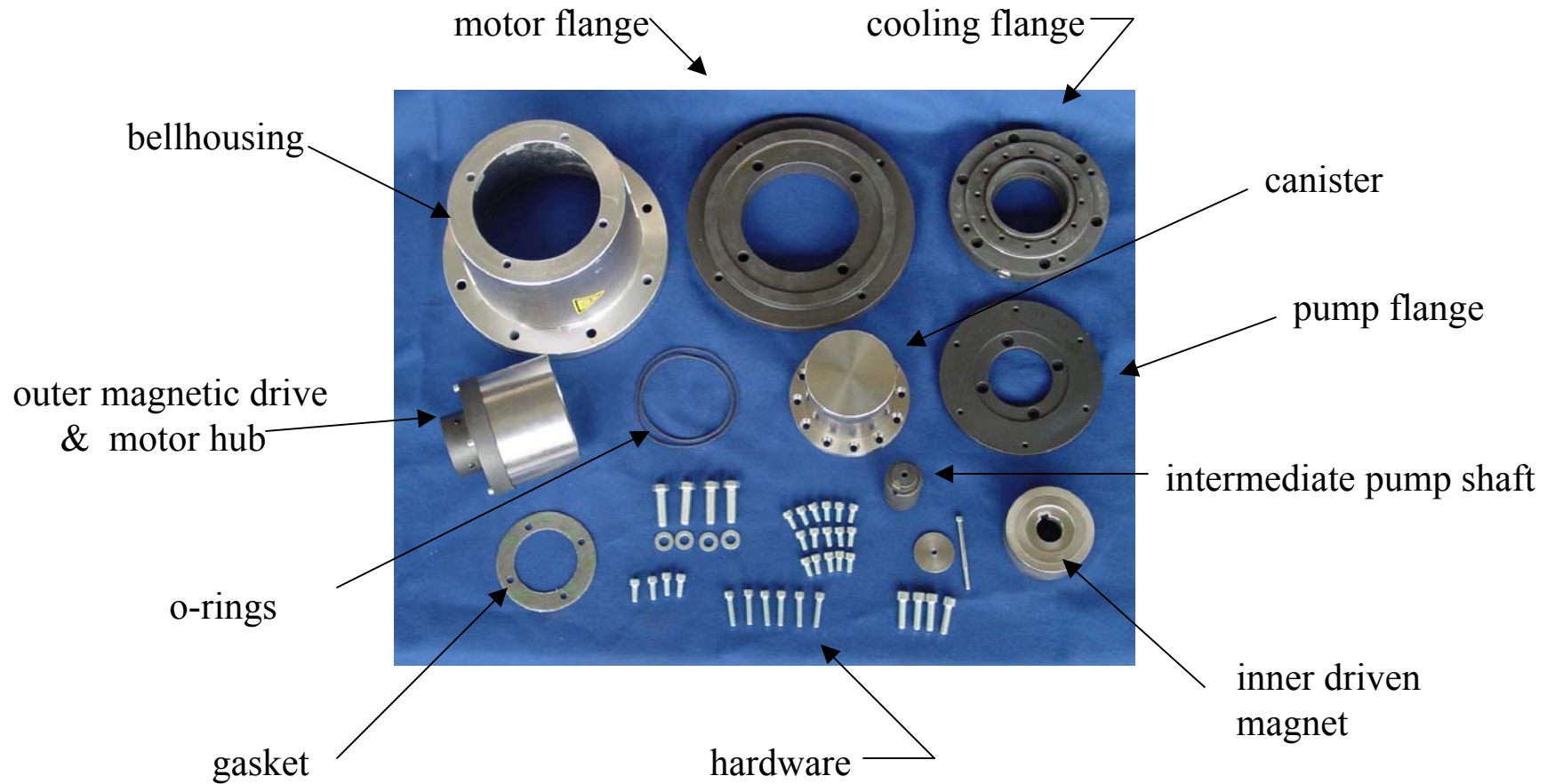


Magnetic Coupling  
(gasket design)  
General Assembly Instructions  
Rexroth Chemical series  
Variable Displacement Pump

