

 **GOULDS PUMPS**

Goulds 3600

Between-Bearing, Axially Split,
Multistage Pump



avrorarm.ru
+7 (495) 956-62-18



ITT

ENGINEERED FOR LIFE

Goulds 3600

A Leader in API Engineered Pump Package Solutions...

Proven API Leadership

ITT Goulds Pumps is a proven leader in API Pumps

- Over 20,000 units installed
 - Over 17,000 OH2 / OH3s
 - Over 3,000 BB1 / BB2 / BB3 pumps
- 40+ years of API expertise
- Participating member on API 610 and API 682 committees

Family of API Pumps

ITT Goulds Pumps has a family of proven API pumps:

- Overhung pumps
- Single and two-stage between-bearing
- Multistage between-bearing pumps – axially split
- Barrel multistage - radially split
- Vertical, double casing pumps
- Specialty pumps

Industry Leading Hydraulic Coverage

- We offer extensive coverage to meet your process needs.
- Better hydraulic fits can mean improved efficiency and long-term reliability and parts life.

8000 HP / 6000 kW Testing Capability

- Our expanded test facility can test your pump in the most demanding conditions.
- Testing at rated speeds is critical to assess the impact of dynamic conditions including vibration.

API Engineering Expertise

- We are experts in packaging engineered pumps that meet your demanding applications – with true conformance to the latest API specifications.
- We have extensive experience in nearly every type of driver, bearing, seal, piping configuration, nozzle configuration, flange and baseplate design to meet your application needs.
- ITT is a world leader in technology and engineering including hydraulics, materials science, mechanical design and fluid dynamics.

Broad Applications

- Petroleum refining, production and distribution
- Petrochemical and demanding chemical processing
- High temperature applications including boiler circulation
- General industrial requiring high temperature or high pressures



Goulds 3600

Proven Leadership

ITT Goulds Pumps is a proven leader in Multistage and API Pumps with several thousand engineered multistage pumps sold and 40+ years of multistage pump expertise.



Heavy-Duty Multistage Pumps Designed for High-Head / High Capacity Services

- Capacities to 8,500 GPM (1930 m³/h)
- Heads to 9,000 feet (2740 m)
- Temperatures to 400° F (205° C)
- Pressures to 4,000 PSIG (275 bar)
- API 610 API / ISO 13709 Latest Edition (API BB3 Compliance is Available)

Design Features

- **Engineered Hydraulics:** dense hydraulic coverage to better match your process for efficiency and reliability. Custom hydraulics are available.
- **Engineered Packaging** with a wide range of drivers, seals, piping, nozzle configurations, flanges, baseplates and QC testing.
- **Axially Split Casing** for ease of maintenance.
- **Dual Volute Design** balances hydraulic radial thrust at each stage for extended seal/bearing life.
- **Heavy Duty Single Row Bolting** prevents distortion and chance of interstage leakage.
- **Precision Cast Impellers:** smooth, dimensionally consistent hydraulic passages for maximum efficiency.
- **Compact Crossover** for streamlined fluid flow, minimum friction loss and maximum efficiency.
- **Dynamically Balanced Impellers and Rotors** ensure smooth operation and increased reliability.

Applications

The model 3600 is a robust solution for a variety of applications. This is an API pump for refineries, injection offshore platforms, remote pipeline, boiler feed in mid-range cogeneration, descaling, mine dewatering, process transfer, desalination and CO₂ injection.

Goulds 3600

Design Features for Optimum Reliability

Low Vibration / Smooth Performance

- Individual impellers and complete rotor assembly dynamically balanced.
- Shrink fit of impellers to shaft ensures precise balancing of rotating assembly.
- Precision cast impellers have equal volumes between vanes for reduced pressure pulsations.
- Impellers are mounted on shaft with vane tips staggered for reduced pressure pulsations.



Staggered impeller vane tips reduce pressure pulsations at vane passing frequency.

Serviceability

- Cartridge type mechanical seals for ease of assembly, proper installation.
- Single row bolting with stud nuts located on upper half for easy accessibility.

Entire rotating assembly can be removed for maintenance without disturbing suction/discharge piping.



Single row bolting simplifies disassembly / reassembly.



Split stage pieces and center case bushing can be removed for inspection of wear surfaces without disassembling rotor assembly.



