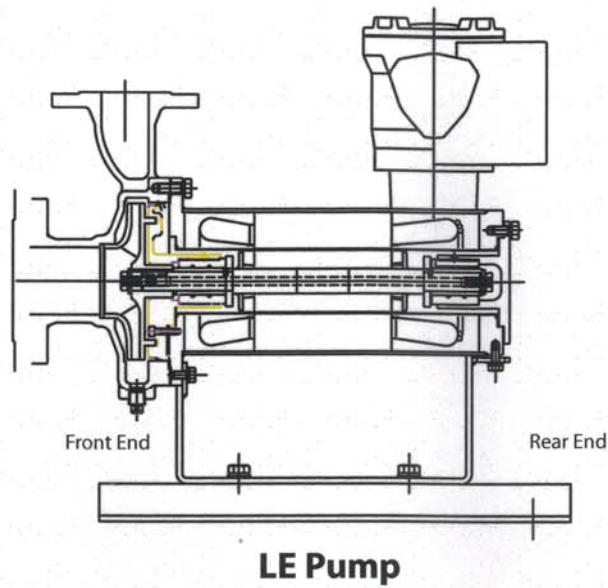


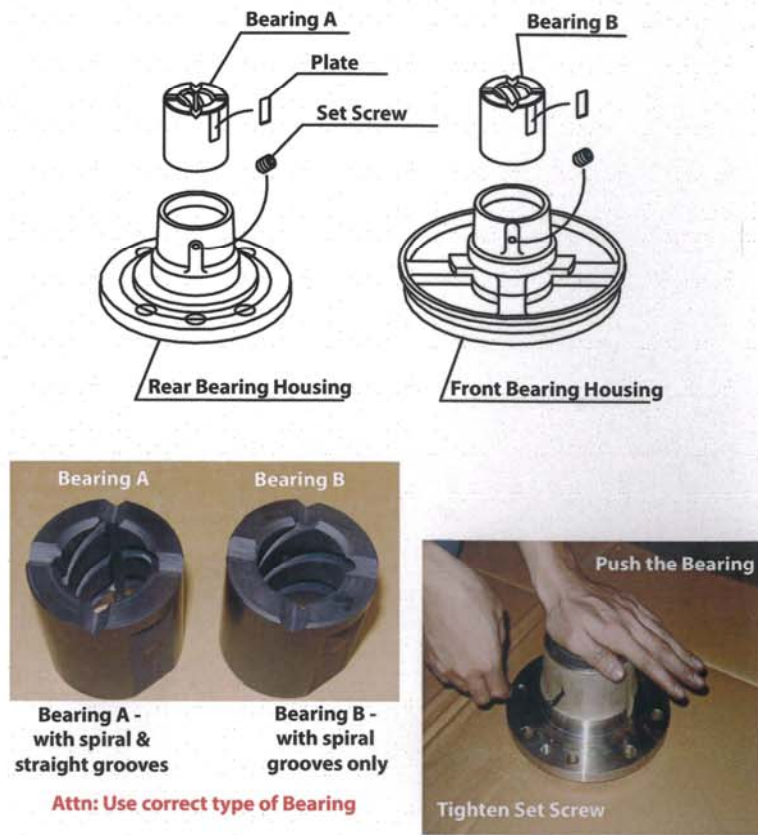
LE Series Maintenance (Assembly) Sheet



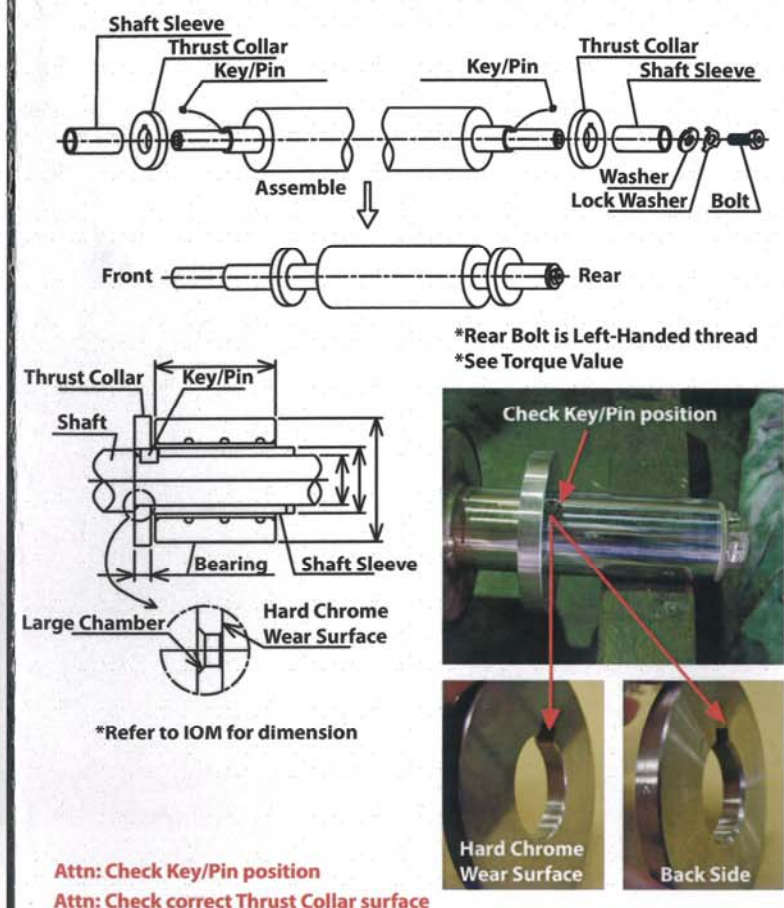
This maintenance sheet covers LE Series Pumps