# Coupling Components



1. Clean out pump flange to make sure all metal shavings are removed.
2. Make sure all other parts are free from debris.

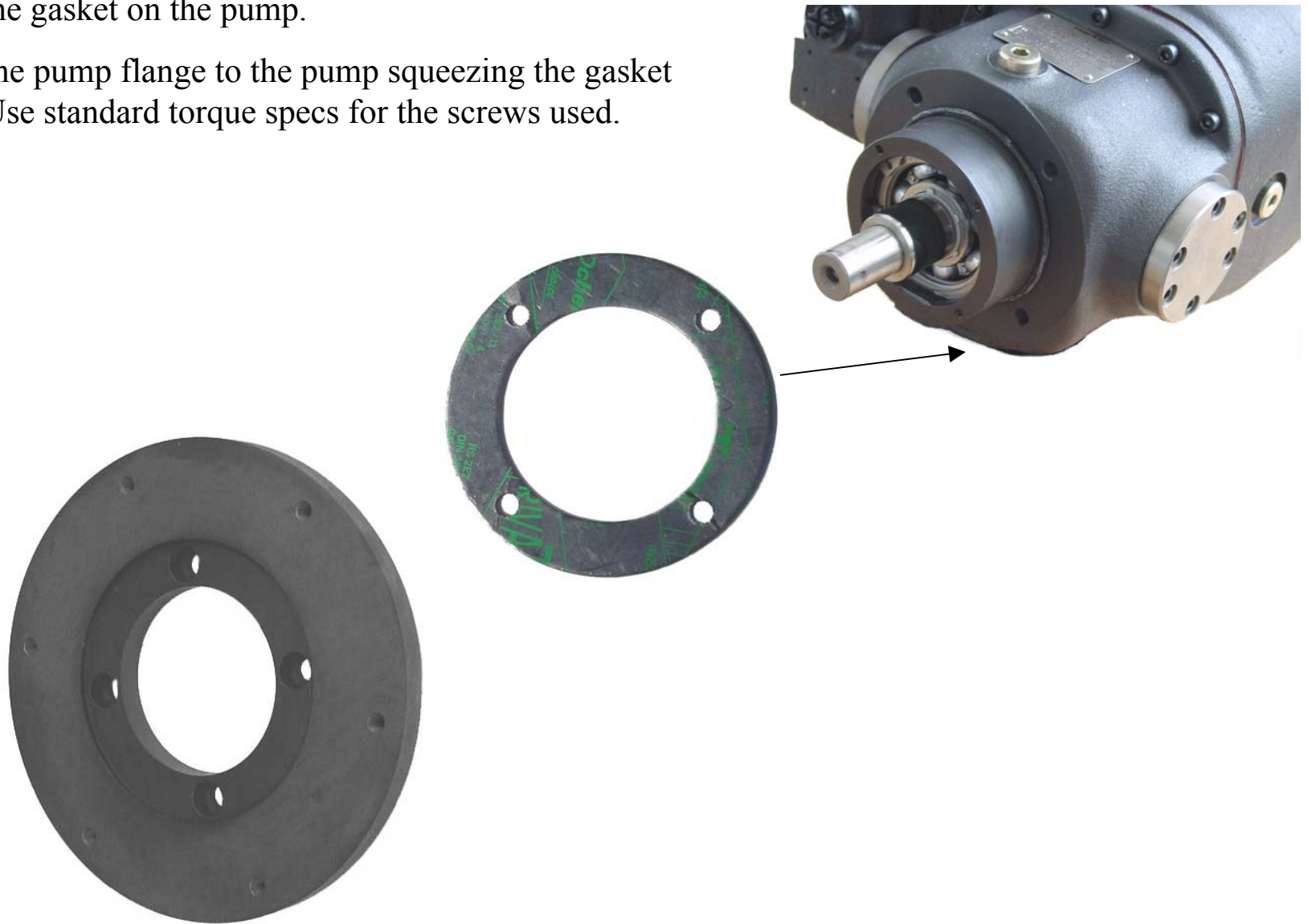


1. Remove the seal cartridge from the pump.



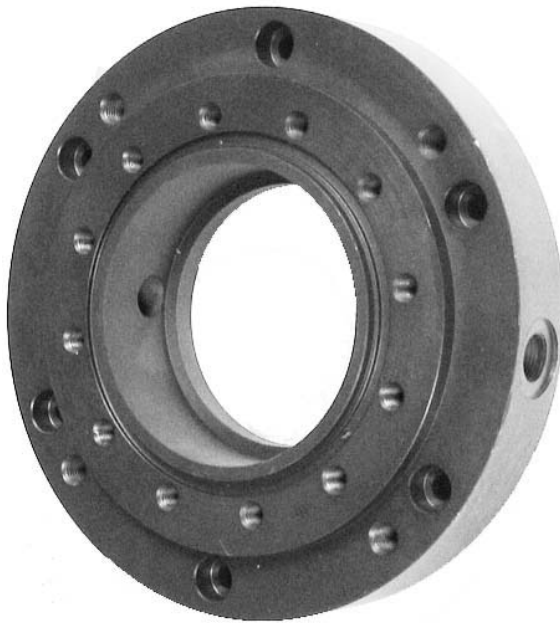
Note: The sleeve bushing can be removed if proper tools are available.

1. Position the gasket on the pump.
