



Specialist for Pumping Technology

Session 47 – New Development in the VS6 Pump Market

Simon Smith February 2026



Presenter Profile – Simon Smith

Simon graduated with an honours degree in Chemical Engineering from the University of Surrey in 1978 and began a long career in the engineered pump industry spanning 45 years (so far!) with Peerless Pump, BW/IP International / Flowserve, SPP Pumps, Ruhrpumpen and Ebara Cryodynamics.

Over his long career he has filled various roles as Applications Engineer / Manager, Project Manager, Key Account Specialist, Vertical Pump Product Specialist, International Sales Engineer / Manager / Director and he has considerable experience in Training & Mentoring young engineers.





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- No 27 – The Importance of System Curves
- No 28 – NPSH & Nss Made Simple
- No 29 – Curve Shape, Head Rise & Allowable Tolerances
- No 30 – Selecting the Right Pump for the Application
- No 31 - Comparison of API610 12th & 11th Editions
- No 32 - Pump Instrumentation
- No 33 - Handling Viscous Fluids with Centrifugal Pumps
- No 34 - Fire Pumps for the Oil & Gas Industries
- No 35 - Vertical Sump Pumps (Type VS4)
- No 36 - Engineered Systems
- No 37 - BB5 Double Case Barrel Pumps
- No 38 - Start-Up, Commissioning & Trouble Shooting
- No 39 – Positive Displacement Pumps
- No 40 – Vertical Pumps Part 1 VS1,2,3
- No 41 – Vertical Pumps Part 2 VS4,5,6,7
- No 42 & 43 – Performance Testing & Inspection of API610 Pumps
- No 44 – Non-Destructive Examination
- No 45 – Customer Specification Requirements
- No 46 – Engineering Analyses for Pumps

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SHORT COURSE 44

Non-Destructive Examination

- Full session
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SHORT COURSE 45

Customer Specification Requirements

- Full session
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- Q&A Report

SHORT COURSE 46

Engineering Analyses

- Full session
- Download presentation
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Session 47 – New Developments in the VS6 Market (vertical double case pumps for low NPSH service)

Vertical pumps, especially VS6 pumps, are among the least well understood pump types among rotating equipment engineers, mainly because they are not as frequently used as their horizontal brothers. This short course will revisit VS6 & VS1 pumps in API610 hydrocarbon applications and introduce an exciting new development in this market segment.

Aimed at Process and Mechanical Engineers, and Consultant Engineers who specify pumping equipment as well as Applications & Sales Engineers selecting and quoting them



Pump Type VS6
“Double Casing, Diffuser Type,
Vertical Suspended” Pumps
“Canned Suction” Pumps
“Vertical Barrel” Pumps

When Does Cavitation Start?



Abhijeet Patil • 2nd

Mechanical Engineer | Rotating Equipment | API 617/6...

1w • 🌐

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LinkedIn Poll: Cavitation in Pumps – When does it REALLY start?

Greetings to all rotating equipment professionals,

A common question that comes up in pump design and troubleshooting:

👉 When does cavitation actually start in a centrifugal pump?

We often use NPSHr (3% head drop) as a reference point — but is that really the onset of cavitation?

Cast your vote 👉

📌 Hint: NPSHr is defined based on performance — not bubble formation.

I'll share my view and references after the poll closes.

Looking forward to insights from field, test lab, and design experience.

#Cavitation #Pumps #NPSH #RotatingEquipment #API610

#ReliabilityEngineering #Hydra

When does cavitation actually start in a centrifugal pump?

The author can see how you vote. [Learn more](#)

at NPSHA = NPSHR(3% head drop) 19%

NPSHA > NPSHR (by some margin) 12%

NPSHA < NPSHR 51%

Well before NPSHr(2-5 times) 19%

59 votes • Poll closed



NPSH_R - Onset of Cavitation

Common Misconception

"Suction cavitation occurs when NPSHa (available) is less than NPSHr (required)."

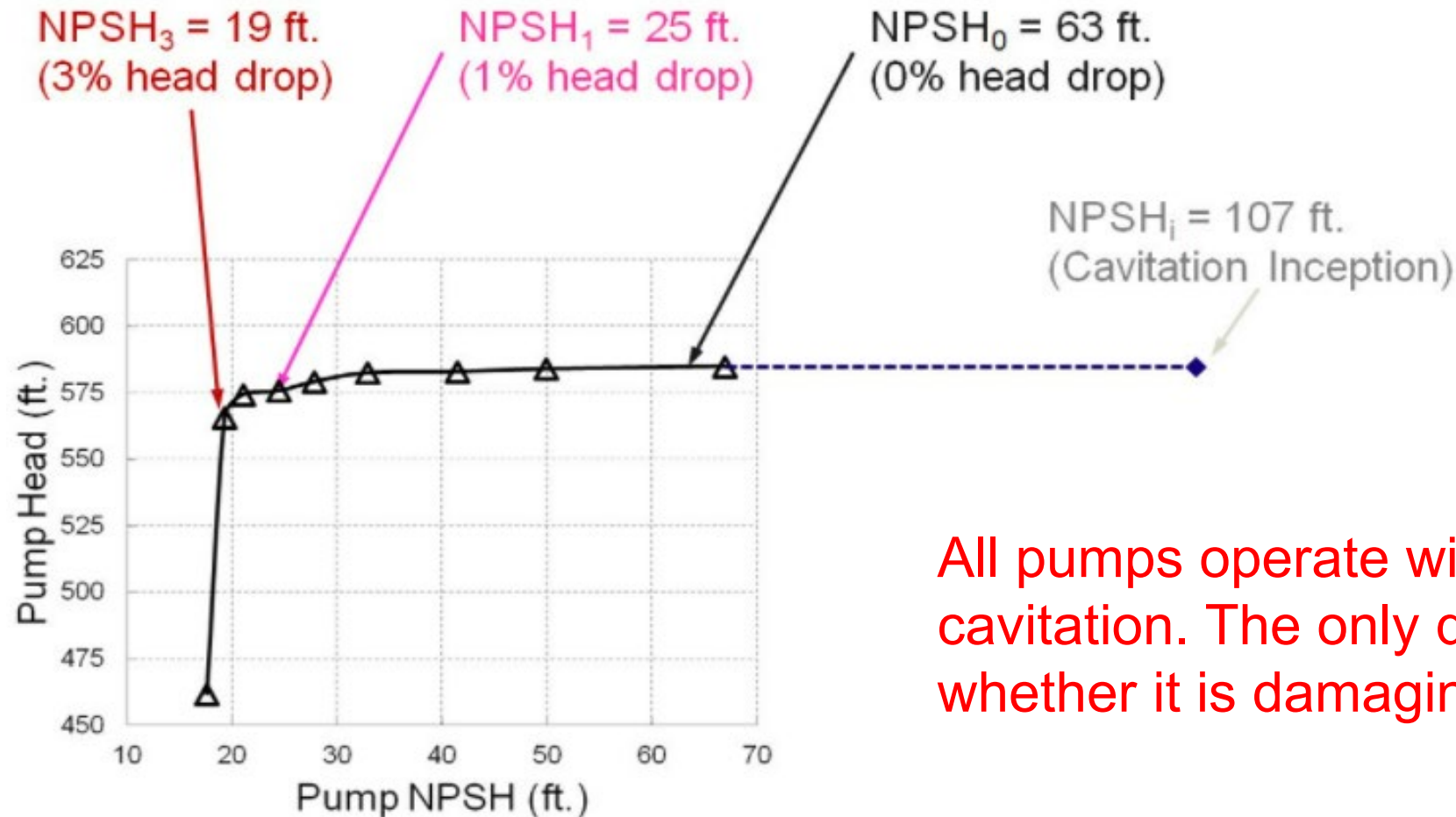
This is completely **wrong** and a misunderstanding of the physics involved in a centrifugal pump. Here is why:

- Consider that NPSH_r is normally determined where the pump head has already degraded by 3%. By that point there is already extensively developed cavitation in the impeller.
- Simply raising NPSH_a slightly above NPSH_r does not result in that cavitation magically disappearing. You need to go to much higher suction pressures to completely eliminate cavitation.
- For an "average" centrifugal pump, to **completely** eliminate cavitation, the NPSH_a would need to be >500% of the NPSH_r (specifically the NPSH_i point shown on the example below).

Source – Simon Bradshaw - Director Engineering, Pumps Americas at CIRCOR

NPSH_R

Onset of Cavitation



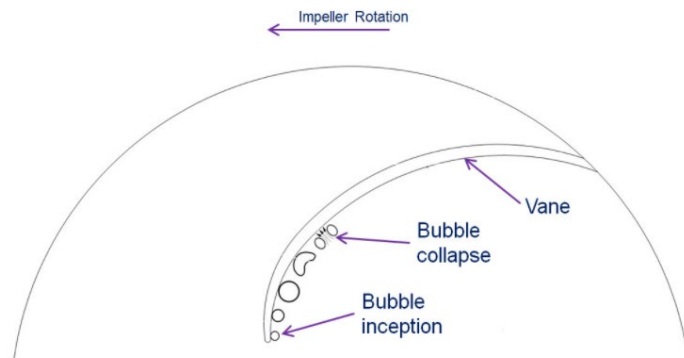
All pumps operate with suction cavitation. The only question is whether it is damaging cavitation.

Cavitation

As the suction head value gets closer to the NPSH_3 value, vapour bubbles form on the underside of the inlet vanes of the impeller.

The closer you get to the NPSH_3 value the more bubbles will form and over a larger area of vane.

As these bubbles are swept into higher pressure areas they collapse with a shock



Cavitation

The Cavitation Mechanism

When a Cavitation vapour bubble collapses, the instantaneous pressure of this small, high energy shock-wave is many thousands of PSI over an extremely small area.

There are two progressive shock waves that impact the metal surface against the bubbles:-

The initial MICRO-JET formed when the top surface of the bubble starts to collapse.

Immediately after this micro-jet, the whole surface of the bubble then collapses & returns to liquid form.

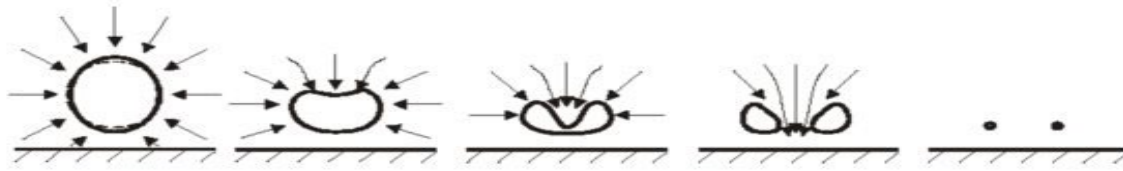
Shock waves are formed by collisions among the surrounding liquid molecules, that rush in to fill the void caused by the collapsing bubble.

Research has shown that the life span of a Cavitation bubble from formation to collapse, is about two milliseconds (two one-thousands of a second), so this event occurs very rapidly.

The more rapidly the surrounding Liquid collides, the greater is the energy of the damaging shock-wave & micro-jet.

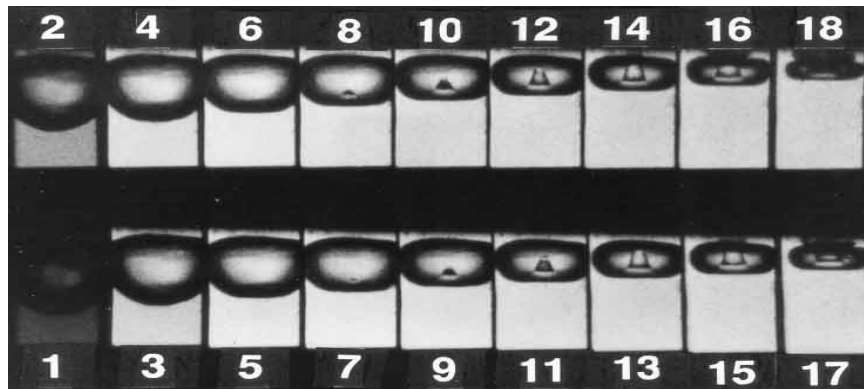
Cavitation

The Cavitation Mechanism



This illustration shows the progression of the vapor bubble collapse.

These ultra-high speed Laboratory photos below show this progression:-



Below is a photo showing the micro-burst jet, just before the final collapse:-





Cavitation

Extent of the Damage

The extent of the damage will depend on several factors:

- The size of the bubbles formed
- The Density of the fluid
- Thermodynamic effects (Enthalpy & Latent heat)

These combined effects comprise “Thermal Cavitation Criteria –B” (see next slide)

But simply put:

- Cold water forms big bubbles and has a high density, so the damage done when the bubbles collapse is high
- Hydrocarbons form small bubbles and have a lower density, so the damage done when the bubbles collapse is much less



Cavitation

Extent of the Damage – in More Detail

COMPARITIVE VALUES OF THE THERMAL CAVITATION CRITERIA-B:-

Below we show a list of the various **THERMAL CAVITATION CRITERIA-B** values for Water which exhibits high cavitation damage, and Butane, a light hydrocarbon, which usually exhibits a much lower cavitation damage rate.

<u>Thermal Cavitation</u>	Water	Water	Water	Water	Butane
<u>Criteria B</u>	<u>70F</u>	<u>180F</u>	<u>212F</u>	<u>300F</u>	<u>70F</u>
<u>Value of B</u>	253	1.048	0.324	0.0223	0.0202

This shows why one of the worst liquids to produce damaging cavitation erosion is COLD WATER. As this has a very high ratio of vapour to liquid and a high density (relative to hydrocarbons which increases the kinetic energy of the cavitation micro-jet causing the erosion damage.



Pump Type VS6
“Double Casing, Diffuser Type,
Vertical Suspended” Pumps
“Canned Suction” Pumps
“Vertical Barrel” Pumps

VS6 Pumps – Zero NPSH_R

The Spacesaver and Costsaver

Works on the basis that if you have 0m NPSHA at Grade, then 3m down you have 3m NPSHA

So we make the pump long enough, by putting in spool pieces as necessary to position the first impeller low enough to give you sufficient NPSH margin.

- Not just an NPSH saver but a space saver too. Around 20% of the floorspace of the equivalent BB2
- And a cost saver too. Less expensive than the equivalent BB2
- One seal, one sealing system
- Once you can persuade your civil engineers to dig a hole you are saving all the way.

0 m NPSH_A

3 m NPSH_A

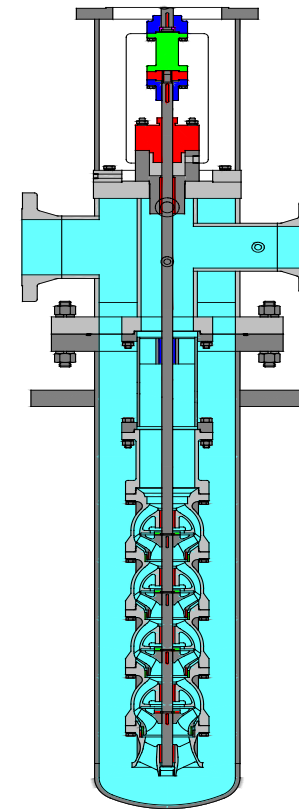
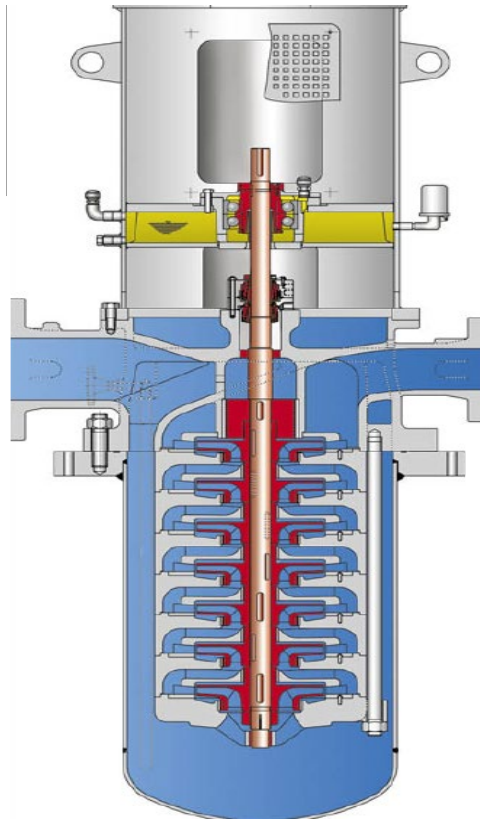




