FMC-75SP-HYD Series Self-Priming Hydraulic Motor Driven Centrifugal Pump

These compact corrosion resistant pumps are perfect for smaller transfer, spray, or tank rinsing applications.

Features:

- Compact and light weight design
- Close coupled with separate pump and motor shafts for easy service
- All polypropylene construction with stainless steel internal hardware providing excellent corrosion resistance
- High efficiency, low flow hydraulic motors for efficient operation

SPECIFICATIONS

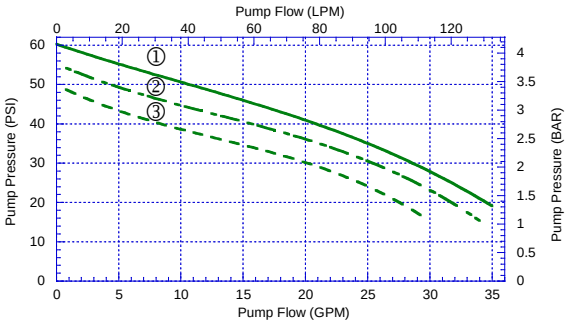
Pump Specifications		
Ports	1" NPT x 3/4" NPT	
Max. Flow	50 GPM (189 LPM) w/206	30 GPM (114 LPM) w/204
Max. Pressure	80 PSI (5.5 BAR) w/206	60 PSI (2.1 BAR) w/204
Construction	Polypropylene	
Seal	Carbon/Ceramic/FKM or Optional Silicon Carbide /FKM	
Shaft	Stainless Steel	
Bearings	Sealed for long life	
Impeller	Polypropylene with key	
Priming Height	Maximum 6 feet (1.8 meters)	

Motor Specifications			
Type	High Efficiency Close Coupled Gear Motor		
Seal	High Pressure Double Lip PTFE		
Internal Coasting Check	Prevents Damaging Pressure Spikes when Turned Off		
Size	-204R	-206R	-206R-PWM
Maximum Flow	4 GPM(15.1 LPM)	7 GPM (26.5 LPM)	
Maximum Pressure	2650 PSI (180 BAR)	2700 PSI (186 BAR)	
Bypass Needle	Up to 9 GPM	Up to 9 GPM	Not included
Use on HYD Systems	PC, LS, and OC	PC, LS, and OC	PC & LS
External Reverse Check	✓ 1/2" FNPT	✓ 1/2" FNPT	✓ #10 SAE
Inlet Adapter / Restrictor Body 1/2"FNPT	✓	✓	×
Restrictor Insert	✓	✓	×
-206R-PWM	Integrated 12V Proportional Control Valve and Pressure Relief Valve for use in Precision Applications using Pulse Width Modulated control systems.		
Flow Limiter (Optional)	LS-204N	LS-206N	Do not use

Available Models		
	FMC-75SP-HYD-204	FMC-75SP-HYD-206
		FMC-75SP-HYD-206-PWM

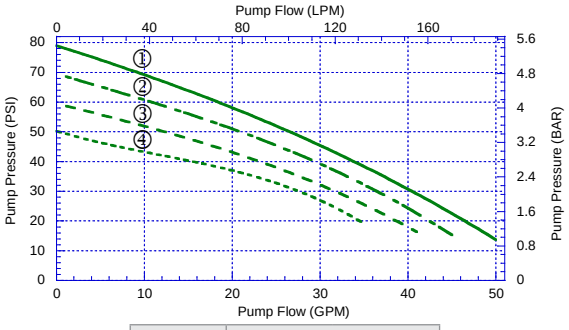
PERFORMANCE

FMC-75SP-HYD-204



CURVE	-204	
1	4.3 GPM	16.3 LPM
2	3.9 GPM	14.8 LPM
3	3.8 GPM	14.4 LPM

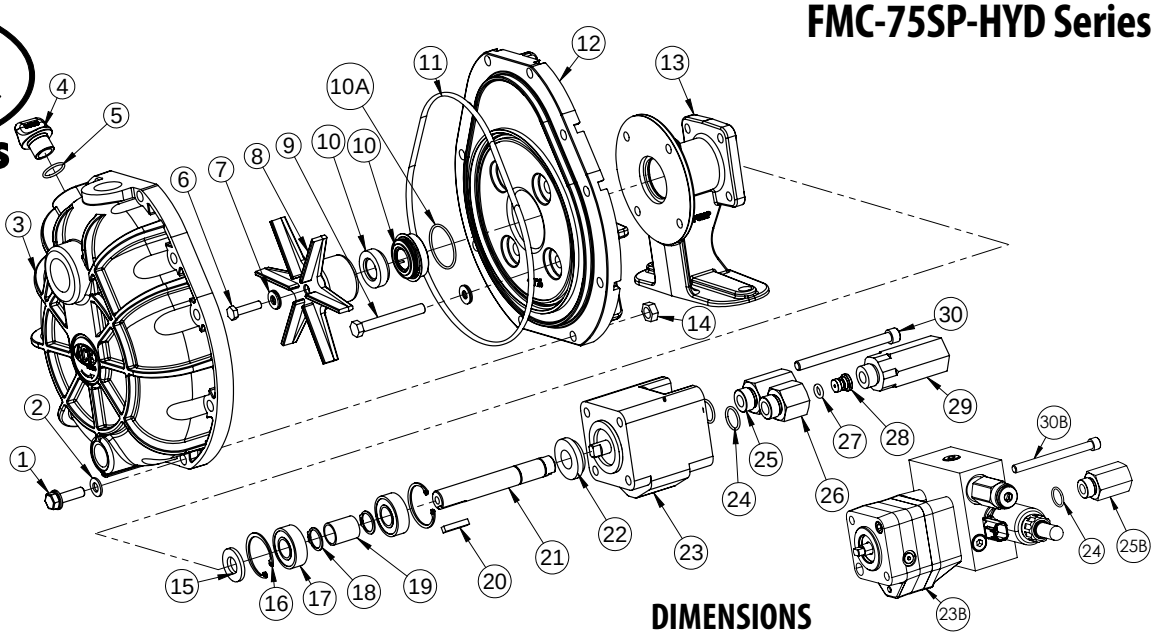
FMC-75SP-HYD-206



CURVE	-206	
1	6.2 GPM	23.5 LPM
2	5.7 GPM	21.5 LPM
3	5.1 GPM	19.3 LPM
4	4.7 GPM	17.8 LPM

Maximum Fluid Temperature - 140° F (60° C)
Fill pump volute prior to starting engine.
Do Not Run Dry - Seal damage will result from running dry. Impeller damage may also occur if run dry for an extended period.
Do Not Run With Flow Shutoff For Extended Periods
Running the pump with no flow for extended periods of time will result in excessive heat and pump failure. A continuous bypass is recommended for low flow applications.
Do not use with flammable liquids.

