

X45 COOLANT PUMP REBUILD KIT Part # 865893K

Disassembly Instructions

⚠ WARNING

Ensure coolant system is cool and not pressurized before starting work.

⚠ WARNING

To avoid the risk of shock, disconnect power to the heater unit during disassembly/reassembly.

NOTICE

Isolating the heat exchanger coolant volume minimizes coolant loss. Collect coolant as per local regulations.

⚠ CAUTION

Replace any worn or damaged coolant hoses.

NOTICE

DO NOT discard any component unless directed to do so.

1. Before proceeding, ensure coolant system is cool and not pressurized.
2. Disconnect power from the heater unit.
3. Isolate the heater coolant by clamping off heater inlet and outlet hoses or by turning off the coolant valves to the heater (if present).
4. Remove the outlet hose clamp (item 8) from the coolant hose.
5. Remove the inlet hose clamp and coolant hose.
6. Remove and discard the four #8-32 screws (item 7). Note the screw length (3/4" or 1").
7. Remove the pump body (item 6), two thrust washers (item 2), O-ring (item 5), shaft (item 4), impeller magnet (item 3) and separator cup (item 1).
8. Discard components as per the disassembly checklist.

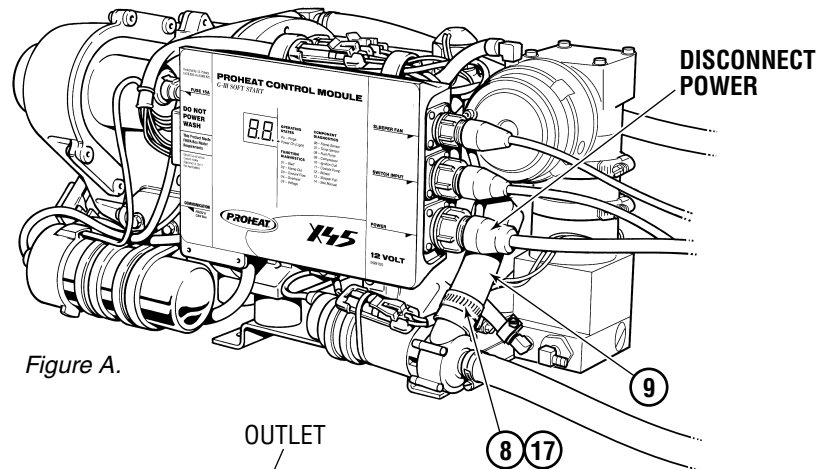


Figure A.

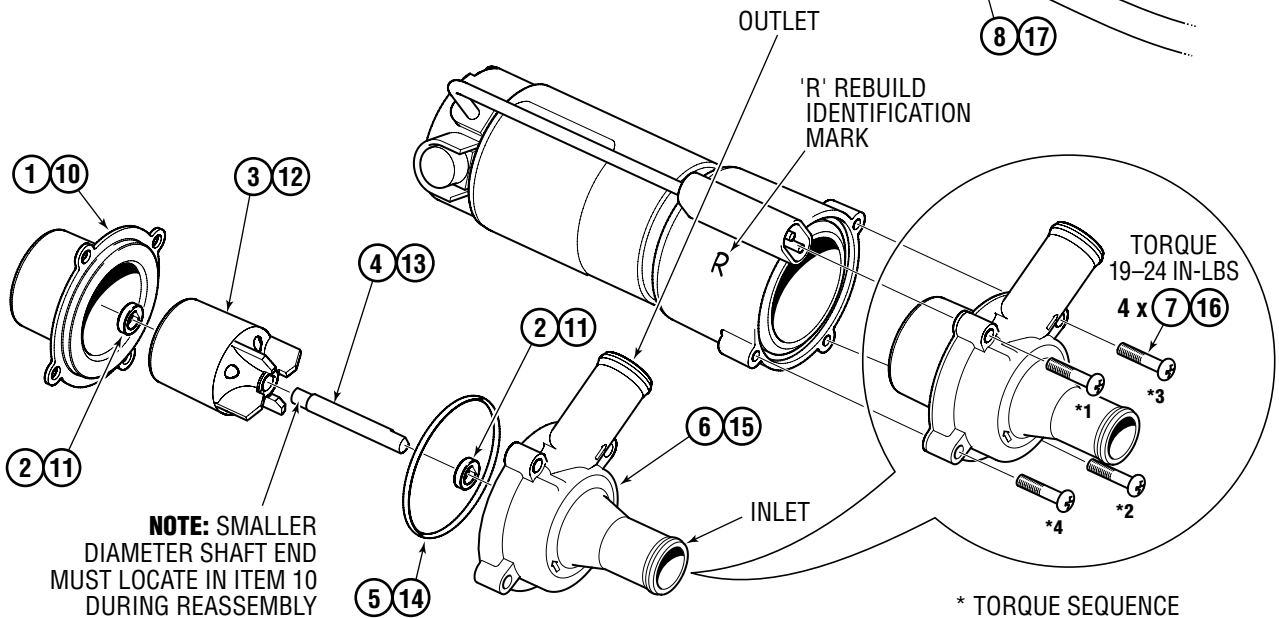


Figure B.



INSTALLATION INSTRUCTIONS

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Disassembly Parts Checklist

ITEM	RE-USE	DISCARD	DESCRIPTION	QTY	UOM
1		X	Separator Cup	1	ea
2		X	Thrust Washer	2	ea
3		X	Impeller Magnet	1	ea
4		X	Impeller Shaft	1	ea
5		X	O-Ring	1	ea
6		X	Pump Body	1	ea
7		X	#8-32 x 3/4" and 1" Thread Rolling Screws (length depends on pump version)	4 and 4	ea
8		X	Hose Clamp, #10	1	ea
9	X		Coolant Hose, 3/4" ID	3	inch

Reassembly Instructions

⚠ CAUTION

Note shaft (item 13) installation orientation as shown in Figure B.

⚠ CAUTION

DO NOT run pump dry. Pump does not self-prime.

1. Remove wire ties (not shown) from pre-assembled pump body assembly.
2. Slide new hose clamp (item 17) onto coolant hose (item 9).
3. Install new pump body assembly into the motor housing and push pump body outlet (item 15) into the coolant hose (item 9). Match the screw length (either 3/4" or 1") to the removed screws. Torque screws as shown in Figure B.
4. Using a paint pen of any colour, write an 'R' on the pump as shown in Figure B. This indicates that the pump was rebuilt.
5. Tighten hose clamp as per included Oetiker® Stepless Screw Clamps Part# 982921 instructions on the pump outlet hose (item 9).
6. Re-install inlet coolant hose and hose clamp. Inspect hose for cracks or damage.
7. Remove coolant hose pliers or open valves to allow coolant to flow through the heater. Do not power heater but run engine and heating system to get coolant flowing if required. Ensure heater and pump are filled with coolant.
8. Check system coolant level. Refill as required.
9. Restore power to the fully re-assembled heater unit and operate for a minimum of two cycles to ensure functionality. Inspect for any coolant leaks.

Reassembly Parts Checklist

ITEM	DESCRIPTION	QTY	UOM
10	Separator Cup	1	ea
11	Thrust Washer	2	ea
12	Impeller Magnet	1	ea
13	Impeller Shaft	1	ea
14	O-Ring	1	ea
15	Pump Body	1	ea
16	#8-32 x 3/4" and 1" Thread Rolling Screws (length depends on pump version)	4 and 4	ea
17	Hose Clamp #10	1	ea