2. Tighten the pump flange to the pump squeezing the gasket tight. Use standard torque specs for the screws used.



1. Insert o-ring on the inside groove between the pump and cooling flange
2. Slide the cooling flange over the pump flange and secure using 6 socket head cap screws.

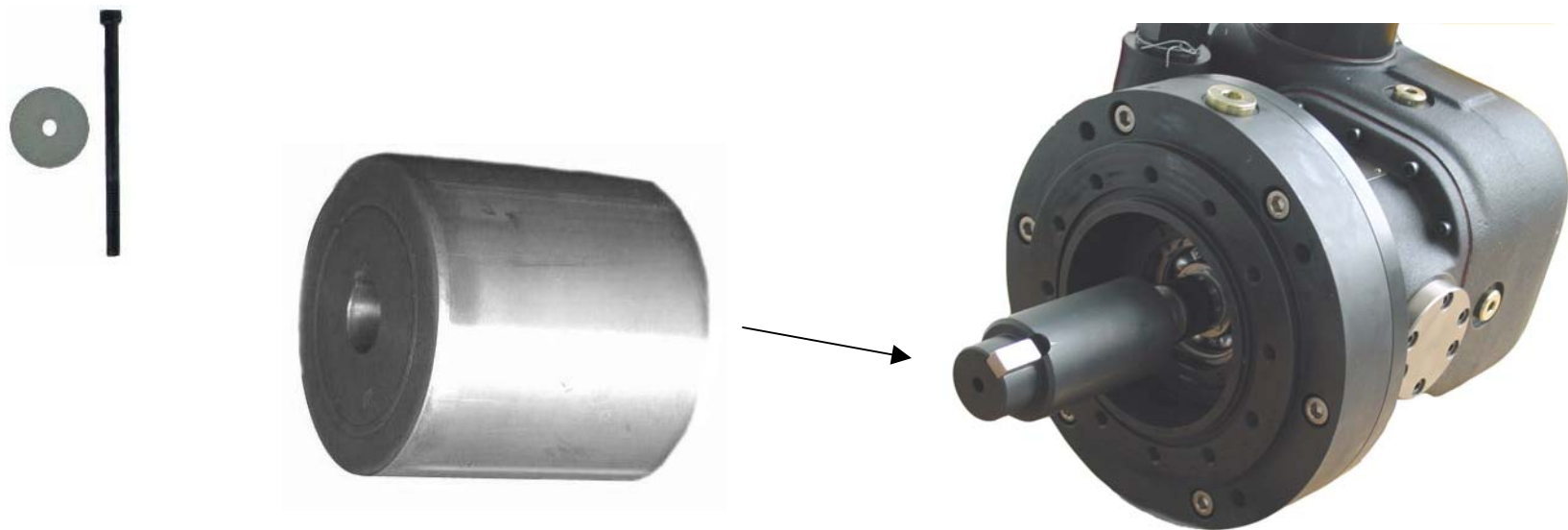
\* this is the 2<sup>nd</sup> static seal