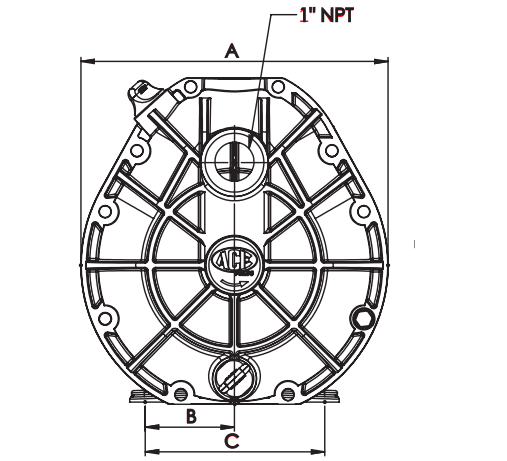
FMC-75SP-HYD Series

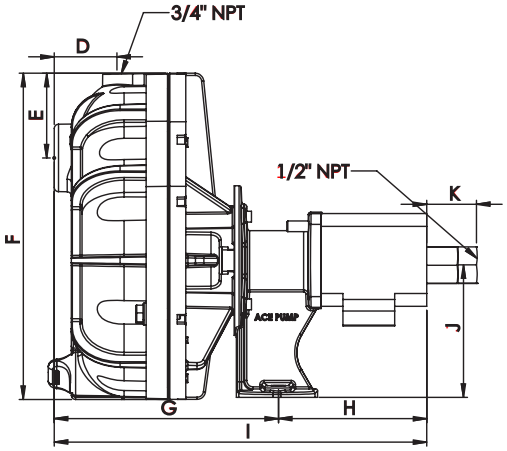


PARTS LIST

REF. #	PART NUMER	EDP #	DESCRIPTION	REQ.
1	42237	42237	Cap screw, 5/16"-18 x 1-3/8", hex head	10
2	20730	20730	Washer, flat, 5/16", volute to bracket	10
3	GE-12SP-75	42708	Volute, 1" x 3/4", polypropylene (includes two 41122 plugs)	1
4	41122	41122	Plug, volute	2
5	40191	40191	O-ring, plug	2
6	42240	42240	Cap screw, 1/4"-28 x 1", hex, SS	1
7 ①②	30028	30028	Washer, sealing	5
8	GE-26-75	42710	Impeller, with keyway, polypropylene	1
9	42238	42238	Cap screw, 5/16" NF x 2-1/2", SS	4
10 ①	BAC-7-75V	42730	Seal, 5/8", carbon/ceramic/FKM (includes 40159 O-ring)	1
10 ②	BAC-7SC-75V	42731	Seal, 5/8", silicon carbide/FKM (optional) (includes 40159 O-ring)	1
10A①②	40159	40159	O-ring, seal seat	1
11①②	40014	40014	O-ring, volute seal	1
12	GE-14-75SP	42725	Bracket, polypropylene	1
13	BAC-14-75-HYD	40293	Mounting frame (for 200R series motors)	1
14	42270	42270	Nut, hex, 5/16"-18	10
15	BAC-54	41130	Slinger	1
16	BAC-33	40810	Snap ring, internal, BAC-14 mounting frame	2
17	BAC-37	40870	Bearing, BAC-6 driven shaft	2
18	BAC-32	40790	Snap ring, external, BAC-6 driven shaft	2
19	BAC-32-S	40795	Spacer for BAC-6 shaft	1
20	41082	41082	Key, 3/16" x 3/16" x 15/16"	1
21	BAC-6-75-HYD-SS	40048	Shaft, 5/8" driven shaft with tang slot, SS	1
22	S200	40161	Seal support spacer for 200 series hydraulic lip seal	1
23	BAC-75-HYD-204R	41437	Hydraulic motor, 4 GPM (15.1 LPM)	1
23	BAC-75-HYD-206R	41438	Hydraulic motor, 7 GPM (26.8 LPM)	1
23B	BAC-75-HYD-206R-PWM	41314	Hydraulic motor, integrated PWM valve, 7 GPM (26.8 LPM)	1
24	41875	41875	O-ring, #8 SAE fitting	2
25	BAC-78-8SAE	41441	Reverse check assembly, #8 SAE male x 1/2" FNPT (includes 41875)	1
25B	BAC-78-10X8SAE	41462	Reverse check assembly, #8 SAE male x #10 SAE (includes 41875)	1
26	BAC-80-8SAE	41455	Body, restrictor orifice, #8 SAE male x 1/2" FNPT (includes 41875)	1
27	41448	41448	O-ring, orifice insert	1
28	BAC-79-5	41457	Orifice, restrictor insert, .078 (204) (includes 41448)	1
28	BAC-79-7	41456	Orifice, restrictor insert, .109 (206) (includes 41448)	1
29	LS-204N	41417	Flow limiting valve(204), #8SAE male x 1/2" FNPT (optional)	1
29	LS-206N	41418	Flow limiting valve(206), #8SAE male x 1/2" FNPT (optional)	1
30	41252	41252	Cap screw, 5/16" NC x 3-1/2" socket head (204), SS	4
30	41259	41259	Cap screw, 5/16" NC x 3-3/4" socket head (206), SS	4
30B	41263	41263	Cap screw, 5/16" NC x 6" socket head (206-PWM), SS	4
①	RK-FMC-75SP	60842	Repair kit for FMC-75SP-HYD series	-
②	RK-FMCSC-75SP	60843	Repair kit for FMC-75SP-HYD series with silicon carbide shaft seal	-
*	RK-BAC-75-HYD-L	43174	Repair kit for 200 series motor	-

DIMENSIONS





Ref.	A	B	C	D	E	F	G	K
Inches	8.98	2.63	5.25	2.32	2.48	9.54	6.56	1.45
MM	228.1	66.8	133.4	58.9	63.0	242.3	166.6	36.8

	-204			-206			-206-PWM		
Ref.	H	I	J	H	I	J	H	I	J
Inches	4.34	10.7	3.86	4.34	10.9	4.27	6.31	12.9	4.27
MM	110	272	98	110	277	109	160	327	109