SECTIONAL OF RADIAL VS FRANCIS VANE

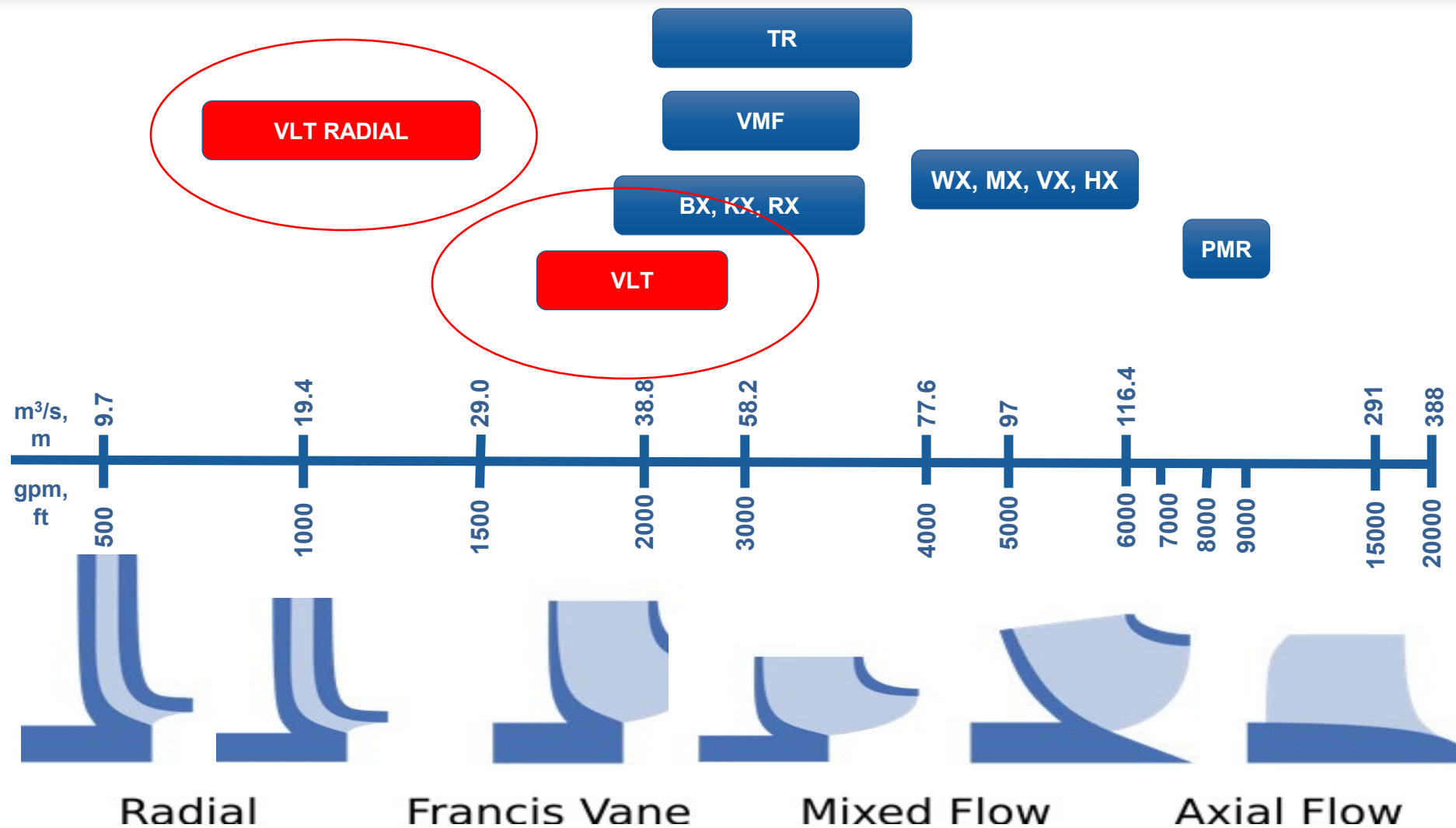
Note the difference between 'flat' appearance of radial design "VLT-Radial" model (low flow, high head)

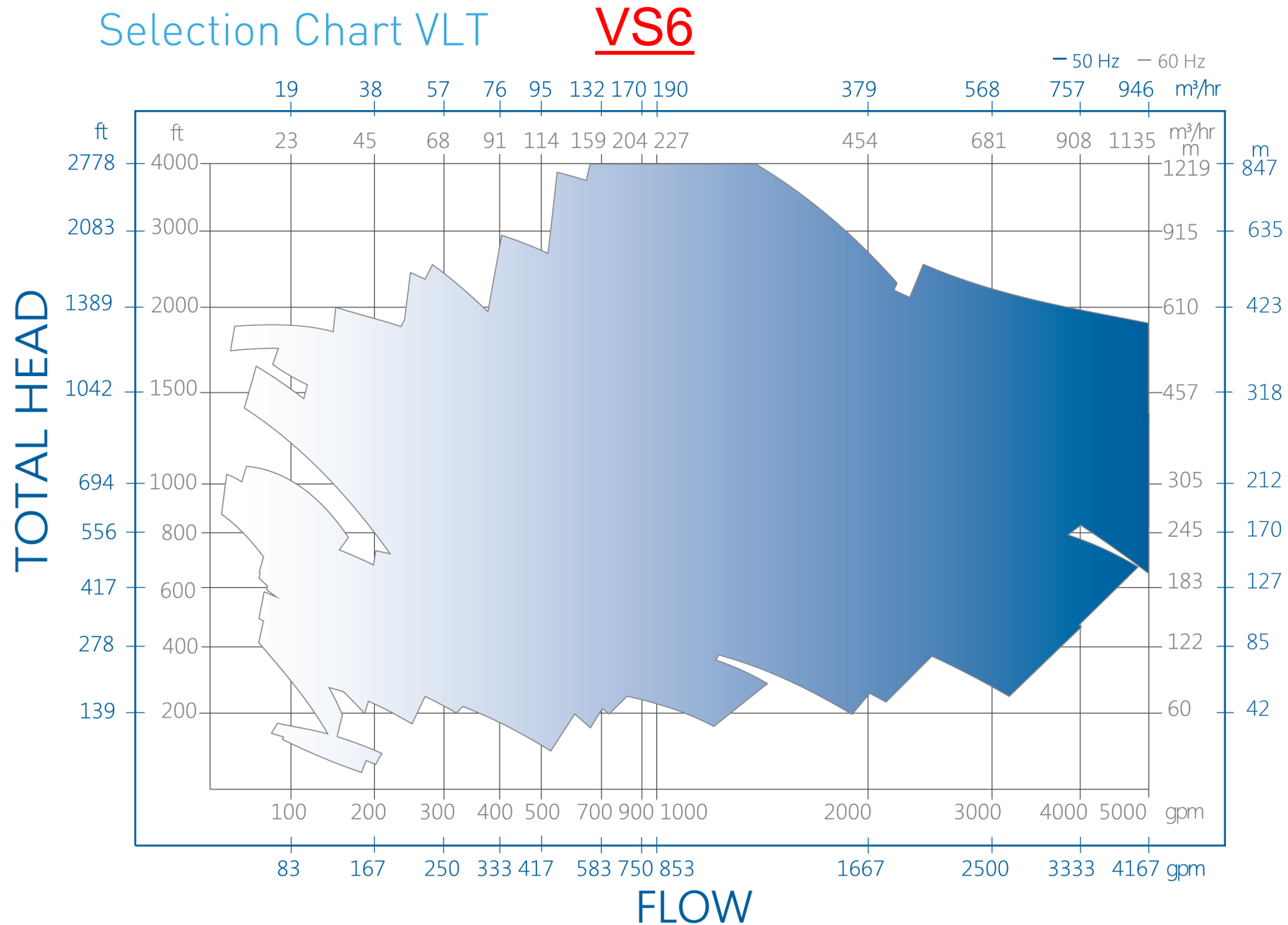
... compared with curved Francis Vane design of "VLT" model





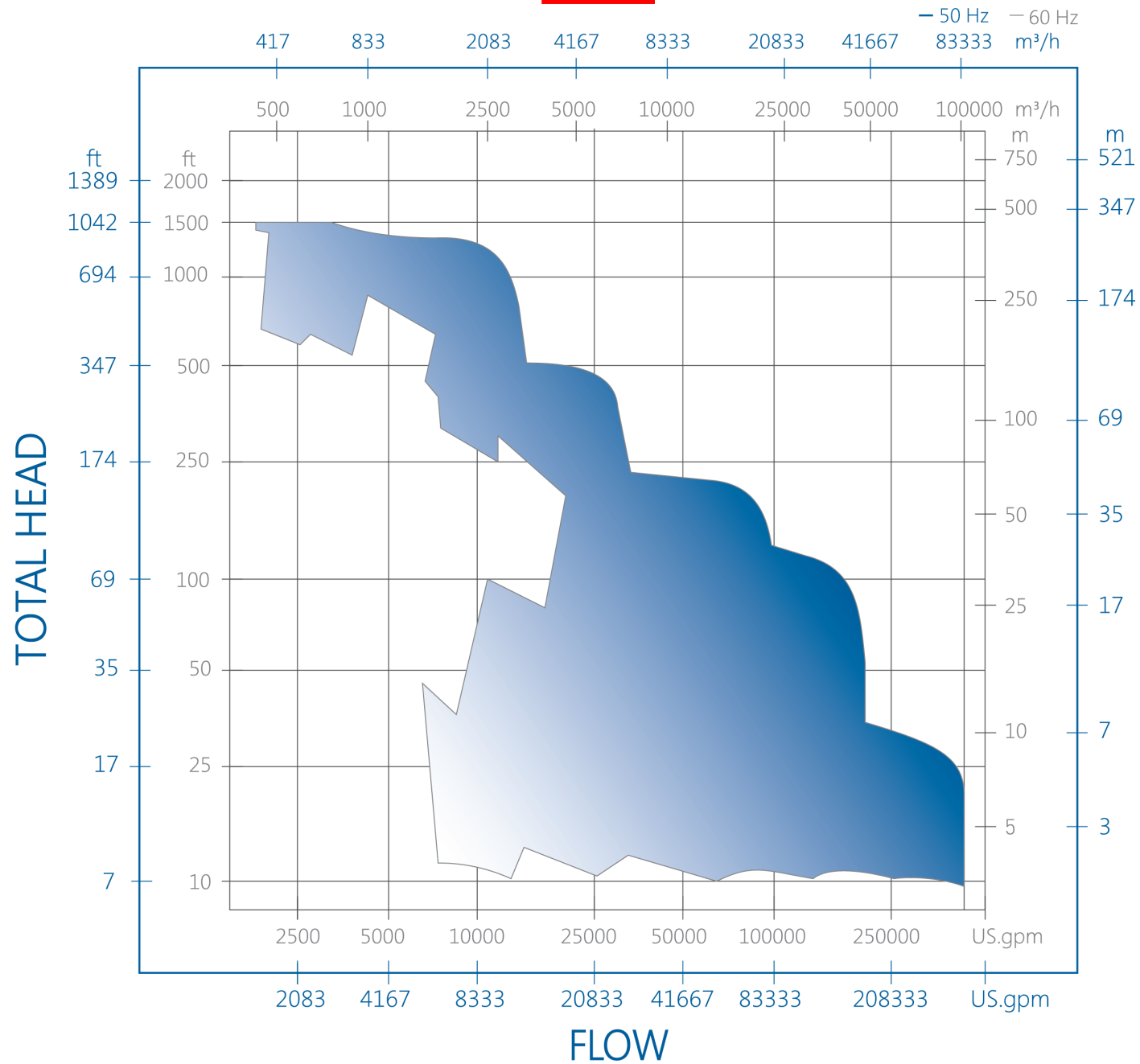
SPECIFIC SPEED, N_s







Selection Chart VMT VS6

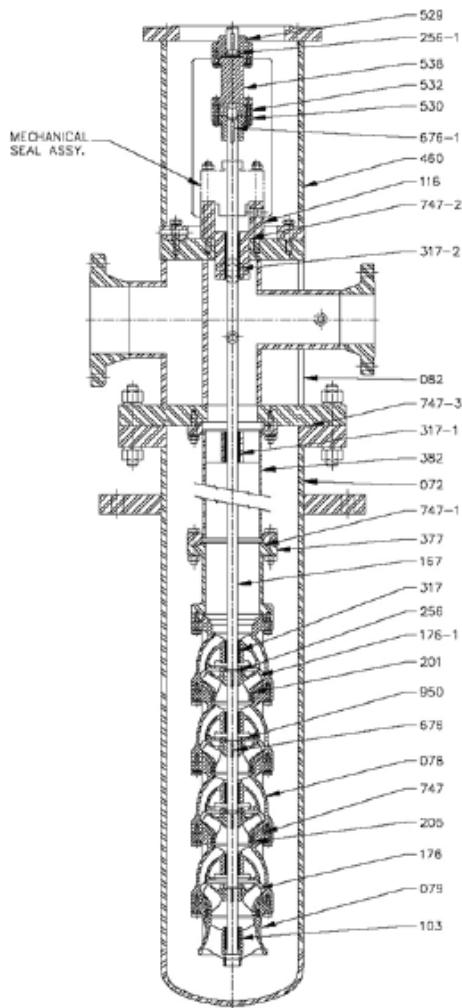




CONFIGURATION AND MOUNTING OPTIONS



SH (SUCTION IN HEAD)

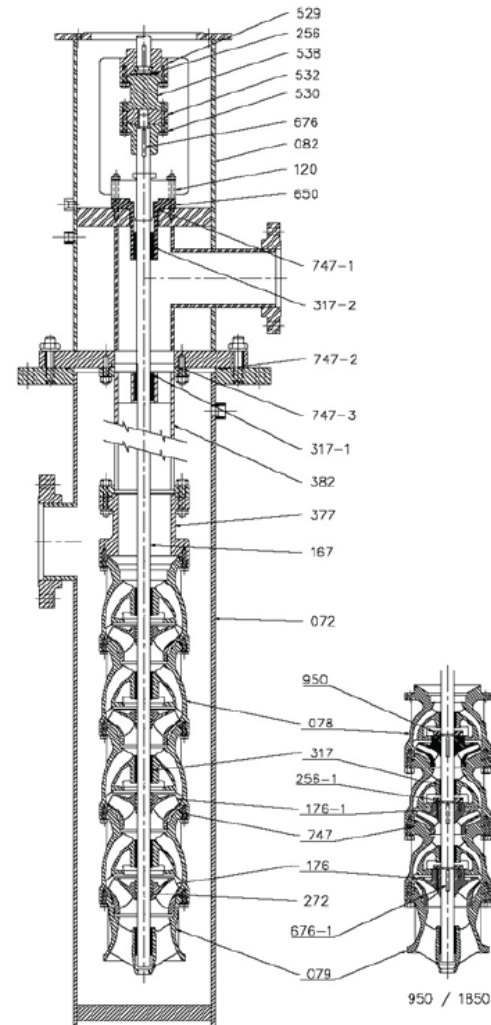


REFERENCE NUMBER	PART DESCRIPTION
072	CAN
078	CASE, SERIES
079	CASE, BOTTOM
082	NOZZLE HEAD
103	BEARING, CASE, BOTTOM
116	SEAL CHAMBER
167	SHAFT, PUMP
176	IMPELLER, 1ST STAGE
176-1	IMPELLER, SERIES
201	WEAR RING, IMPELLER
205	WEAR RING, CASE
256	RING, SPLIT, IMPELLER
256-1	RING, SPLIT, COUPLING
317	BEARING, CASE, SERIES
317-1	BEARING, COLUMN
317-2	BEARING, SEAL CHAMBER
377	FLANGE, CASE, TOP
382	COLUMN, SPOOL
460	SUPPORT, DRIVER
529	COUPLING, DRIVER
530	COUPLING, PUMP
532	PLATE, ADJUSTING
538	COUPLING, SPACER
676	KEY, IMPELLER
676-1	KEY, COUPLING
747	O-RING, CASE
747-1	O-RING, COLUMN
747-2	O-RING, SEAL CHAMBER
747-3	O-RING, BARREL
950	GUARD, RING, RETAINING

NOTE: S-1 Bowls have integrally cast impeller wear rings as Standard.



SB (SUCTION IN CAN)



REFERENCE NUMBER	PART DESCRIPTION
072	CAN
078*	CASE, SERIES
079	CASE, BOTTOM
082	NOZZLE HEAD
120*	SEAL, CRTG
167*	SHAFT, PUMP
176*	IMPELLER, 1ST STAGE
176-1*	IMPELLER, SERIES
256	RING, SPLIT, COUPLING
256-1	RING, SPLIT, IMPELLER
272	COLLER, LOCK
317*	BEARING, CASE
317-1*	BEARING, COLUMN
317-2*	BEARING, STUFFING BOX
377	FLANGE, CASE, TOP
382	COLUMN, SPOOL
529	COUPLING, DRIVER
530	COUPLING, PUMP
532	PLATE, ADJUSTING
538	COUPLING, SPACER
650	HOUSING, BEARING
676	KEY, COUPLING
676-1	KEY, IMPELLER
747*	O-RING, CASE
747-1*	O-RING STUFFING BOX
747-2*	O-RING, BARREL
747-3*	O-RING, COLUMN
950	GUARD, RING, RTNG

