

---

## 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

MCC - IM060

MCS - IM052

**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.

---

**Xylem Inc.**

2881 East Bayard Street Ext., Suite A, Seneca Falls, NY 13148

Phone: (800) 453-6777 Fax: (888) 322-5877

[www.xylem.com/brands/gouldswatertechnology](http://www.xylem.com/brands/gouldswatertechnology)



Goulds is a registered trademark of Goulds Pumps, Inc. and is used under license.

© 2012 Xylem Inc. IM197 Revision Number 1 July 2012