3D Model Available

https://www.3DContentCentral.com/parts/supplier/Ace-Pumps.aspx

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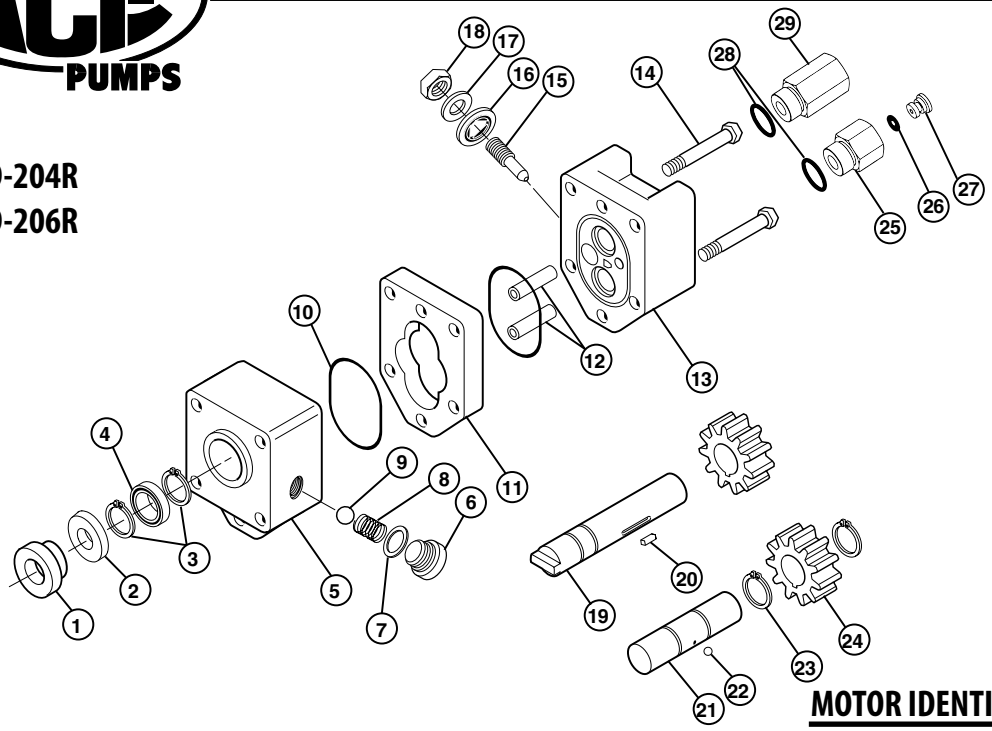
200R SERIES HYDRAULIC MOTORS

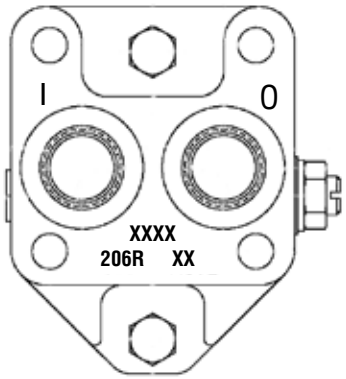
BAC-75-HYD-204R
BAC-75-HYD-206R



PARTS LIST

REF. #	MODEL 204R	MODEL 206R	DESCRIPTION	REQ.
1	S200	S200	Seal support spacer	1
2①	40153	40153	Seal cartridge	1
3	41941	41941	Snap ring, bearing	2
4	41961	41961	Ball bearing, 7/16" I.D.	1
5	41733	41733	Drive plate	1
6	42041	42041	Valve cap, coasting check	1
7①	42044	42044	O-ring, coasting check	1
8	42042	42042	Spring, coasting check	1
9	42043	42043	Ball, coasting check	1
10①	41850	41850	O-ring, housing seal	2
11	41720	41721	Gear housing	1
12	41800	41801	Dowel pin, housing	2
13	41743	41743	End plate	1
14	41900	41900	Cap screw, 1/4" N.C. hex head	2
15	42010	42010	Adjusting screw, needle valve	1
16①	42030	42030	Thread seal, 3/8", needle valve	1
17	42040	42040	Washer, flat steel, needle valve	1
18	40960	40960	Nut, 3/8" N.C. jam, needle valve	1
19	41761	41764	Drive shaft	1
20	41920	41921	Dowel pin, drive shaft	1
21	41970	41971	Idler shaft	1
22	41990	41990	Ball, idler shaft	1
23	41980	41980	Retaining ring, idler gear	2
24	41750	41751	Gear	2
25	41455	41455	Adapter body, #8 SAE male x 1/2" NPT (includes 41875)	1
26	41448	41448	O-ring, orifice insert (use with insert)	1
27	41457	41456	Insert, restrictor orifice (use with body) (includes 41448)	1
28	41875	41875	O-ring, #8 SAE male fitting	2
29	41441	41441	Reverse check, #8 SAE male x 1/2" NPT (includes 41875)	1
①	41374	41374	Repair Kit, RK-BAC-75-HYD-L	-

MOTOR IDENTIFICATION



Part number engraved on end plate (#13)