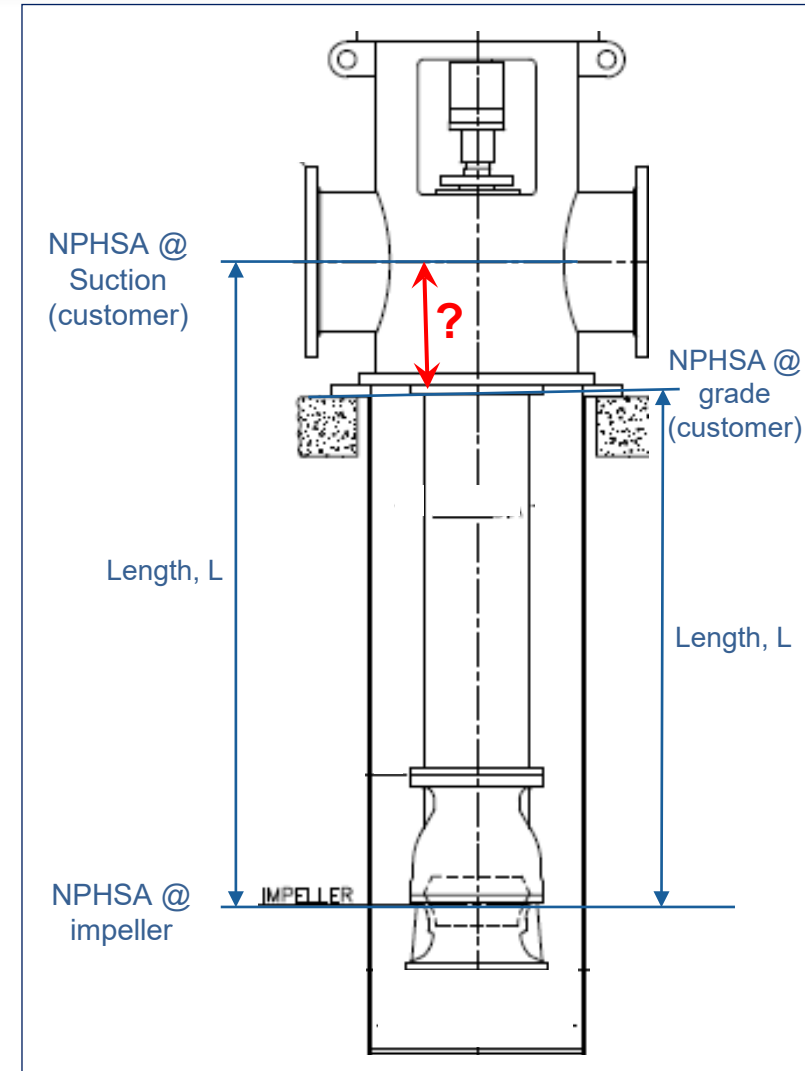
* Recommended Spare Parts

1. IMPACT OF NPSH (SUCTION IN HEAD)

- NPSH Available must be stated by the customer
- We can assume head/can is always full of fluid
- Vendor should ensure that it's clear what is the reference level of customer NPSHA. Often stated @ pump suction flange or @ grade. When stated @ suction flange vendor should check with customer what is the assumed height of pump suction from grade. This ensure we are 100% clear on the actual submergence over the impeller

$$NPSHA @ \text{Impeller} = NPSHA \text{ customer} + L$$

- If NPSHA @ Impeller is still not sufficient - lengthen the pump with column pipe to increase L
- NPSHR of pump defined by 1st stage only
- Once 'L' is known then total can length can be calculated

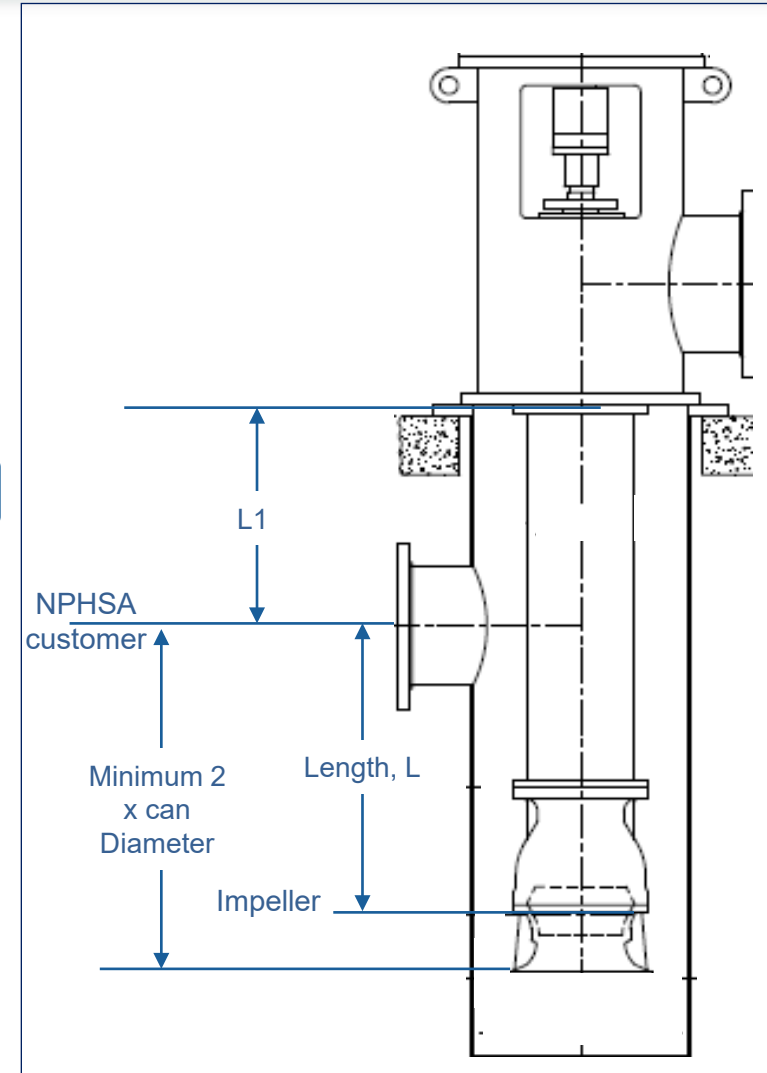


1. IMPACT OF NPSH (SUCTION IN CAN)

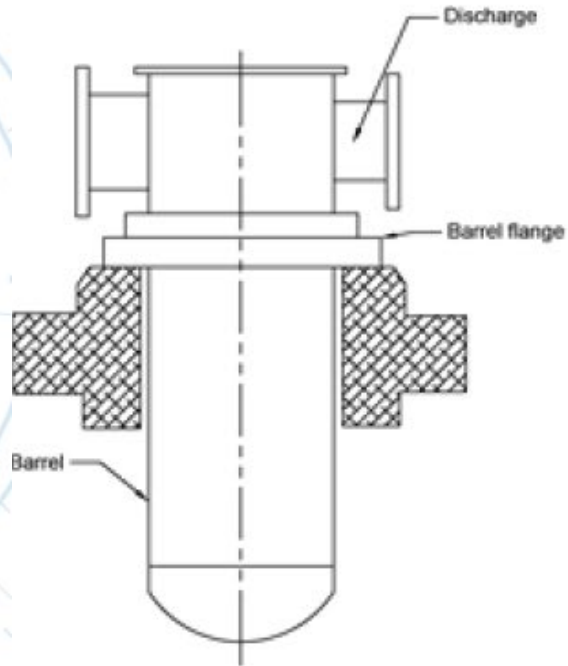
- With suction-in-can the situation is different
- Minimum distance of 2 can diameters must be considered for distance from CL of suction-in-can to inlet of pump
- Vendor shall ensure that it's clear what is the reference level of customer NPSHA and correct to CL suction if necessary

$$NPSHA @ \text{Impeller} = NPSHA \text{ customer} @ \text{CL Suction} + L$$

- If NPSHA @ Impeller is still not sufficient then lengthen the pump with column pipe to increase L. Suction flange remains on same elevation
- Can is likely to be full above CL suction during operation, but we do not assume it. Also there is usually some turbulence on the open surface of the fluid so we do not consider L1 for NPSH purposes
- Once 'L' is known then total can length can be calculated

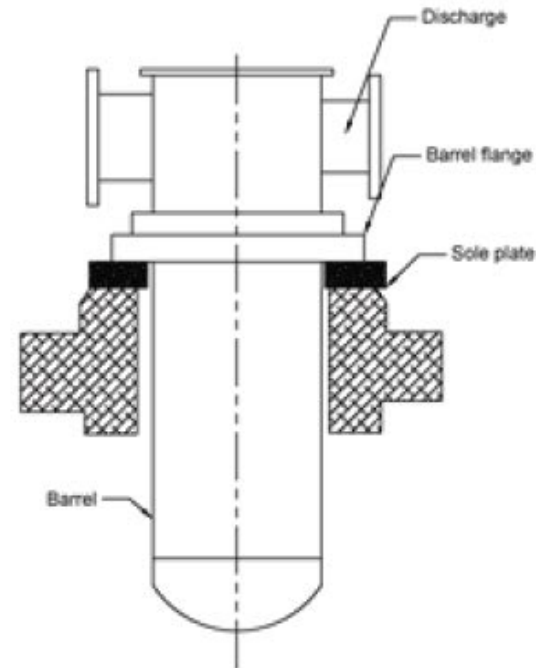


MOUNTING OPTIONS



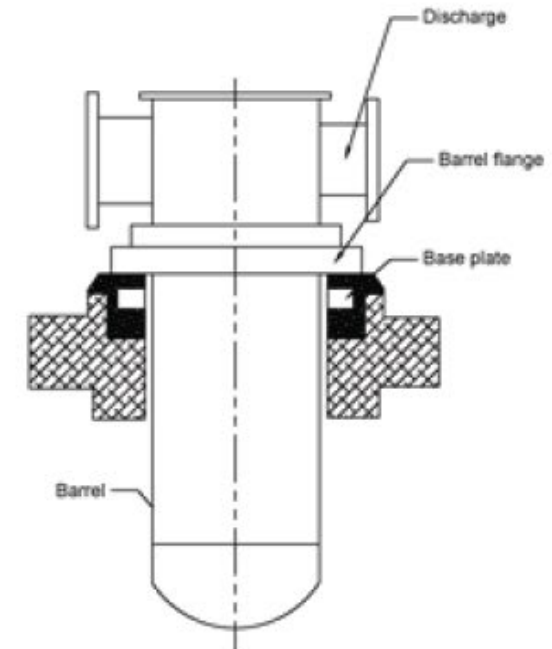
Standard Design

One flange at the barrel
Barrel directly mounted on the foundation



Standard Design with Sole Plate

One flange at the barrel
Barrel mounted on the sole plate
Sole plate mounted and adjusted on the foundation

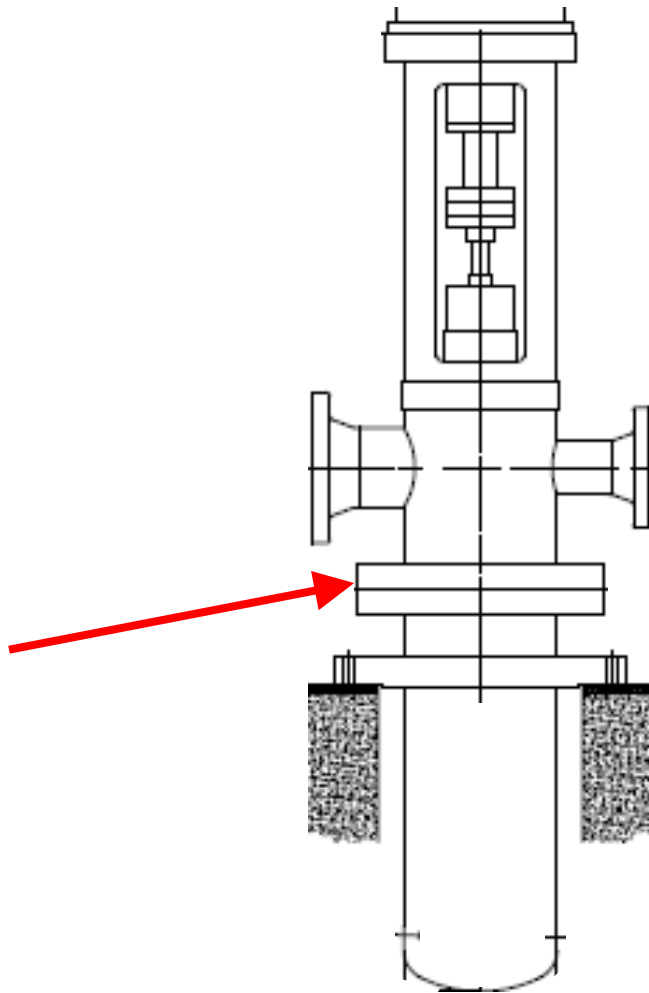


Standard Design with Base Plate

One flange on the barrel
Barrel mounted on the base plate
Base plate mounted and adjusted in the foundation Grouted with concrete



MOUNTING OPTIONS

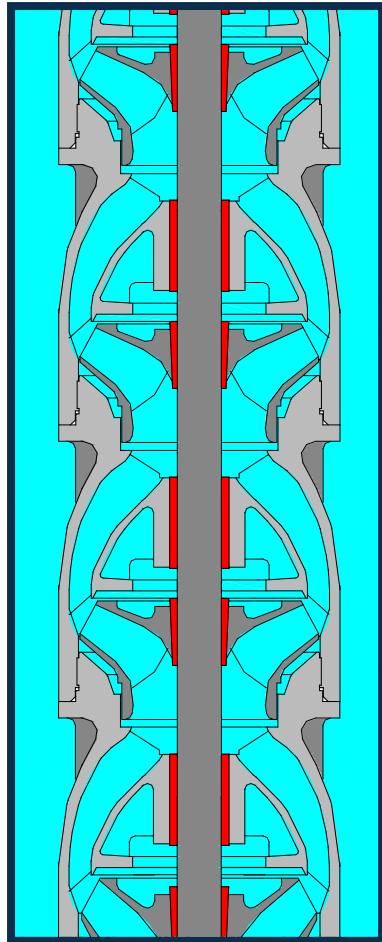


- Separate mounting flange on can was required for API 610 8th edition
- No longer required by API, but is available as an option if required by the customer

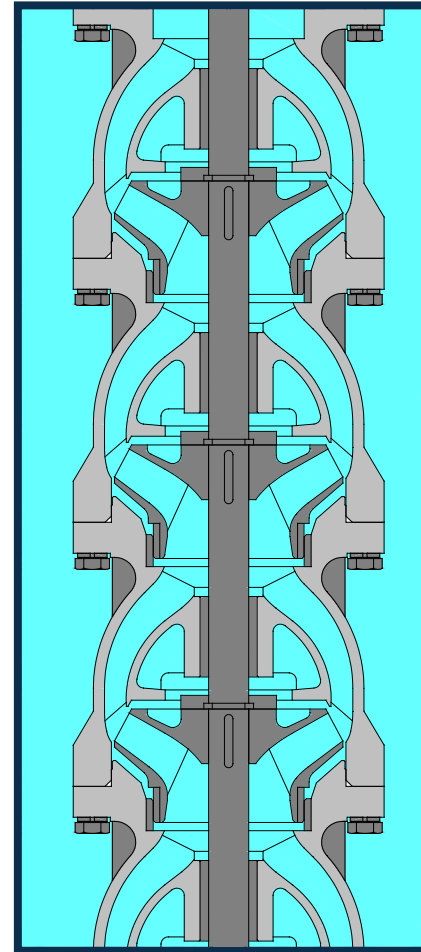


FLANGED VS THREADED BOWLS

Threaded Bowls (Non API)



Flanged Bowls (API)



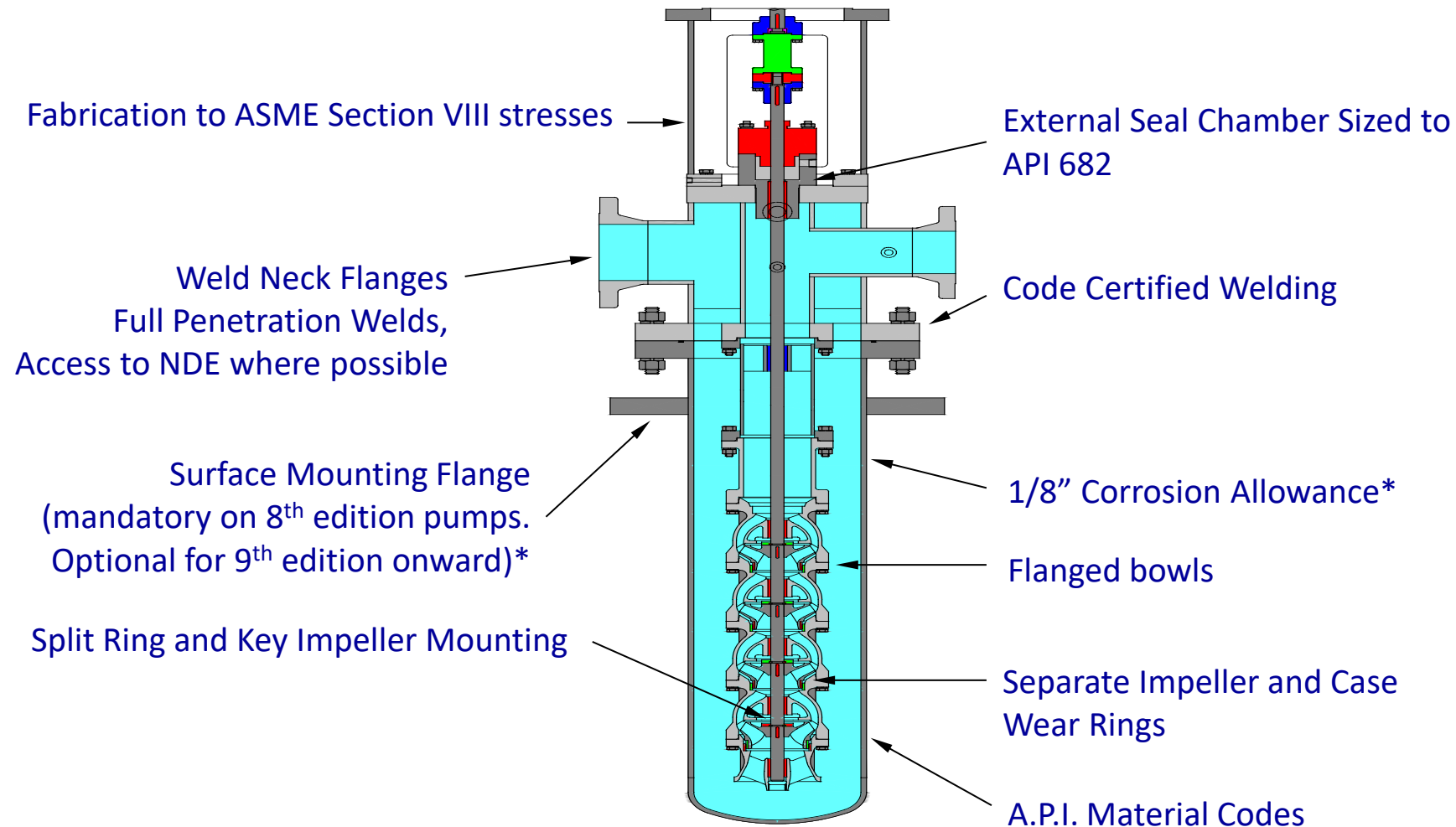


LOW NPSH FIRST STAGE

- Low NPSH First Stage (13,000 Nss) with wide operating range (15-120% BEP)
- Some (non RP) designs use an inducer.
- Inducers historically had a limited operating range (U shaped NPSH curve)
- More recent designs have a broader range



