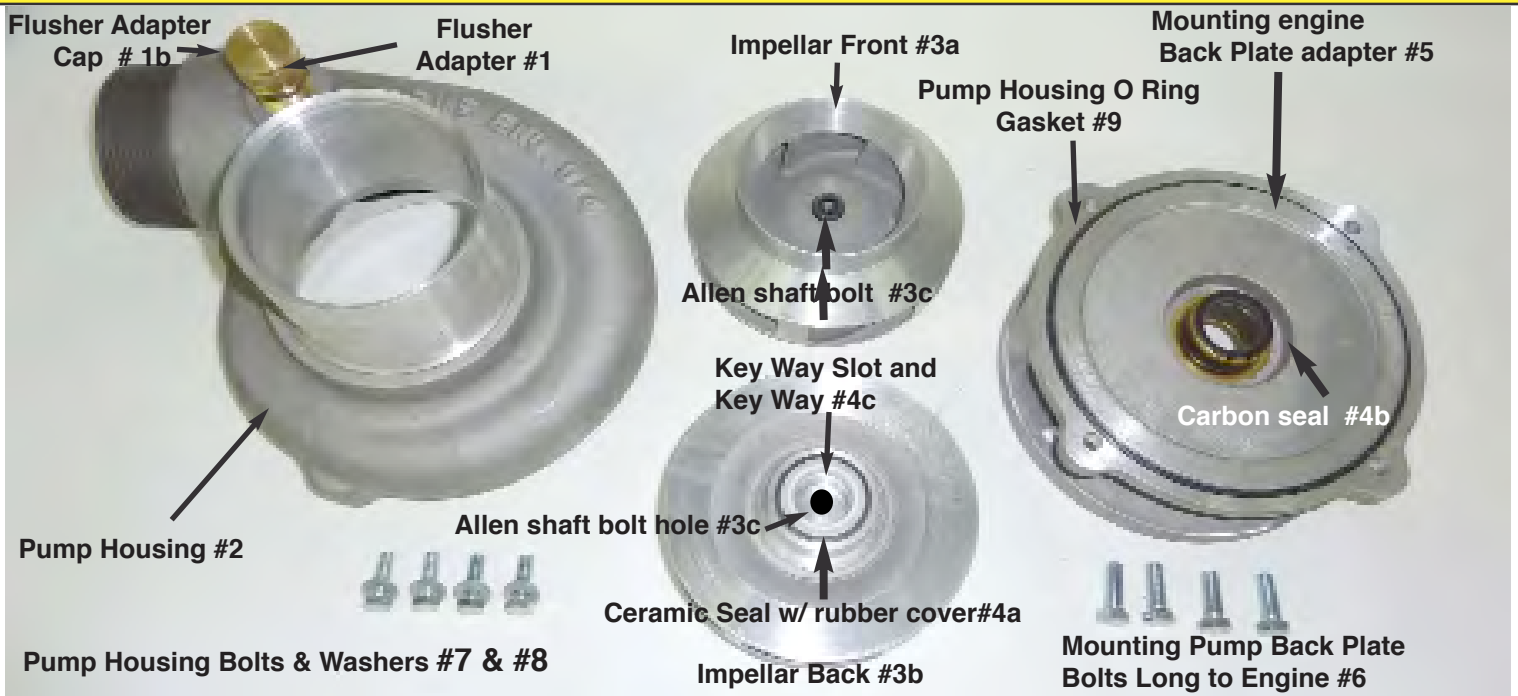


# P350 KEY WAY SHAFT PUMP ASSEMBLY



**TOOLS REQUIRED:** Standard Allen wrench 3/16ths. Standard 3/8 " & 1/2" open end wrench,

ITEM #	DESCRIPTION	QUANTITY	PART NUMBER
1a	Flusher Adapter	1	FA
1b	Flusher Adapter Cap	1	FAC
2	Pump Housing	1	301
3a	Impeller Front Side	1	35211
3b	Impeller Back Side	1	35211
3c	Allen head shaft connector bolt 3/8" X 16 X 1" -1/4" socket	1	SHC375161250
4a	Ceramic portion of pump seal	1	WPS3
4b	Carbon portion of pump seal	1	WPS3
4c	Key for key slot	1	502KK
5	Engine mounting back plate adapter complete	1	204 & 207
6	Mounting back plate bolts 3/8 x 16 x 1" hex head	4	HHB375161000
7	Pump Housing Mounting bolts 5/16" x 18 x 1" hex head	4	HHB312181000
8	Pump Housing Mounting washers 5/16".	4	WASHFL312
9	Pump housing "O" ring gasket	1	2080

## MOUNTING THE BACK PLATE TO ENGINE.

Set the back plate assembly (#5) and mount using the four back plate bolts (#6). Set bolts into place and tighten finger tight then tighten gently with a 3/8 inch wrench. Make sure the seal assembly (#4b\_ is in place on outer side of the engine adapter before mounting.

## MOUNT IMPELLER TO ENGINE SHAFT

1. Insert Impeller Key (#4c) into center of impeller as shown in figure #4c. (Impeller key not shown)
2. Insert Impeller pump ceramic seal (#4a) firmly into center of impeller as shown in figure (#3a & #3b).
3. Place allen head shaft connector bolt (3c) onto shaft and press firmly. Be sure to align key in keyway slot (3c) on the drive shaft correctly or the impeller will not slide completely onto the engine shaft.
4. Insert Impeller Attaching (#3c) Allen Head Bolt into threaded hole in the center of the engine shaft and tighten firmly. Take care to not damage the ceramic seal while inserting impeller onto shaft.

## INSERT O RING ON BACK PLATE ASSEMBLY

Insert Pump Housing "O" ring (#9) gasket and press into slot firmly.

## MOUNT PUMP HOUSING ONTO ENGINE BACK PLATE

Place Pump Housing (#2) onto back plate (#5) and secure with 4 Pump Housing Mounting Bolts and 4 Pump Housing Mounting washers (#7 & #8). Set bolt and washers loosely though back Plate into Pump Housing. Make sure alignment is correct and tighten firmly. Double check to see that the Pump back plate contains the "O" Ring Washer (#9) and is in its proper position. Care must be taken not to overtighten as the bolts in the housing as the threads are aluminum and could become easily stripped.