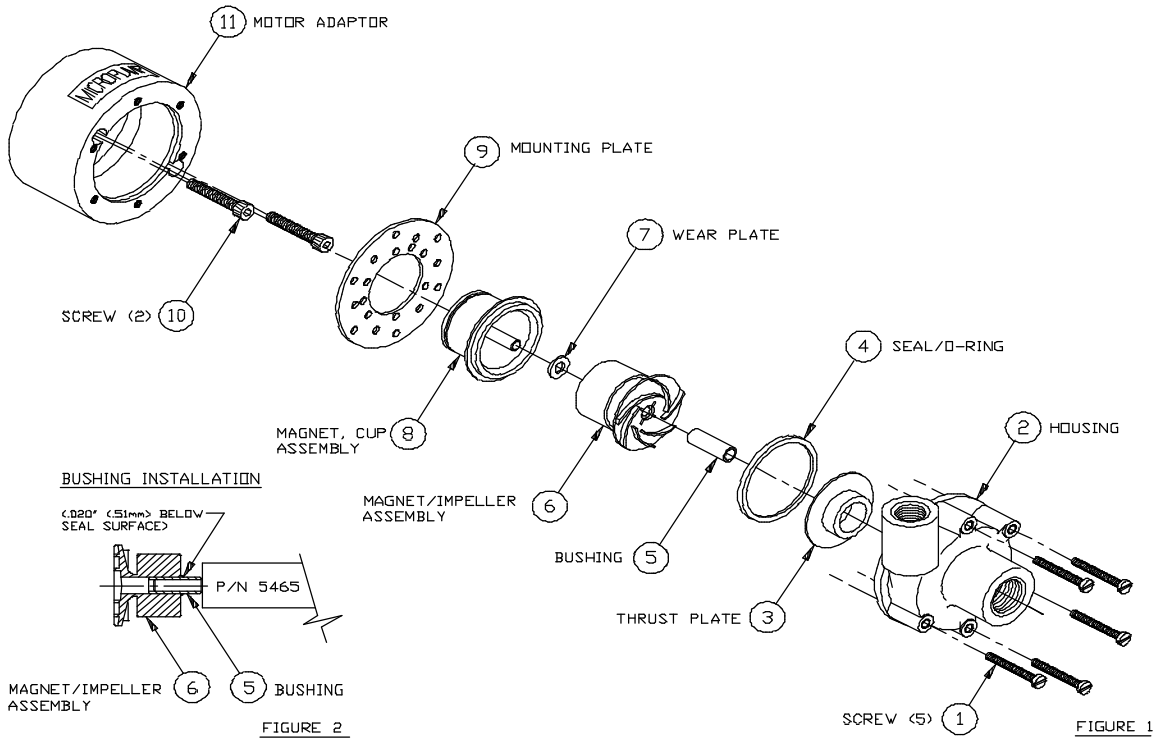


SERVICE INSTRUCTIONS: 5478

REVISION			
LTR.	DESCRIPTION	DATE	BY
D	REVISED PER ECN-5175	4/14/00	PJN

MOD: 101



**GENERAL:**

1. All service work should be performed in a clean area.
2. Care should be taken to avoid scratching any sealing surfaces or allowing metal chips to come in contact with the driven magnet assembly.
3. An even, light coat of high vacuum silicone grease (Dow Corning or equiv.) should be applied to all seals or O-Rings.
4. O-Rings with chamfers should always be installed with the chamfer up, away from the groove.
5. All assembly screws should be tightened evenly and in an alternating pattern.
6. Only Micropump factory authorized replacement parts should be used when servicing any Micropump products.

**SPECIFIC:**

1. Care must be taken not to bend, nick or damage the vanes on the Impeller Assembly (6).
2. Remove Bushing (5) using a screw extractor.
3. Insert new Bushing into Impeller Assembly from magnet end using Bushing Insertion Tool (P/N 5465). Install flush to .020 inch (.51 mm) below end of Impeller Assembly (See Fig. 2).
4. Boss on Thrust Plate (3) should be away from Impeller Assembly.
5. Use #12 Reamer to ream Bushing in Impeller Assembly if necessary .
6. Complete assembly as shown above (See Fig. 1).

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