API 610 - MANDATORY REQUIREMENTS



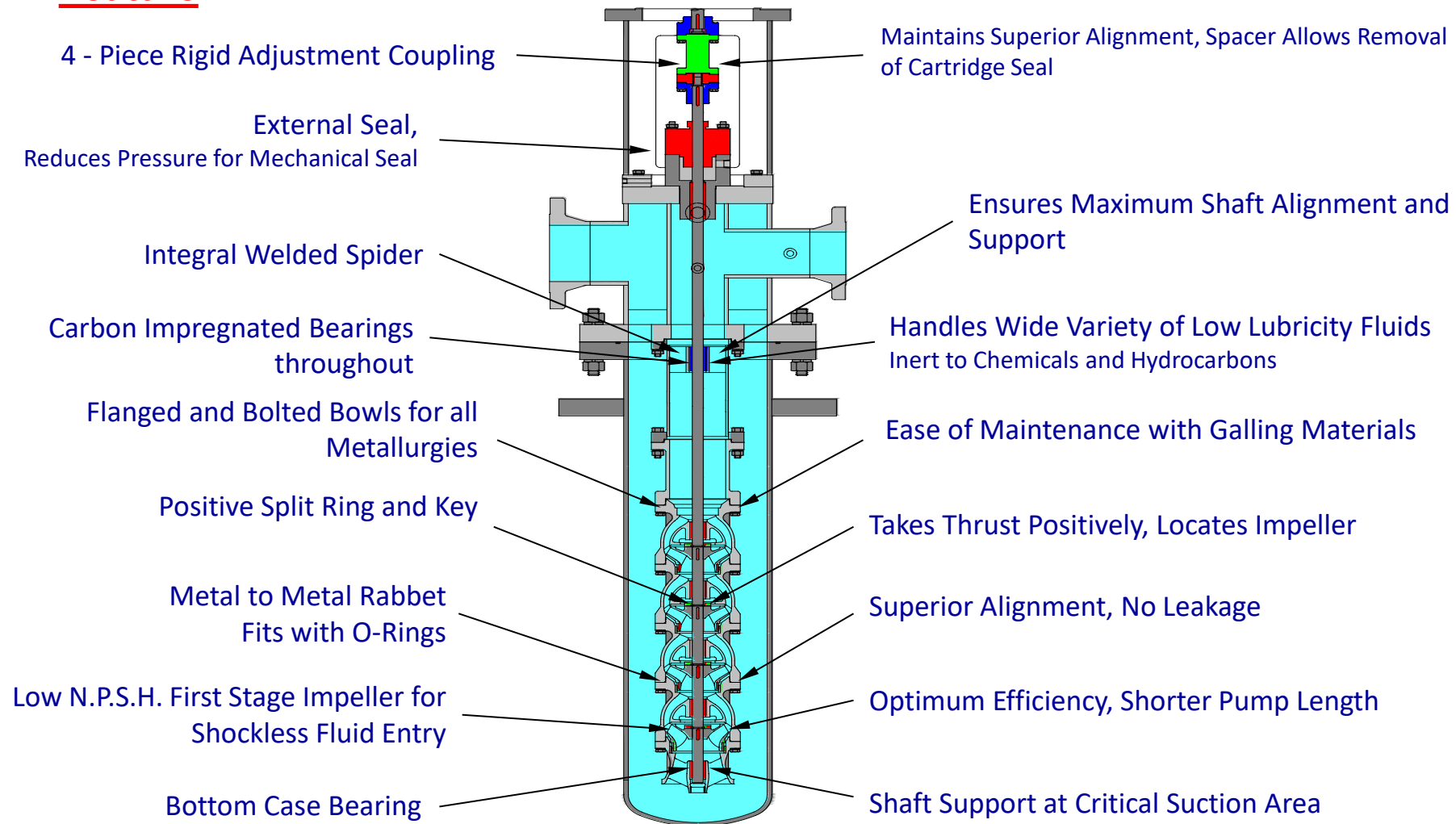


FEATURES AND BENEFITS

API 610 VLT

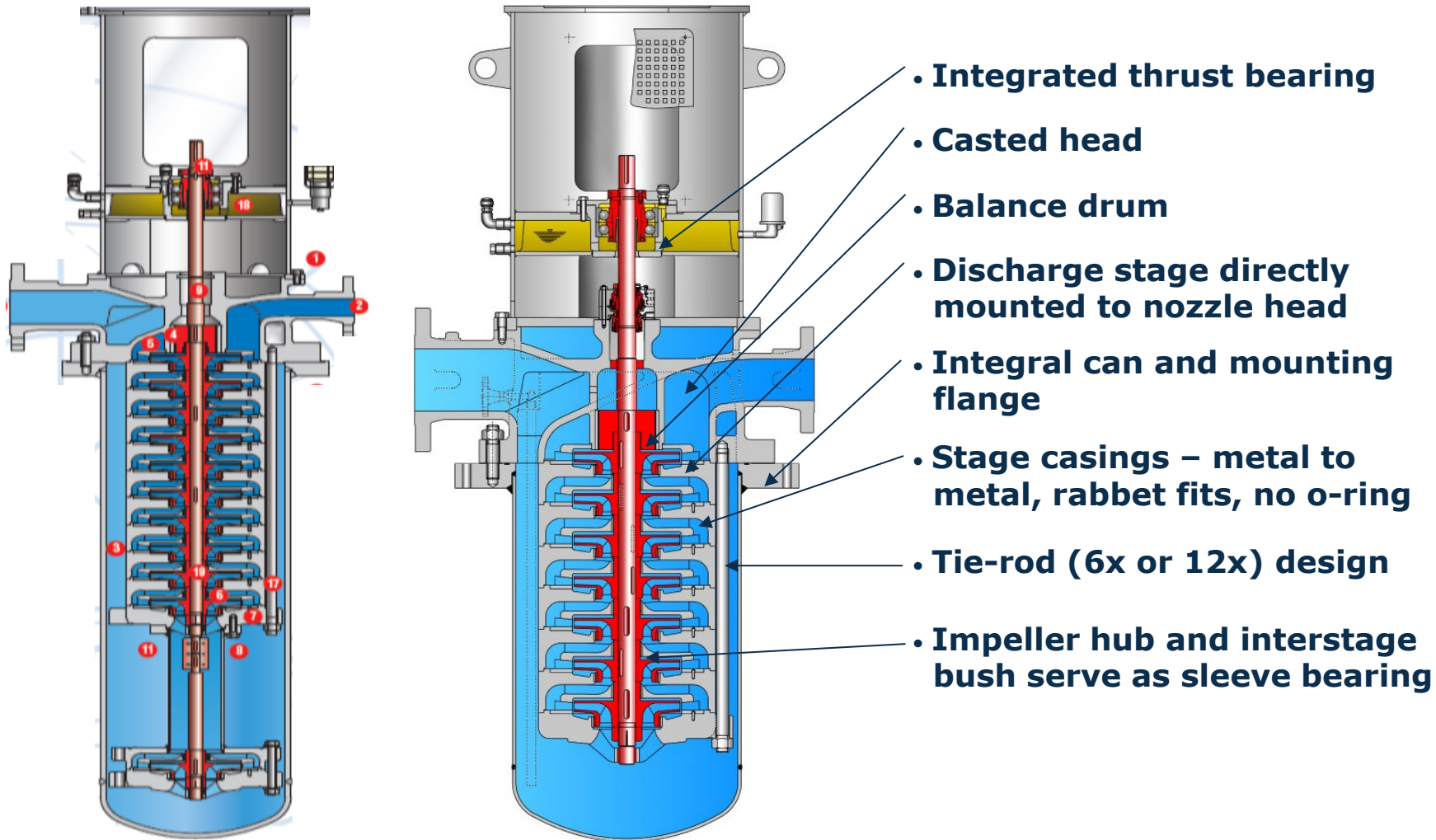
Feature

Benefit

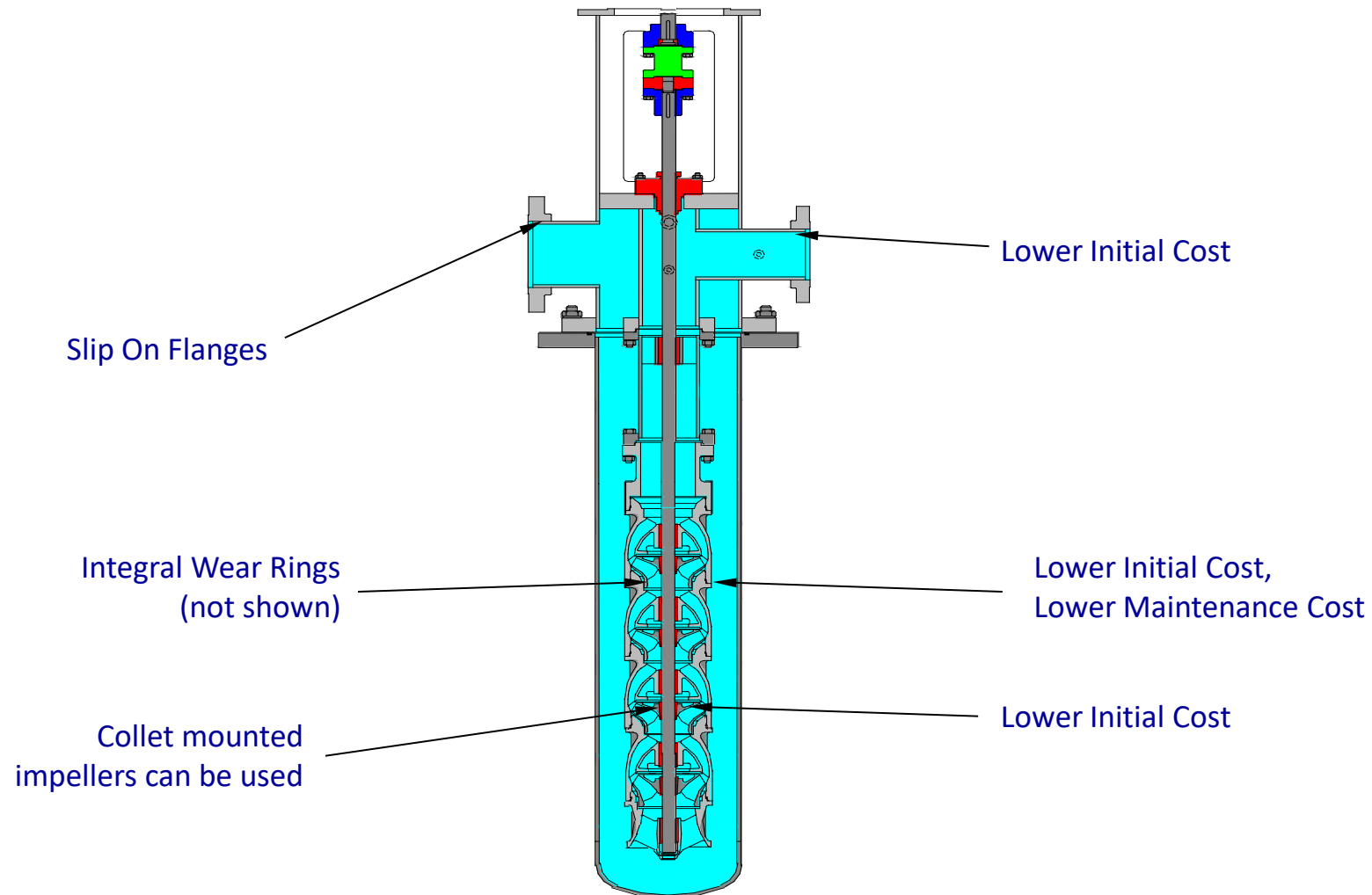


FEATURES AND BENEFITS

VLT RADIAL FLOW

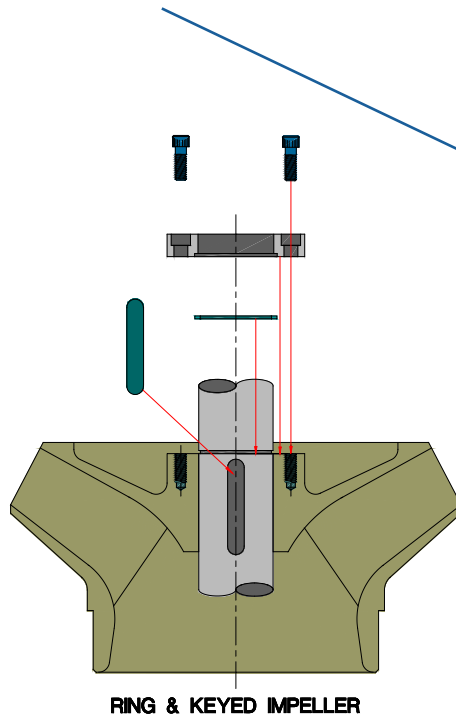


FEATURES AND BENEFITS COMMERCIAL VLT – DIFFERENT FROM API



FEATURES AND BENEFITS DESIGN CHARACTERISTICS

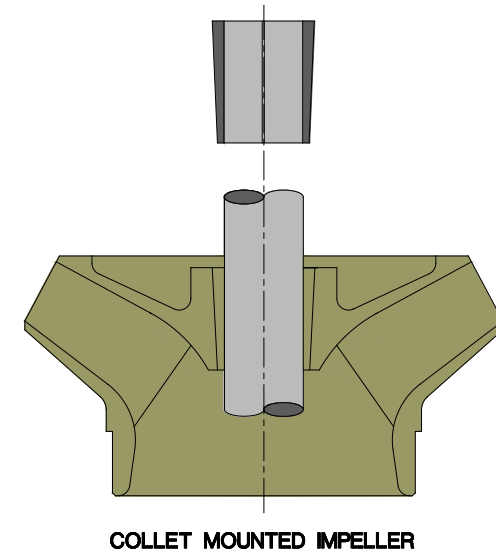
API



- Collet mounted Impellers
 - Ease of assembly and disassembly
 - Ensures positioning of impeller
 - Lower cost and easier for maintenance

- Locked and keyed Impellers.
 - Positive retention.
 - Important when pumping hot/cold liquids.
 - Less susceptible to loosening when subject to shock load

Non
API

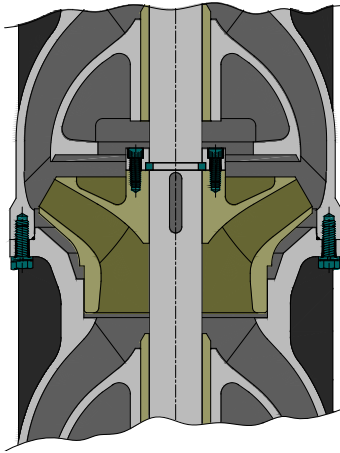


The use of locked and keyed impellers is mandatory for hot services above 230 deg F and below -20 deg F. The reason for this is the tendency for collets to loosen.