Designed for API 610 11th Edition / ISO 13709 Services

- Casing, nozzles and baseplate meet API 610 / ISO 13709 nozzle load requirements.
- Impellers are shrink fit to shaft and independently secured against axial movement.
- Seal chambers meet dimensional requirements of API 610 / ISO 13709 and can be fitted with single, double or tandem cartridge mechanical seals.
- Non metallic rings available for applications with low specific gravity, or for increased efficiency or ability to withstand short periods of dry running
- Impellers and rotating equipment element dynamically balanced to API 610 / ISO 13709 requirements.



Design / Analysis Capabilities

Casing pressure capability and structural design developed and refined using advanced finite element analysis. Goulds engineering staff is fully equipped to perform the rotor lateral response analysis and residual unbalance checks necessary to ensure stable operation and low vibration levels.

Thermal transient analysis using finite element models used to determine allowable casing temperature rise and ensure mechanical reliability.

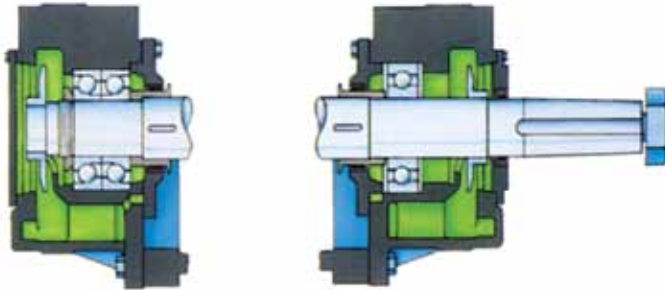
Hydraulic designs developed using dynamic flow models ensure stable performance with consistent, high efficiency levels.



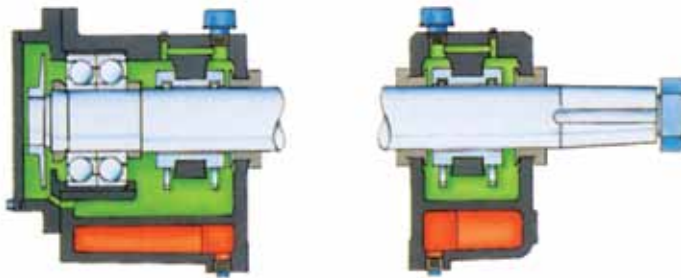
Optional Features for Application Flexibility

Bearing Arrangements

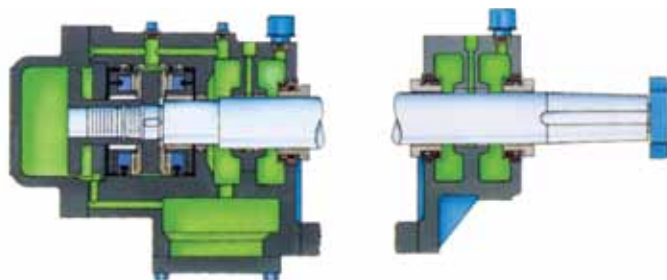
Oil lubricated ball radial and duplex thrust bearings are standard on the Model 3600. Ring oil lubricated sleeve radial and ball thrust or pressure lubricated sleeve radial and tilting pad thrust bearings can be furnished to meet customer or operating requirements. Hydrodynamic bearings offered with pressurized oil lube systems.



Duplex Ball Thrust / Ball Radial Bearings



Duplex Ball Thrust / Sleeve Radial Bearings



Tilting Pad Thrust / Sleeve Radial Bearings

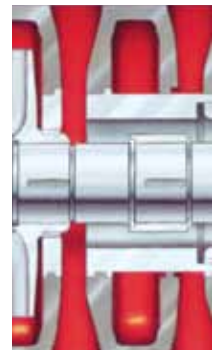
Double Suction First Stage Impeller

Available on 4-inch and larger discharge size pumps for services where $NPSH_A$ is limited.



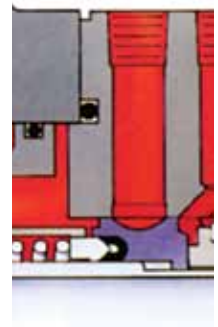
Shaft Sealing and Seal Chambers

Seal chambers meet API 610 / ISO 13709 dimensional requirements. We offer any available seal and seal systems that are appropriate for your specific application including API 682 seals.



Destaging

Goulds Model 3600 can be supplied with one or more blank stages to meet existing head conditions and allow for future increases. The shaft is protected by a sleeve to maintain the impeller fit. A bypass cylinder ensures smooth, even flow to the next impeller.



