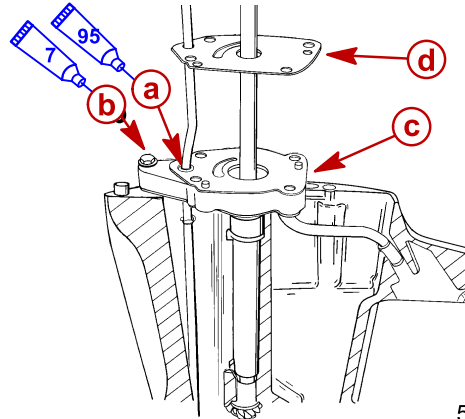
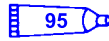




5. Apply 2-4-C w/Teflon to I.D. and O.D. of shift shaft quad ring. Seat quad ring in pump base.
6. Apply Loctite 271 to bolt threads and secure pump base to housing with bolt and washer. Torque bolt to 50 lb. in. (5.6 N·m).
7. Install gasket and face plate.



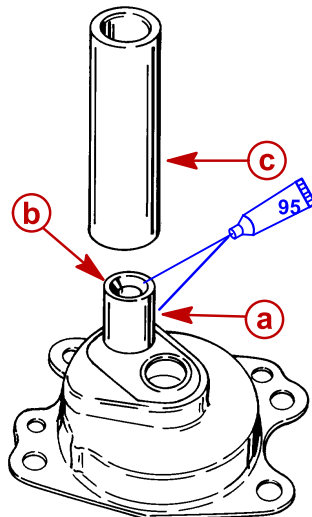
53012

 Loctite 271 (92-809820)  2-4-C With Teflon (92-825407A12)

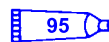
- a** - Quad Ring
- b** - Bolt and Washer [Torque to 50 lb. in. (5.6 N·m)]
- c** - Gasket
- d** - Face Plate

Water Pump Cover Reassembly

1. Apply 2-4-C w/Teflon to O.D. of seal and seal surface.
2. Install seal into cover.
3. Place water tube guide onto seal.



53032

 2-4-C With Teflon (92-825407A12)

- a** - Seal
- b** - Seal Surface
- c** - Guide



Impeller and Pump Cover Installation

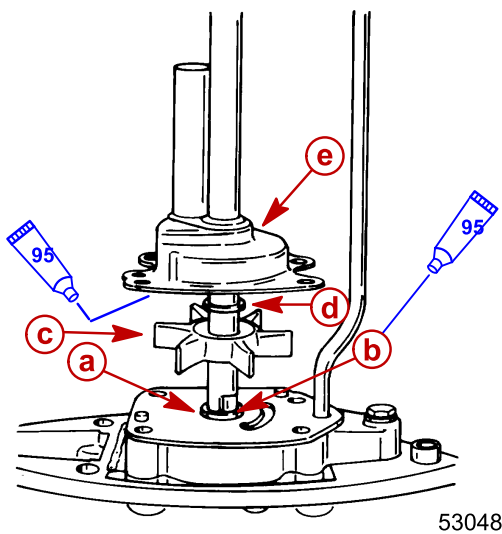
1. Install neoprene washer.
2. Install drive key. Use 2-4-C w/Teflon to hold key to drive shaft.

IMPORTANT: It is recommended that the impeller be replaced regardless of appearance. If impeller must be reused, it must be installed in the direction of original rotation. Installing impeller with vanes reversed from their previous “set” will result in vane breakage shortly after unit is returned to service.

3. Install new impeller and align with drive key.
4. Install neoprene washer.
5. Lubricate I.D. of water pump cover with 2-4-C w/Teflon.
6. Install cover on drive shaft and while pushing down on cover, rotate drive shaft CLOCKWISE and install cover over impeller.

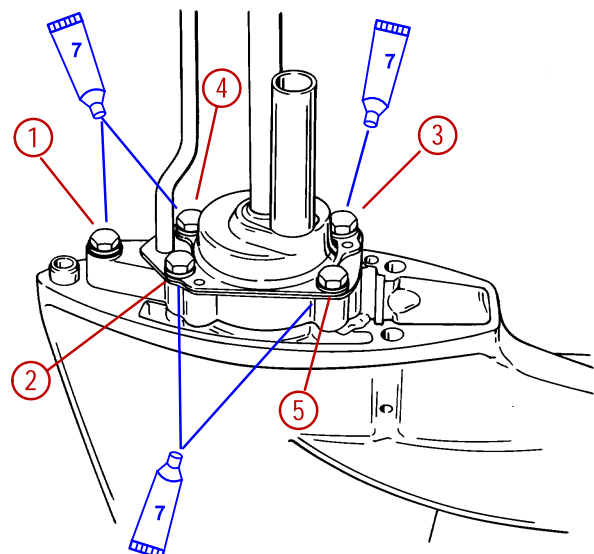
- a** - Neoprene Washer
- b** - Drive Key
- c** - Impeller
- d** - Neoprene Washer
- e** - Cover

7. Apply Loctite 271 to threads of bolts. Secure cover with bolts and torque to 50 lb. in. (5.6 N·m) per following numbered torque sequence.



53048

95 2-4-C With Teflon (92-825407A12)



53023

7 Loctite 271 (92-809820)