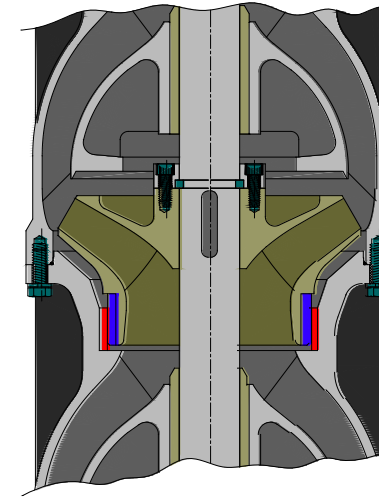
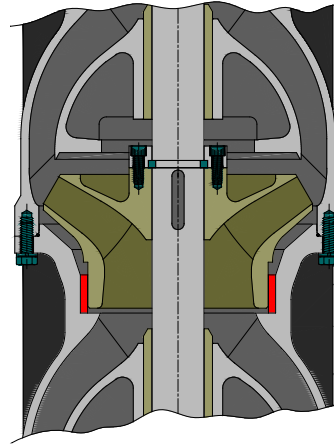
We also like to use locked and keyed impellers for high suction pressures and also series pump operation

FEATURES AND BENEFITS

WEAR RINGS



Integral Wear Rings (Non API)



Renewable Wear Rings (API)

- The choice of wear rings is available
- Integral wear rings is a cost saving

FEATURES AND BENEFITS

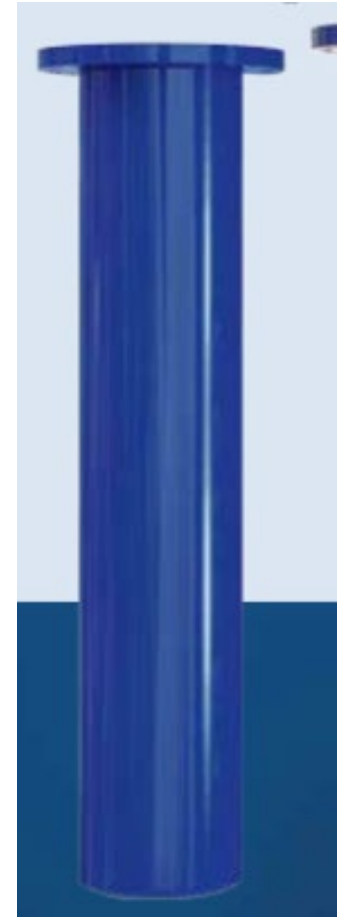
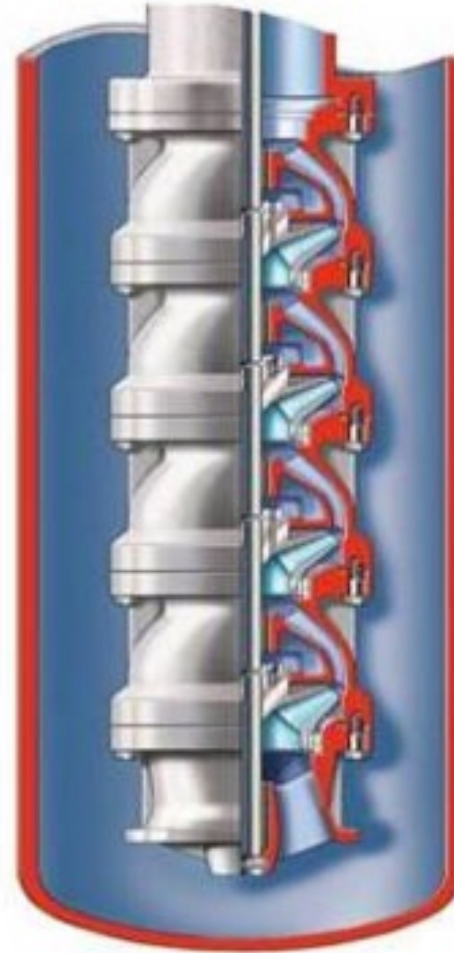
NOZZLE HEAD

- Fabricated Steel Discharge Heads
- Pre-Engineered standard designs for the 100 to the 2000 VLT size
- Meets API 610 nozzle load requirements (Only API model)
- 300# flanges standard for API VLT. 150#, 600# & 900# optional
- All pipe, vent & gauge connections are ANSI Class 300
- 150# flanges are standard for Commercial VLT
- 300# and above optional
- Top flange has rabbet / register fit for motor - no field doweling or fit-up
- Lifting Lugs
- OSHA coupling guards
- Standard motor mating flanges to NEMA standards for Vertical Solid Shaft Motor



FEATURES AND BENEFITS SUCTION CAN AND SHAFTING

- Fabricated Steel Barrel (or “Can”)
- O-ring gasket seal to the head
- Sized to meet allowable velocities
- Elliptical bottom is standard on API VLT
- Flat bottom standard on Commercial VLT
- 416ss shafting as standard





DESIGN CHARACTERISTICS COLUMN AND LINE SHAFT

- For API design bearing holder / 'spider' is welded into the top of each column piece and machined concentric with mating flanges
- For Commercial design spiders can be drop—in type. But there is an option for welded
- Better radial loading capability
- Rabbet /Register fit and o-ring sealing between column and head, and column and bowl assembly
- Carbon Impregnated bearings as standard (usually graphalloy)
 - Suitable for wide range of services and can tolerate upset conditions
 - These bearings give excellent life when pumping dry liquids like propane, butane, ethane and also condensate
- Bronze, Cast Iron, Nitronics are also available depending on the service





MECHANICAL SEALING OPTIONS

DESIGN CHARACTERISTICS

MECHANICAL SEALS

- Seal chambers suitable for API 682 mechanical seals
- Choice of arrangements to suit process
- Seal systems normally mounted away from the pump, but engineering will look at mounting on pump head on case to case basis if required (photo)

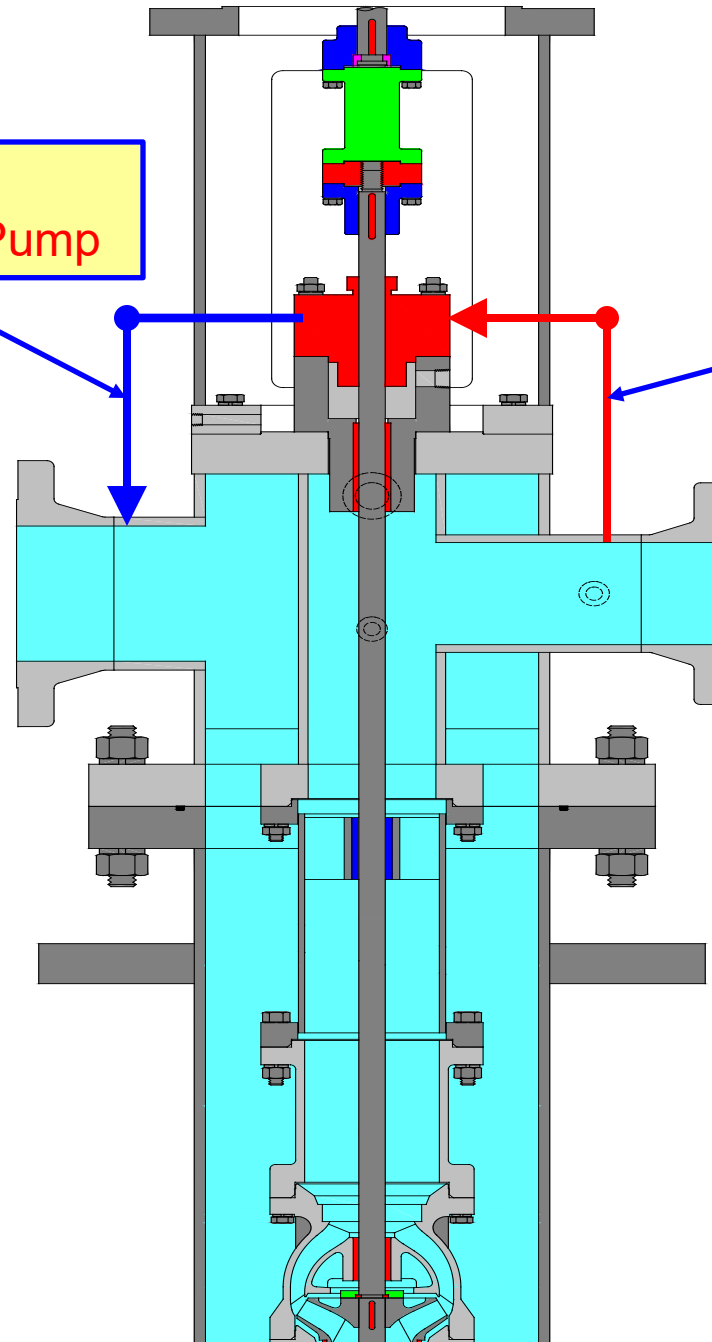




API Plans 13 & 14

Plan 13
Usual for VS6 Pump

Plan 11
Plan 11 + Plan 13 = Plan 14



Plan 13

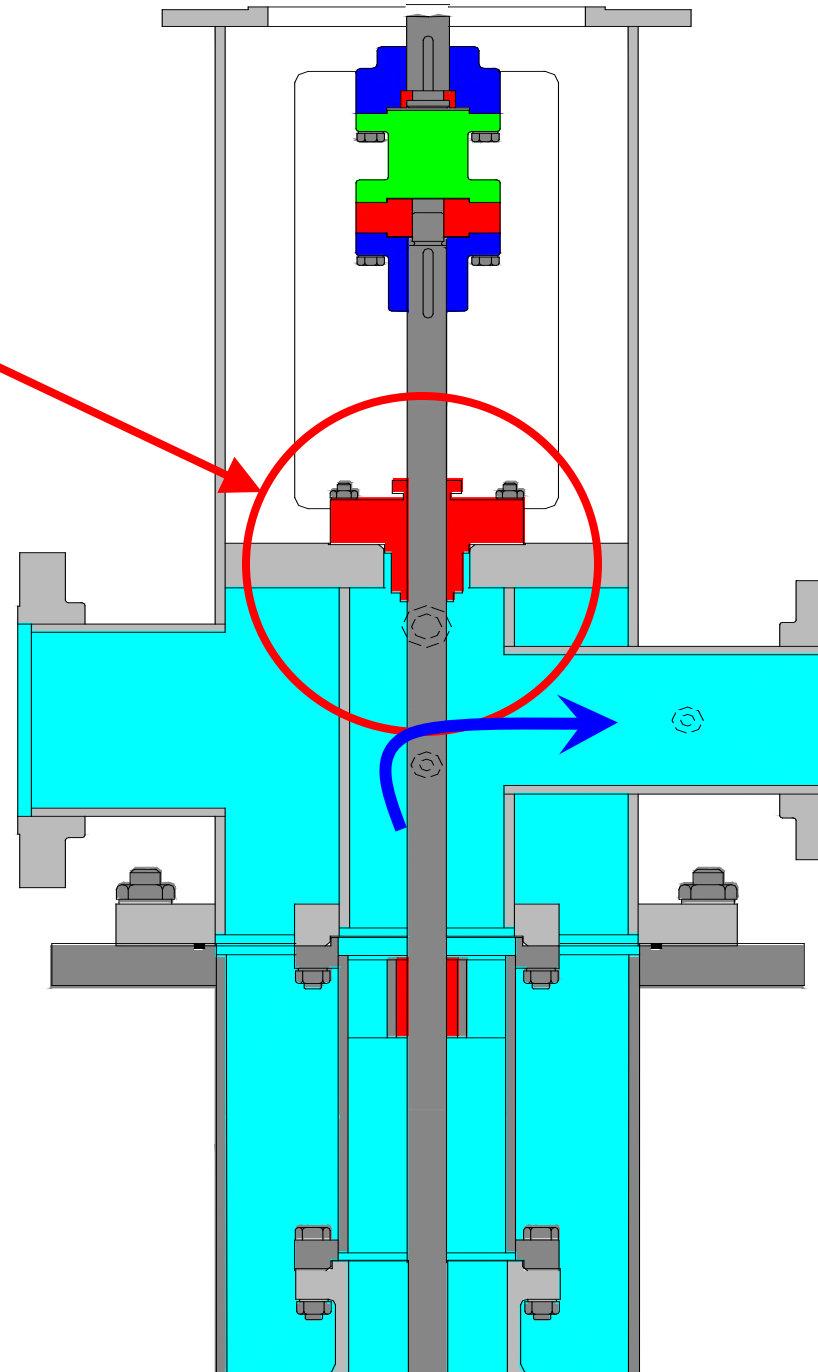
Seal chamber pressure =
Suction Pressure + 25% of
Differential Pressure

Plan 14

Seal chamber pressure =
Suction Pressure + 75% of
Differential Pressure

Non-API VS6 Seal Arrangement

- No seal chamber (as standard)
- Seal is set in the pump discharge flow and is self flushing
- No seal flush piping required
- (Seal chamber and flush plans are options)



API Plan 52

- Plan 52 uses an external reservoir to provide buffer fluid for the outer seal of an Unpressurized Double seal arrangement.
- Advantages: In comparison to single seals, Dual Unpressurized Seals can provide reduced net leakage rates as well as redundancy in the event of a primary seal failure.
- General: Cooling coils in the reservoir are available for removing heat from the buffer fluid. Plan 52 is often used where the process fluid cannot be affected with the buffer fluid.

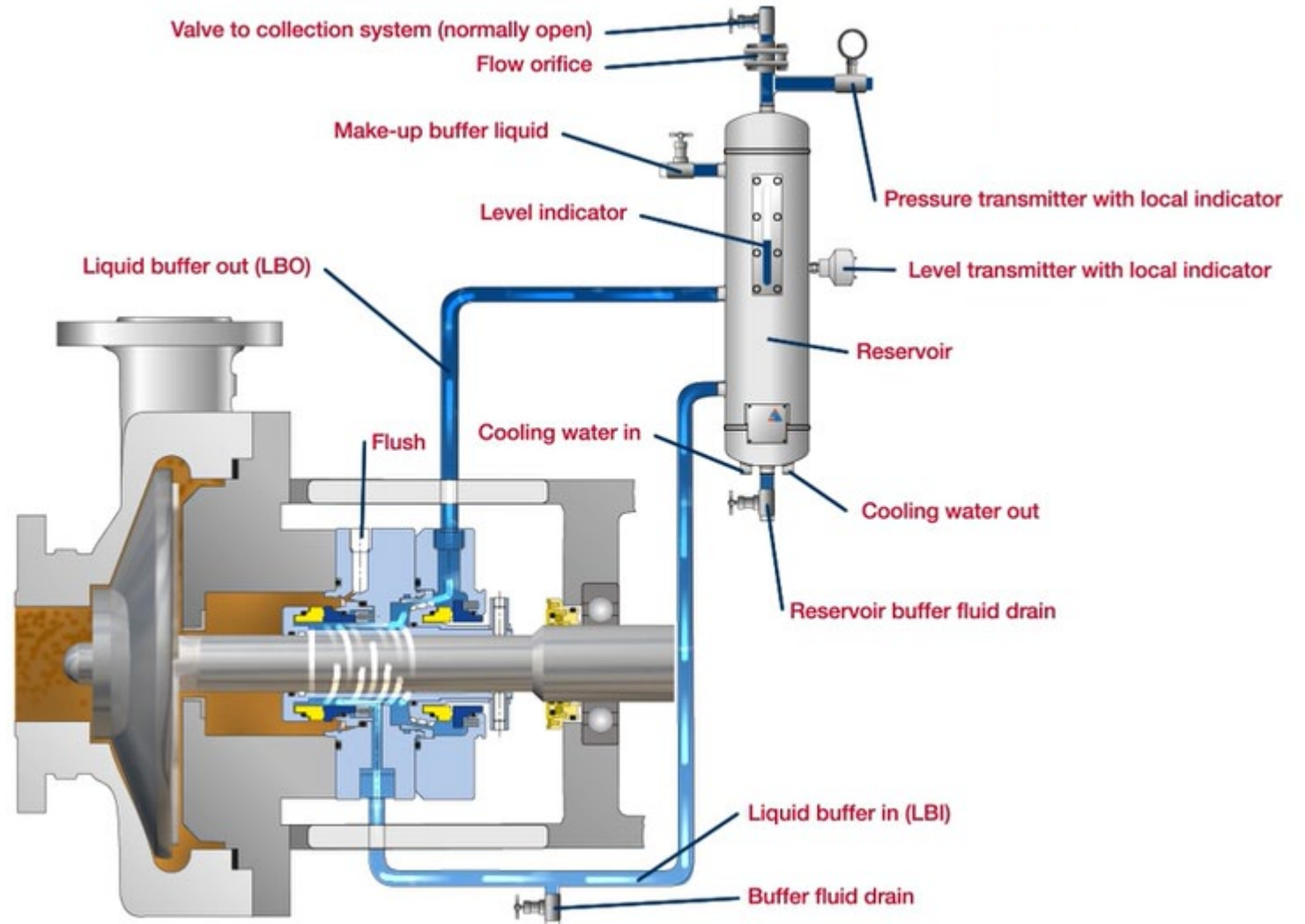


Image borrowed from AES Seals

API Plan 53A

- Plan 53A uses an external reservoir to provide a pressurized barrier fluid for a pressurized Double seal arrangement. Reservoir pressure is produced by a gas, usually nitrogen. Flow is induced by a pumping ring within the Seal Gland.
- Advantages: Reservoir size can be optimized dependent on flow rate. Wear particles settle to bottom of reservoir and don't get recirculated.
- General: Heat is dissipated by reservoir cooling coils. Barrier fluid is subject to gas entrainment at pressures/temperatures above 300 psi/250F 20 Bar/120C.

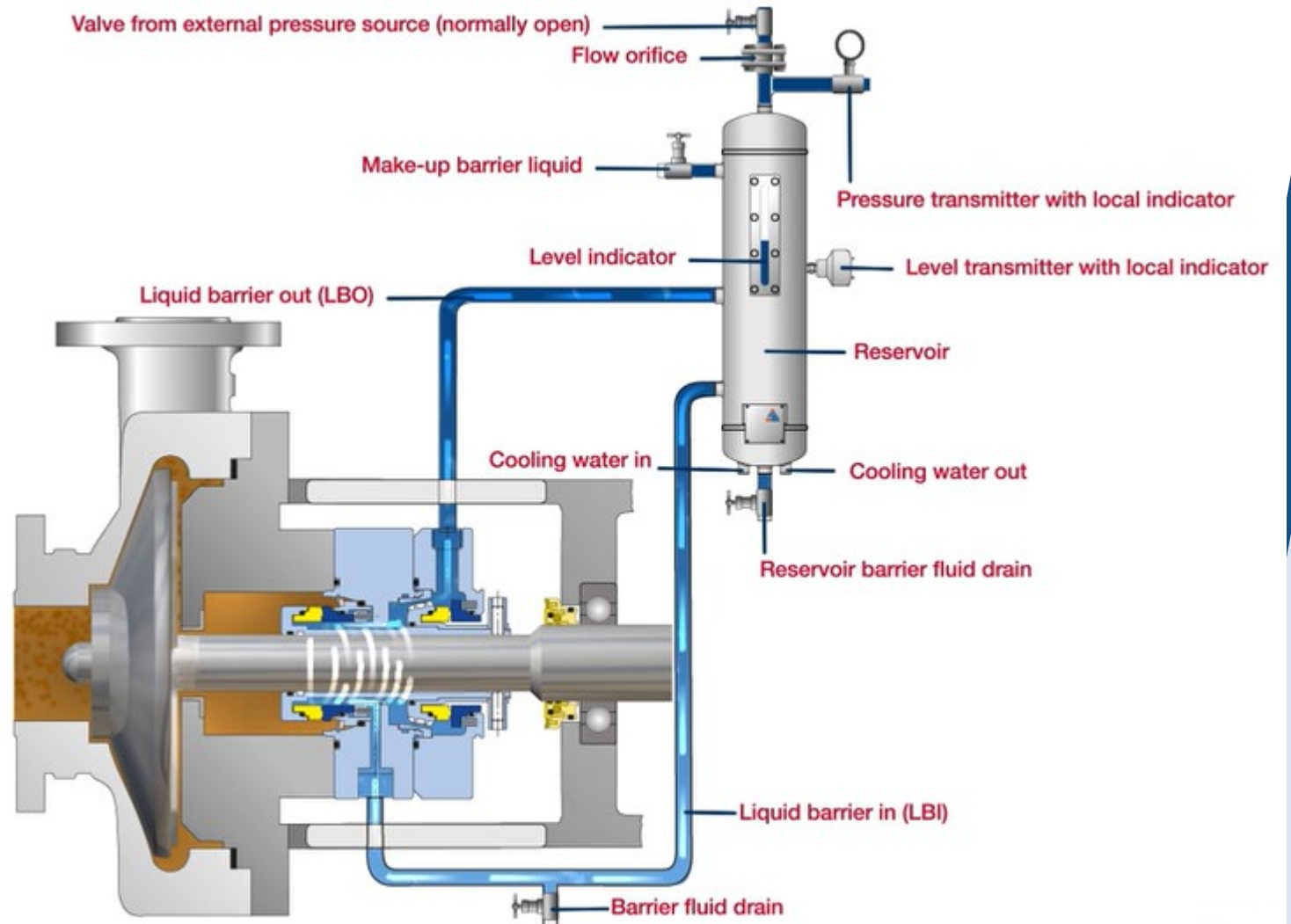


Image borrowed from AES Seals

API Plan 53B

- Plan 53B, previously termed 53 Modified, uses an accumulator to provide the pressurizing gas and the barrier fluid. A heat exchanger is included in the circulation loop to cool the barrier fluid. Flow is induced by a pumping ring in the Seal Gland.
- Advantages: If the loop is contaminated by the Pumped Liquid for any reason, the contamination is contained within the closed circuit. The make-up system can supply barrier fluid to multiple dual pressurized sealing systems, on between bearing Pumps with 2 Stuffing Boxes & 2 sets of Mechanical Seals.
- General: The bladder accumulator isolates the pressurizing gas from the barrier fluid to prevent gas entrainment. The heat exchanger can be a water-cooled unit, an air-cooled unit, or utilize finned tubing based upon the system heat load.

