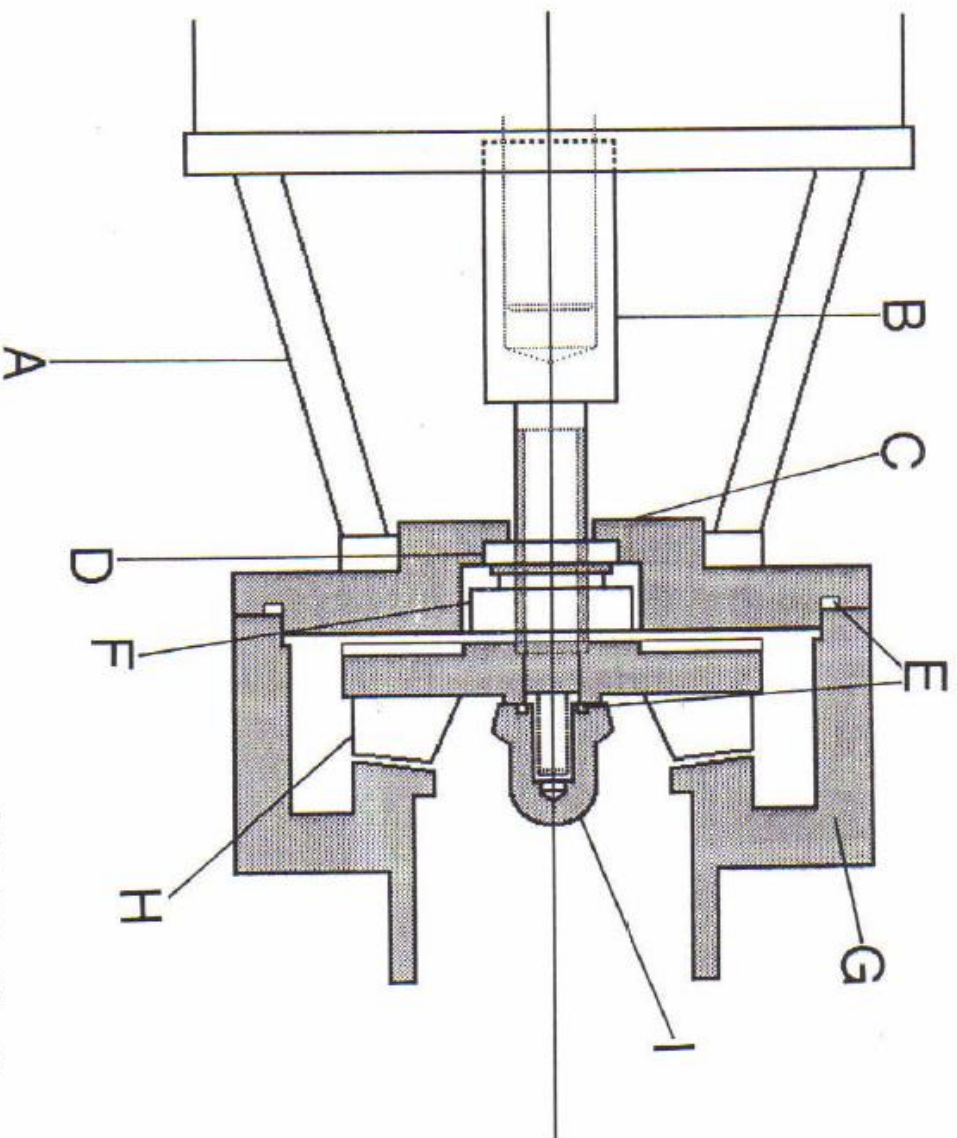




## ASSEMBLY INSTRUCTIONS FOR HORIZONTAL TRANSFER PUMPS MODELS HVC-40 THROUGH HVC-90

### Camac Type 27 Bellows Seal

1. Attach motor mounting bracket to motor face with four (4) 1/2-13 x 1.5" stainless steel bolts and flat washers.
2. Slide impeller shaft on motor shaft aligning set screws with motor shaft keyway. (Do not tighten set screws. Shaft will move freely).
3. Insert ceramic/viton stationary seat into seal plug with ceramic face up. (Use vegetable oil or dish soap if needed)
4. Bolt seal plug to motor mount with four (4) 5/16-18 x 7/8" stainless steel bolts and flat washers.
5. Slide carbon/viton rotating bellows onto impeller with viton bellows towards impeller body and carbon face up.  
NOTE: Make sure that the viton bellows is seated entirely within rotating carbon piece and is bottomed out on the tube of impeller.
6. Slide impeller/seal assembly onto shaft.
7. Insert key into impeller/shaft keyway and tighten impeller nut with O-ring to the shaft.
8. Press impeller shaft assembly towards motor and position .03125" from face of seal plug.
9. Tighten the set screws onto the motor shaft. The bellows seal faces are now compressed and the seal is formed.
10. Spin impeller to ensure no interference in rotation.
11. Mount volute case with viton O-ring to seal plug with six (6) 3/8-16 x 1-1/4" stainless steel bolts and flat washers.
12. See *Horizontal Pump Installation – Operation – Maintenance Instructions*



- A = Mounting Bracket
- B = Impeller Shaft
- C = Seal Plug
- D = Stationary Seat
- E = O Ring-Impeller Cap Volute
- F = Rotating Bellows Two (2) Piece
- G = Volute Case
- H = Impeller / Sleeve One (1) Piece
- I = Impeller Cap

## HVC Bellows Seal