

## 1500 PSI PCDP

### “PCDP” Pollution Control Double Packed Stuffing Box Assembly Procedures

Starting with the PCDP base, make sure that all mating surface areas are clear and clean of any debris include the following locations:

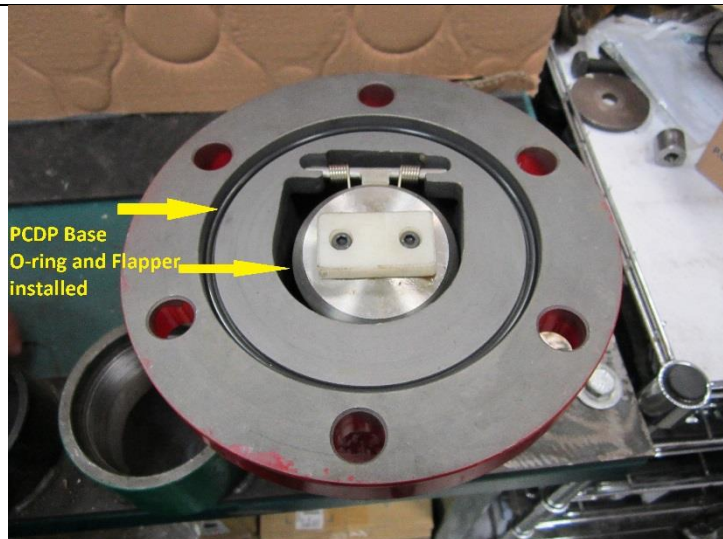
- Mating flange area
- O-ring groove
- Flapper assemble channel



Once all surface areas stated above are clean the next step is to assemble the following items:

- Lightly grease and insert o-ring into groove
- Insert flapper valve assemble  
NOTE: Make sure that the white wear pad is facing UP

Finally, recheck all surface areas stated in first step to ensure cleanliness and debris free.



Now you are ready to install the PCDP spool. Before installing the spool, complete the following:

- Make sure spool and base mating areas are free of any debris.
- Slightly grease and insert O-ring into bottom of spool.

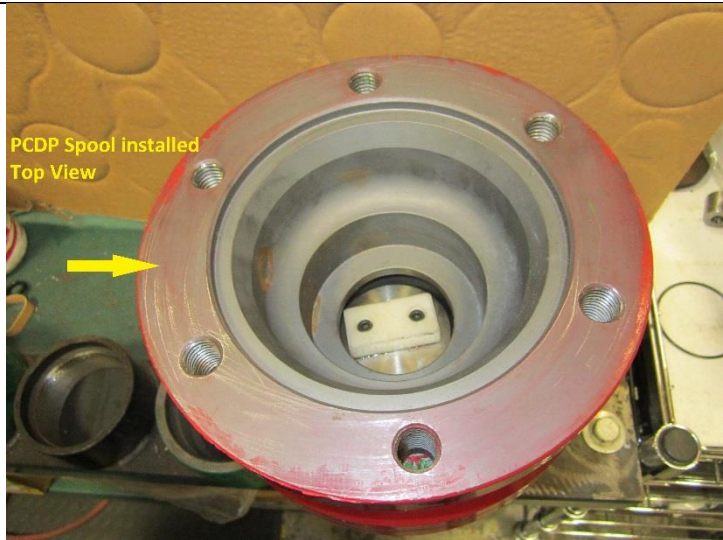


Once you have complete the above steps and aligned bolt holes, you are now ready to begin installing the following:

- 5/8" X 2" bolts (6 per)  
NOTE: As you begin to tighten the bolts, make sure that you tighten in a flange fashion by alternating sides. Tighten bolt on one side, then bolt on the opposite side. DO NOT tighten in a row around the flange, this could cause a failure in sealing between the mating components.

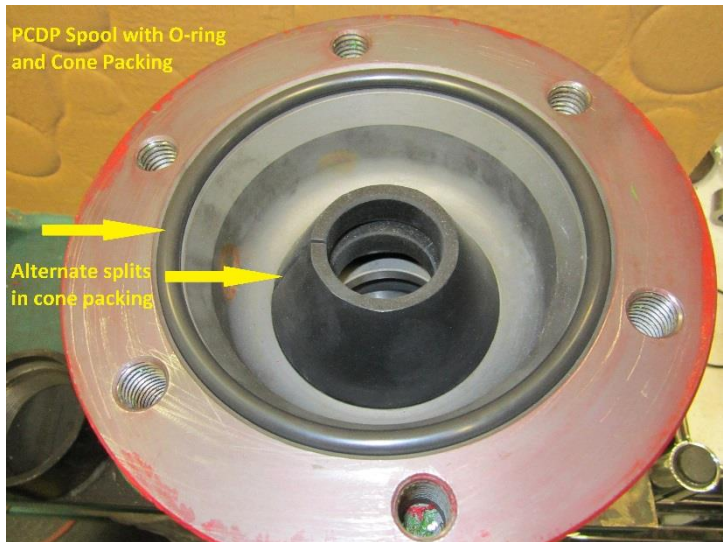


Once PCDP spool is installed you are ready to begin preparing for the body. Make sure once again to thoroughly clean flange mating area and o-ring groove of any debris to ensure a proper seal between the spool and body.



