



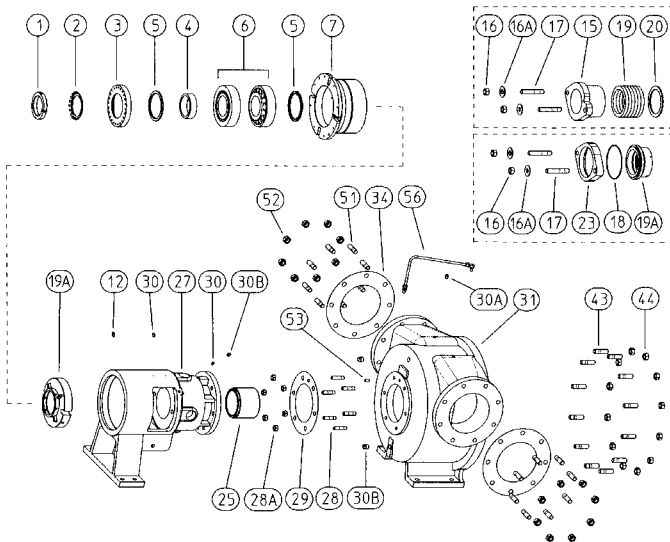
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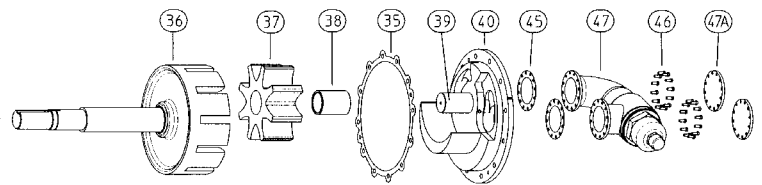
406 State Street • Cedar Falls, IA 50613 • Phone: 319.266.1741 • Fax: 319.273.8157

www.vikingpump.com

**Exploded Diagram for Series 324A/4324A, 323A/4323A, 327A/4327A, Sizes N & R**  
**PLUS (Not Pictured): Series 324E Electronically Heated Pumps, Size N.**



**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. Both a Seal Kit and a Rebuild Kit are needed to completely rebuild the pump. Additional non-kit parts, such as Rotor and Shaft Assembly, may also be required, depending on wear.



| ITEM | PART<br>(may not exactly match<br>parts list descriptions) | PART INCLUDED IN:    |                         |                |
|------|--|----------------------|-------------------------|----------------|
|      |  | SEAL KIT<br>(Packed) | SEAL KIT<br>(Mech Seal) | REBUILD<br>KIT |
| 1    | Locknut  | ✓                    | ✓                       |                |
| 2    | Lockwasher   | ✓                    | ✓                       |                |
| 3    | End Cap for Bearing Housing                                |                      |                         |                |
| 4    | Bearing Spacer Collar                                      | ✓                    | ✓                       |                |
| 5    | Lip Seal, 2 Req'd  | ✓                    | ✓                       |                |
| 6    | Roller Bearings, 2 Req'd                                   | ✓                    | ✓                       |                |
| 7    | Bearing Housing  |                      |                         |                |
| 12   | Grease Fitting (Straight)                                  |                      |                         |                |
| 15   | Packing Gland  |                      |                         |                |
| 16   | Packing/Seal Gland Nut, 2 Req'd                            | ✓                    | ✓                       |                |
| 16A  | Packing Gland Washer, 2 Req'd                              | ✓                    | ✓                       |                |
| 17   | Packing/Seal Gland Stud, 2 Req'd                           | ✓                    | ✓                       |                |
| 18   | O-ring for Seal Plate                                      |                      | ✓                       |                |
| 19   | Packing  | ✓                    |                         |                |
| 19A  | Mechanical Seal  |                      | ✓                       |                |
| 20   | Packing Retaining Washer                                   | ✓                    |                         |                |
| 23   | Seal Plate   |                      |                         |                |
| 25   | Bracket Bushing (part of 27)                               |                      |                         | ✓              |
| 27   | Jacketed Bracket and Bushing                               |                      |                         |                |
| 28   | Stud for Bracket, 6 Req'd                                  |                      |                         |                |
| 28A  | Nut for Bracket, 6 Req'd                                   |                      |                         |                |
| 29   | Bracket Gasket   | ✓                    | ✓                       |                |
| 30   | Pipe Plug, 2 Req'd   |                      |                         |                |
| 30A  | Pipe Plug, 2 Req'd   |                      |                         |                |
| 30B  | Pipe Plug  |                      |                         |                |

| ITEM       | PART<br>(may not exactly match<br>parts list descriptions) | PART INCLUDED IN:    |                         |                |
|------------|--|----------------------|-------------------------|----------------|
|            |  | SEAL KIT<br>(Packed) | SEAL KIT<br>(Mech Seal) | REBUILD<br>KIT |
| 31         | Casing   |                      |                         |                |
| 34         | Pipe Flange Gasket, 2 Req'd                                |                      |                         |                |
| 35         | Head Gasket  | ✓                    | ✓                       |                |
| 36         | Rotor and Shaft Assembly                                   |                      |                         |                |
| 37         | Idle and Bushing Assembly                                  |                      |                         | ✓              |
| 38         | Idle Bushing (part of 37)                                  |                      |                         |                |
| 39         | Idle Pin (part of 40)                                      |                      |                         |                |
| 40         | Head and Idle Pin Assembly                                 |                      |                         | ✓              |
| 43         | Stud for Head ①  |                      |                         | ✓              |
| 44         | Nut for Head ①   |                      |                         | ✓              |
| 45         | Relief Valve or Cover Plate Gaskets, 2 Req'd               | ✓                    | ✓                       |                |
| 46         | Capscrews for Relief Valve or Cover Plates ①               |                      |                         | ✓              |
| 47         | Internal Relief Valve                                      |                      |                         |                |
| 47A        | Cover Plate (For Plain Head Pump), 2 Req'd                 |                      |                         |                |
| 51         | Stud for Flanges   |                      |                         |                |
| 52         | Nut for Flanges  |                      |                         |                |
| 53         | Locating Pin   |                      |                         |                |
| 56         | Flush Line Assembly (For Packed Pump)                      |                      |                         |                |
| 56         | Suckback Line Assembly (For Mechanically Sealed Pump)      |                      |                         |                |
| not illus. | Bearing Housing Set Screws, 2 Req'd                        | ✓                    | ✓                       |                |
| not illus. | Insert used with End Cap Set Screw, 2 Req'd                | ✓                    | ✓                       |                |
| not illus. | End Cap Set Screws, 2 Req'd                                | ✓                    | ✓                       |                |

① Quantity of Capscrews depends on pump size.

Use Seal Lubricant in Seal Kit for installing mechanical seal and O-rings.

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

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

TSM 000 – Installation, Startup, Troubleshooting, Preventative Maintenance, Do's &amp; Don'ts

TSM 630.3 – Universal Seal Heavy Duty Pumps, Series 323A/4323A, 324A/4324A, 327A/4327A Sizes N, R, RS