1. Place the intermediate shaft onto the pump shaft, making sure the key is in place.



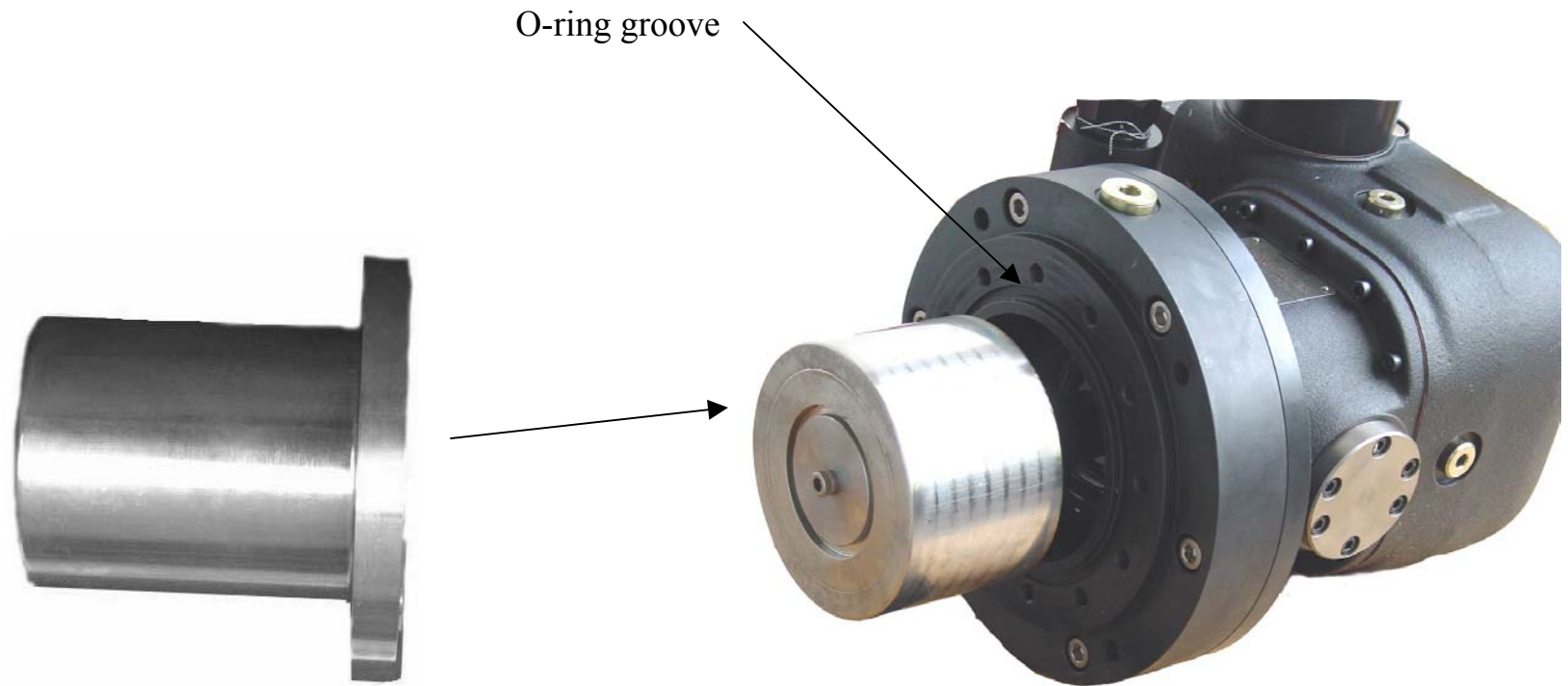


1. Slide the inner magnet over the intermediate shaft, making sure key is in place.
2. Apply some removable loctite 242 or equivalent to the screw.
3. Tighten down the magnet to the shaft using the screw and washer.