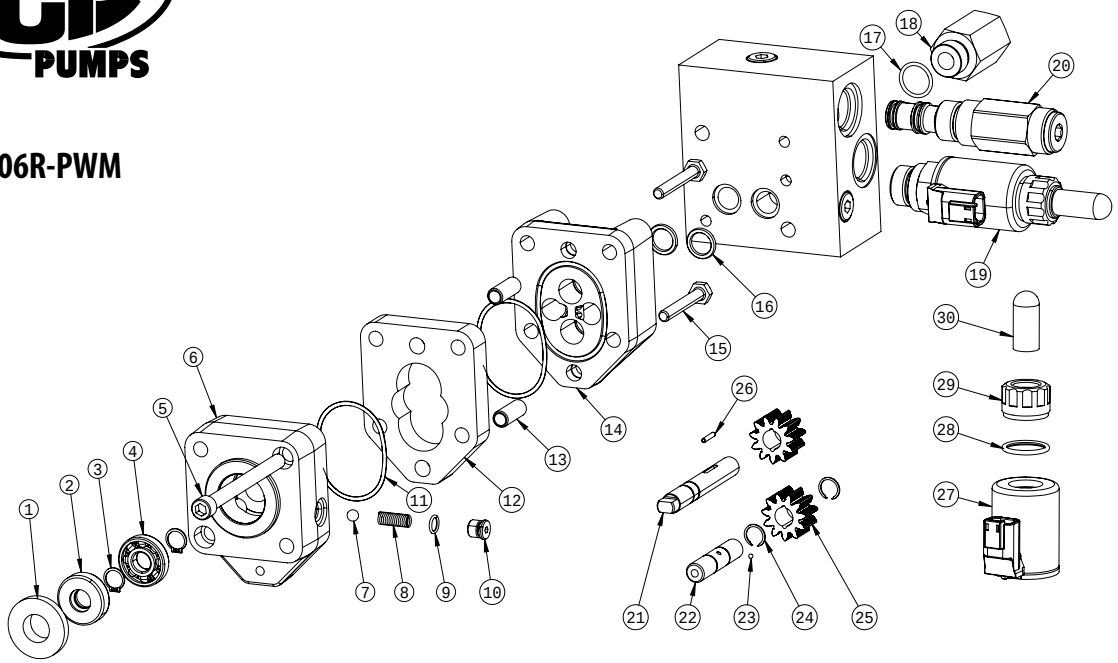
HYDRAULIC INFO

There are three general types of hydraulic systems:
1) Load Sensing (LS), also known as Pressure-Flow Compensating (PFC) Closed Center
2) Pressure Compensating Closed Center (PC)
3) Open Center (OPEN)

Please consult the Tractor Hydraulic System Pump Selection Guide(HSG), Internet Hydraulic Selection Guide (IHSG) at www.AcePumps.com, or your tractor dealer to determine your tractor's hydraulic system.

200R SERIES HYDRAULIC MOTORS

BAC-75-HYD-206R-PWM

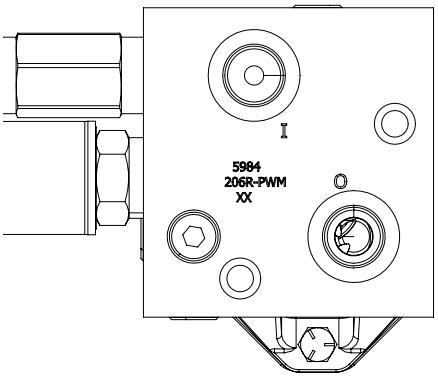


PARTS LIST

REF. #	PART NUMER	EDP #	DESCRIPTION	REQ.
1	S200	40161	Seal support spacer	1
2①	BAC-75-200-TLS	40153	Seal cartridge	1
3	41941	41941	Snap ring, bearing	2
4	41961	41961	Ball bearing, 7/16" I.D.	1
5	41256	41256	Cap screw, 5/16" N.C. x 3.5" socket head	2
6	41731	41731	Drive plate, 200 series motors	1
7	42043	42043	Ball, coasting check	1
8	42042	42042	Spring, coasting check	1
9①	42044	42044	O-ring, coasting check	1
10	42041	42041	Valve cap, coasting check	1
11①	41850	41850	O-ring, housing seal	2
12	41721	41721	Gear housing	1
13	41801	41801	Dowel pin, housing	2
14	41771	41771	End plate, 200R-PWM series motors	1
15	41900	41900	Cap screw	2
16	74209	74209	O-ring, port sealing, manifold to motor	2
17	41875	41875	O-ring, #8 SAE male fitting	2
18	BAC-78-10X8 SAE	41462	Reverse check, #8 SAE male x #10 SAE female (includes 41875)	1
19	PWM-18-PRO-6	74222	Valve assembly, 12V proportional	1
20	PWM-18-PRV-11	74210	Valve assembly, pressure reducing	1
21	41764	41764	Drive shaft	1
22	41971	41971	Idler shaft	1
23	41990	41990	Ball, idler shaft	1
24	41980	41980	Retaining ring, idler gear	2
25	41751	41751	Gear	2
26	41921	41921	Dowel pin, drive shaft	1
27	74225	74225	Coil, 12V for PWM-18-PRO-6 and -11	1
28	41445	41445	O-ring, coil nut	1
29	74230	74230	Nut, coil retainer for PWM-18-PRO-6 and -11	1
30	74235	74235	Protector, manual override, PWM-18-PRO-6 and -11	1
31	BAC-75-HYD-206R-P	41313	Motor, BAC-75-HYD-206R-PWM, less manifold	-
*	PWM-1-206R	74202	Manifold assembly, 206R-PWM, includes 16 - 20	-
①	RK-BAC-75-HYD-L	41374	Motor repair kit	-

* Not shown in parts diagram

MOTOR IDENTIFICATION



PWM HYDRAULIC INFO

There are three general types of hydraulic systems:
1) Load Sensing (LS), also known as Pressure-Flow Compensating (PFC) Closed Center
2) Pressure Compensating Closed Center (PC)
3) Open Center (OPEN)

This product is designed to operate on both Closed Center Hydraulic Systems. It should not be used with Open Center systems. Please consult the Tractor Hydraulic System Pump Selection Guide(HSG), Internet Hydraulic Selection Guide (IHSG) at www.AcePumps.com, or your tractor dealer to determine your tractor's hydraulic system.

The two valve design limits the maximum oil flow to the motor and prevents overspeeding. The Restrictor Orifice and Flow Limiter are not needed with this product.

All PWM controllers are slightly different in the terminology used and setup procedures. Please consult your controller documentation or their technical service department for additional assistance with your specific application and implement in use.

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FMC-75SP Series Self-Priming Frame Mounted Centrifugal Pump

These compact corrosion resistant pumps are perfect for smaller transfer, spray, or tank rinsing applications.

Features:

- Compact and light weight design
- All polypropylene construction with stainless steel internal hardware providing excellent corrosion resistance
- Self-priming up to 6 ft. (1.8 m)
- For belt driven applications.
- Clockwise rotation when viewed from shaft end

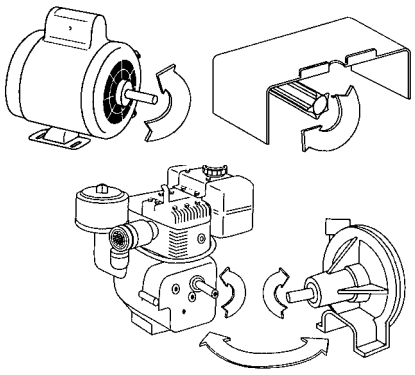
SPECIFICATIONS

Pump Specifications	
Ports	1″ NPT x 3/4″ NPT
Max. Flow	50 GPM (189 LPM)
Max. Pressure	80 PSI (5.5 BAR)
Max. Speed	4800 RPM
Construction	Polypropylene
Seal	Carbon/Ceramic/FKM or Optional Silicon Carbide /FKM
Shaft	Stainless Steel
Bearings	Sealed for long life
Rotation	Clockwise (-CW) from shaft end
Impeller	Polypropylene with key
Priming Height	Maximum 6 feet (1.8 meters)

