

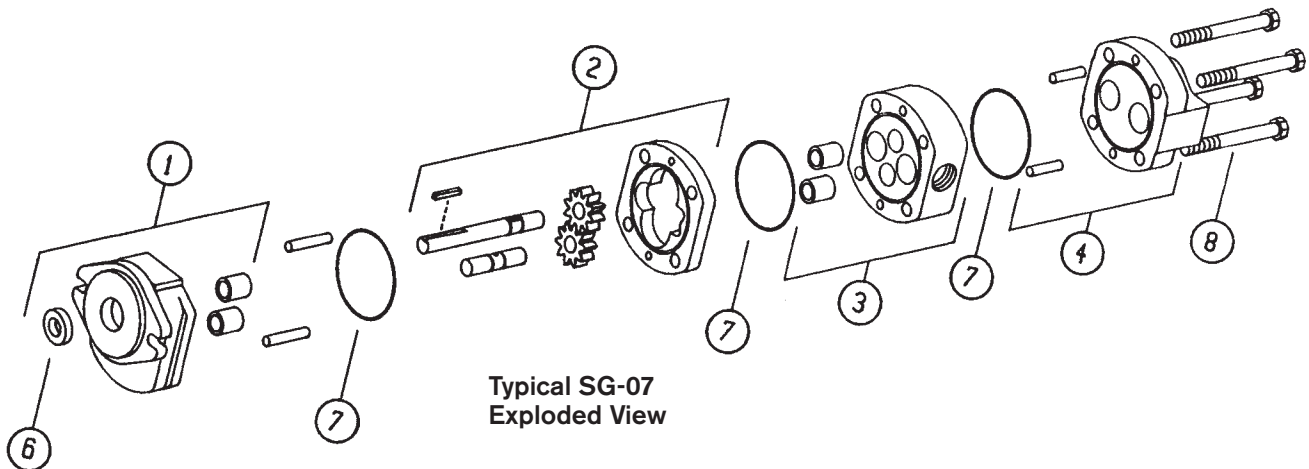


SERVICE INSTRUCTIONS

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VIKING REBUILT PUMP KIT

- A. **To Replace “O” Rings** (refer to exploded view)
1. Remove 4 bolts #8. The housing will come apart. Replace “O” rings making sure the “O” ring is in the groove in the housing.
- B. **To Replace Lip Seal**
1. The lip seal is located in the bracket Item #1. Using a flat blade screwdriver, knock out the old lip seal. **CAUTION:** Be careful not to damage the bearings.
 2. Using an Arbor Press, press the new lip seal into the bracket #1.
 3. Replace all sections of the pump making sure none of the “O” rings are pinched between the sections.
 4. Tighten down the 4 bolts by alternating between them.



ITEM	DESCRIPTION
1	Bracket, lipseal & bearing section
2	Match ground casing & (2) gears, driver & driven shafts
3	Separation plate & bearing assembly
4	Head and alignment sleeve assembly
6	Lipseal
7	O-ring
8	Assembly capscrews