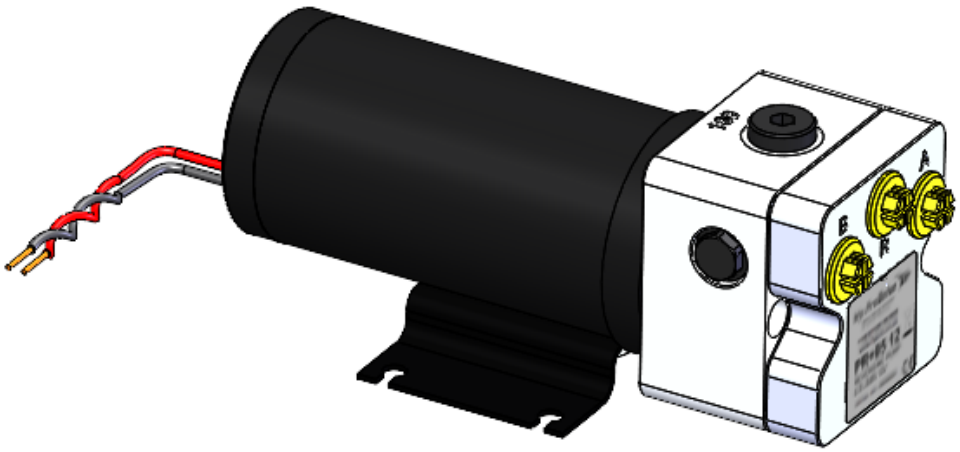
RV PUMP COVER REPLACEMENT INSTRUCTIONS.

Tools(equipment) needed;

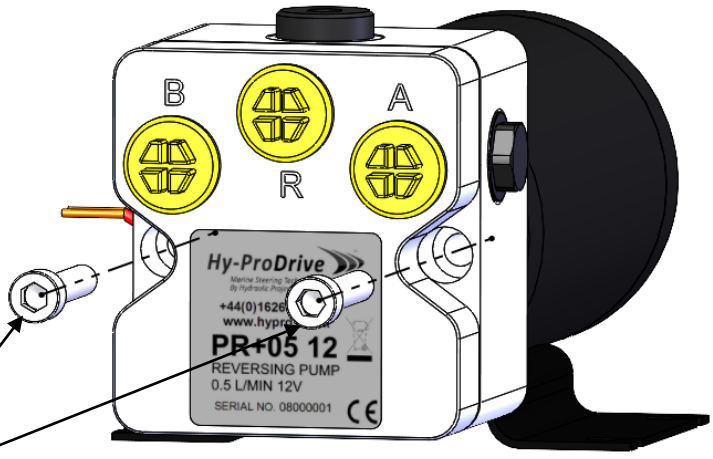
- 5mm allen key + torque wrench,
- Loctite 222 or 243,
- Replacement O-rings,

Before you start make sure area is clean, carry work out on a flat suitable bench preferably with a sheet of card to prevent any marking or damages.

