | 72 |
| 25      | 4016-9  | POWER END STUD (WITH 1-1/2" HEAVY HEX NUT) * TORQUE TO 2775 FT.LBS           | 18 |
| 26      | 4017-36   | LINER RETAINER FLANGE SOCKET HEAD CAP SCREW *TORQUE TO 2600 FT.LBS           | 24 |

| ITEM NO. | PART NO. | DESCRIPTION | QTY. REQ' D |
|----------|----------|-------------|-------------|
|----------|----------|-------------|-------------|

|  |           |  |    |
|--|-----------|--|----|
| 27   | 6490-3    | LINER RETAINER FLANGE  | 3  |
| 28   | 8422-3    | LINER RETAINER PILOT RING  | 3  |
| 29   | 6590-1    | LINER RETAINER NUT   | 3  |
| 30   | 4016-97   | SUCTION MODULE STUD (WITH 1-1/2" $\diamond$ #8 HEAVY HEX NUT) *TORQUE TO 2775 FT.LBS     | 18 |
| 31   | 4018-19   | SUCTION MANIFOLD CAP SCREW (WITH LOCK WASHER) *TORQUE TO 500 FT.LBS                      | 18 |
| 32   | 8590-6    | SUCTION MANIFOLD (FRONT OR SIDE INLET)   | 1  |
| 33   | 568-442   | SUCTION MANIFOLD SEAL  | 3  |
| 34   | 8490-2S   | SUCTION MODULE (STUDED ONLY)   | 3  |
| 35   | 8490-1D   | DISCHARGE MODULE (STUDED ONLY)   | 3  |
| 36   | 8488-5    | DOWEL PIN  | 6  |
| 37   | 8390-50   | DISCHARGE MANIFOLD   | 1  |
| 38   | 568-343   | DISCHARGE MANIFOLD SEAL  | 3  |
| 39   | 4017-46   | DISCHARGE MANIFOLD STUD (WITH 1-1/4" $\diamond$ #8 HEAVY HEX NUT) *TORQUE TO 1350 FT.LBS | 12 |
| THE FOLLOWING PARTS ARE USED WITH THE SOUTHWEST FB-1600 / FB-1300 HYDRAULIC LINER RETAINER |           |  |    |
| 40   | 1388XX    | LINER  | 3  |
| 41   | 2974XX    | LINER SEAL   | 3  |
| 42   | 8490-20   | LINER WEARPLATE / USE 2988 WEARPLATE GASKET SAME AS ORIGINAL                             | 3  |
| 43   | 8488-7    | SET SCREW  | 12 |
| 44   | 6588-22-2 | LINER NUT  | 3  |
| 45   | 6590-20A  | HYDRAULIC LINER RETAINER FOR THE FB-1600 / FB-1300                                       |    |

| SIZE   | FAIL-SAFE® | DUAL-DURO® | GRAYLOY® | ZIRCONIA   | RUBBER   | URETHANE   |
|--------|------------|------------|----------|------------|----------|------------|
| 4"     | 76-BFS     | 76-BDD     | 6390G-06 | 6390ZIR-06 | AJO-428S | AJO-428-SU |
| 4 1/2" | 78-BFS     | 78-BDD     | 6390G-08 | 6390ZIR-08 | AJO-428S | AJO-428-SU |
| 5"     | 81-BFS     | 81-BDD     | 6390G-1  | 6390ZIR-1  | AJO-428S | AJO-428-SU |
| 5 1/2" | 83-BFS     | 83-BDD     | 6390G-3  | 6390ZIR-3  | AJO-428S | AJO-428-SU |
| 6"     | 85-BFS     | 85-BDD     | 6390G-5  | 6390ZIR-5  | AJO-428S | AJO-428-SU |
| 6 1/2" | 87-BFS     | 87-BDD     | 6390G-7  | 6390ZIR-7  | AJO-428S | AJO-428-SU |
| 7"     | 89-BFS     | 89-BDD     | 6390G-9  | 6390ZIR-9  | AJO-428S | AJO-428-SU |

WHEN USING THE SOUTHWEST  
HYDRAULIC LINER RETAINER USE THE CHART BELOW

| SIZE   | FAIL-SAFE® | DUAL-DURO® | GRAYLOY® | ZIRCONIA   | RUBBER  | URETHANE |
|--------|------------|------------|----------|------------|---------|----------|
| 4"     | 76-BFS     | 76-BDD     | 1388G-06 | 1388ZIR-06 | 2974-06 | 2974-06U |
| 4 1/2" | 78-BFS     | 78-BDD     | 1388G-08 | 1388ZIR-08 | 2974-08 | 2974-08U |
| 5"     | 81-BFS     | 81-BDD     | 1388G-1  | 1388ZIR-1  | 2974-1  | 2974-1U  |
| 5 1/2" | 83-BFS     | 83-BDD     | 1388G-3  | 1388ZIR-3  | 2974-3  | 2974-3U  |
| 6"     | 85-BFS     | 85-BDD     | 1388G-5  | 1388ZIR-5  | 2974-5  | 2974-5U  |
| 6 1/2" | 87-BFS     | 87-BDD     | 1388G-7  | 1388ZIR-7  | 2974-7  | 2974-7U  |
| 7"     | 89-BFS     | 89-BDD     | 1388G-9  | 1388ZIR-9  | 2974-9  | 2974-9U  |

| TYPE VALVE INSERT SPRING STAINLESS SPRING SEAT<br>PULLER HEAD |             |             |             |             |             |           |
|---|-------------|-------------|-------------|-------------|-------------|-----------|
| FULL OPENING  | 777-7       | 977         | 951         | N/A         | 877-7       | SWTM-4250 |
| *DBL-ANGLE O-RING   | SWR-0500110 | SWR-0514275 | SWR-0513989 | SWR-0514785 | SWR-0509309 | SWTM-3-7T |
| *STANDARD PLATE   | SWR-0505062 | SWR-0504893 | SWR-0513988 | SWR-0514202 | SWR-0509309 | SWTM-3-7T |
| * CENTER GUIDED VALVES AND SEATS                              |             |             |             |             |             |           |