
ADDENDUM

Installation, Operation and Maintenance Instructions

Subject:

Revision to Impeller Assembly Process
Effective August, 2006

To Be Used With Model and IOM Form Number:

NPE - IM013

DISASSEMBLY: To remove impeller, apply localized heat to the impeller hub to a temperature between 150°C - 250°C. Heat Impeller hub for 1-3 minutes. This will decrease the breakloose strength of the Loctite 271 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 271 high strength threadlocker to shaft threads and 2 drops to the impeller threads. Tighten impeller and jam nut to 144 lb-in or 12 lb-ft. Allow impeller to cure for 30 minutes before testing or running.

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