

## REPLACING DOUBLE SUCTION IMPELLERS

*A double suction impeller has blades on the top and bottom.*

1. Remove old pin, nut, impeller and spring.
2. With pump up-side-down replace spring on shaft.
3. Slip new impeller on shaft. The words, "Top" and "Bottom," are embossed on the impeller. Be sure the top of the impeller is towards the motor.
4. Replace nut. Tightening it will push the impeller against the spring compressing it.
5. Tighten the nut until the impeller is about .045 from the casting. The IMPELLER **MUST NOT BE FORCED AGAINST THE CASTING**. A convenient gauge is a dime. Use it to check the clearance between the impeller blades and the pump. *Impeller should now turn freely without rubbing top.*
6. Replace the pin to lock the nut.
7. Replace gasket if part of assembly. Assemble lower volute or volute coverplate. Spin impeller. It should spin freely without rubbing top or bottom.

## REPLACING SINGLE SUCTION IMPELLERS

*A single suction impeller has blades on the bottom only and is secured to the shaft with a set screw.*

1. Loosen set screw and remove old impeller.
2. Slip new impeller on the shaft with hub towards the motor until the impeller touches the casting, then back off slightly so there is no contact between the pump housing and impeller.
3. Tighten set screw.
4. Replace gasket if part of assembly. Assemble lower volute or volute coverplate. Spin impeller. It should spin freely without rubbing top or bottom.