



1. Install compression plate (G) onto the three studs on mount assembly. Install the rubber grommets, washers and nuts. **No tightening.**
2. Insert thick neoprene ring (A) into impeller ring holder (H).
3. Drop thin carbon ring (B) into impeller ring holder (H), machined face upwards.
4. Drop thick carbon ring (C) into seal plug (D) aligning flat surfaces. Machined face downwards.
5. Place seal plug (D) onto impeller ring holder (H) with machined ring faces touching each other.
6. **Strongly stretch out thin neoprene ring (E) by hand** ensuring all sides fit snug into seal plug and insert on top of non machined side of thick carbon ring (C).
7. Drop tapered ring (F) over impeller shaft tapered side down.
8. Drop backing gasket onto the seal plug.
9. Hold all parts together while you push the impeller shaft through bearing mount assembly.
10. Keep pressure on the seal assembly and **lightly tighten** compression plate (G) onto the three studs on the mount assembly just enough to keep the seal assembly in place.
11. Making sure the seal plug is pressed onto the mount assembly, tighten the bearing locking collars on the shaft leaving a minimal distance between the impeller back vanes and the seal plug.
12. Center and bolt the volute case.
13. Tighten the compression plate snugly with wrench. **Do not over tighten.**
14. Test unit by filling with water. Pressure testing can be accomplished by increasing the pressure on the water to 5 PSI. If the pump does not leak at 5 PSI on test, it will not leak after installation.
15. If the unit leaks, lightly tighten the three adjusting nuts a turn or two at a time with wrench. If leaking does not stop, disassemble pump and check. **Excessive pressure and tightening on the seal will accomplish nothing and damage the parts.**

