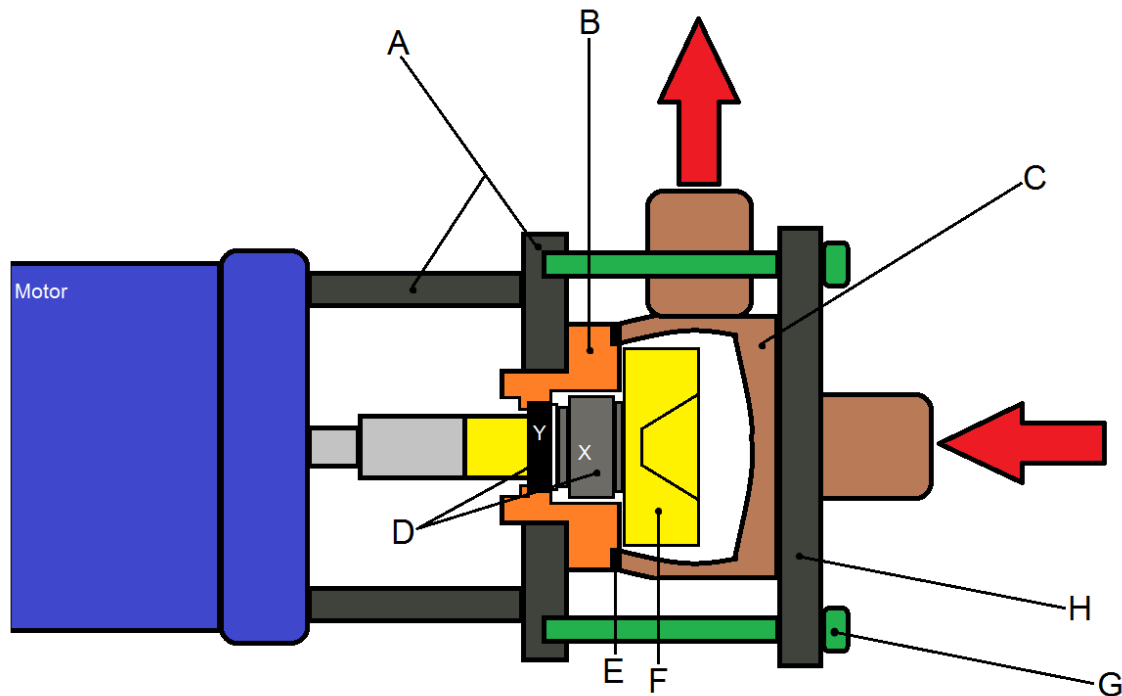




ASSEMBLY INSTRUCTIONS FOR 166 RL-CC-27 and 666 RL-CC-27

1. Attach motor mount assembly to motor by inserting the supplied hex head cap screws and washers through the mount plate and spacer tubes and into the motor face.
2. Insert ceramic/viton stationary seat into seal plug with ceramic face up. (Use vegetable oil or dish soap if lubrication needed)
3. Carefully slide seal assembly on impeller shaft with rubber boot facing impeller blades, making sure that the rubber is pressing against the rear of the impeller and properly seated within carbon. (use vegetable oil or dish soap if lubrication needed)
4. Insert impeller into seal plug. Install assembly onto motor mount.
5. Tighten the three impeller set screws onto the motor shaft, making sure that there is a minimal clearance between the rear impeller vanes and the seal plug.
6. Assemble gasket and volute case to seal plug.
7. Place clamp plate on top of volute case and fasten with the five supplied hex head cap screws and washers. (Snug fit)



- A - Mount Assembly - Mount Plate (1), Spacer Tubes (4)
- B - Seal Plug
- C - Volute Case
- D - Seal (2pc) - Rotating Seat X, Stationary Seat Y
- E - Volute Gasket
- F - Impeller
- G - Volute Bolt (5)
- H - Clamp Plate