*This is a complimentary maintenance sheet, please refer to IOM for detailed information

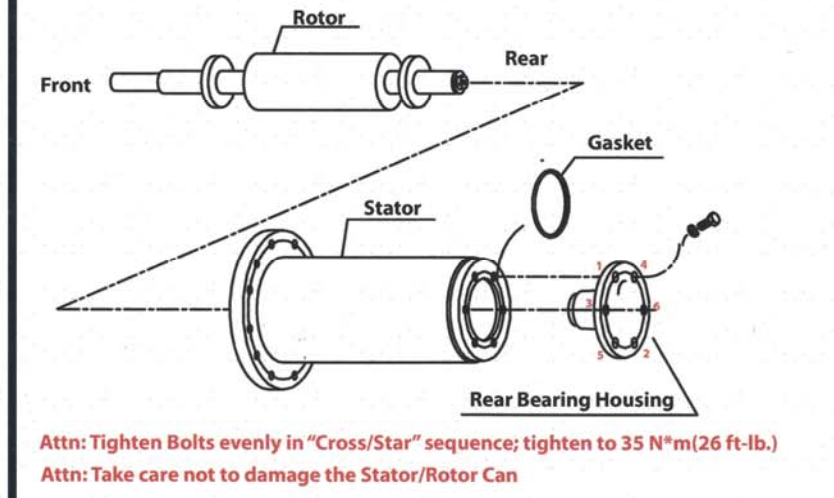
Step 1: Assemble Bearing Housings



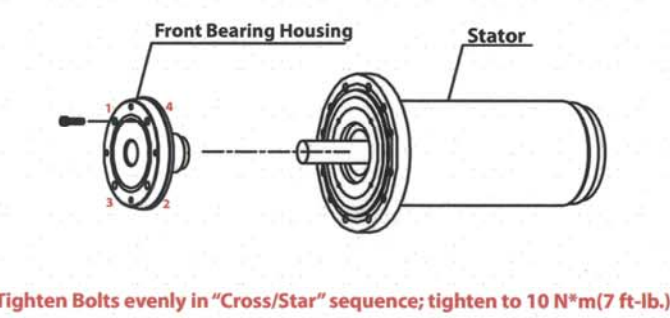
Step 2: Assemble Rotor



Step 3: Insert Rotor & Install Rear Bearing Housing



Step 4: Install Front Bearing Housing



Step 5: Check the Rotor & Impeller Gap

Step 5a

Step 5b

Step 5c

Measure dimension "A", "B" & "C"

Attn: Check that each gap is within tolerance

Attn: Make sure that Shaft Sleeve is properly fitted into key/pin

| Motor Type | Impeller Type |
|------------|---------------|
| 3111 | R, SG, SF |
| 3115 | SS, S, TS |
| 3211 | SG, SF, TG |
| 3215 | T, TF |
| 3311 | T, TF |
| 3315 | T, TF |

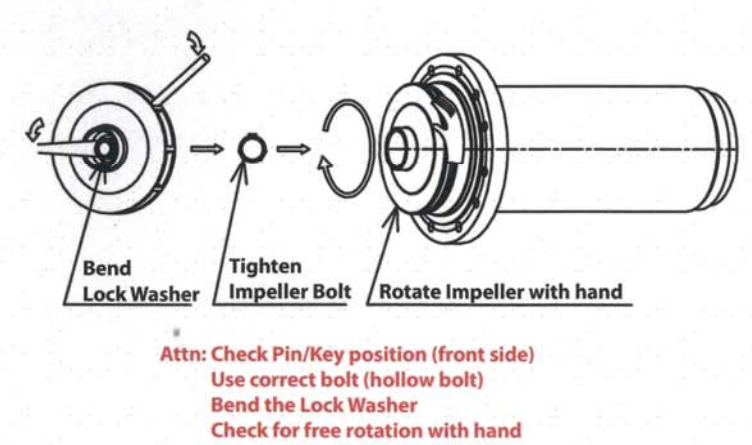
| Motor Type | Rotor Gap | |
|------------|-----------|---------------|
| | (mm) | (inch) |
| 3111 | 0.7 - 1.9 | 0.028 - 0.075 |
| 3115 | 0.7 - 2.1 | 0.028 - 0.083 |
| 3215 | 0.7 - 2.1 | 0.028 - 0.083 |
| 3311 | 0.7 - 2.1 | 0.028 - 0.083 |
| 3315 | 0.9 - 2.5 | 0.035 - 0.098 |

| Motor Type | Impeller | Impeller Gap | |
|------------|------------|--------------|--------|
| | | (mm) | (inch) |
| 3111 | R, SG, SF | 4 | 0.158 |
| 3115 | SS, S, TS | 4 | 0.158 |
| 3211 | SG, SF, TG | 4.2 | 0.165 |
| 3215 | T, TF | 4 | 0.158 |
| 3311 | T, TF | 4.2 | 0.165 |
| 3315 | T, TF | 4.5 | 0.177 |

Rotor Gap = "C" - "B"

Impeller Gap = "A" - "B"

Step 6: Insert Impeller & Bend Lock Washer



Tightening Torque

| Bolt Size | Tightening Torque | |
|-----------|-------------------|---------|
| | N*m | ft.-lb. |
| M8 | 11 | 8 |
| M10 | 17 | 13 |
| M12 | 30 | 22 |
| M14 | 47 | 34 |



Step 7: Install Casing

