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ADDENDUM

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Revision to Impeller Assembly Process Effective August, 2006

To Be Used With Model and IOM Form Number:

Series 3530 Centrifugal Pump - P81845

DISASSEMBLY

To remove impeller, apply localized heat to the impeller hub to a temperature between 150°C - 250°C if needed. Heat Impeller hub for 1-3 minutes. This will decrease the breakloose strength of the Loctite 243 and allow for easy removal.

ASSEMBLY

To install impeller clean shaft thoroughly with denatured alcohol let dry. Apply Loctite 7649 primer to shaft, impeller threads and allow 3-5 minutes to dry. Apply 3 drops of Loctite 243 medium strength threadlocker to shaft threads and 2 drops to the impeller threads. Tighten impeller to 144 lb-in or 12 lb-ft. **No Jam nut needed.** Allow impeller to cure for 30 minutes before testing or running.

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