1. Place o-ring in the groove (shown below)
  2. Slide the canister over the inner magnet, making sure that the o-ring is properly seated.
  3. Tighten down with socket head screws.
- \* this is the 3<sup>rd</sup> and final static seal



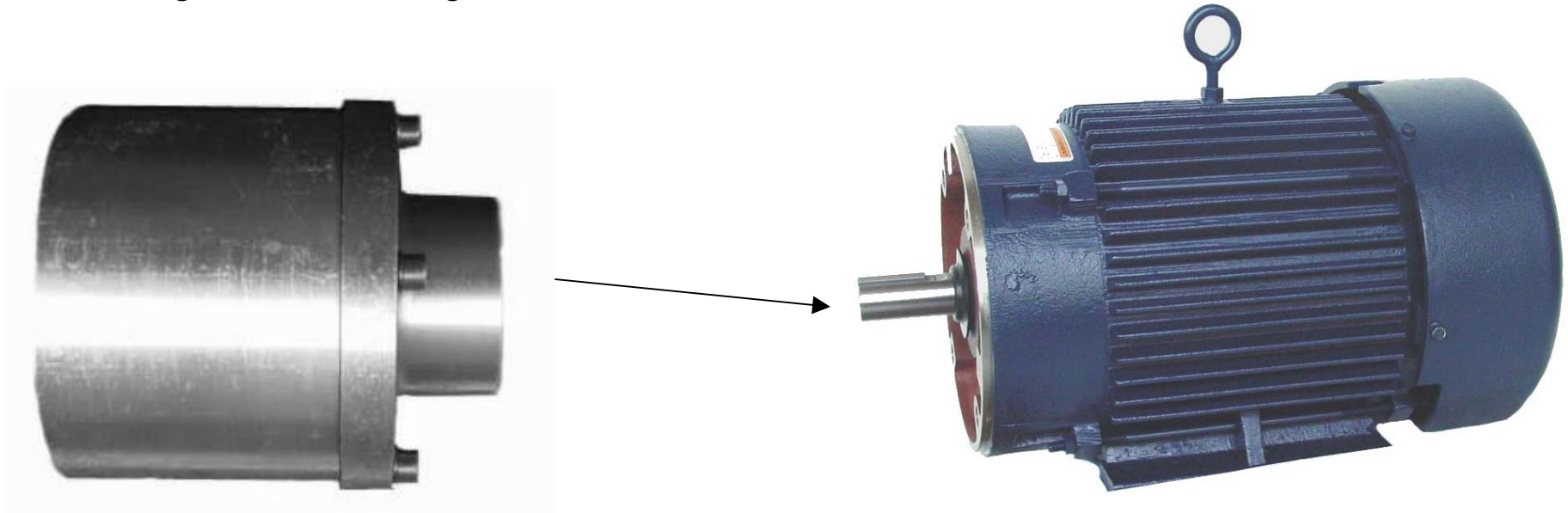
1. Plug all of the ports on the pump.
2. Pressurize the cooling ports with 30 – 50 psi of air pressure. Make sure that the pressure holds for at least 30 minutes. This is done to assure that there is no leakage in the seals.



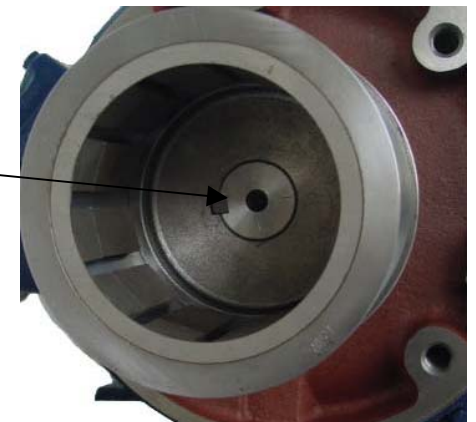
1. Place the bellhousing onto the flange.
2. Tighten into place using the appropriate bolts.