Instrumentation

The 3600 can be furnished with instrumentation options to measure vibration and temperature. RTDs or thermocouples can be furnished to measure bearing temperatures and to monitor temperature rise in the casing. Bearing housing vibration can be monitored on pumps furnished with ball bearings. Pumps supplied with sleeve bearings can be furnished with non-contacting vibration probes to measure actual rotor vibration.

Interstage Bleedoff

Interstage bleedoff available for multiple discharge conditions

Model 3600

Between-Bearing, Axially Split, Multistage Pump

DUAL VOLUTE CASING

Assures radial balance, minimum shaft deflection.

SINGLE ROW BOLTING

All nuts located on top for ease of maintenance.

DYNAMICALLY BALANCED IMPELLERS AND ASSEMBLED ROTATING ELEMENT

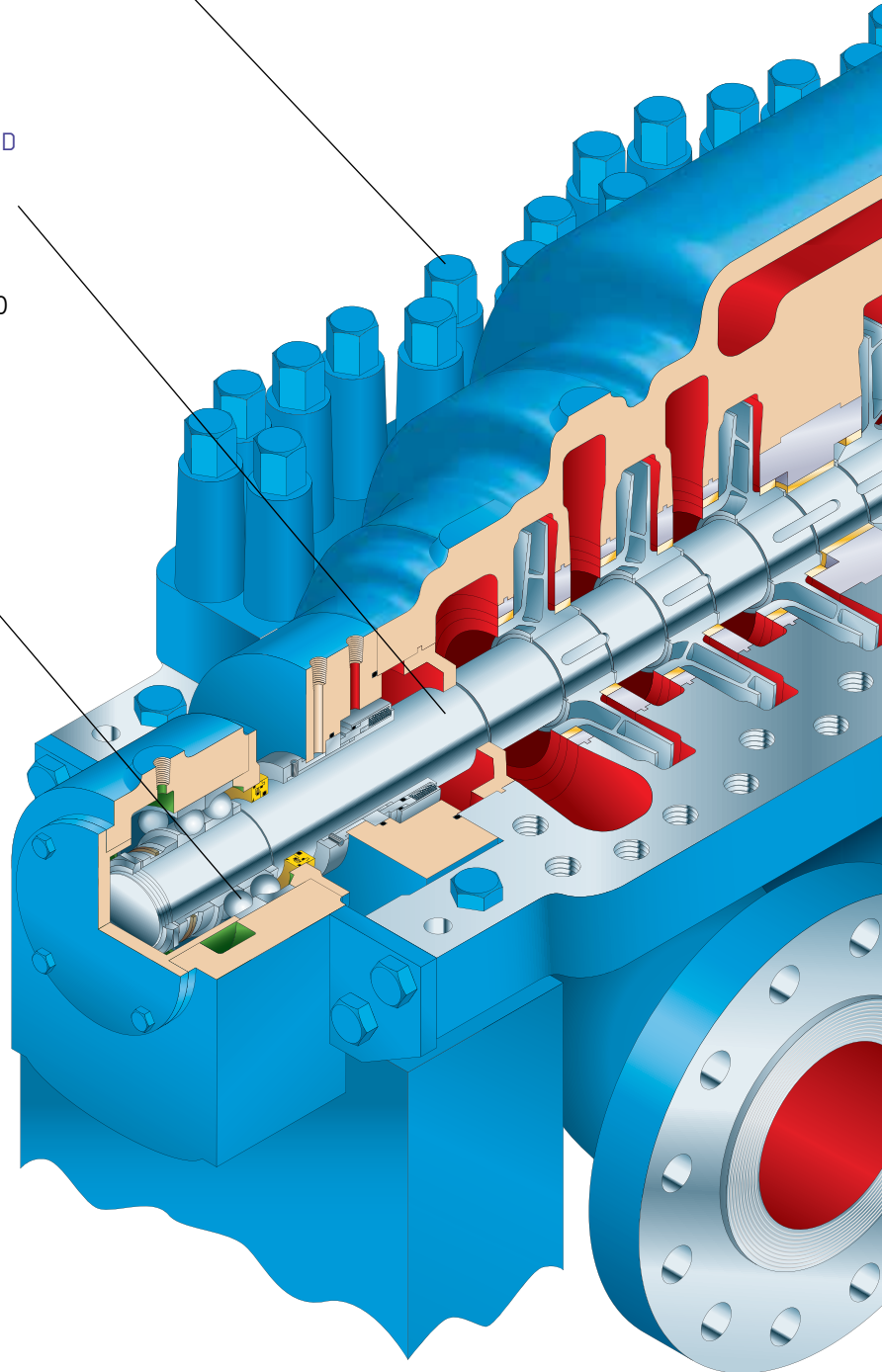
For smooth vibration-free operation. Impellers staggered on shaft to minimize vane-pass vibration. Rotor and impeller balanced to stringent ISO 1940 Grade 1.0 (exceeds API minimum).

