

ASME B73.1-2020
(Revision of ASME B73.1-2012)

Specification for Horizontal End Suction Centrifugal Pumps for Chemical Process

AN AMERICAN NATIONAL STANDARD



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Mechanical Engineers**

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CONTENTS

Foreword	v
Committee Roster	vi
Correspondence With the B73 Committee	vii
1 Scope	1
2 References	1
3 Alternative Designs	8
4 Nomenclature and Definitions	8
5 Design and Construction Features for Metallic Pumps	8
6 Design and Construction Features for Thermoplastic and Thermoset Polymer Material Pumps	20
7 General Information	25
8 Documentation	28
 Mandatory Appendices	
I ASME Centrifugal Pump Data Sheet (As of November 2019)	32
II Mechanical Seal and Packing Configuration Codes	41
 Nonmandatory Appendix	
A Electronic Data Exchange	43
 Figures	
5.5.3-1 Shaft Sleeve Runout	10
5.6.2-1 Cylindrical Seal Chamber	11
5.6.2-2 Self-Venting Tapered Seal Chamber	11
5.6.2.1-1 Seal Chamber Face Runout	12
5.6.2.1-2 Seal Chamber Register Concentricity	12
5.6.3-1 Universal Cover	13
5.6.4-1 Packing Box	14
5.13.8-1 Pump With C-Face Motor Adapter, Short Coupled	21
6.6.3-1 Cover With Bolt on Seal Chamber	23
6.6.5-1 Cover With Clamp Ring	23
8.3.1 Sample Outline Drawing	29
II- Mechanical Seal and Packaging Configuration Codes	42
 Tables	
1-1 Pump Dimensions	2
1-2 Baseplate Dimensions	5
5.8.1.2-1 Pump Material Classification Codes	15

5.8.1.3-1	ASTM Material Specifications	16
5.8.3.1-1	Minimum Requirements for Auxiliary Piping Materials	17
5.12.1-1	Welding Requirements	18
6.1.1.1-1	Thermoplastic and Thermoset Pump Minimum Design Pressures	21
7.1.9.1-1	Published Performance Curve Rated Speeds	26
7.2.2.3-1	Specified Nondestructive Testing Levels	28
 Forms		
I-1	Centrifugal Pump Data Sheet (U.S. Customary)	33
I-1M	Centrifugal Pump Data Sheet (SI)	37

FOREWORD

In 1955, the Standards Committee on Centrifugal Pumps for Chemical Industry Use, B73, undertook the development of centrifugal pump standards to meet the needs of the chemical industry. Although the Standards Committee had not completed its assignment, the work of one of its task forces resulted in the development of a de facto standard that was published by the Manufacturing Chemists Association in 1962 as an American Voluntary Standard (AVS). More than a dozen manufacturers of chemical process pumps marketed pumps conforming with the AVS.

In 1965, the Hydraulic Institute published a tentative standard similar in content to the AVS, but updated certain portions. Although the Hydraulic Institute Tentative Standard reflected more nearly the current practice of manufacturers and users, it was believed necessary to publish a new document that would supersede both the original AVS and the tentative standard, and that could incorporate the technical content of both documents and dimensional criteria and features generally accepted by manufacturers and users. The January 1968 revision of the AVS was therefore approved as an American National Standard under the existing standards method and published as ANSI B123.1-1971.

ANSI B73.1 superseded ANSI B123.1-1971 and was first published in 1974. The 1974 edition brought to 15 the number of pump sizes covered by the standard. The committee continued to be active, adding 3 more sizes for a total of 20, and making a number of revisions in the text of the standard.

Shortly thereafter, the American National Standards Committee B73 undertook to revise the standard, and, as a result, new information on baseplate rigidity, bearing frame adapter, and bearing housing drain was introduced. The 1984 edition included, for the first time, information that covered documentation of the pump and driver outline drawing of the centrifugal pump, data sheet, mechanical seal drawing, packing box piping plans, and cooling/heating piping plans.

The 1991 revision included larger and self-venting tapered seal chambers, as well as conventional packing boxes; revised baseplate dimensions, with a new identification numbering system; and a ductile material requirement for the bearing frame adapter if it clamps the rear cover plate to the casing.

With the expanding utilization of the ASME B73.1 pumps in the chemical process industry and its growing acceptance in the hydrocarbons processing industry, the B73 committee continued to improve the B73.1 standard. The 2001 revision of the standard incorporated 7 new sizes of pumps, bringing the total number to 27. Many of the new additions were at the request of the user population. Inclusion of ISO standard size pumps was considered by the committee. It was consensus that the ISO inclusion would have made the B73.1 standard overly complex and weakened its mechanical fortitude. Thus, this action was rejected by the committee. The "Materials of Construction" section of the standard was expanded to include readily available corrosion-resistant alloys. Recent publications by the Hydraulic Institute in areas such as baseplate tolerance, acceptable nozzle load, preferred operating region, and NPSH margin were incorporated into this revision. A standardized electronic data exchange file specification was established as an integral portion of the standard. This was, in part, in response to the needs of the user community for compliance to U.S. government regulations covering chemical process equipment and plants, specifically OSHA Process Safety Management, 29 CFR 1910.119. In total, these revisions to the standard were intended to better serve process industries and expand the use of ASME B73 pumps worldwide.

