

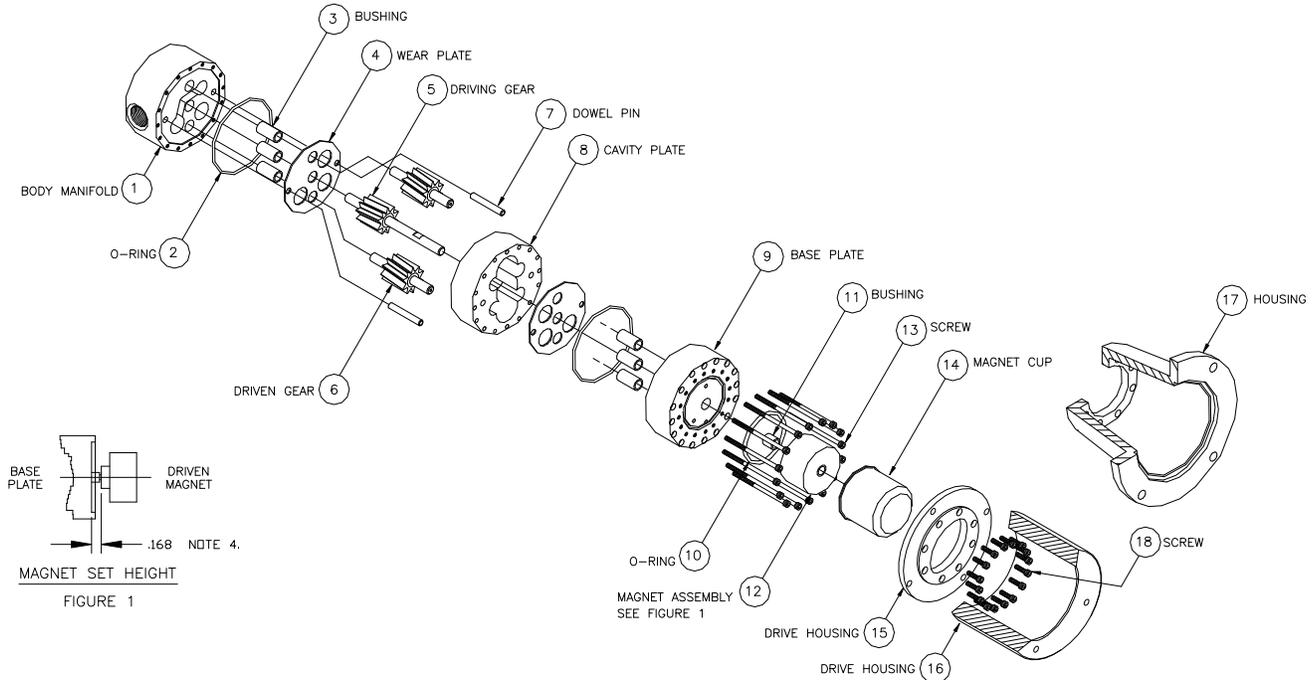


PART NUMBER:	L24298
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**SERVICE INSTRUCTIONS:**

REVISION			
LTR.	DESCRIPTION	DATE	BY
A	ORIGINATE PER E14779	8/8/05	TJC

MOD: GN SERIES



**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 silicon grease (Dow Corning or equivalent) should be applied to all seals or o-rings (except o-rings made from Teflon).
4. All assembly screws should be tightened evenly and in an alternating pattern.
5. Only Micropump factory authorized replacement parts should be used when servicing any Micropump products.

**SPECIFIC:**

1. Remove worn bushings, gears, and o-rings. Clean the pump components using a suitable solvent to remove any grease, sludge, etc.
2. Press new bushings into the manifold and baseplate until they are flush with the top surface of the stainless steel. Please note that the bushing to be inserted into the driven magnet end of the baseplate is one-half as wide as the others (see drawing above) and may protrude slightly.
3. Lay the manifold on a flat surface and assemble the pump as shown above. Take special care to align the flow holes in the wear plates - incorrect orientation will cause low pump performance.
4. Torque Screws (13) to 40 in-lbs in an alternating pattern.
5. Slip the driven magnet assembly onto the driving gear shaft and tighten the setscrews to 10 in-lbs, ensuring that the magnet set height is  $.168'' \pm .003''$  from the inner surface of the base plate.
6. Finish assembling the pump and torque the motor housing to pump screws (18) to 40 in-lbs in an alternating pattern.

**MICROPUMP, INC.**

A Unit of IDEX Corporation

PO Box 8975, Vancouver, WA 98668-8975 • Phone: 360/253-2008 • Fax: 360/253-8294

**MICROPUMP LIMITED**

A Subsidiary of Micropump, Inc.

Howard Road, Eaton Socon, St. Neots, Cambridgeshire, PE 19 8ET England, • Phone: (44) (0) 1480-356600 • Fax: (44) (0) 1480-356300