HEAVY DUTY BEARINGS

Oil lubricated ball radial and duplex thrust standard; sleeve radial / ball thrust also available, or pressure lubricated sleeve radial and tilt pad thrust.

DOUBLE SUCTION FIRST STAGE IMPELLER

Available for low NPSH service requirements.





COMPACT CROSSOVERS

For streamlined fluid flow – minimum friction loss, maximum efficiency.

ISO 13709 / API-610

SEAL CHAMBERS

Accept wide range of sealing options including seals conforming to ISO 13709 / API 610, packing, cartridge and conventional mechanical seals.

PRECISION CAST IMPELLERS

Investment cast impellers yield smooth, dimensionally consistent hydraulic passages which maximize efficiency; double suction first stage available for low NPSH applications.

POSITIVELY DRIVEN IMPELLERS

Key driven with shrink fit and secured against axial movement in both directions. Allows precise balancing of rotating element.

OPPOSED IMPELLER ARRANGEMENT

Provides permanent hydraulic axial balance, impellers staggered on shaft to minimize vibration due to vane pass.

SPLIT STATE PIECES AND CENTER BUSHING

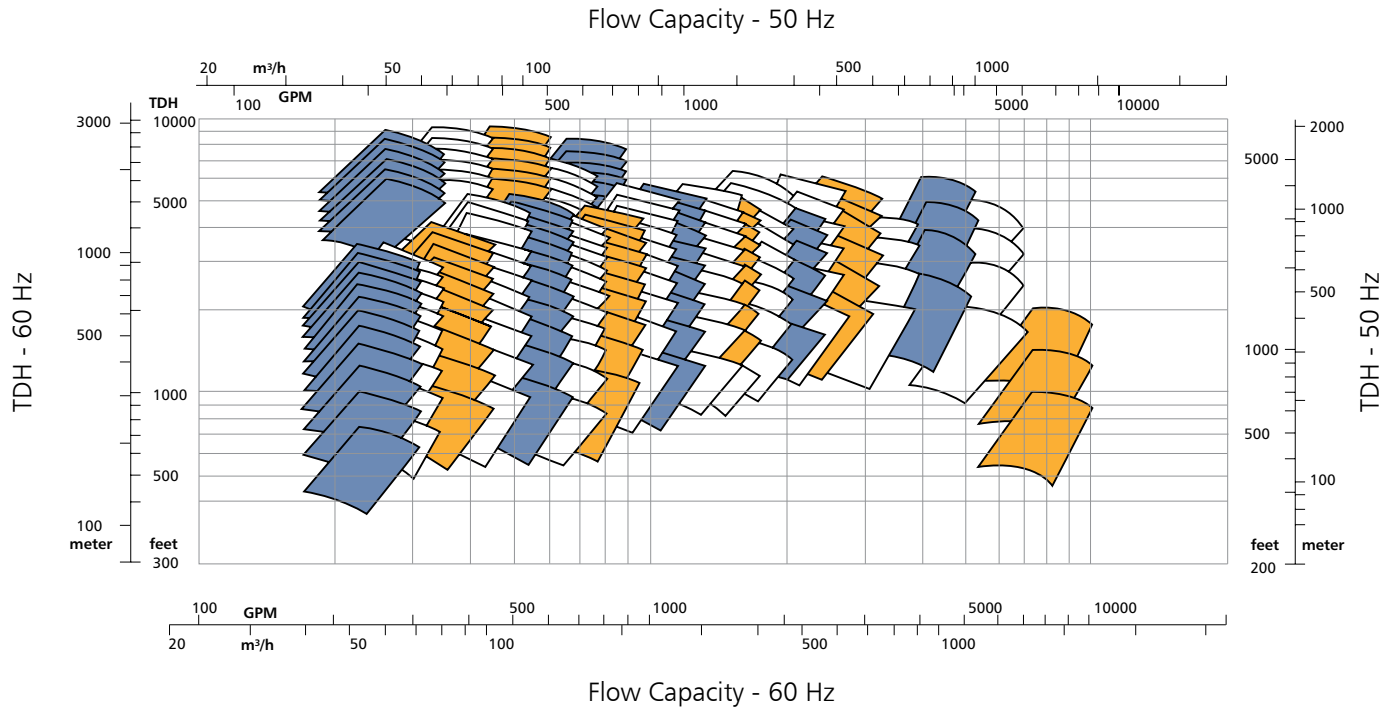
Allow dynamic balancing of assembled rotating element.