The 2012 revision of the standard includes several changes to reduce redundancy in the B73 set of standards and to better align with the Hydraulic Institute (HI) and American Petroleum Institute (API) pump standards. Revisions have also been made to further improve the reliability of the B73.1 pumps. ASME standard B73.5 on solid polymer pumps has been merged into B73.1 due to the many similarities of the two standards. B73.5 will be withdrawn. Reference is now made to API practices for mechanical seal configurations and cooling and heating plans. A mechanical seal configuration code and a material classification code have been added to B73.1. A universal cover has been added to the standard as an alternative to the existing cover. Requirements for the bearing frame have been revised to assure more robust pumps. C-face motor adapters are now an option. The default performance test acceptance grade has been revised to reflect the new HI/ISO performance test standard. More detail has been added to the required drawings, curve, and documentation that should be included with the pump. A new data sheet has been developed and added to the standard. The standard endorses the electronic data exchange standard that was developed by the Hydraulic Institute and Fiatech Automating Equipment Information Exchange (AEX) project.

This revision was approved as an American National Standard on March 19, 2020.

ASME B73 COMMITTEE

Chemical Standard Pumps

(The following is the roster of the Committee at the time of approval of this Standard.)

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Proposing Revisions. Revisions are made periodically to the Standard to incorporate changes that appear necessary or desirable, as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published periodically.

The Committee welcomes proposals for revisions to this Standard. Such proposals should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent documentation.

Proposing a Case. Cases may be issued to provide alternative rules when justified, to permit early implementation of an approved revision when the need is urgent, or to provide rules not covered by existing provisions. Cases are effective immediately upon ASME approval and shall be posted on the ASME Committee web page.

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SPECIFICATION FOR HORIZONTAL END SUCTION CENTRIFUGAL PUMPS FOR CHEMICAL PROCESS

1 SCOPE

(a) This Standard is a design and specification standard that covers metallic and solid polymer centrifugal pumps of horizontal, end suction single stage, centerline discharge design. This Standard includes dimensional interchangeability requirements and certain design features to facilitate installation and maintenance and to enhance reliability and safety of B73.1 pumps. It is the intent of this Standard that pumps of the same standard dimension designation from all sources of supply shall be interchangeable with respect to mounting dimensions, size, and location of suction and discharge nozzles, input shafts, baseplates, and foundation bolt holes (see [Tables 1-1](#) and [1-2](#)). Maintenance and operation requirements are not included in this Standard.

(b) This Standard has been revised to include solid polymer pumps formerly covered under ASME B73.5. The design and construction features for metallic pumps are covered in [section 5](#). The design and construction features for solid polymer pumps are covered in [section 6](#). This Standard must be read in its entirety for proper application.

(c) This Standard has been revised to broaden the scope to include specialty designs developed for ASME B73.1 product line platforms. These specialty designs have many common components with the B73.1 models and meet the intent of the standard except for most notably the standard's dimensional and hydraulic coverage requirements. These specialty designs include pump models referred to as self-primer, recessed impeller, low flow, and vane pump pumps.

(d) Sealless Pumps (Magnetic Drive and Canned Motor) are covered in ASME B73.3.

2 REFERENCE

The following documents form a part of this Standard to the extent specified herein. The latest edition shall apply.

ANSI Z39.1-19, Performance Criteria for Safeguarding
 Publisher: Association for Manufacturing Technology (AMT), 7901 Jones Branch Drive, Suite 900, McLean, VA 22102-3316 (www.amtonline.org)

ANSI/ABMA-9, Load Ratings and Fatigue Life for Ball Bearings

ANSI/ABMA-11, Load Ratings and Fatigue Life for Roller Bearings

Publisher: American Bearing Manufacturers Association (ABMA), 1001 N. Fairfax Street, Suite 500, Alexandria, VA 22314 (www.americanbearing.org)

ANSI/AGMA 9000, Flexible Couplings – Potential Unbalance Classification

ANSI/AGMA 9002, Bore and Keyways for Flexible Couplings (Inch Series)

Publisher: American Gear Manufacturers Association (AGMA) 1001 North Fairfax Street, Suite 500, Alexandria, VA 22314 (www.agma.org)

ANSI/HI 1.4, Rotodynamic (Centrifugal) Pumps for Manufacturers Describing Installation, Operation and Maintenance

ANSI/HI 9.1-9.5, Pumps — General Guidelines for Types, Definitions, Application, Sound Measurement and Decontamination

ANSI/HI 9.6.1, Rotodynamic Pumps — Guideline for NPSH Margin

ANSI/HI 9.6.2, Rotodynamic Pumps for Assessment of Applied Nozzle Loads

ANSI/HI 9.6.3, Rotodynamic (Centrifugal and Vertical) Pumps — Guideline for Allowable Operating Region

ANSI/HI 9.6.4, Rotodynamic Pumps Vibration Measurements and Allowable Values

ANSI/HI 9.6.8, Dynamics of Pumping Machinery

ANSI/HI 14.1-14.2, Rotodynamic Pumps for Nomenclature and Definitions

ANSI/HI 14.3, Rotodynamic Pumps for Design and Application

ANSI/HI 14.6, Rotodynamic Pumps for Hydraulic Performance Acceptance Tests

Publisher: Hydraulic Institute (HI), 6 Campus Drive, Parsippany, NJ 07054-4406 (www.pumps.org)

API Std 610, Centrifugal Pumps for Petroleum, Petrochemical and Natural Gas Industries

API Std 682, Pumps — Shaft Sealing Systems for Centrifugal and Rotary Pumps

Publisher: American Petroleum Institute (API), 200 Massachusetts Avenue NW, Suite 1100, Washington, DC 20001-5571 (www.api.org)