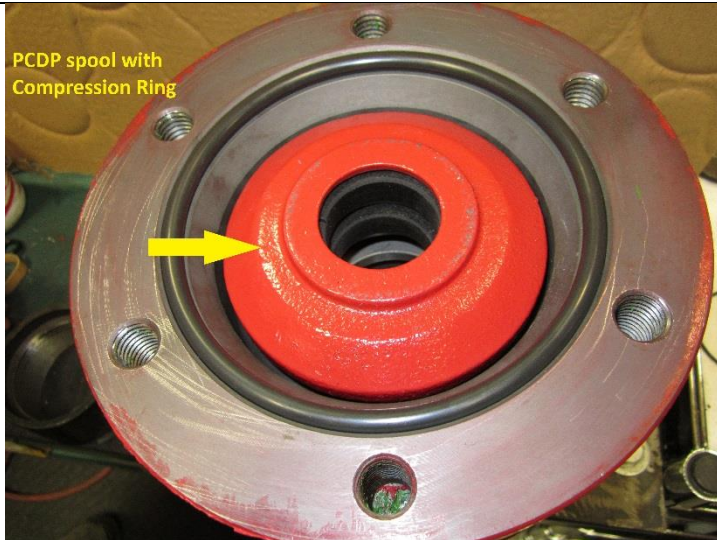
Once all areas mentioned above are cleaned and prepped, you are ready to install the following:

- Lightly grease and install PCDP spool top O-ring
- Thoroughly grease the 2 bottom cleaner cones and **make sure** to alternate splits  
NOTE: Make sure that **proper rubber and size cones** are being used per customer request (IE. HSN, Brass Filled, High Temp, Teflon, Etc.)
- The cones should fit snugly inside the machined cavity.





The next step is to install the PCDP spool compression ring. Once again, **make sure** that the proper size compression ring is installed according to customer order.



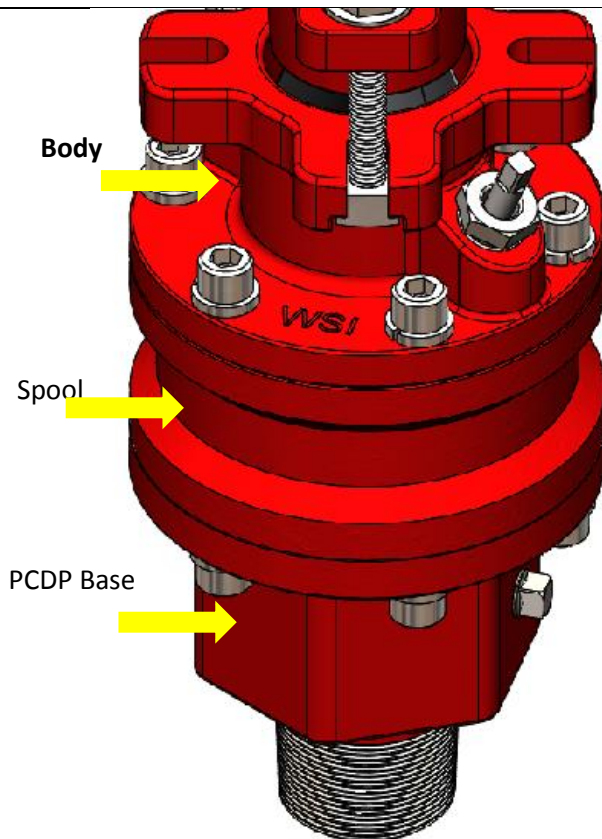
Now you are ready to install the body. Once again, make sure surface flange area top of spool and bottom of Body are clean and free of any debris before mating together.

Set body onto spool top and align bolt holes. Add the 5/8" X 1-3/4" bolts (6 per).

NOTE: As you begin to tighten the bolts, make sure that you tighten in a flange fashion by alternating sides. Tighten bolt on one side, then bolt on the opposite side. DO NOT tighten in a row around the flange, this could cause a failure in sealing between the mating components.

You have now completed the following components:

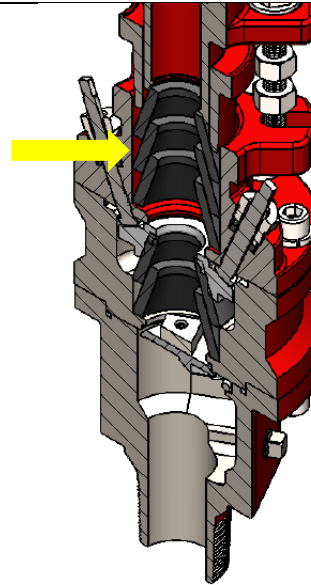
- PCDP Base
- Spool w/ Flapper Assembly
- PCDP Body



You are now ready to begin installing the packing. Make sure to follow these steps in order to ensure a proper seal between stuffing box and polished rod.

