Goulds API 3600 i-FRAME®
API BB3 Between-Bearing, Axially Split, Multistage Pump
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
- 50+ 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
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

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.
- **Bearing Housing**: Filter

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.

i-FRAME™ Bearing Housing Features

- This modern i-FRAME™ Ball/Ball design bearing housing comes standard on all Goulds between-bearings pumps. A revolutionary oil capture and delivery system provides consistent lubrication to lower bearing temperatures and optimize bearing life.
- See the difference
  - Patent Pending Oil Filter Assembly removes debris and moisture
  - Optimized Housing Design Lowers bearing temperatures up to 6.7+ °C (20+ °F)
  - i-ALERT2 Machine Health Monitor identifies potential problems before they become costly failures
  - Instrumentation provisions as standard
3600 i-FRAME®
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.
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.

SPLIT STAGE 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.

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

OPPOSED IMPELLER ARRANGEMENT
Provides permanent hydraulic axial balance, impellers staggered on shaft to minimize vibration due to vane pass.
3600 i-FRAME®

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.

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.

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

Designed for API 610 11th Edition / ISO 13709 Services
- Casing, nozzles and baseplate meet API 610 / ISO 13709 nozzle load requirements.
- 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
Goulds utilizes FEA and CFD analysis to check the pressure capability, structure integrity of the casings and flow pattern in the pump. Goulds Engineering staff is fully equipped to perform the Rotor Lateral response analysis, Torsional analysis and Rotor residual unbalance checks to ensure stable operation, low vibration level and trouble free operation of the pumps.
Optional Features for Application Flexibility

**Bearing Arrangements**
Oil lubricated Ball/Ball bearings are standard on the Model 3600. Ring oil lubricated Sleeve/Ball or pressure lubricated Sleeve/Tilt bearings can be furnished to meet customer or operating requirements. Hydrodynamic bearings are offered with pressurized oil lube system.

**Double Suction First Stage Impeller**
Available on 4-inch and larger discharge size pumps for services where NPSH<sub>a</sub> is limited.

**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.

**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 and seal systems.

**Instrumentation**
The 3600 can be furnished with instrumentation options to measure vibration and temperature. RTDs can be furnished to measure bearing temperatures and to monitor temperature rise in the casing. Bearing housing vibration can be monitored on pumps. Pumps supplied with Hydrodynamic bearings can be furnished with non contacting vibration probes to measure rotor vibration.

**Interstage Bleedoff**
Interstage bleedoff available for multiple discharge conditions.
Bearings & Bearing Housings

To get superior MTBF you need two things: Optimum pump hydraulics and a robust pump structure. The new i-FRAME housings delivers on the second point by providing a premium robust housing with unique new and improved features that raises the bar on what you can expect from your pump’s long term performance. These i-FRAME bearing housings include the new patented one piece design bearing housing for the ball/ball bearing arrangement, as well as the patent pending split bearing housing for the sleeve/ball and sleeve/tilt pad bearing arrangement.

Bearing housings constructed in ASTM A216 Grade WCB carbon steel. Three bearing arrangements available:

- **Ball/Ball bearings**
  - Duplex 40° Angular Contact Bearing Set on the Non-Drive End (NDE) to handle radial and axial loads. Bearing set is supplied with a light clearance.
  - Deep Groove Ball Bearing on the Drive End (DE) to handle radial loads.

- **Sleeve/Ball bearings**
  - Duplex 40° Angular contact Bearing Set on the Non-Drive End (NDE) handle axial loads. Bearing set is supplied with a light clearance.
  - Babbitt lined Sleeve Bearings handle radial loads on NDE and DE (Non Drive End and Drive End).

- **Sleeve/Tilt pad bearings**
  - Babbitt lined Sleeve Bearings handle radial loads and are installed on NDE and DE (Non Drive End and Drive End).
  - Tilting pad Bearings are installed on NDE to handle axial load.
  - This bearing configuration utilizes an external pressurized LOS to lubricate and cool the bearings. Both API, standard and custom designed systems can be offered.

All bearing housings feature a 180° bearing saddle bolted to the casing positioned with precision dowels for accurate, repeatable alignment. The 180° bearing saddle is optimized for stiffness and rigidity of connection between the pump casing and housing along with increased bolt diameters. This provides significantly increased stiffness compared to the previous design housings, resulting in reduced vibration.