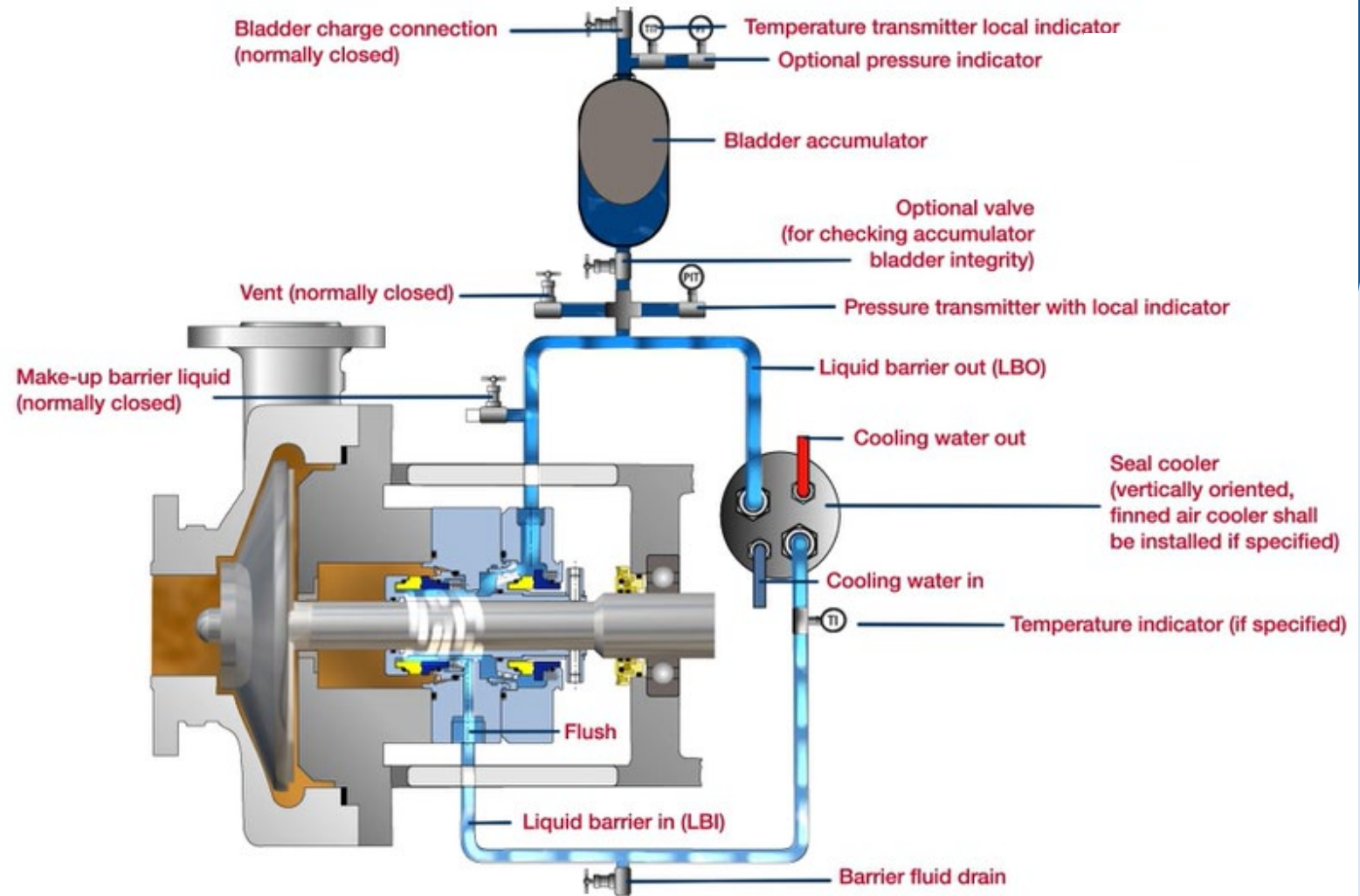


Image borrowed from AES Seals



API Plan 76

- Plan 76 is a system to divert non-condensing primary seal leakage to a flare or vapor recovery system.
- Advantages: Lower initial and maintenance costs than dual unpressurized seals using a Plan 52.
- General: Plan 76 can be used in conjunction with a gas purge from Plan 72. Can be used with dry-running, contacting or non-contacting Secondary Containment Seals.

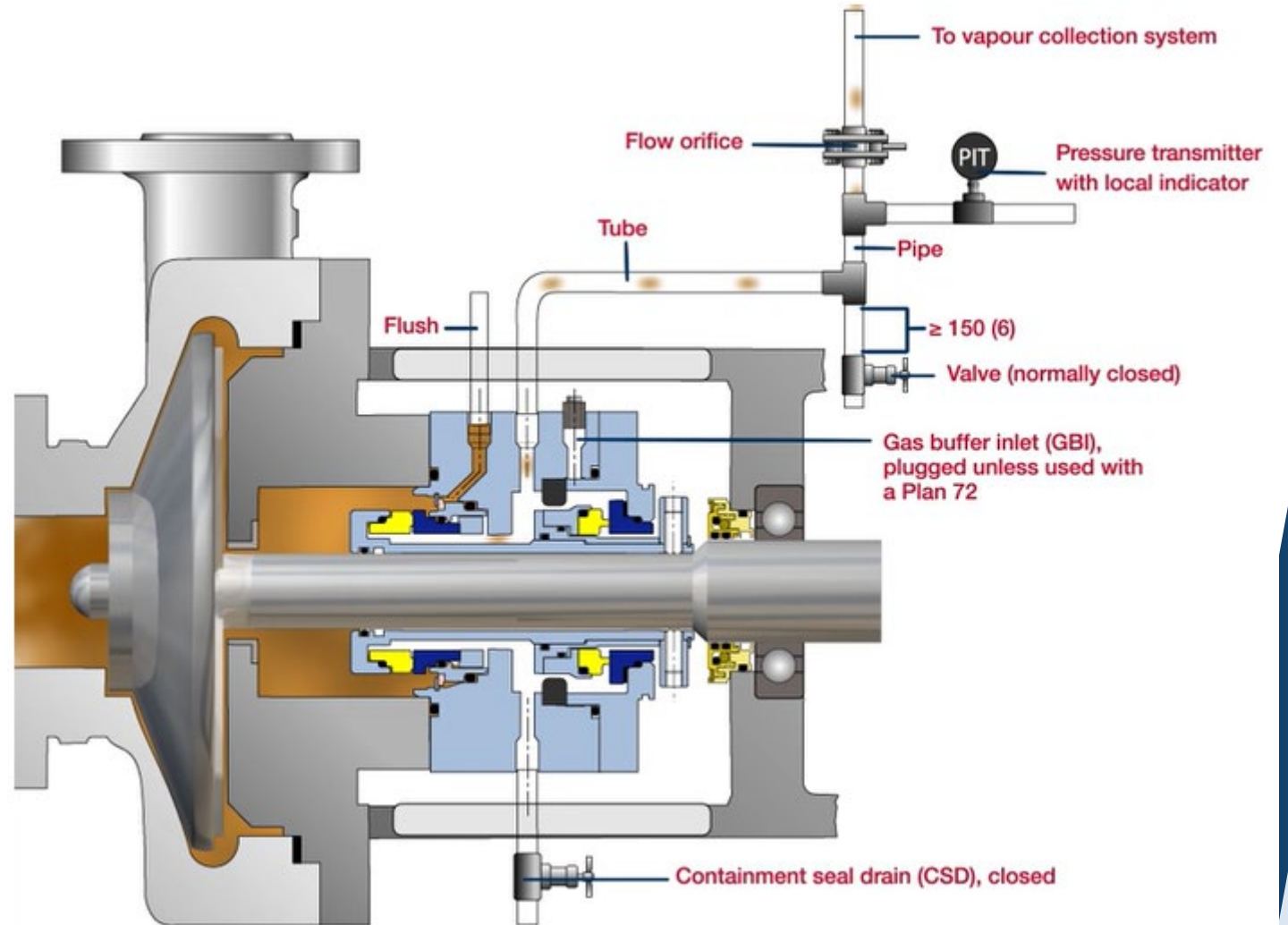


Image borrowed from AES Seals



API Plan 75

- Plan 75 is a collection system used with Secondary Containment Seals for process fluid that will condense at lower temperatures or is always in a liquid state.
- Advantages: The collection reservoir contains a pressure gauge and a high pressure switch to indicate a build up in pressure from excessive primary seal leakage or failure.
- General: Plan 75 can be used in conjunction with a gas purge from Plan 72. Typically dry-running, contacting Secondary Containment Seals are used with this plan.

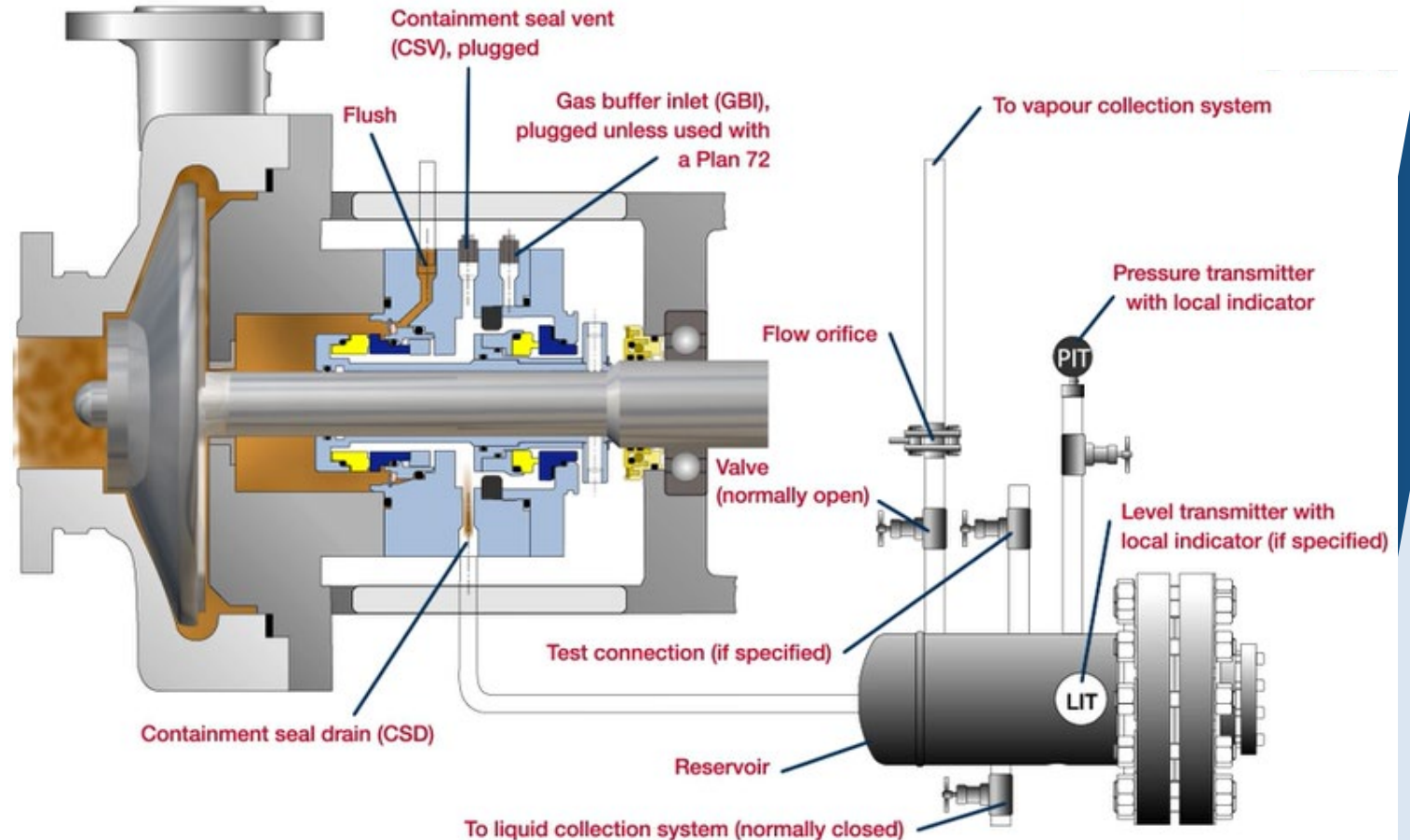
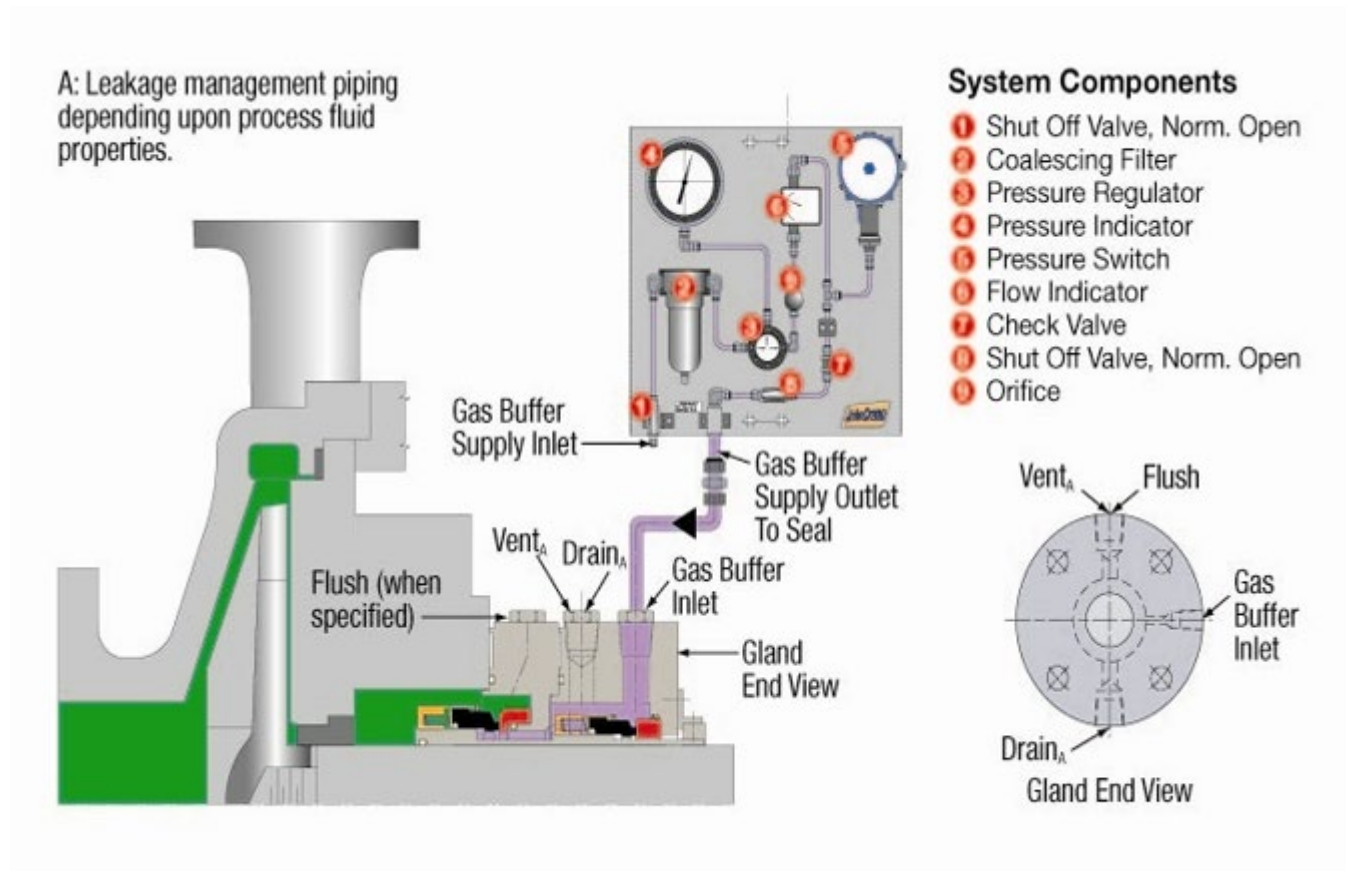


Image borrowed from AES Seals



API Plan 72

- Plan 72 for secondary containment uses an external low pressure buffer gas, usually nitrogen, regulated by a control panel that injects it into the outer seal cavity.
- Advantages: Introduction of a buffer gas like nitrogen reduces fugitive emissions, prevents icing on cold applications, and provides for some cooling to the outboard seal.
- General: Plan 72 is normally used with Plan 75 for primary seal leakage that is condensing, or with Plan 76 for non-condensing leakage.