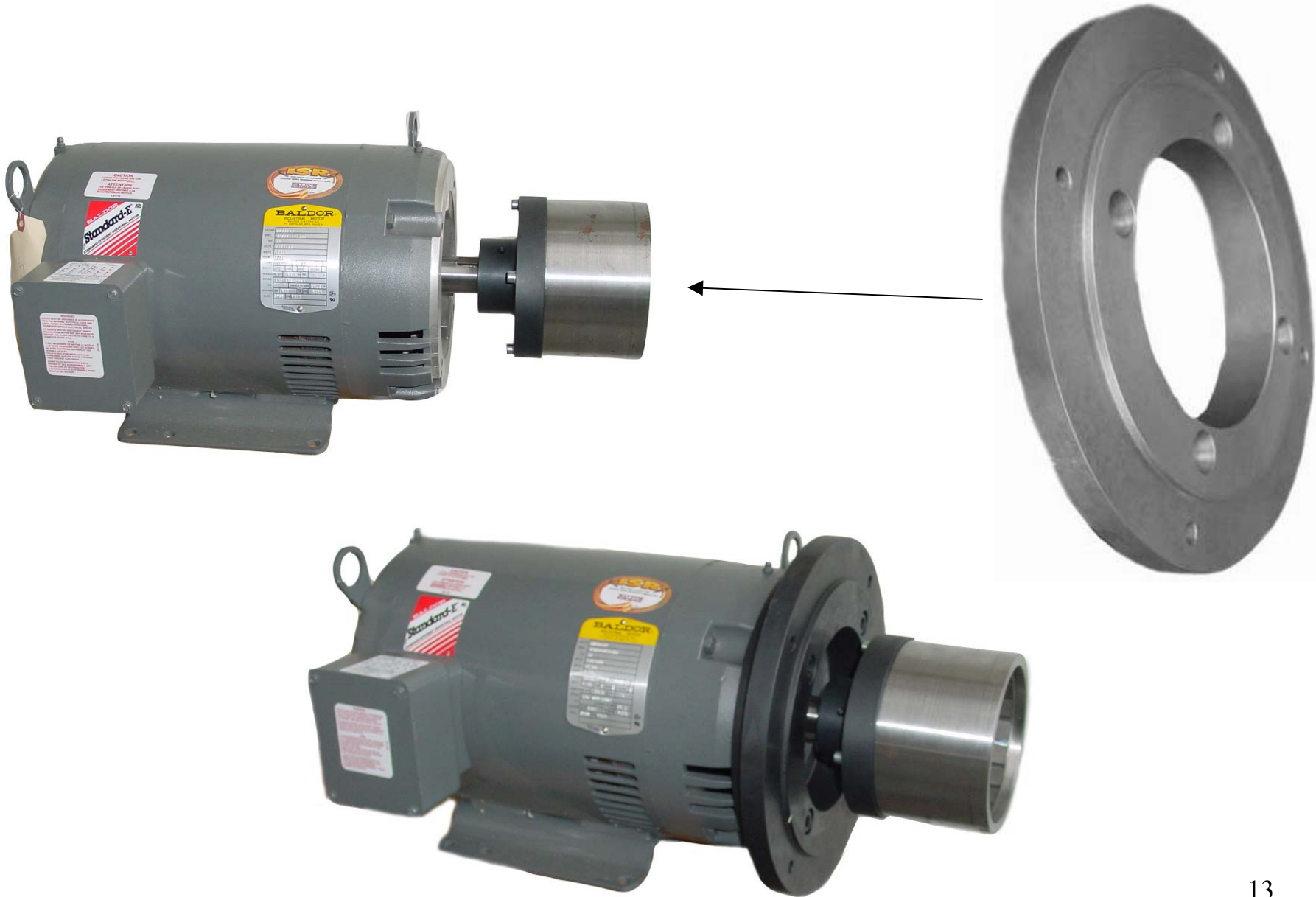
1. Slide the outer magnet onto the motor shaft, making sure the key is in place. The end of the pump shaft should then be flush with the magnet hub.
2. Tighten the hub using the set screws in the hub.



