



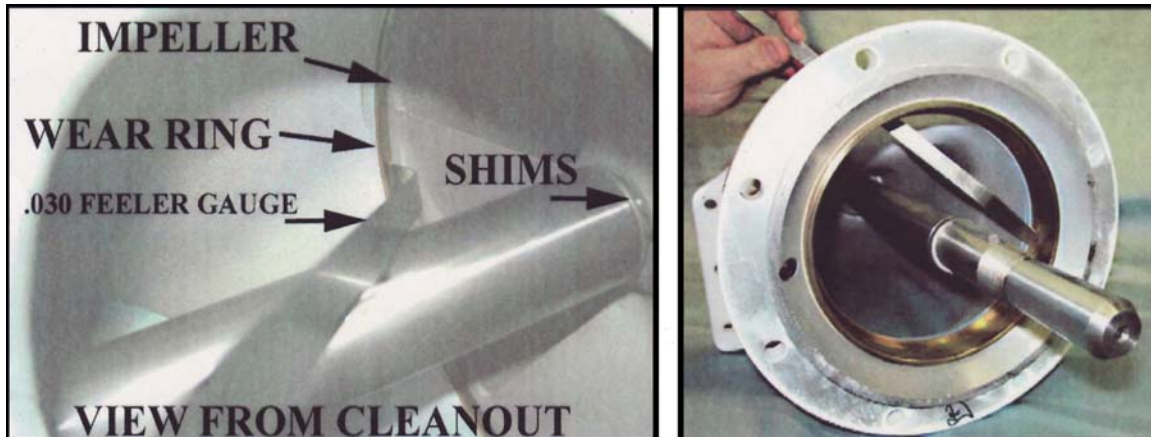
5725 REDWOOD DRIVE.  
ROHNERT PARK, CA 94928  
PHONE 707.585.9871  
FAX 707.585.2935

## IMPELLE/R WEAR RING SHIMMING INSTRUCTIONS

AT, TJ, SD-309, DOMINATOR, BERKELEY, ENERGIZER KITS

### Tools Needed:

1. .030 Feeler Gauge
2. Propane Torch
3. Bent Screw Driver
4. WD-40
5. Impeller Wrench
6.  $\frac{3}{4}$  Wrench
7. 9/16 Wrench
8. Dead Blow Hammer



### To remove old wear ring:

Use a propane torch. Place the flame on the brass ring and go around in a circular motion until the insulator starts to melt. Grab the ring with a bent over screwdriver (90 deg.) and pull it out. Clean up the wear ring bore.

### Installation:

Place the wear ring in the freezer for four hours. Place the insulator in the suction bore. Spray with WD-40. Start the wear ring by hand. Tap the wear ring in using a wooden block and a mallet. You may use an old impeller but it may bottom out on the shaft before seating the ring.

### Important:

The wear ring must be seated square in the bore within 0.004" side to side.

The axial clearance between the impeller and the impeller shoulder must be 0.025" – 0.035" (check several places around the wear ring). Check again after the impeller nut has been tightened.

Torque the impeller nut to 70 ft/lbs. Torque the bowl nuts to 50 ft/lbs.