

Procedure To Replace Shaft Seal

Make sure there are NO burrs or sharp edges on the motor shaft BEFORE installing the new shaft seal!

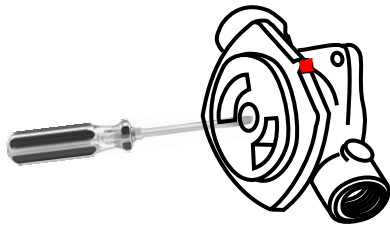
1. To remove cover, use a 3/16" allen wrench to remove the four cap screws.
2. Arrange the pump with the shaft vertical so the rollers do not fall away from the pump when the cover is removed.
Remove and save the 5 rollers.
3. Carefully remove rotor from shaft. Use 2 screw drivers to apply even pressure under webs of rotor to ease the rotor off the shaft.
4. Make sure pump surfaces are clean. Wipe the rotor, housing and rollers.
5. Use wrench to remove 2 x 5/16" bolts holding the pump base to the face of the motor.
6. Remove the old seal seat from cavity of pump base. (See diagram below)
7. Install the new steel seal seat with polished seal face visible.
(Side marked with X goes inside pump see *a)

8. Remove the rest of the old seal parts from the shaft:
Clean the shaft and install the new seal parts on shaft.

**Note: Be sure to add oil film to rubber seal inside the carbon seal face before installing it on the shaft.

9. Reinstall the pump base to the end face of the motor.
10. Install the rotor back on the shaft and place the rollers back into position in the deep rotor slots.
11. Inspect the O-ring to make sure it has no cuts. Carefully replace the O-ring in the groove.
12. **There is a line in the castings of the pump end cap and the pump body/base. Make sure these are lined up when reassembling the end cap to the pump base**

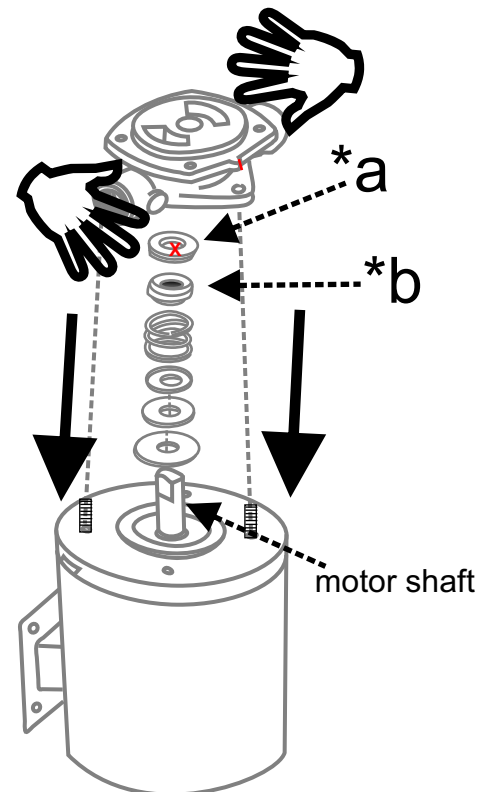
Add a light coating of mineral oil to shaft seal parts & motor shaft
*a. to steel seal face, and
*b. to rubber shaft seal section of carbon seal face



6. Using a screwdriver and hammer, gently tap out the old seal seat from the cavity of the pump body.
Be careful NOT to damage cavity of body.

Once you have the shaft seal on the motor shaft and the steel face in the pump head, apply equal pressure on the pump head while pushing down on the shaft seal.

