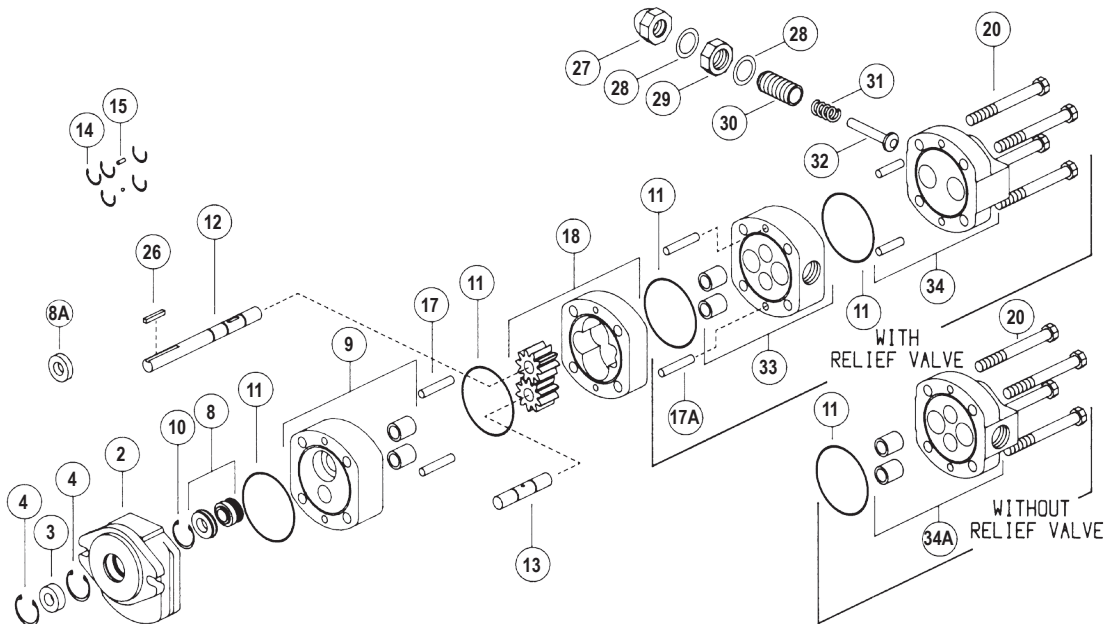




**VIKING PUMP, INC.** • A Unit of IDEX Corporation  
406 State Street • Cedar Falls, IA 50613 • Phone: 319.266.1741 • Fax: 319.273.8157  
[www.vikingpump.com](http://www.vikingpump.com)



**NOTE:** Kit may not apply to all models of these pumps. Contact your Viking Pump distributor with pump serial number for correct kit part numbers for that pump. Additional non-kit parts, such as gears and shafts, may also be required depending on wear.

ITEM	PART (may not exactly match parts list descriptions)	PART INCLUDED IN SEAL KIT	
		SERIES SG-07	SERIES SG-407
2	Bracket		
3	Ball Bearing		
4	Retaining Ring, Int. Truarc ; 2 Req'd		
8	Mechanical Seal ①		✓
8A	Lip Seal ①	✓	
9	C.W. Separation Plate & Bushings Assembly		
10	Retaining Ring, Int. Truarc		
11	O-Ring Between Sections (Quantity Based on Model) ①	✓	✓
12	Driver Shaft		
13	Driven Shaft		
14	Retaining Rings		
15	Balls & Pins Kit		
17	Dowel Pin (2-Req'd) (Bracket to Casing)		
17A	Dowel Pin - (2-Req'd) (Separation Plate to Casing)		
18	Match Ground Casing & (2) Gears Assembly		
20	Assembly Capscrew 1/2" 13NC Grade 8 - Length Dependant on Model (4 Req'd)		
26	Key, Square 3/16" x 1-1/4" Lg.	✓	✓
27	Relief Valve Adjusting Screw Cap		
28	Relief Valve Gasket (2 Req'd) ②	✓	✓
29	Relief Valve Adjusting Screw Lock Nut		
30	Relief Valve Adjusting Screw		
31	Relief Valve Spring		
32	Relief Valve Poppet		
33	Separation Plate & Bearing/Bushing Assembly		
34	Head & (2) Bearing/Bushing Assembly for Relief Valve		
34A	Plain Head & (2) Bearing/Bushing Assembly		

① Elastomers in this kit are specified in seal kit description.

② Kits include parts for Relief Valve head. Plain head pumps will not need Relief Valve gaskets. Discard extra parts.

Use seal lubricant in seal kit for installing mechanical seal.

Important safety information and rebuild instructions are found in the Technical Service Manual.

**Download current Technical Service Manuals from [www.vikingpump.com](http://www.vikingpump.com):**

TSM 340 - Installation, Startup, Troubleshooting,  
Preventative Maintenance, Do's & Don'ts  
for SG-04, SG-05 & SG-07 Spur Gear Pumps