



## ASSEMBLY INSTRUCTIONS FOR HORIZONTAL TRANSFER PUMPS

### MODELS HVC-40 THROUGH HVC-90

#### Double Mechanical Water Cooled Seal

1. Attach motor mounting bracket (L) to motor with four (4) stainless steel bolts.
2. Insert ceramic seat (F) into seal plug (J) and seal cap (B) with ceramic face up.
3. Insert impeller (E) through seal plug.
4. Slide first rotating seal (I) onto impeller sleeve with raised carbon face down to the ceramic face. A small amount of dish soap may be used if necessary for lubrication.
5. Slide spring (C) down and install second rotating seal onto the impeller sleeve with carbon face up. A small amount of dish soap may be used if necessary for lubrication.
6. Place seal cap o-ring on seal plug.
7. Bolt seal cap to the seal plug with four (4) stainless steel bolts.
8. Insert stainless steel shaft (A) into impeller assembly, insert key into impeller and tighten impeller nut with O-ring to shaft.
9. Slide completed assembly onto motor shaft and bolt seal plug to motor mounting bracket with four (4) stainless steel bolts.
10. Tighten the impeller set screws making sure there is a minimal clearance between the rear impeller vanes and the seal plug.
11. Mount volute case with O-ring to seal plug with six (6) stainless steel bolts.