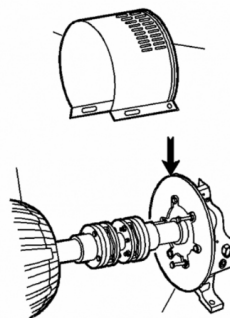
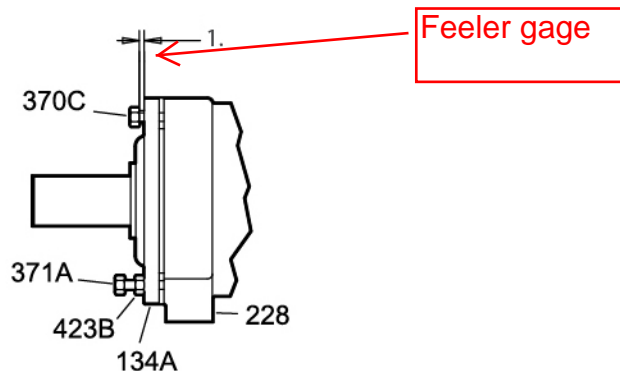
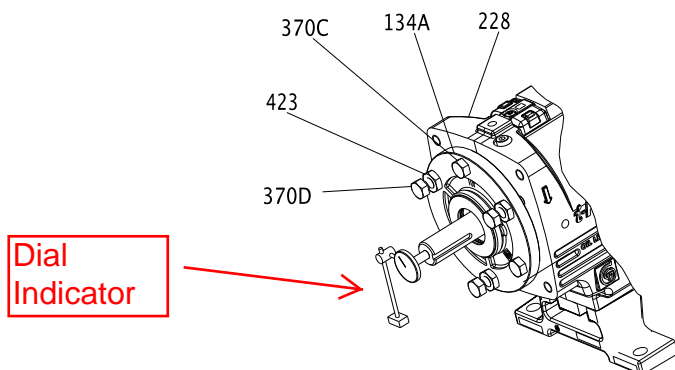


1. Remove the coupling guard.



2. Set the indicator so that the button contacts either the shaft end or the face of the coupling.



3. Loosen the jam nuts (423) on the jack bolts (370D), and then back the bolts out about two turns.
4. Tighten the locking bolts evenly (370C), bringing the bearing housing (134A) towards the frame (228) until the impeller contacts the casing.
5. Turn the shaft to ensure that there is contact between the impeller and the casing.

If using Dial Indicator

6. Set the indicator to zero and loosen the locking bolt (370C) about one turn.
7. Thread in the jack bolts (370D) until the jack bolts evenly contact the bearing frame.
8. Tighten the jack bolts evenly about one flat at a time, moving the bearing housing (134A) away from the bearing frame until the indicator shows the correct clearance. Refer to the impeller clearance table to determine the correct clearance.

If using Feeler Gages

6. Use a feeler gauge to set the gap between the three locking bolts (370C) and the bearing housing (134A) to the correct impeller clearance. Refer to the impeller clearance table to determine the correct clearance.
- 7&8. Use the three jack bolts (370D) to evenly loosen the bearing housing (134A) until it contacts the locking bolts (370C).

9. Tighten the bolts evenly in this order:
 - a) Tighten the locking bolts (370C).
 - b) Tighten the jack bolts (370D).
 Make sure to keep the indicator reading at the proper setting.
10. Make sure the shaft turns freely.

Table 8: Impeller clearances

This pump requires the impeller clearances in the following table.

Service temperature in. (mm)	STi in. (mm)	MTi/LTi in. (mm)	XLT-i/i17
-20 to 200°F (-29 to 93°C)	0.005 (0.13)	0.008 (0.20)	0.015 (0.38)
Up to 250°F (121°C)	0.006 (0.15)	0.009 (0.22)	0.016 (0.41)
Up to 300°F (149°C)	0.007 (0.18)	0.010 (0.25)	0.017 (0.43)
Up to 350°F (177°C)	0.009 (0.22)	0.012 (0.30)	0.019 (0.48)