



SEAL REPLACEMENT INSTRUCTIONS FOR ROLLER PUMPS RP-600 AND RP-800 MODELS

PUMP REPAIR KIT

This universal repair kit includes the shaft seals, O-rings, and rollers needed to repair a standard PTO driven roller pump.

Ace Pump Series	Part #	Also Fits Models:
RP-600	RK-RP-600	Hypro 6500
RP-800	RK-RP-800	Hypro 7560

REPAIR KIT INSTALLATION

DISASSEMBLY:

1. Remove PTO adapter from pump shaft.
2. Use a file to remove any burrs from pump shaft.
3. Use a small screwdriver to pry dust caps from cover and housing.
4. Remove cover cap screws.
5. Support pump at ports as shown in Figure 1. Place pump on fixture with cover down and center shaft under press. Press pump apart as in Figure 2. Shaft and rotor will remain with cover.
6. Remove and discard rollers and cover O-ring seal.
7. Remove rotor/shaft assembly from cover assembly:
 - a) Place the cover in press support fixture with rotor down as shown in Figure 3.
 - b) Use a deep well socket (smaller than pump shaft) or bolt from pump to press shaft out of cover bearing.
8. Flip cover and use a 1" shaft (8 roller) or 21/32" shaft (6 roller) to slowly press bearing out of cover. Repeat procedure to remove bearing from pump housing.
9. Punch seals out of cover and housing with screw driver and mallet as in Figure 4. Discard seals.

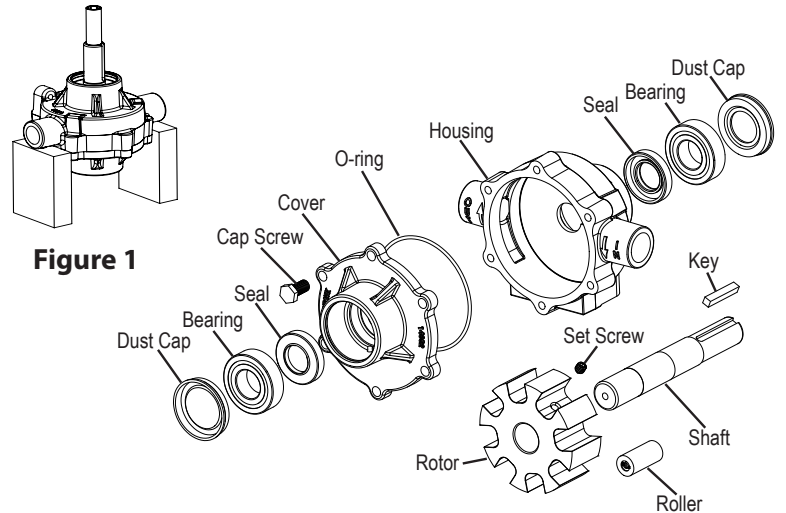


Figure 1

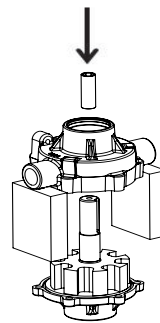


Figure 2

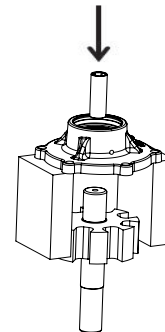


Figure 3

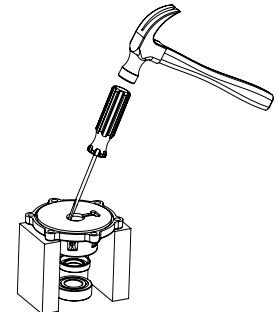


Figure 4

ASSEMBLY:

1. Carefully place seal in the cover centered with the crimped side down (see Figure 5). Press seal to bottom of cavity using a socket or dowel a little smaller than 1-1/8" (6 roller) or 1-1/4" (8 roller) to press evenly on seal diameter.
2. Put bearing in position in cover. Press until it stops using a socket or dowel that is a little smaller than 1-3/8" (6 roller) and 2" (8 roller) see Figure 6.
3. Repeat Steps 1 and 2 with housing.
4. Seat O-ring in groove (Figure 7).
Note: The O-ring may need to be stretched to ensure it stays in place.
A light coating of grease may also help hold it in place during assembly.
5. Install shaft/rotor assembly by carefully pushing short end of shaft/rotor assembly through shaft seal into cover. Place in arbor press with drive end of shaft pointed up as shown in Figure 8. Use same socket as used in step 2 to support outer race of bearing. Press shaft/ rotor assembly into cover assembly until it stops.
6. Install each new roller into each rotor slot.
7. Place housing (containing bearing and seal from step 3) onto pump shaft. Align the weep holes of housing and cover as shown in Figure 9.
8. Place bearing assembly tool over shaft and press housing until it stops against cover (see Figure 9).
9. Install pump cover to housing bolts and tighten.
10. If pump will not rotate when turned using a crescent wrench, place a short brass rod (or hardwood dowel) against shaft end (at cover end of the pump). Center rod on shaft (not on bearing). Tap lightly with a hammer. Try turning again.
11. If this fails to center rotor allowing the pump to turn freely, tap other end of the shaft, protecting it as above. Repeat steps 10 and 11 until pump turns freely by hand with a wrench.

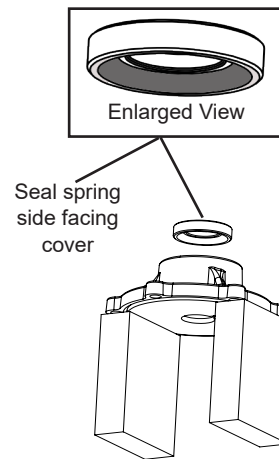


Figure 5

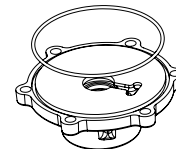


Figure 7

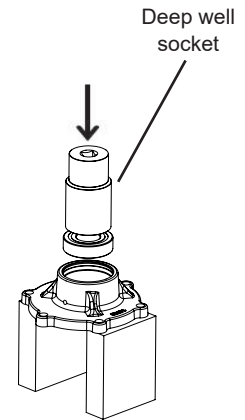


Figure 6

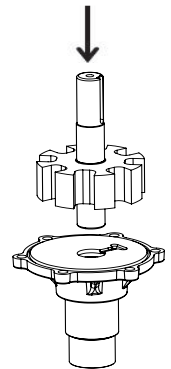


Figure 8

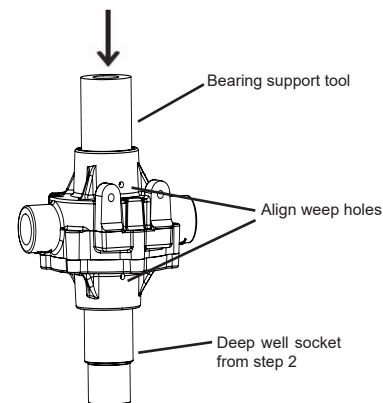


Figure 9