Existing **PR Pump Assembly**

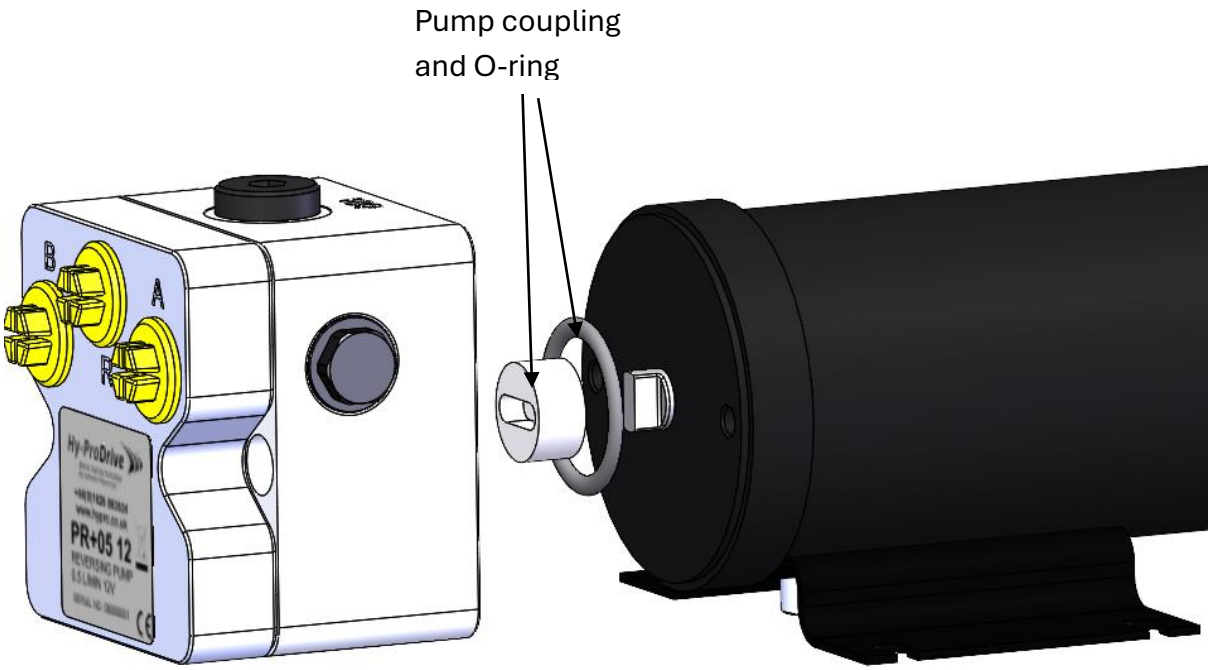


Step 1 – Remove the two M6 Stainless Steel Socket Head Cap Screws securing motor to pump. **Note**: these where glued in so may be tight.

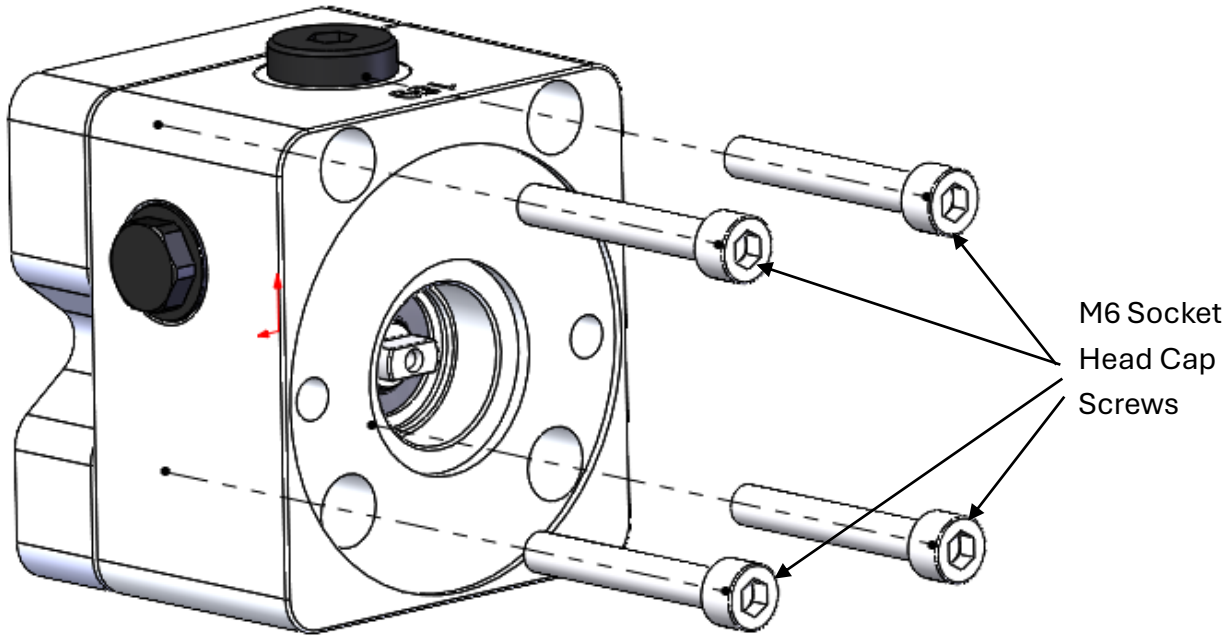


M6 Stainless Steel Socket Head Cap Screws

Step 2 – Gently remove the motor. The pump coupling and O-ring may detach from the gear at this stage. If so, when reassembling note orientation.