HEAVY DUTY ANSI B16.5 FLANGES

Class 900 RF standard on suction and discharge; other classes available as options.

Goulds 3600

Hydraulic Coverage 60 Hz and 50 Hz



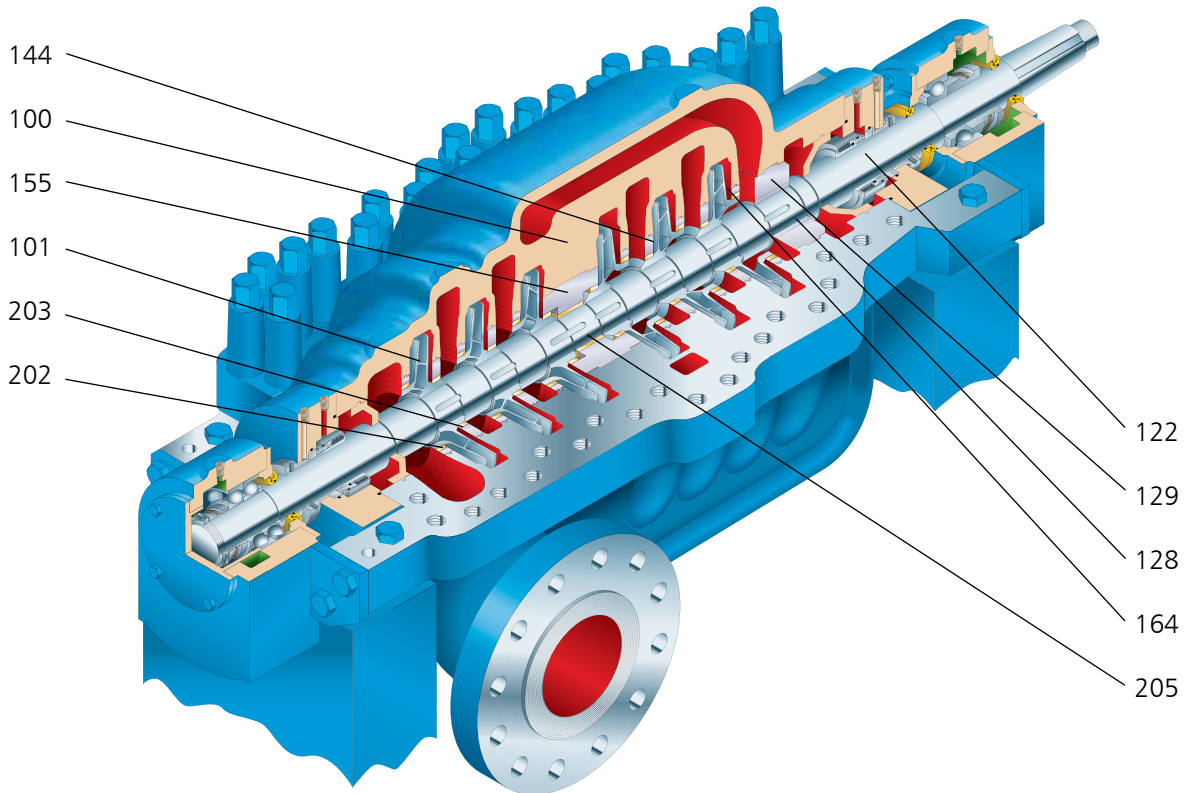
Pump Installations

The Goulds Model 3600 is built to handle the toughest services in harsh environments. These pictures show demanding installations in the deserts of the Middle East and Australia.