THRUST HANDLING IN PUMP IN-HEAD THRUST POTS

REFERENCE NUMBER	PART DESCRIPTION	MATERIAL
120	SEAL, CARTRIDGE	ASSY
167	SHAFT, PUMP	A582 TP 416
252	NUT, SHAFT, DRIVER	A582 TP 416
346	SLEEVE, BEARING, BALL, THRUST	STL 1213
486	RING, SEALING-V	NITRILE
486-1	RING, SEALING-V	NITRILE
508	THRUST POT	A48, CL 30
510	COVER, THRUST POT	A36
655	BEARING, BALL, RADIAL	ASSY
673	WASHER, LK, BBRG	A36
678	KEY, GIB	AISI 302-316
747-4	O-RING	NITRILE
878	NUT, LK, BBRG	A36

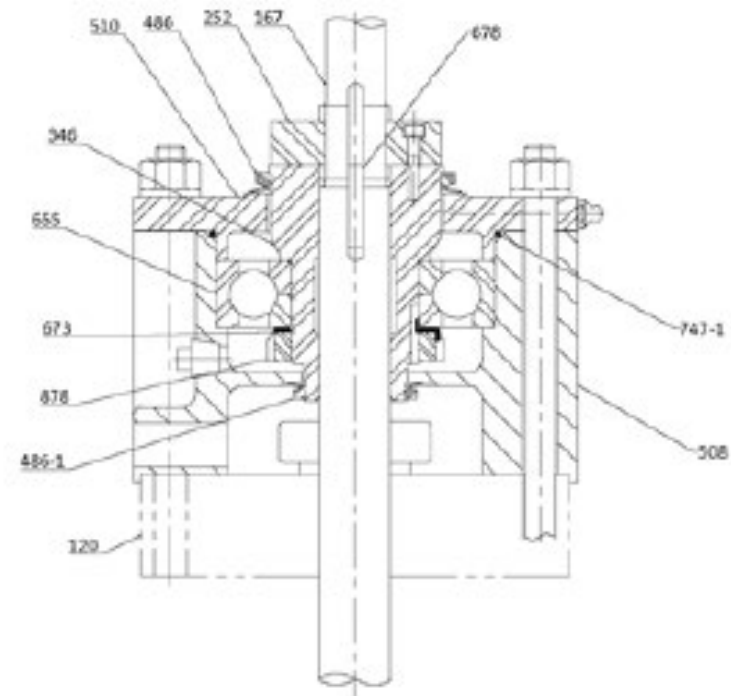
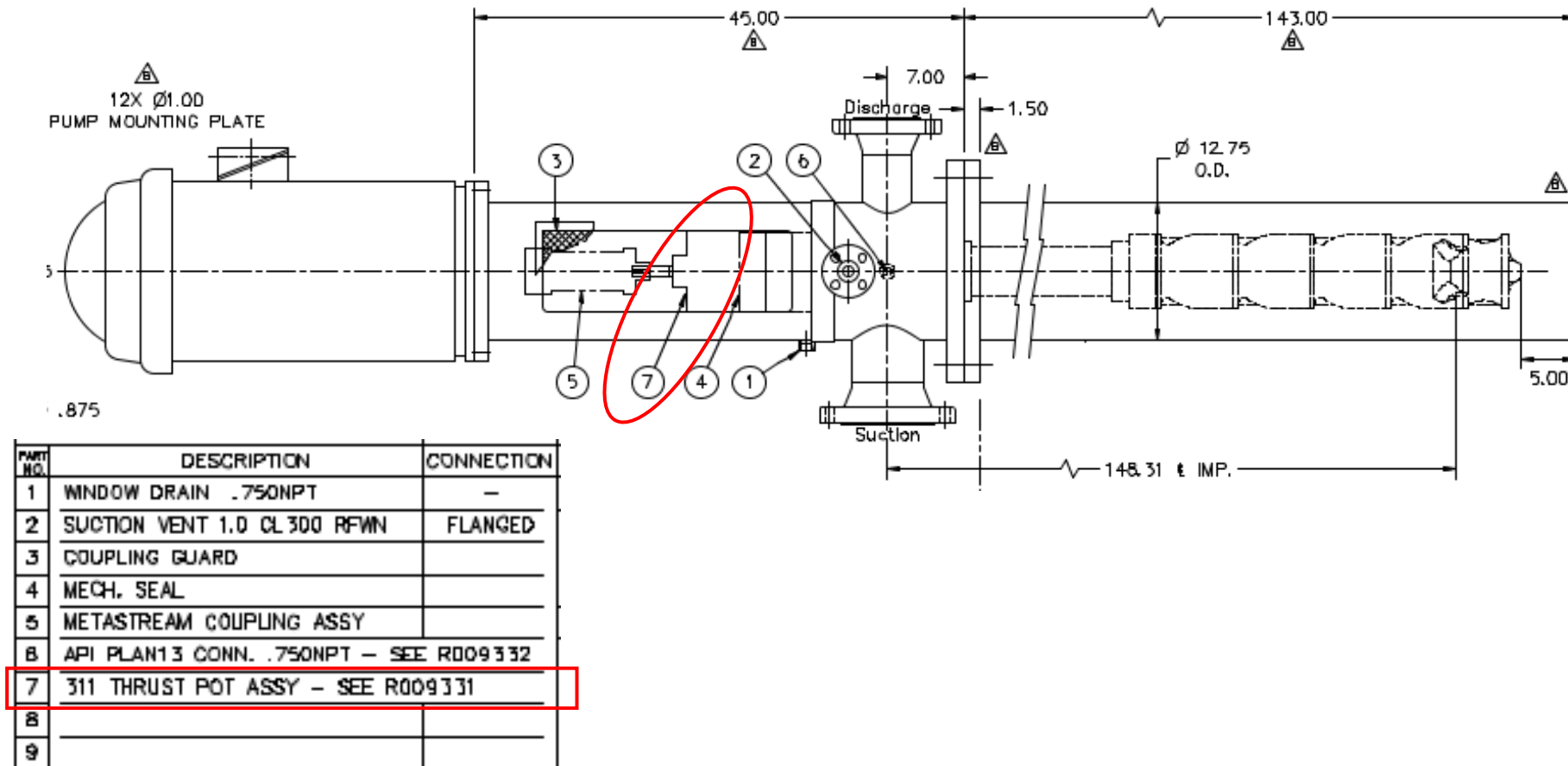


Figure 6.1 Thrust Pot Model 311 / 311 QJ Sectional Drawing

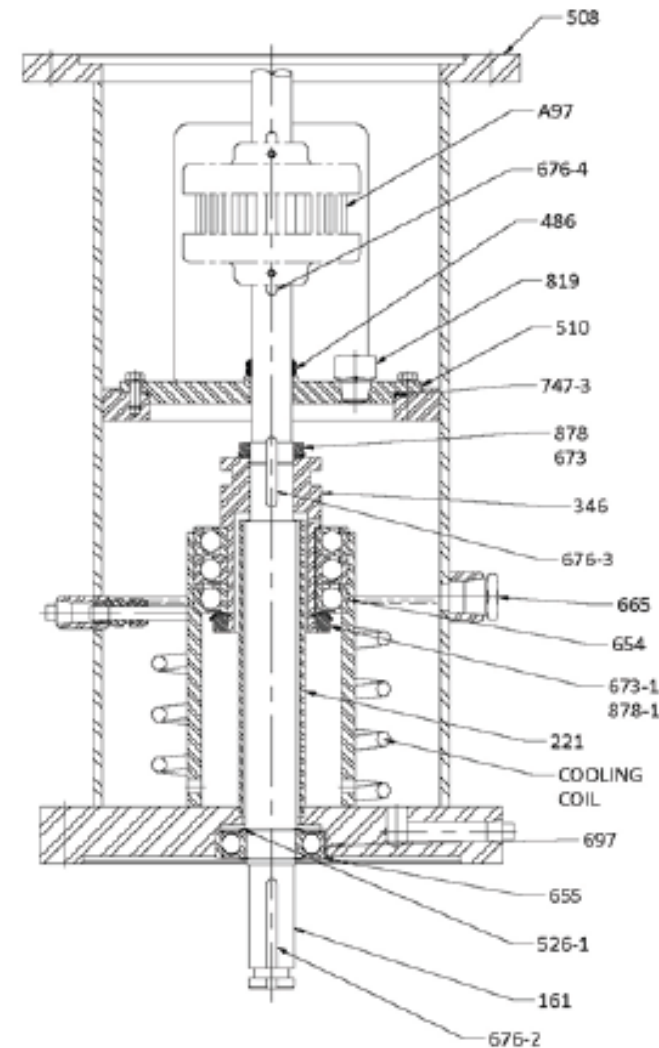
THRUST HANDLING IN PUMP IN-HEAD THRUST POTS





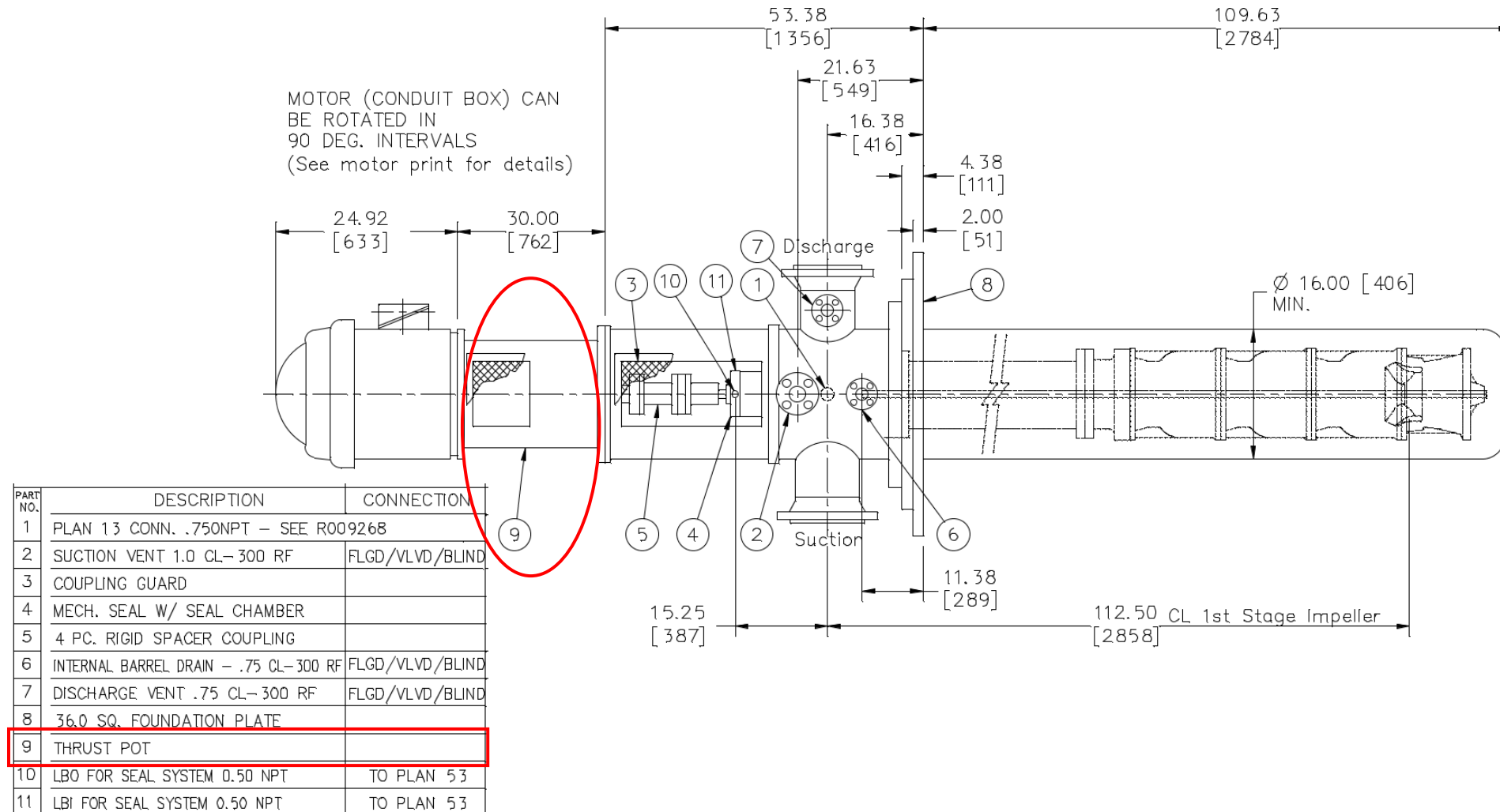
THRUST HANDLING IN PUMP SEPARATE THRUST POTS

REF. NO.	PART DESCRIPTION	MATERIAL
161	SHAFT, THRUST POT	A528 TP 416
221	SLEEVE, OIL	A36 - STL LC
346	SLEEVE, BEARING, BALL	A36 - STL LC
486	RING, SEALING-V	NITRILE
508	THRUST POT	FABRICATION NOTE
510	COVER, THRUST POT	A36 - STL LC
523-1	RING, RETAINING	AISI 302
654	BEARING, BALL, THRUST (QTY: 3)	SKF # 7216-BG
655	BEARING, BALL, RADIAL (QTY: 1)	SKF # 6309-2RSNR
665	GAUGE, LEVEL	BW20 GITS # 04054
673	WASHER, LOCKNUT 40 W-80	STL SKF W08
673-1	WASHER, LOCKNUT 80 W-16	STL SKF W16
676-3	KEY, PRL (QTY: 1)	AISI 302-316
676-4	KEY, PRL (QTY: 2)	AISI 302-316
697	PIN, ANTI-ROTATION	AISI 302
747-3	O-RING	NITRILE
819	FITTING, VENT, BREATHER	M-841 TEDECO
878	NUT, BEARING, THRUST 40 N-08	STL SKF N-08
878-1	NUT, BEARING, THRUST 80 AN-16	STL SKF AN-16
A97	COUPLING METASTREAM TSKS 0135	





THRUST HANDLING IN PUMP SEPARATE THRUST POTS



VLT



VLT prepared for Can



New Development

- Quickship VLT

API 610 Build Quickship Pump

This is what you get:-

- A fully compliant API610 12th Edition pumpset
- Built as a semi-engineered package with limited (but extensive) options
- Pump Sizes 100VLT through to 2000VLT (21 Pump sizes, 35 hydraulics)
1000 m³/hr & 850m head 50 Hz
5000 usgpm & 4000ft head 60 Hz
- Delivery Time **18 weeks** (complete pump) ex works after receipt of order
(future target 15 weeks), 8 weeks (bowl assembly)

API 610 Build Quickship Pump

This is what you get -1

BOWL ASSEMBLY:
bowl(s)/suction bell - dual certification WCB/LCB
flanged bowl(s)
impeller(s) - Duplex SS
keyed impeller(s)
case & impeller wear rings - 12% chrome
bowl bearing(s) - carbon
product lube bowl bearings
bowl shaft - 12% chrome
bowl bolting - carbon steel
<i>OPTION: basket strainer - galvanized steel</i>
COLUMN ASSEMBLY:
carbon steel
flanged
open lineshaft
column bearing(s) - carbon
column lineshaft - 12% chrome
columnng bolting - carbon steel

API 610 Build Quickship Pump

This is what you get -2

HEAD ASSEMBLY:
fabricated - 150# RF discharge flange - carbon steel
stuffing box bearings - carbon
mechanical seal - cartridge (single or double; Ruhrpumpen choice of vendor)
Plan 13 seal flush - 304SS tubing
rigid adjustable 4-piece coupling
coupling guard - aluminum
head bolting - carbon steel
OPTION: <i>flanged discharge vent connection</i>
OPTION: <i>flanged suction vent connection (when pump in can)</i>
OPTION: <i>packing</i>
OPTION: <i>suction in head - 150# RF suction flange</i>
OPTION: <i>300# RF discharge flange</i>
OPTION: <i>300# RF suction flange</i>
OPTION: <i>seal flush plan 14/52/53A/53B/65A/65B/66A/66B</i>
OPTION: <i>seal pot (for plan 52, 53)</i>
OPTION: <i>sole plate (standard RP dimensions) - carbon steel</i>

API 610 Build Quickship Pump

This is what you get -3

MISCELLANEOUS:
Performance Test - Nonwitnessed only (Ruhrpumpen choice: use of job or test lab motor/seal & full length or short set pump)
Hydro Test - Nonwitnessed only
coating system A02-M: corrosivity category C2 / SSPC-SP10 surface preparation / EP top coat / color code RAL 5003 ("Ruhrpumpen blue") / exterior surfaces only
standard packaging for shipment (goods mounted on pallet)
<i>OPTION: can (for VS6 configuration) - carbon steel</i>
<i>OPTION: suction in can - 150# RF</i>
<i>OPTION: suction in can - 300# RF</i>
<i>OPTION: Material Certificates [bowl(s)/impeller(s)]</i>
<i>OPTION: non-standard head and/or can dimensions</i>
MOTOR:
Vertical Solid Shaft (thrust handling) - NEMA design standard
Ruhrpumpen choice of vendor & option to drop ship direct from vendor
500 HP maximum
2, 4, or 6 pole
Enclosure options: WP1, WP2, TEFC, TEFC Div 2
460 V / 3 Phase / 60 Hz / 1.15 S.F. (1.0 if used w/ VFD)
Premium Efficiency