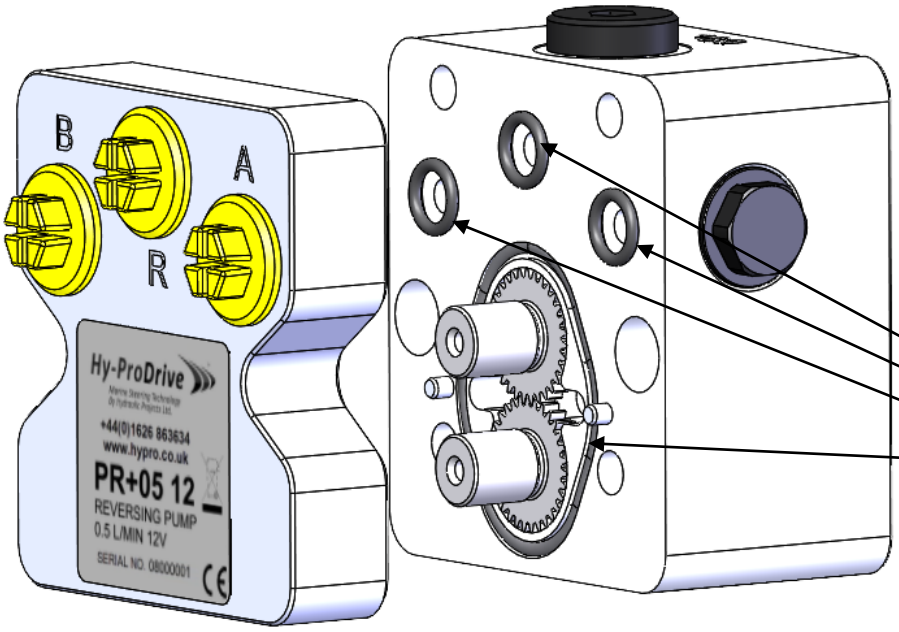


Step 3 – Remove the four M6 Socket Head Cap Screws securing pump to pump cover.



BEFORE YOU DISMANTLE THE PUMP BODY IT IS IMPERATIVE THAT THE AREA IS CLEAN.