Outer shaft flush with motor hub.

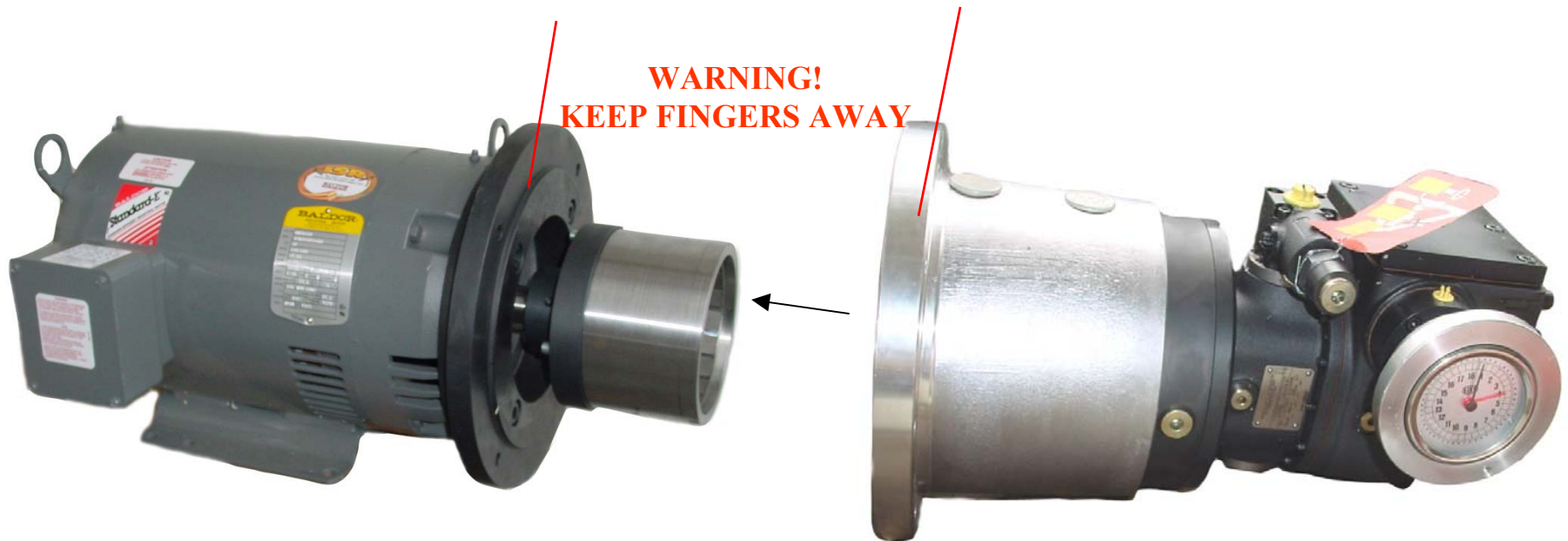


1. Place motor flange on the motor. Only socket head screws can be used to tighten in place.





1. Align the 2 assemblies and carefully bring them together. Make sure fingers are not between the bellhousing and motor flange.
2. The magnetic force will naturally pull the 2 together. Once they are close it will be necessary to resist the magnetic force a little in order to keep the bellhousing from slamming into the motor flange.
3. Align the holes and tighten bellhousing to mag flange.



1. Remove the plug closest to the motor.
2. Back off the set screws in the motor hub. This allows the hub to slide into its natural position.  
Note: The hub may not move at all.
3. Tighten the set screws.



Assembly complete!

