


## Installation Instructions

 **California Proposition 65 Warning** -- This product and related accessories contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

### Please Note:

These instructions are for the gearbox only. Please consult separate documents for preparing the gas engine and diaphragm pump for service.

1. Install Ref. No. 1 o-ring into gear box housing and lubricate with grease. Install housing half onto diaphragm pump using M10 screws and washers. Be sure o-ring seats properly around pilot on pump and is not pinched or cut. Apply Loctite 242 to threads prior to installation. Torque M10 screws to 12-16 ft.-lbs. (See Figure 1.)
2. Install driven gear onto pump crankshaft using M10 screws. Apply Loctite 242 to threads prior to installation. Torque M10 screws to 18-22 ft.-lbs. (See Figure 2.)
3. Install paper gasket over the housing pilot. (See Figure 3.)
4. Install gas engine flange onto pump housing and secure with M8 screws. Apply Loctite 242 to threads prior to assembly. Torque screws to 12-16 ft.-lbs. Install o-ring into groove of gas engine flange. Install and tighten the lower and one side pipe plug. Teflon tape or pipe sealant is recommended. (See Figure 4.)
5. Install pinion gear and key onto gas engine shaft. Insert 5/16 bolt into pinion to secure gear onto crankshaft. (See Figure 5.)
6. Apply Loctite 242 to threads prior to installation. Torque screw to 12-16 ft.-lbs. (See Figure 6.)
7. Slide pump and gearbox over pinion gear. The pinion may need to be rotated to align the gears. Apply Loctite 242 to screw threads prior to assembly. Torque screws to 12-16 ft.-lbs. (See Figure 7.)
8. Fill gearbox with SAE 80/90 gear lube until the lube appears at the side pipe plug hole (approximately 20 ounces required to fill to side). Insert and tighten remaining side pipe plug and breather. Teflon tape or pipe sealant is recommended.



Fig. 1



Fig. 2



Fig. 3



Fig. 4



Fig. 5

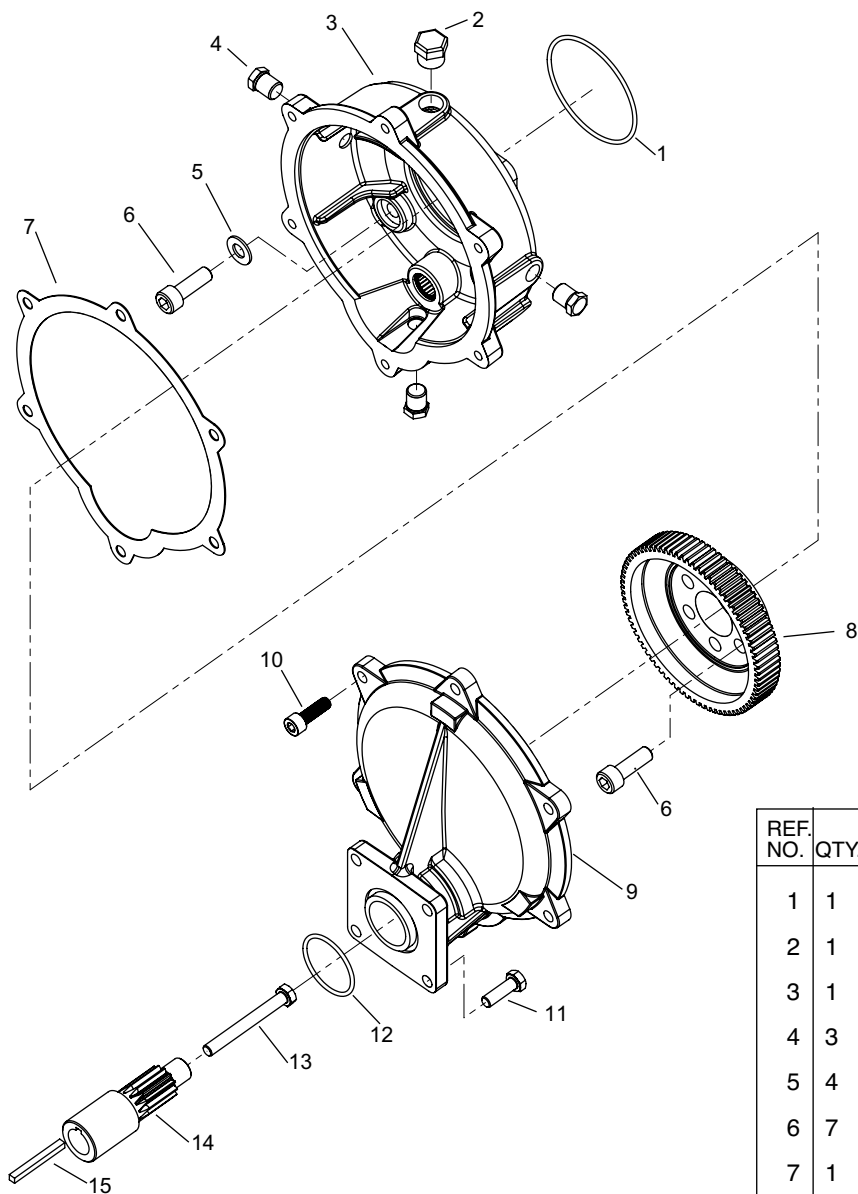


Fig. 6



Fig. 7

## Parts List



REF. NO.	QTY.	PART NO.	DESCRIPTION
1	1	1720-0086	O-Ring
2	1	1450-0020	Vent Breather Cap, 3/8" NPT
3	1	0701-D403A	Gear Box, Body Sub Assy.
4	3	2406-0019	Pipe Plug
5	4	2270-0117	Washer, M10
6	7	2220-0116	SH Cap Screw, M10x1.0x30mm
7	1	1710-0016	Cover Gasket
8	1	3900-0054D	Machined Gear
9	1	0700-D403A	Mounting Flange
10	6	2220-0118	SH Cap Screw, M8x1.25x25mm
11	4	2210-0077	Hex Head Cap Screw, 5/16"-24 x 1"
12	1	1720-0243	O-Ring
13	1	2210-0151	Hex Head Cap Screw, 5/16"-24 x 2-3/4"
14	1	3900-0055	Driver Gear
15	1	1610-0064	Key