EVERY PRECAUTION MUST BE TAKEN TO MAKE SURE THE PUMP DOES NOT GET CONTAMINATED WITH FOREIGN BODIES

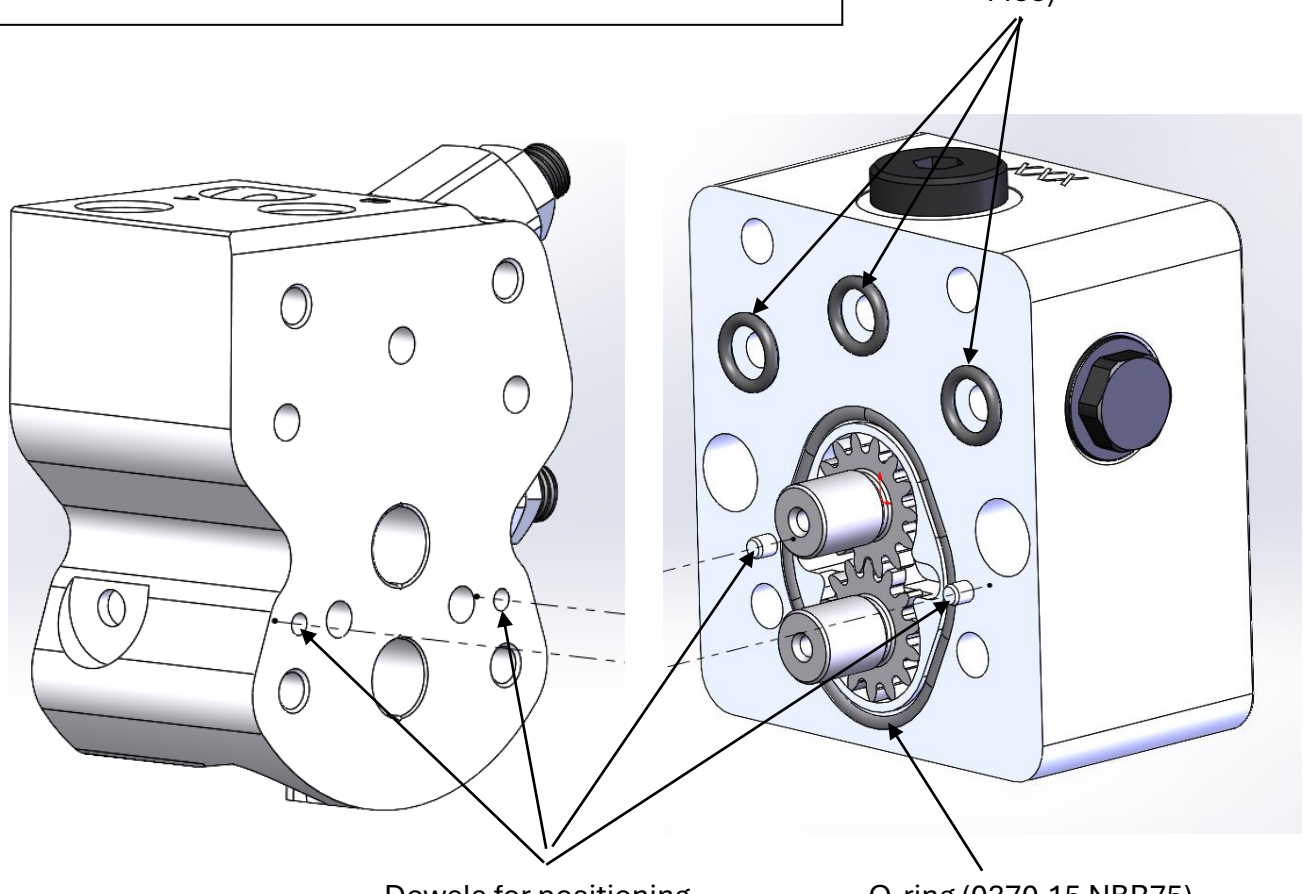


Step 4 – Gently remove pump cover. This may be tight to start with but DO NOT prize apart as this may damage the dowls or integrity of the surface's later.

These 4 O-rings will need to be replaced.