Goulds 3600

Sectional View

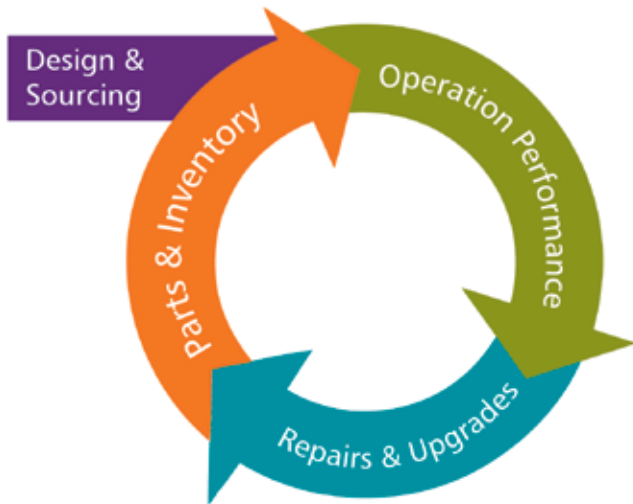


Parts List and Materials of Construction

Item	Part Name	S-6	S-8	C-6	A-8	D-1	D-2
100	Casing	Carbon Steel		12% Chrome	316L SS	Duplex SS	S. Duplex SS
101	Impeller	12% Chrome	316L SS	12% Chrome	316L SS	Duplex SS	S. Duplex SS
122	Shaft	17-4 ph	Nitronic 50	17-4 ph	Nitronic 50	Duplex SS	S. Duplex SS
202, 203	Wear Ring - Impeller **	17-4 ph	Nitronic 60	12% Chrome	Nitronic 60	Duplex SS/ Stellite 12	S. Duplex SS/ Stellite 6
128	Throttle Sleeve	Nitronic 60				Duplex SS	S. Duplex SS
205	Center Sleeve	Nitronic 60				Duplex SS	S. Duplex SS
164	Wear Ring - Casing **	420 SS	316L SS	420 SS	316L SS	Duplex SS	S. Duplex SS
129	Throttle Bushing	420 SS	316L SS	420 SS	316L SS	Duplex SS	S. Duplex SS
144	Stage Pieces (rings)	420 SS	316L SS	420 SS	316L SS	Duplex SS	S. Duplex SS
155	Center Bushing	420 SS	316L SS	420 SS	316L SS	Duplex SS	S. Duplex SS

* 410 SS on S-6 when temperature exceeds 350°F (175°C)

* Not utilized on 3700LF low flow pumps.



Reliability has no quitting time.

PRO Services provides an array of services focused on reducing equipment total cost of ownership (TCO) and increasing plant output, including predictive monitoring, maintenance contracts, field service, engineered upgrades, inventory management, and overhauls for pumps and other rotating equipment.



PRO Services provides OEM parts for Goulds Pumps, Bornemann Pumps, AC, Morris, Goynes, CB, HVC, UXN and ROV in a timely manner to meet end user requirements. Significant levels of inventory and quick response capability provides the necessary programs to meet all repair needs.

PRO Services provides programs of reliability services, energy assessments, asset management and training. These can be deployed as stand-alone or integrated solutions, tailored to the needs of your company.

PRO Services provides an array of repairs and upgrades services to extend equipment life. PRO Services helps customers develop effective maintenance and asset management programs to lower maintenance costs, improve uptime, reduce inventory costs and extend equipment life.

A Leader in API Engineered Pump Package Solutions

API Family of Pumps

Model 3700
OH-2



Model 3910
OH-3

Model 3620
3640
BB-2



Model 3610
BB-1



API Type	Goulds Model	Capacity GPM (M ³ /Hour)	TDH Feet (Meters)	Temperature °F (°C)	Pressure PSIG (kg/cm ²)
OH-2	3700	8500 (1930)	1200 (360)	800 (425)	870 (60)
OH-3	3910	6000 (1360)	750 (230)	650 (340)	600 (42)
BB-1	3610	50000 (11355)	700 (215)	300 (150)	300 (21)
BB-2	3640	7500 (1700)	2500 (760)	850 (455)	1130 (75)
BB-2	3620	20000 (4540)	1500 (455)	850 (455)	1000 (70)
BB-3	3600	8500 (1930)	9000 (2740)	400 (205)	4000 (275)
BB-5	7200CB	4000 (910)	9000 (2740)	800 (425)	4000 (275)
VS4	API 3171	3180 (720)	525 (160)	450 (232)	750 (50)
VS1	VIT	70000 (14760)	3500 (1060)	500 (260)	2500 (175)
VS6	VIC	70000 (14760)	3500 (1060)	500 (260)	2500 (175)



Model 3600
BB-3



Model 7200CB
BB-5



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