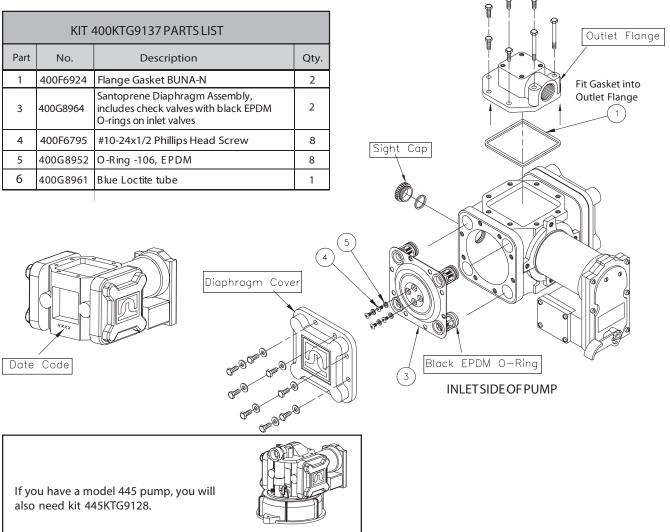


400 Pump Retrofit Kit - Diaphragms with EPDM Seals

- A. Drain Oil out of pump by removing sight caps.
- B. Diaphragm Removal:
- 1. Remove diaphragm cover screws and drain any remaining fluid from pump.
- 2. Remove four small screws and O-rings that secure diaphragm.
- Remove diaphragm and check valves by pulling check valves out of pump body.
 NOTE: Valves may be tight. Be careful not to damage pump body when extracting old valves.

C. Install New Diaphragms:

- 1. Coat the ball of each check valve with a dab of oil or Vaseline.
- 2. Install the new diaphragms (3) as shown in the drawing. Note that the valves with the O-rings go nearest the inlet side of the pump.
- 3. Slide the small O-ring (5) on the four small phillips head screws (4) as shown. Put a drop of blue Loctite® (included) on the thread of each screw. Start all four screws before tightening securely.
- 4. Install pump covers and tighten to 50 inch* lbs. For phillips head screws, this is as tight as you can hand tighten with a screw driver. For Hex-head bolts, 50 inch*lbs is slightly more than snug. Do not over tighten hex head bolts!
- D. Add Oil and replace Sight Caps:
- 1. Add 16 oz of 30 wt motor oil to the crank case through the sight cap opening.
- 2. Replace the sight cap O-rings (2) if needed, then tighten sight caps snug.
- E. Inlet and outlet Flange Gaskets:
- 1. Included are two gaskets (1) for the pump inlet and outlet flanges. If your pump has a manufacture date on the front of the pump before 1295 (month-year) you will also need to replace these two gaskets. Re-install pump flange covers and tighten to 50 inch*lbs. For phillips head screws, this is as tight as you can hand tighten with a screw driver. For hex-head bolts, 5 inch*lbs is slightly more than snug. Do not over tighten hex head bolts!



Model 445