Pump Speed Calculation

$$\frac{\text{Pump RPM}}{\text{Driveshaft RPM}} = \frac{\text{Drive Pulley Diameter}}{\text{Pump Pulley Diameter}}$$

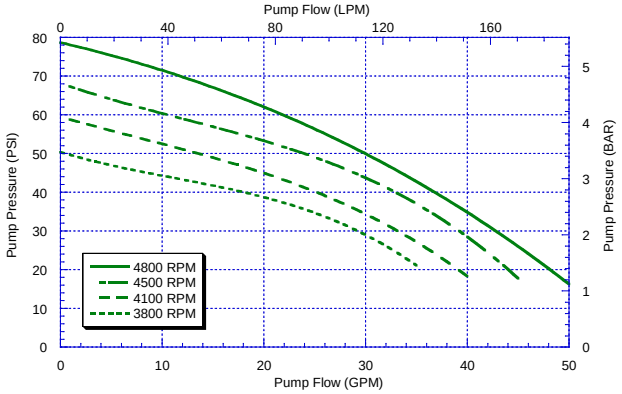
Rotation of Common Power Sources



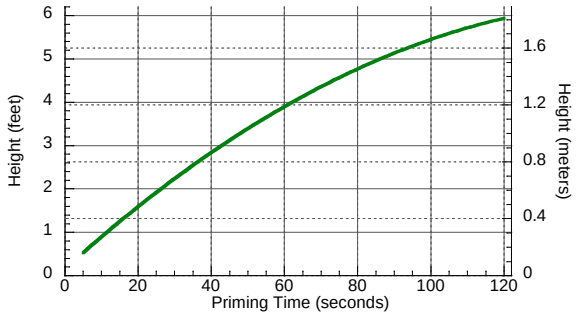
Consider GE-85SP model for direct mount to gas engine.

Available Models	
	FMC-CW-75SP
	FMCSC-CW-75SP

PERFORMANCE



Priming Curve



Maximum Fluid Temperature - 140° F (60° C)

Fill pump volute prior to starting engine.

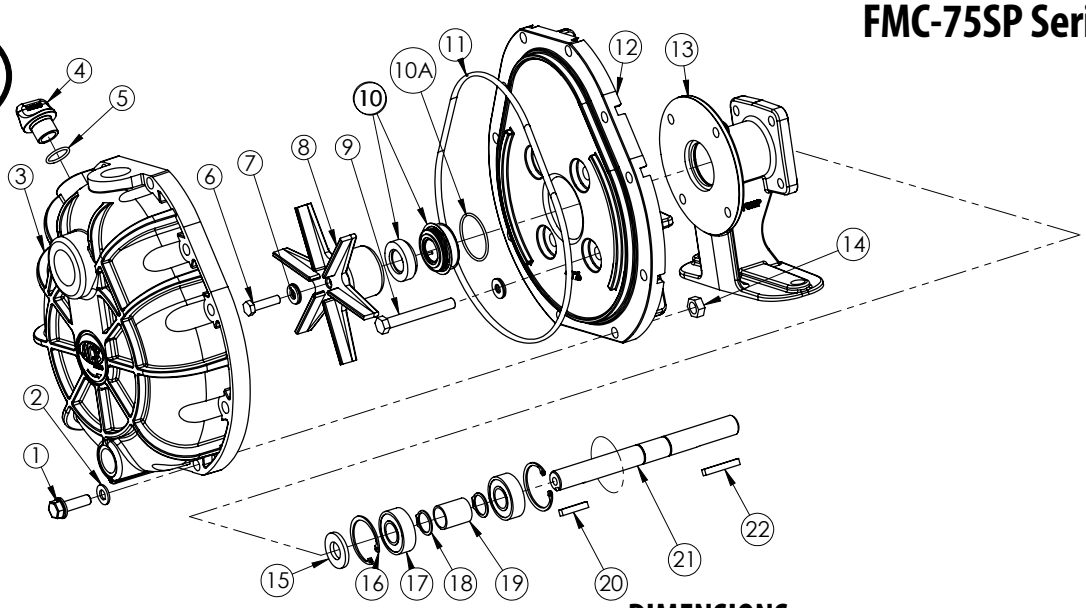
Do Not Run Dry - Seal damage will result from running dry. Impeller damage may also occur if run dry for an extended period.

Do Not Run With Flow Shutoff For Extended Periods

Running the pump with no flow for extended periods of time will result in excessive heat and pump failure. A continuous bypass is recommended for low flow applications.

Do not use with flammable liquids.

