HOMA™
Pump Technology Inc.

Procedures

Collet Impeller Assembly

You will need:

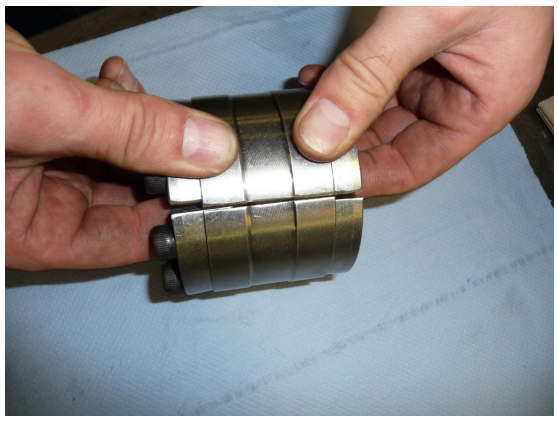
-A torque wrench with a 40 foot pound capacity
-Allen key socket and extension
-Liquid soap to lubricate o rings

Instructions

- Place o-ring around outside diameter and inside diameter of distance ring, lubricate with liquid soap, and place in impeller. (A) DO NOT USE GREASE TO LUBRICATE.
- Lightly tap ring in with a plastic hammer.
- Loosen all screws in impeller locking mechanism, and pull the opposite sides to extend the mechanism. (B)
- Degrease inside and outside surface of locking mechanism, shaft, and impeller borehole. Any residual on these surfaces may cause collet to slip.
- Place locking mechanism into impeller borehole. (C)
- Lubricate inner o-ring in distance ring with liquid soap.
- Slide impeller onto shaft until locking mechanism reaches shoulder of the shaft.
- Be certain that the locking mechanism stays in the proper position while installing on shaft.

A

B

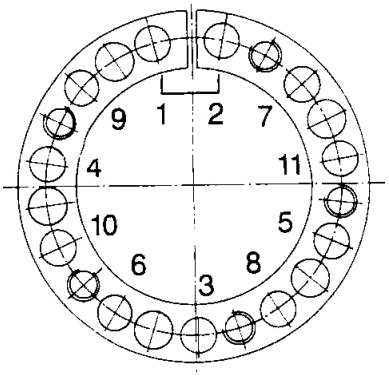


C.

E.

Part number	Inside Diameter (inch)	Outside Diameter (inch)	Torque (inch pounds)
4492007	1.575	2.5	100
4492010	1.75	2.875	80
4492016	2	2.875	90
4492020	2.2	3.35	120
4492025	2.36	3.35	140
4492027	2.56	3.75	160
4492033	2.75	4.33	400

- Snug all screws in locking mechanism.
- Tighten screws in the order shown in (D)
- Tighten the screws to the required torque, given in table (E).
- Retighten screws in the same pattern to the same torque to ensure the collet will not slip. This will take 5-8 repetitions. THE COLLET WILL NOT HOLD IF SCREWS ARE ONLY TIGHTENED ONCE.
- Put o-ring on cover disc and lubricate it.
- Install cover disc over locking mechanism on impeller borehole.
- Make certain to place copper washer and loctite on bolt before installation. (F)
- Tighten bolt.



D

F.