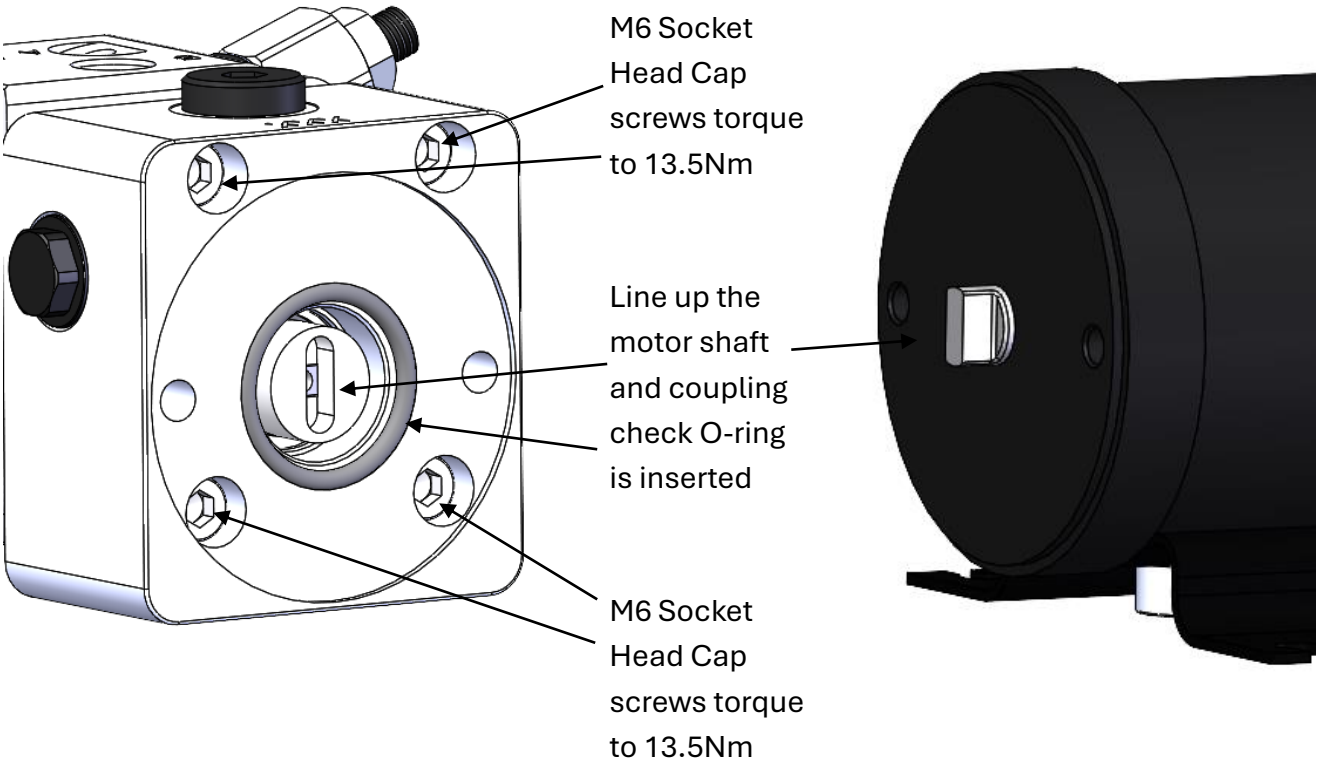
Step 5 – Replace with new pump cover using the dowels for positioning.

Replace the three O-rings (200-011-4485) & one O-ring (0370-15 NBR75). This needs to be formed around the groove which can be done manually.

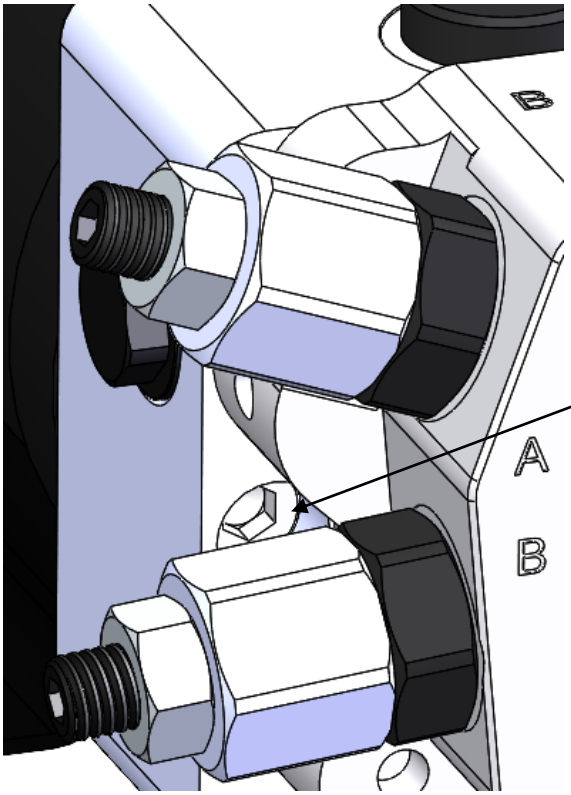


Step 6 – Insert the four M6 Socket Head Cap screws and torque to 13.5Nm. This is very crucial as if less the pump will leak.