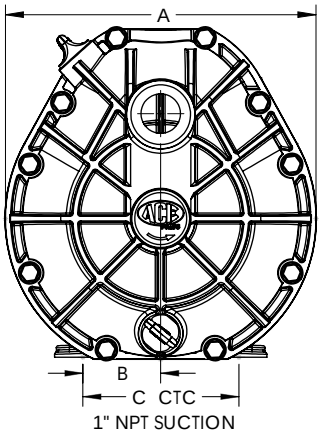
FMC-75SP Series

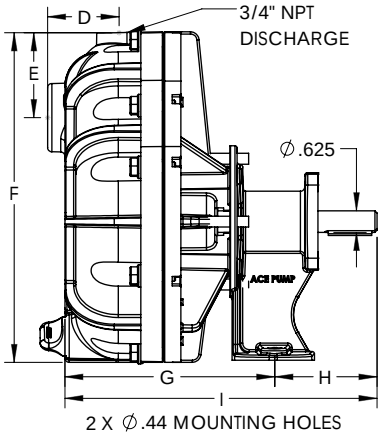


PARTS LIST

REF. #	PART NUMER	EDP #	DESCRIPTION	REQ.
1	42237	42237	Cap screw, 5/16"-18 x 1-3/8", hex head	10
2	20730	20730	Washer, flat, 5/16", volute to bracket	10
3	GE-12SP-75	42708	Volute, 1" x 3/4" , polypropylene, CW	1
4	41122	41122	Plug, volute	2
5	40191	40191	O-ring, plug	2
6	42240	42240	Cap screw, 1/4"-28 x 1", hex, stainless steel	1
7 ①②	30028	30028	Washer, sealing	5
8	GE-26-75	42710	Impeller, with keyway, polypropylene	1
9	42238	42238	Cap screw, 5/16"NF x 2-1/2"	4
10 ①	BAC-7-75V	42730	Seal, 5/8" , FKM/carbon/ceramic (includes 40159 O-ring)	1
10 ②	BAC-7SC-75V	42731	Seal, 5/8" , FKM/silicon carbide (optional) (includes 40159 O-ring)	1
10A①②	40159	40159	O-ring, seal seat	1
11①②	40014	40014	O-ring, volute seal	1
12	GE-14-75SP	42725	Bracket, polypropylene	1
13	BAC-14-75-HYD	40293	Mounting frame (for 200R series motors)	1
14	42270	42270	Nut, hex, 5/16"-18	10
15	BAC-54	41130	Slinger	1
16	BAC-33	40810	Snap ring, internal, BAC-14 mounting frame	2
17	BAC-37	40870	Bearing, BAC-6 driven shaft	2
18	BAC-32	40790	Snap ring, external, BAC-6 driven shaft	2
19	BAC-32-S	40795	Spacer for BAC-6 shaft	1
20	41082	41082	Key, 3/16" x 3/16" x 15/16"	1
21	BAC-6-75-SS	40046	Shaft, 5/8" Belt drive, stainless steel	1
22	BAC-50	41080	Key, 3/16" x 3/16" x 1-1/4"	1
①	RK-FMC-75SP	60842	Repair kit for FMC-75SP-HYD series	-
②	RK-FMCSC-75SP	60843	Repair kit for FMC-75SP-HYD series with silicon carbide shaft seal	-

DIMENSIONS

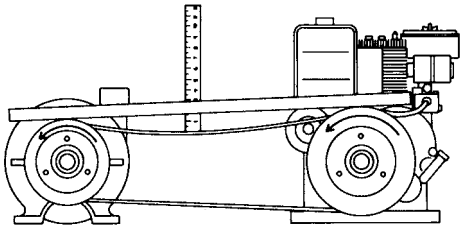




Ref.	A	B	C	D	E	F	G	H	I
Inches	8.98	2.63	5.25	2.32	2.48	9.54	6.56	3.00	9.56
MM	228.1	66.8	133.4	58.9	63.0	242.3	166.6	76.2	242.8

Belt Tension

Proper tension will allow 1/2" (1 cm) of deflection for each 12" (30 cm) of distance between shaft centers.



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3D Model Available
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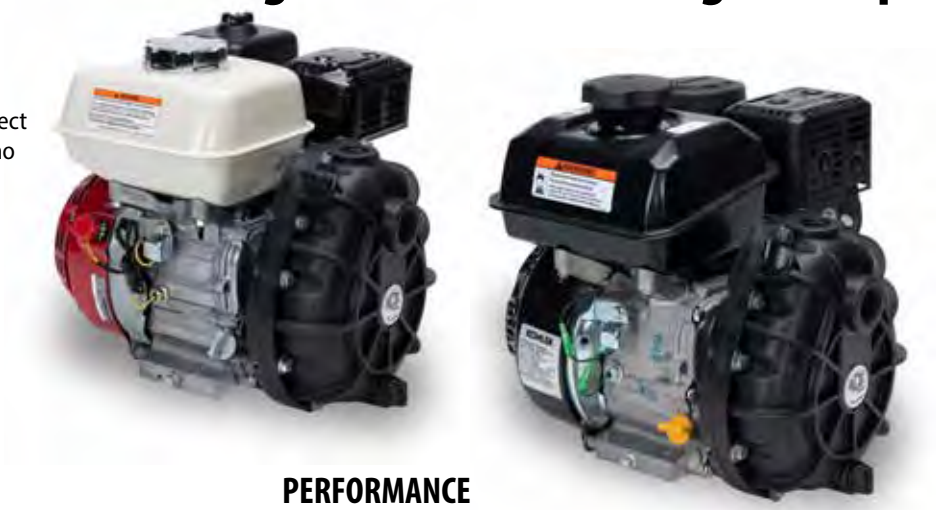
Ace Form # FMC-75SP
01/21

GE-85SP Self-Priming Gas Engine Driven Centrifugal Pump



These compact corrosion resistant pumps are perfect for smaller transfer and spray applications where no other power source is available.

Features include:

- Compact, light weight design
- All polypropylene construction with stainless steel internal hardware providing excellent corrosion resistance
- Directly mounts on engine with no need for expensive gear reduction models

SPECIFICATIONS

Pump Specifications		
Ports	1" NPT x 3/4" NPT	
Max. Flow	24 GPM (90 LPM)	
Max. Pressure	60 PSI (4.1 BAR) w/KOHLER	55 PSI (3.8 BAR) w/HONDA
Priming Height	Maximum 6 feet (1.8 meters)	
Construction	Polypropylene Corrosion Resistant Construction	
Seal	Carbon/Ceramic/FKM or Optional Silicon Carbide/FKM	
Shaft	Mounts Directly on 3/4" Keyed Engine Shaft	
Impeller	Polypropylene with key	

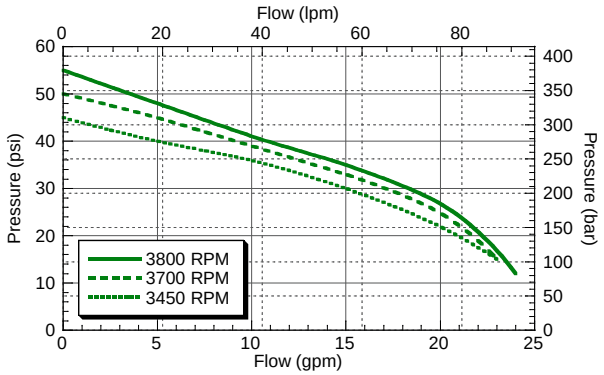
Engine Specifications		
Model	Honda GX-120 Commercial Series	Kohler Command Pro CH245 Professional Series
Power	3.5 HP (2.6 kW) @ 3600 RPM	4.5 HP (3.3 kW)
Starting System	Recoil	Recoil
Shaft	3/4" straight keyed shaft	3/4" straight keyed shaft