The bearing housing exterior includes distinctive cooling fins optimized by CFD/FEA analysis to aid in heat dissipation.

The Ball/Ball and Sleeve/Ball i-FRAME bearing housings have enhanced air cooling with axial fans and achieves metal and oil temperature reductions of up to 30° F from previous design without the need for cooling water. The NDE side comes standard with a guarded extension to accept a fan for ease of field retrofit, so if your process needs change the fan can be fitted without the need for expensive pump disassembly and installation.
Bearing oil contamination often discussed as black oil, caused by wind-blown sand and dust together with atmospheric moisture are major contributors to bearings failing well before their design life. In an industry first, all self-contained bearing housings include a cartridge filter assembly that will help safeguard the bearing oil from debris contamination.

The patent pending filter cartridge will also continuously work to scrub water from the bearing oil utilizing specifically engineered moisture absorbing materials built into the filter.

The design allows for easy changeover of filter cartridges even while the pump is operating – no need to stop your process. All this additional reliability is achieved without the need for additional oil pumps or piping – no additional system complexity, monitoring or control overhead.

You change the oil and filter in your car, and it doesn’t have a sight glass

• Black oil caused by debris and moisture contaminating the oil.

• Multi-functional filter assembly captures oil and circulates down through filter and liquid absorbing beads.

• Filter captures debris and beads absorb any water that may be present.

• Moisture absorbing beads are non-toxic and biodegradable.

• New bearing housings designed so oil is thrown by oil ring to trough that leads to the oil filter assembly.

Typical oil change interval was every 3 months. That is extended to every 6 months with the filter. Pump doesn’t need to be stopped in order to change the filter.
i-ALERT® Monitoring Solution
Sensor | App | Ai Platform  www.i-alert.com

What it Does:

Monitor
Tracks vibration, temperature & run-time hours 24/7/365.

Alarm
Takes high resolution data when an alarm condition occurs and stores it for later analysis.

Trend
Captures data every 1-60 minutes and has up to 170 days of hourly on-board storage.

Analyze
Diagnose machine faults with vibration tools
Fast Fourier Transform (FFT) & Time Wave Form Analysis.

Environment
Rated for any industrial environment. water & dust resistant.
Intrinsically Safe with a 3-year battery life (use dependent).
• ATEX Zone 0 AEx ia IIB Ga (Groups C & D)

Wireless
Sync data via Bluetooth Smart enabled smartphones and tablets.

Online Monitoring
Monitor and manage all of your i-ALERT enabled machines in one place - i-ALERT Ai Online Platform. This subscription service requires no software to download or dedicated hardware to run.

How it Works:

1. ACTIVATE
The i-ALERT2 devices are light activated by removing the sticker. The sensor begins wirelessly broadcasting once activated.

2. AUTO CONFIGURATION
The i-ALERT device averages the vibration over 25 hours of run-time and sets the alarm levels to 2 x average (0.1-1.5ips minimum). Temperature alarm default to 80°C (176°F)

OR

2. MANUAL CONFIGURATION
User manually sets the alarm thresholds via the i-ALERT mobile application.

3. Monitor
The i-ALERT2 sensor is configurable to check every 1-5 minutes. If two consecutive readings are above alarm threshold the i-ALERT device will go into alarm.

Dashboard
Simple, intuitive dashboard to track vibration, temperature, run-time & battery life.

Trending
Trend vibration, temperature, & kurtosis to monitor any changes in the equipment operation.

BOM
Load the as built of materials based on the pump serial number.

Spend less time collecting data and more time fixing problems. The i-ALERT mobile app has the ability to scan multiple i-ALERT2 sensors within range to quickly and safely inspect multiple machines.
Hydraulic Coverage 60 Hz and 50 Hz

Flow Capacity - 50 Hz
Flow Capacity - 60 Hz

Note: Hydraulics above represent 80% to 110% of best efficiency point (BEP).

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.
A Leader in API Engineered Pump Package Solutions

API Family of Pumps

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<tr>
<th>API Type</th>
<th>Goulds Model</th>
<th>Capacity GPM (M3/hr)</th>
<th>TDH Feet (Meters)</th>
<th>Temperature °F (°C)</th>
<th>Pressure PSI (kg/cm²)</th>
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<tr>
<td>OH-2</td>
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<td>8500 (1330)</td>
<td>1200 (360)</td>
<td>800 (425)</td>
<td>870 (60)</td>
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An ITT Brand

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