Line up the motor shaft and coupling ready for assembly

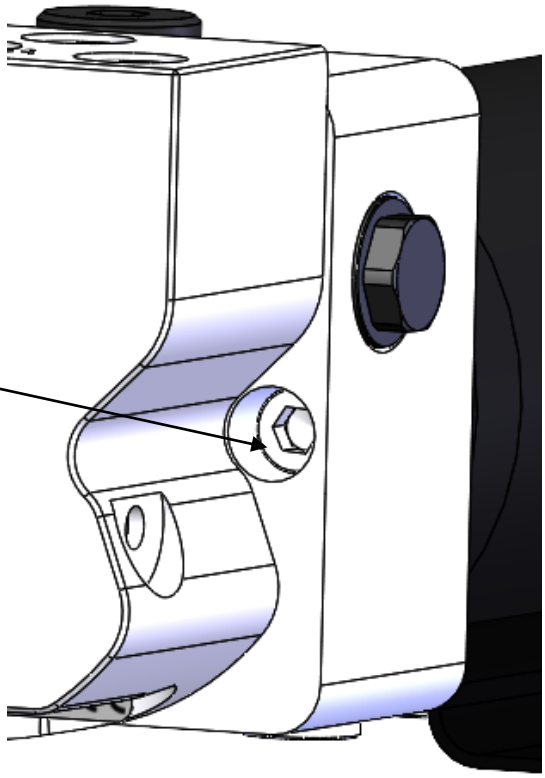


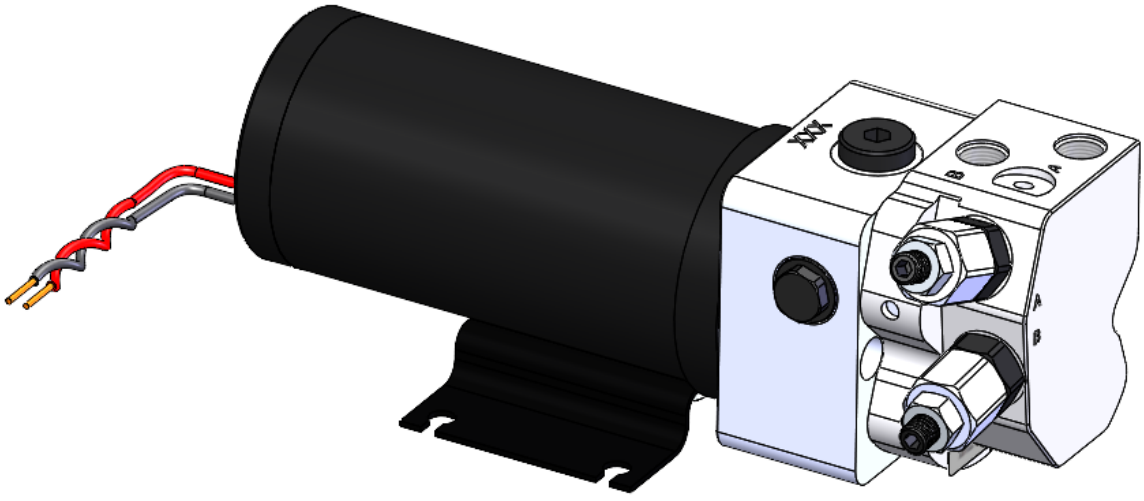
Step 7– Insert the two M6 Stainless Steel Socket Head Cap screws and torque to 8Nm. Apply adhesive (Loctite 222 or 243) to the threads.



M6 Stainless Steel Socket Head Cap screws and torque to 8Nm.

Apply adhesive to the threads



If Relief Valve Cartridges need to be removed, when re-assembling lightly grease O-rings to prevent damage and Torque to 16Nm.

PR + RV Pump Assembly