- First, **Make sure** to use proper size packing.
- Make sure to stagger the splits on the packing to avoid a leak path. There should be 3 top cones and 1 bottom cleaner cone, (4) cones total. Alternate sides of splits to ensure proper installation. In addition, make sure to thoroughly grease the packing before installing.
- If using any other type of split packing, follow above guidelines.

Packing



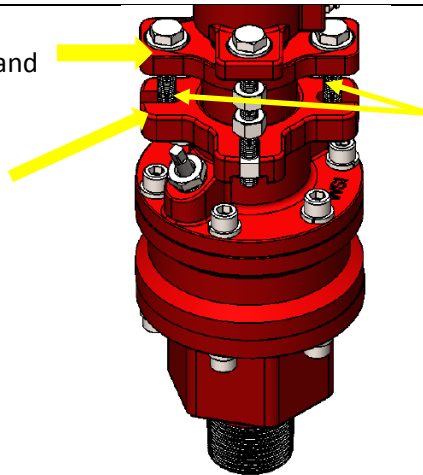
Next step is install the Lower Gland. The lower gland should set on top of last cone and fastened with bolts (5/8" X 4") from the lower gland ears to the body ears.

There should be 2 bolts with square head nuts.

Lower Gland Ears

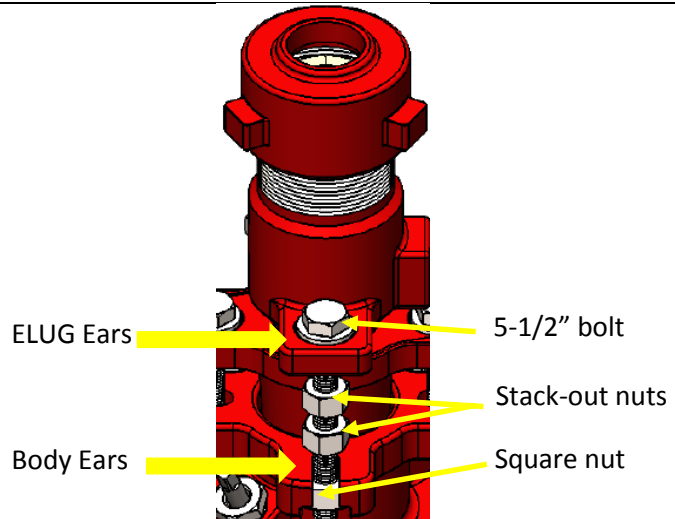
Body Ears

4" bolts



Next, install ELUG and fasten hand tight and evenly, the long bolts from the ELUG ears to the body ears.

NOTE: There should be (2) 5/8" X 5-1/2" bolts with (2) stack-out nuts and (1) square fastener nut.



Finally, install ELUG packing

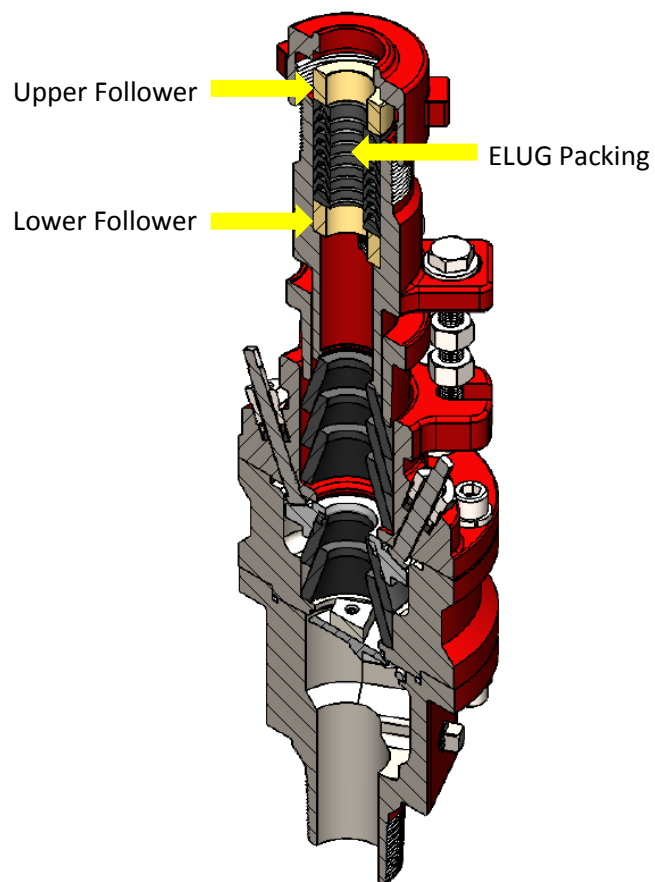
NOTE: **Make sure** to install proper size packing.

First: Insert the ELUG Lower Follower

Second: Grease and stagger each piece of ELUG packing

Third: Insert the ELUG Upper Follower

Fourth: Install top cap until it just touches the Upper Follower



Complete 1500 PSI PCDP