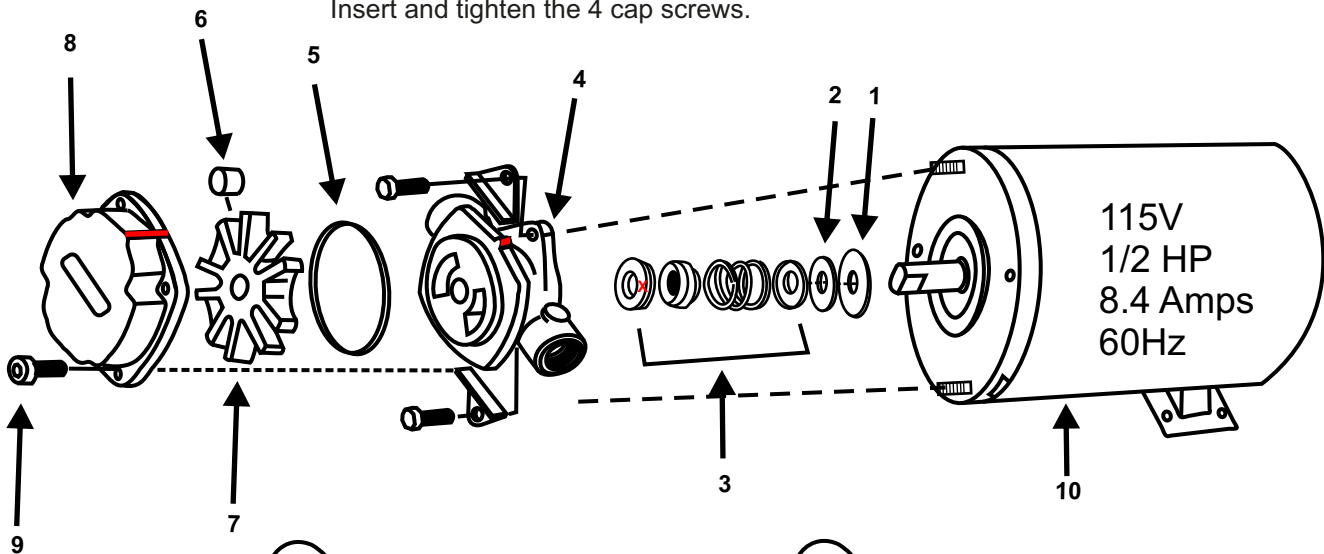
Once the pump head is down, attach the 2 x 5/16" bolts. Take equal turns on each bolt with the wrench.
(Example: take 2 turns on 1 bolt then 2 turns on the other bolt).



To Replace Parts or Clean Pump

1. There is a line in the castings of the pump end cap flange (#8) and the pump body/base flange (#4).
2. Remove end cap (#8). Use a 3/16" allen wrench to remove the four cap screws.
3. Arrange the pump shaft in a vertical position so the rollers (#6) do not fall away from the pump when the end cap (#8) is removed. Save the 5 rollers (#6).
4. Carefully remove the rotor from shaft. Apply even pressure under webs of rotor (#7). You may use 2 screw drivers to ease the rotor off the shaft.
5. Carefully remove any debris or crumb. Make sure pump surfaces are clean. Wipe the rotor, housing and rollers.
5. Install the rotor back on the shaft and place the rollers back into position in the deeper rotor slots.
6. Inspect the O ring. Make sure it has no cuts. Carefully replace the O ring in the groove.
7. **Make sure the 2 lines in the castings of the end cap (#8) and the pump body/base (#4) are lined up with each other when installing the pump cover.**

Insert and tighten the 4 cap screws.



SP/PPU159-008 COMPLETE R45 PUMP

PUMP INCLUDES
REF. #'s: 4-9

SP/PPU159-009 COMPLETE R55 PUMP

PUMP INCLUDES
REF. #'s: 4-9

Ref #	Description	Part # for R45 PUMP	Part # for R55 PUMP
1	SLINGER RING	PPU180-000	
2	PUMP WASHER	PPU179-000	
3	SHAFT SEAL	PPU170-000	
4	PUMP BODY (base)	PPU182-000	
5	O-RING	PPU169-000	
6	ROLLERS	PPU161-000 (5pc)	PPU162-000 (5pc)
7	ROTOR	PPU164-000	PPU165-000
8	END CAP (cover)	PPU167-000	PPU168-000
9	CAP SCREW	PPU175-000 (4pc)	
10	MOTOR	PEL119-020	