Available Models		
	GE-85SP-LE (Less Engine)	GE-85SP-HONDA
		GE-85SP-KOHLER

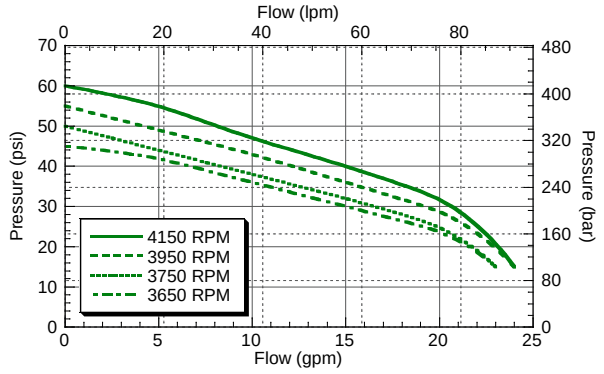
Maximum Fluid Temperature - 140° F (60° C)
Fill pump volute prior to starting engine.
Do Not Run Dry - Seal damage will result from running dry. Impeller damage may also occur if run dry for an extended period.
Do Not Run With Flow Shutoff For Extended Periods
Running the pump with no flow for extended periods of time will result in excessive heat and pump failure. A continuous bypass is recommended for low flow applications.
Do not use with flammable liquids.

PERFORMANCE

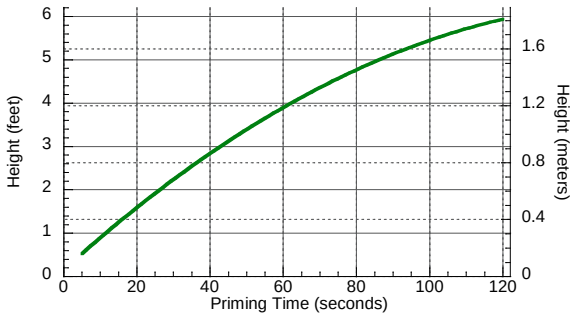
GE-85SP-HONDA



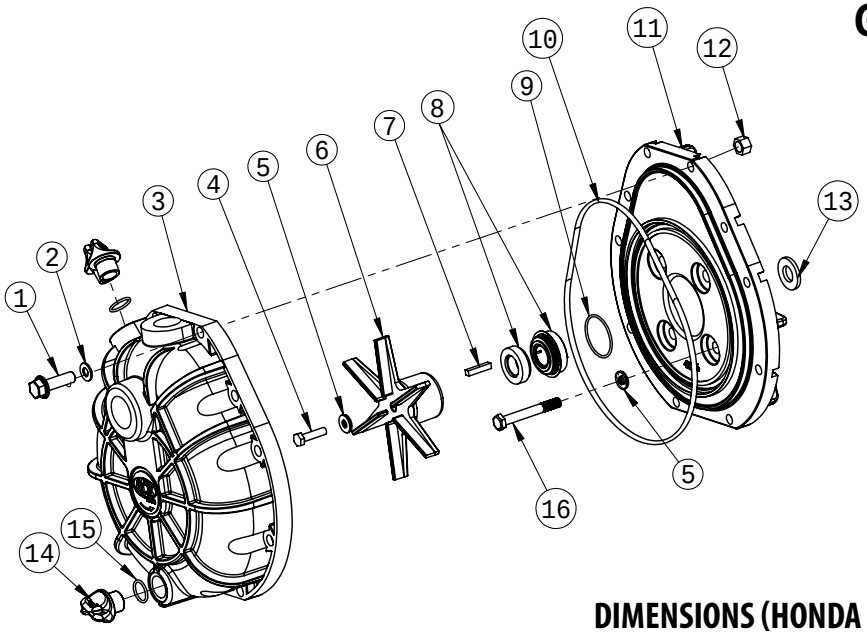
GE-85SP-KOHLER



Priming Curve



GE-85SP Series

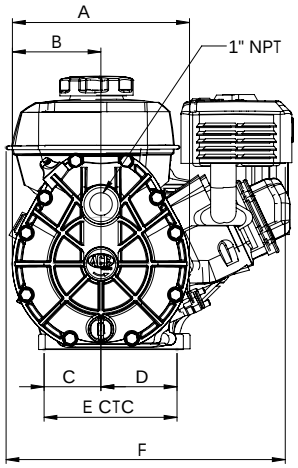


PARTS LIST

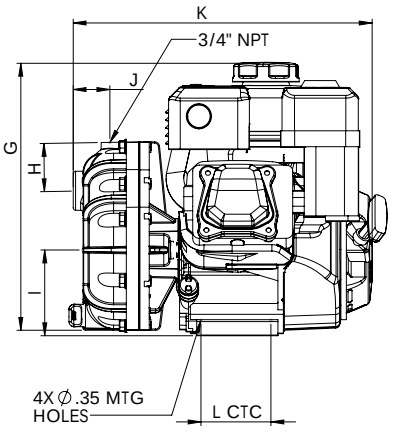
REF. #	PART NUMER	EDP #	DESCRIPTION	REQ.
1	42237	42237	Cap screw, 5/16"-18 x 1-3/8", hex head	10
2	20730	20730	Washer, 5/16", flat, volute to bracket	10
3	GE-12-75SP	42708	Volute, 3/4" x 1", polypropylene (includes two 41122 plugs)	1
4	GE-60-SS	42235	Cap screw, 5/16" NF x 3/4", hex head, stainless steel	1
5 ①②	30028	30028	Washer, sealing, stainless steel	5
6	GE-26-85	42711	Impeller with keyway, polypropylene	1
7	41082	41082	Key, 3/16" x 3/16" x 15/16"	1
8 ①	BAC-7-660V	30225	Shaft seal, carbon/ceramic/FKM (includes 40159 O-ring)	1
8 ②	BAC-7SC-660V	30226	Shaft seal, silicon carbide/FKM (includes 40159) (optional)	1
9①②	40159	40159	O-ring, shaft seal, GE-85	1
10①②	40014	40014	O-ring, volute seal, GE-85SP	1
11	GE-14-85SP	42726	Bracket, GE-85SP, polypropylene	1
12	42270	42270	Nut, hex, 5/16"-18	10
13	BAC-54	41130	Slinger	1
14	41122	41122	Plug, volute (includes 40191 O-ring)	2
15	40191	40191	O-ring, fill and drain plug	2
16	42238	42238	Cap screw, 5/16" NF x 2-1/2", stainless steel	4
*	42056	42056	Engine, 3.5 HP Honda GX120UT2QA2	-
*	42076	42076	Engine, 4.5 HP Kohler CH245-3152	-
*①②	30035	30035	Thread locker, removable	1
①	RK-GE-85SP	60847	Repair kit for GE-85SP	-
②	RK-GESC-85SP	60848	Repair kit for GE-85SP, silicon carbide (optional)	-

* Not shown in parts diagram.

