



ASSEMBLY INSTRUCTIONS FOR 166-P THROUGH 666-P

Internal Bellows Type Seal

1. Attach motor mount to motor with bolts
2. Insert ceramic/viton seat into seal plug with ceramic face up. (use vegetable oil)
3. Carefully slide seal assembly on impeller shaft with rubber boot facing impeller blades, making sure that the rubber is pressing against the rear of the impeller and properly seated within carbon. (use vegetable oil)
4. Insert impeller into seal plug. Install assembly onto motor mount.
5. Tighten the impeller set screws, making sure that there is a minimal clearance between the rear impeller vanes and the seal plug, onto the motor shaft.
6. Assemble gasket and volute case to seal plug and mount with bolts. (Snug fit)