API 610 Build Quickship Pump

This is what you get – 4 – Documentation 1

Drawings	Duration (Weeks)
Cross-sectional drawing (pump)	8
Certified dimensional outline drawing (with allowable forces and moments)	8
Certified dimensional outline drawing (driver only)	10
Shaft seal drawing	10
Cross-sectional drawing (shaft seal)	10
Wiring diagram (driver)	10
Coupling assembly drawing	16
Documents	Duration (Wks)
Document index	5
Performance curve (predicted)	7
Production schedule	7
Inspection and Test Plan	6
Data sheet (pump)	8
Complete parts list (pump)	8
Nameplate (pump) data	8
Data sheet (driver)	10
Spare parts list (pump)	8
Final Data Book (all submitted documentation) index	8.8
Sub-vendor list	10.8

API 610 Build Quickship Pump

This is what you get – 5 – Documentation 2

Test Results	Duration (WAT)
Performance test data	2
Final Inspection report	2
Certified hydrostatic test data	In FDB
Driver test data	In FDB
Material test report	In FDB
NDT report	In FDB
Balance data (impeller)	In FDB
Final Documentation	Duration (WAD)
IOM manual	In FDB
Final Data Book (all submitted documentation)	4 Weeks

API 610 Build Quickship Pump

This is what you **DON'T** get

1. **No** Bespoke documentation package
2. **No** Witnessed or Observed testing
(Testing might be carried out on a Saturday or on second shift or be rearranged at no notice so there is no possibility of giving you advance warning of a date for even an Observed Test never mind a Witnessed test)
3. **No** NDE
4. **No** Customer Specifications with PO
(These will be reviewed, commented and agreed during proposal stage as required but the agreed scope of supply in the PO will be a standalone document)
5. **No** Dedicated Project Manager. (Your PM will have 50 other jobs!)
6. **NOTE** – All the above **are** available but not in the Quickship Program

The above limitations make this more applicable to end user purchasers than EPC Contractors who are usually constrained by Project Specifications and Requirements

API 610 Build Quickship Pump

This Program has been rolled out, initially, predominantly for the North American market. For Europe, Middle East, Africa & Asia (EMEAA) it will need some “tweaking”

It does not currently allow for:

- European / Asian IEC design & supply motors
- Separate Thrust Pots
- Flanged & welded seal piping
- Maybe other “essential EMEAA” requirements? You tell us!

NOTE – All the above **are** available but not in the Quickship Program

If the demand is there the program will be expanded to suit the EMEAA markets

HI Standard (Non-API 610) Quickship Pump

This is what you get:-

- An HI Standard pumpset
- Built as a semi-engineered package with limited options
- Pump Sizes 100VLT through to 2000VLT
1000 m³/hr & 850m head 50 Hz
5000 usgpm & 4000ft head 60 Hz
- Delivery Time **18 weeks** ex works after receipt of order (future target 15 weeks), 8 weeks (bowl assembly)

HI Standard (Non-API 610) Build Quickship Pump

This is what you get -1

BOWL ASSEMBLY:
bowl(s)/suction bell - ductile iron or dual certification WCB/LCB (depending on model)
threaded or flanged bowl(s) (depending on model)
impeller(s) - Duplex SS
keyed impeller(s)
no wear rings
bowl bearing(s) - carbon
product lube bowl bearings
bowl shaft - 12% chrome
bowl bolting - carbon steel
<i>OPTION: case & impeller wear rings - 12% chrome</i>
<i>OPTION: basket strainer - galvanized steel</i>
COLUMN ASSEMBLY
carbon steel
flanged
open lineshaft
column bearing(s) - carbon
column lineshaft - 12% chrome
column bolting - carbon steel

HI Standard (Non-API 610) Build Quickship Pump

This is what you get -2

HEAD ASSEMBLY:
fabricated - 150# RF discharge flange - carbon steel
stuffing box bearings - carbon
mechanical seal - cartridge (single or double; Ruhrpumpen choice of vendor)
Plan 13 seal flush - 304SS tubing
rigid adjustable 4-piece coupling
coupling guard - aluminum
head bolting - carbon steel
OPTION: threaded discharge vent connection
OPTION: threaded suction vent connection (when pump in can)
OPTION: packing
OPTION: suction in head - 150# RF suction flange
OPTION: 300# RF discharge flange
OPTION: 300# RF suction flange
OPTION: seal flush plan 14/52/53A/53B/65A/65B/66A/66B
OPTION: seal pot (for plan 52, 53)
OPTION: sole plate (standard RP dimensions) - carbon steel
OPTION: full penetration welds on discharge head

HI Standard (Non-API 610) Build Quickship Pump

This is what you get -3

MISCELLANEOUS:
coating system A02-M: corrosivity category C2 / SSPC-SP10 surface preparation / EP top coat / color code RAL 5003 ("Ruhrpumpen blue") / exterior surfaces only
standard packaging for shipment (goods mounted on pallet)
OPTION: can (for VS6 configuration) - carbon steel
OPTION: suction in can - 150# RF
OPTION: suction in can - 300# RF
OPTION: Material Certificates [bowl(s)/impeller(s)]
OPTION: Performance Test - Nonwitnessed only; acceptance grade 2B (Ruhrpumpen choice: use of job or test lab motor/seal & full length or short set pump)
OPTION: Hydro Test - Nonwitnessed only
OPTION: full penetration welds on can
OPTION: non-standard head and/or can dimensions
MOTOR:
Vertical Solid Shaft (thrust handling) - NEMA design standard
Ruhrpumpen choice of vendor & option to drop ship direct from vendor
500 HP maximum
2, 4, or 6 pole
Enclosure options: WP1, WP2, TEFC, TEFC Div 2
460 V / 3 Phase / 60 Hz / 1.15 S.F. (1.0 if used w/ VFD)
Premium Efficiency

HI Standard (Non-API 610) Build Quickship Pump

This is what you get – 4 – Documentation 1

Drawings	Duration (Weeks)
Cross-sectional drawing (pump)	8
Certified dimensional outline drawing (with allowable forces and moments)	8
Certified dimensional outline drawing (driver only)	10
Shaft seal drawing	10
Cross-sectional drawing (shaft seal)	10
Wiring diagram (driver)	10
Coupling assembly drawing	16
Documents	Duration (Wks)
Document index	5
Performance curve (predicted)	7
Production schedule	7
Inspection and Test Plan	6
Complete parts list (pump)	8
Spare parts list (pump)	8

HI Standard (Non-API 610) Build Quickship Pump

This is what you get – 5 – Documentation 2

Test Results	Duration (WAT)
Performance test data	2
Final Inspection report	2
Certified hydrostatic test data	In FDB
Material test report	In FDB
NDT report	In FDB
Balance data (impeller)	In FDB
Final Documentation	Duration (WAD)
IOM manual	In FDB
Final Data Book (all submitted documentation)	4 Weeks
Documentation package "1" items submitted individually (NOT ONLY IN Final Data Book)	NO



Coming Attractions 😊

“Single Case, Multistage, Radially Split Case Pumps, (API Type BB4)”

Thurs 9th April 2026 – 08.00 (UK GMT+1) (Eastern Hemisphere) & 17.00 (UK GMT+1) (Western Hemisphere)

This short course will look at BB4 Pumps with a particular emphasis on the Power Industry (Boiler Feedwater Pumps). They are also commonly used in the Reverse Osmosis & Desalination Market (which will be the subject of a future session).

Aimed at Process and Mechanical Engineers, and Consultant Engineers who specify pumping equipment as well as Applications & Sales Engineers selecting and quoting them



Specialist for Pumping Technology

Q & A

ssmith@ruhrpumpen.com

www.ruhrpumpen.com

marketing@ruhrpumpen.com

RUHRPUMPEN AT A GLANCE

**VERTICAL
INTEGRATION**

**SALES
OFFICES IN
+35 COUNTRIES**

**MANUFACTURING
FACILITIES
IN 10 COUNTRIES**

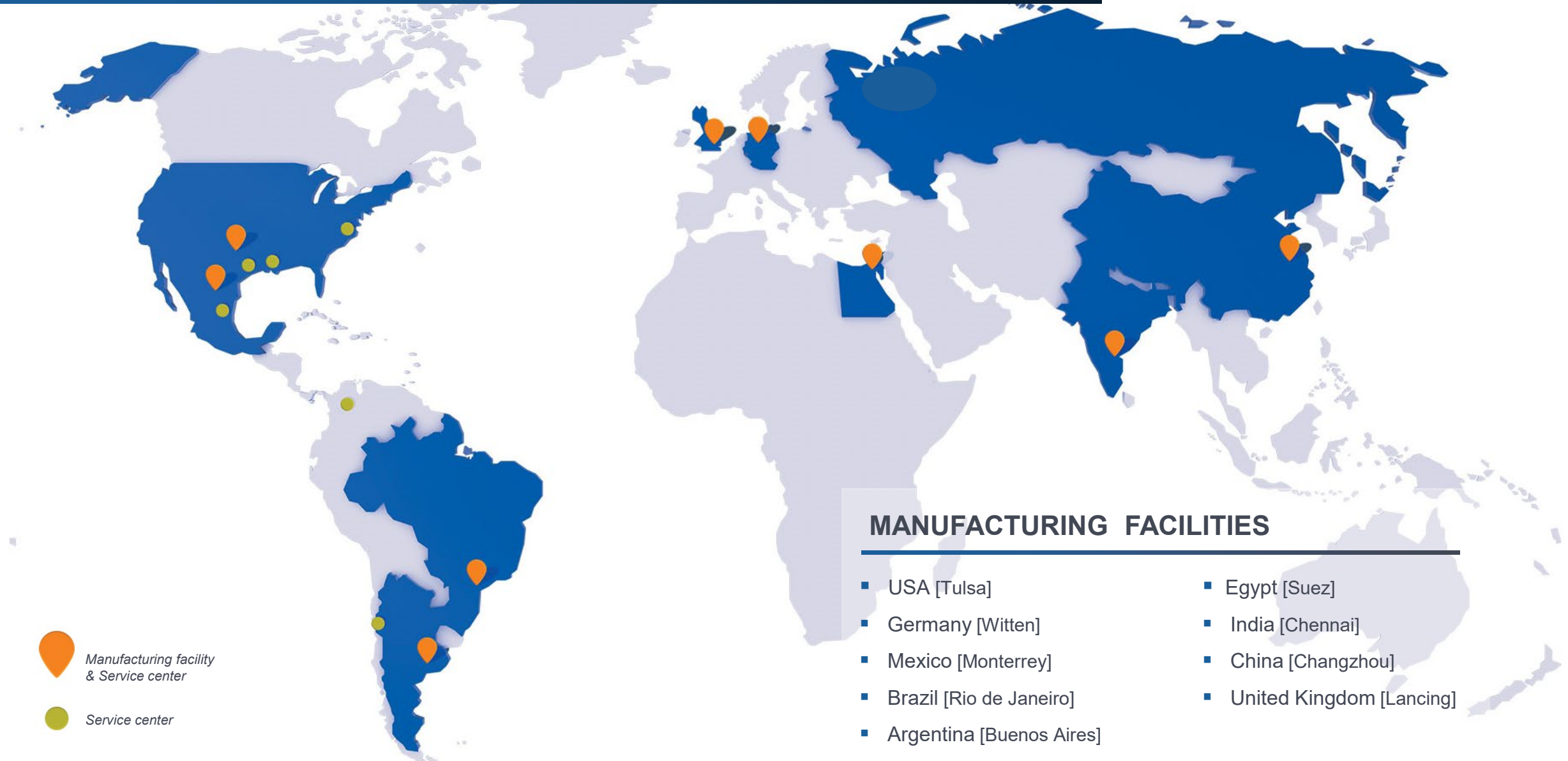
**+70 YEARS
OF EXPERIENCE**

**+2,000
EMPLOYEES**

**15 SERVICE
CENTERS**

+70,000 PUMPING SOLUTIONS INSTALLED WORLDWIDE

A GLOBAL COMPANY





MANUFACTURING FACILITIES

Monterrey, MX



Area: 18,000 m²
Testing: 7,500 HP

Tulsa, USA



Area: 29,000 m²
Testing: 2,000 HP

Witten, DE



Area: 48,000 m²
Testing: 8,850 HP

Changzhou, CN



Area: 15,000 m²
Testing: 6,000 HP

Lancing, UK



Area: 1,703 m²
Testing: 670 HP

Rio de Janeiro, BR



Area: 7,500 m²
Testing: 6,000 HP

Buenos Aires, AR



Area: 7,500 m²
Testing: 1,500 HP

Suez, EG



Area: 2,280 m²
Testing: 2,680 HP

Chennai, IN



Area: 11,000m²
Testing: 6,000 HP

MARKETS WE SERVE

Our commitment to create innovations that offer reliable solutions to our customers allow us to provide a complete range of pump systems to support **core markets** as:





OUR PUMP LINES

Ruhrpumpen offers a broad range of highly engineered and standard pumping products that meet and exceed the requirements of the most demanding quality specifications and industry standards.

Our pumps can handle head requirements as high as 13,000 ft (4,000 m) and capacities up to 300,000 gpm (68,000 m³/hr). Moreover, our pump designs cover temperatures from cryogenic temperatures of -310 °F (-196 °C) up to 752 °F (400 °C).

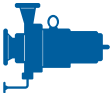
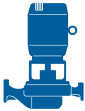
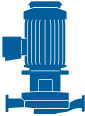


Products include:

- Single Stage Overhung Pumps
- Between Bearings Pumps
- Horizontal Multi-Stage Pumps
- Vertical Multi-Stage Pumps
- Vertical Mixed Flow & Axial Flow Pumps
- Positive Displacement Pumps
- Full Range of Industrial Pumps
- Submersible Pumps
- Magnetic Drive Pumps
- Decoking Systems
- Packaged Systems
- Fire Systems



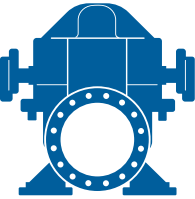
OVERHUNG PUMPS

CATEGORY	RP MODEL	DESIGN STANDARD	
Sealless Magnetic Drive Pumps	CRP-M / CRP-M-CC	ISO 2858 & 15783 HI design (OH11)	
	SCE-M	API 685	
Foot Mounted OH1 and General End Suction Pumps	IPP	HI design (OH1)	
	CPP / CPP-L	HI design (OH1) ANSI B73.1	
	CPO / CPO-L	HI design (OH1) ANSI B73.1	
	CRP	HI design (OH1) ISO 2858 & 5199	
	GSD	HI design (OH0)	
	SHD / ESK / SK / SKO SKV / ST / STV	HI design (OH1)	
	SWP	HI design (OH3A)	
Centerline Mounted	SCE	API 610 (OH2)	
Vertical In-Line Pumps	SPI	API 610 (OH3)	
	IVP / IVP-CC	HI design (OH4 / OH5)	
	IIL	HI design (OH5) Dimensionally compliant with ANSI B73.2	
	SPN	API 610 (OH5)	





BETWEEN BEARING PUMPS

CATEGORY		RP MODEL	DESIGN STANDARD	
1 and 2 stage	Axially split	HSC / HSD / HSL HSR / ZW	HI design (BB1)	
		HSM	HI design (BB3)	
		ZM / ZMS ZLM / ZME	API design (BB1)	
	Radially split	HVN / J	API design (BB2)	
		RON / RON-D	API design (BB2)	
Multi-stage	Axially split	SM / SM-I	API design (BB3)	
		JTN	API design (BB3)	
	Radially split <i>single casing</i>	GP	API design (BB4)	
	Radially split <i>double casing</i>	A LINE	API design (BB5)	





VERTICAL PUMPS

CATEGORY		RP MODEL	DESIGN STANDARD	
Single casing	Diffuser	VTP	HI & API 610 (VS1)	
		VCT	HI & API 610 (VS1)	
		HQ	HI & API 610 (VS1)	
		VLT	HI & API 610 (VS1)	
	Volute	DSV / DX	HI & API 610 (VS2)	
	Discharge through column – Axial flow	VAF	HI & API 610 (VS3)	
Double casing	Separate discharge line	VSP / VSP-Chem	HI & API 610 (VS4)	
	Diffuser	VLT / VMT	HI & API 610 (VS6)	
	Volute	DSV / DX	HI & API 610 (VS7)	
Submersible pumps		SMF	HI design (OH8A)	
		VLT-Sub / VTP-Sub	HI design (VS0)	





SPECIAL SERVICE PUMPS

CATEGORY	RP MODEL	DESIGN STANDARD	
Pitot tube pumps	COMBITUBE	HI design	
Reciprocating pumps	RDP	API 674 ISO 13710	
Vertical turbine generator	VTG	HI design (VS6)	
Barge	LS BARGE	HI design	
Floating dock pumps	ZVZ	HI design	
	LVZ	HI design	
Cryogenic pumps	SVNV	-	
	VTG Cryogenic	-	
	VLT Cryogenic VLTV	-	
Pre-packaged fire pump systems	Fire systems incorporate pumps, drivers, control systems and pipework in a single container. They can be skid mounted, with or without enclosure and supplied with electric motor or diesel engine.		
		NFPA-20-850 UL and FM approved components	