DIMENSIONS (HONDA GX-120)



Ref.	A	B	C	D	E	F
Inches	9	4.5	2.6	3.8	6.4	13.6
MM	228.6	114.3	66	96	162	329



Ref.	G	H	I	J	K	L
Inches	13	5.43	4.33	1.85	15	3.1
MM	329	137.9	110.0	47.0	380	80

3D Model Available
https://www.3DContentCentral.com/parts/supplier/Ace-Pumps.aspx

GE-85SP-LE Assembly Instructions

WARNINGS:

Maximum Fluid Temperature - 140° F

Fill pump volute prior to starting engine.

Do Not Run With Flow Shutoff For Extended Periods - Running the pump with no flow for extended periods of time will result in excessive heat and pump failure. Running the pump with flow shutoff for more than 5 minutes causes the fluid temperature to rise and melt pump components. A bypass is recommended for low flow applications.

Do Not Run Dry - Seal damage or failure will result from running dry. Impeller damage may also occur if run dry for an extended period.

NOTE: Refer to the engine Owner's Manual for proper operation and safety precautions.

The GE-85SP-LE pump kit includes all parts necessary to assemble the pump on a gas engine with 3/4" keyed shaft.

Assembly:

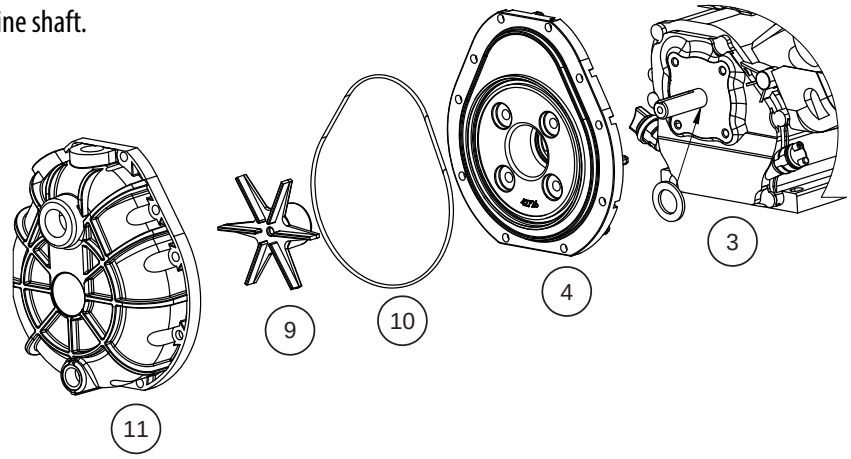
1) Remove box contents and verify all parts were received. The rotating seal face (Ref. 8) and 41082 key (Ref. 7) are factory installed in the impeller hub (Ref. 6). The stationary seal face (Ref. 8) and 40159 O-ring (Ref. 9) are factory installed in the bracket (Ref. 11).

2) Clean engine shaft internal threads with brake cleaner or similar degreasing material and dry.

3) Insert the BAC-54 slinger onto the engine shaft and slide over the keyway to the shaft shoulder.

4) Place the GE-14-85SP bracket carefully over the engine shaft.

5) Attach the GE-14-85SP bracket to the engine using(4) 42238 5/16"NF cap screws and (4) 30028 sealing washers. The rubber side of the washer faces the GE-14-85SP bracket. Torque bolts to 10 ft-lb (14 N-m).
Caution: Aluminum engine housing threads may strip if over tightened.



6) Verify that the slinger is on the shaft with clearance on both sides for proper function.

7) Verify that the key is in place in the impeller keyway. If the key is loose apply silicone and reinstall in the keyway.
Caution: Be careful not to touch or contaminate the seal face.

8) Install the GE-26-85 impeller over the engine shaft, aligning the impeller key with the shaft keyway.

9) Attach the impeller with (1) GE-60-SS 5/16" cap screw and (1) 30028 5/16" sealing washer. The rubber side of the sealing washer faces the impeller.
Important: Apply included removable threadlocker (Nut Lock) to screw threads and torque to 60 in-lb (7 N-m).

10) Lightly grease the 40014 housing seal O-ring and place onto the GE-14-85SP pump bracket around the pilot.

11) Install the GE-12-75SP volute to the GE-14-85SP bracket with (10) 42237 5/16" cap screws, (10) 20730 5/16" flat washers and (10) 42270 5/16" hex nuts. Start all bolts first then torque opposing bolts until all are tightened to 60 in-lb (7 N-m) of torque.

12) Follow engine manufacturers instructions for engine startup procedures.

Seal Replacement Instructions

Disassembly:

1) Remove (10) 42237 5/16" volute cap screws, (10) 20730 5/16" flat washers and (10) 42270 5/16" nuts.

2) Remove GE-12-75SP volute and 40014 volute O-ring. Discard used O-ring.
   Note: Do not remove the screws inside the volute. There are no serviceable parts in the assembly. Only remove in case of blockage using care to not strip the holes. Locking material should be used when reinstalling the screws.

3) Remove the GE-60-SS 5/16" cap screw and 30028 sealing washer from the end of the engine shaft. Discard the used sealing washer.

4) Remove the GE-26-85 impeller from the engine shaft.

5) Remove and discard the rotating seal face and rubber cup from the impeller hub by prying with a screwdriver inside the seal ID. Verify that 41082 key is in place in the impeller keyway. If the key is loose apply silicone and reinstall in the keyway.

6) Clean the impeller seal bore prior to installing the new seal. Wet the rubber cup with soapy water to lubricate the seal for installation. Place a clean, non-abrasive cloth over the seal face to prevent damage during installation. Use your hand to press the seal into the bore until it is seated flat.

7) Remove the GE-14-85SP bracket from the engine by removing (4) 42238 cap screws and (4) 30028 sealing washers. Discard the used sealing washers.

8) Turn the bracket over and press or tap out the stationary seal and 40159 O-ring. Discard used O-ring.

9) Clean the seal bore. Install the new 40159 O-ring under the seal cup on the new stationary seal. Press or tap the seal cup evenly into the seal bore with a 1-1/2" pipe nipple.
   Caution: Be careful not to touch or contaminate the seal face.

10) Refer to the pump assembly instructions on the previous page for re-assembly.

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