



EXTERNAL PUMP ASSEMBLY

012-2111-50

INSTALLATION INSTRUCTIONS

PART#	DESCRIPTION	QTY REQ
000-1853-00	5 Gal. White Container Plastic	1
000-1853-05	Plastic Lid with Spigot	1
000-1919-02	Heavy Duty Pump 115V	1
003-0002-49	¼" Dia. Polyflo Tube	4 ft.
012-2111-00	Lid Support	1
794-8013-85	Plastic Tube .750 X .500	3
794-8071-36	Tube Fitting .375 X .500	1
794-8688-00	Cable Tie 3/16 X 7.5	3
800-8014-71	Strain Relief	1
000-1261-50	115V 3-Wire Plug (MALE)	1
000-1261-51	115V 3-Wire Plug (FEMALE)	1
000-1502-74	½ X 3 ½ Pipe Nipple	2
000-1502-77	½ Malleable Coupling	2
000-1502-78	½ - 3/8 (F-F) 90Deg Elbow	1
003-0003-38	Cable Tie - 3.65	1
003-0003-46	1" Square Cable Tie Mount	1



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Preparation

Unplug electrical from the wall, disconnect the air line, and fully drain all coolant oil from your machine. Clean all residue from the reservoir wells and drain pump lines. It's best to start with a clean machine.

Remove the existing pump from the machine reservoir and cut the power cord close to where it enters the pump housing.

CAUTION: BE SURE YOUR MACHINE IS UNPLUGGED FROM ANY POWER SOURCE BEFORE CUTTING THE CORD AND USE RUBBER OR VINYL COATED CUTTERS TO INSURE PROTECTION AGAINST POSSIBLE ELECTRICAL DISCHARGE.

After cutting, remove approximately 1.5" of the outer cord covering exposing the 3 wires.

Strip approximately ½" of insulation from each of the 3 wires. Twist the stranded wire of each so they don't fray when connecting them.



FIGURE 1



Remove the screw holding the female plug end together. Open the plug end to expose the connectors. [Figure 2]



FIGURE 2

Connect the three wires as pictured in Figure 3.

- Brown wire to the gold colored screw (A)
- Blue wire to the silver colored screw (B)
- Green wire to the green colored screw. (C)

Once the wires are secured to the screws, close the outer plug casing and replace the screw to secure the casing in place.

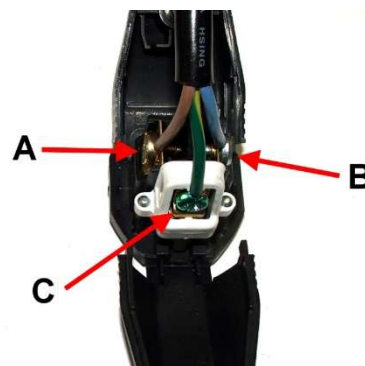


FIGURE 3

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Using a glass cleaner and a clean cloth, thoroughly clean the location on the back side of your SVS where the plastic tie mount will be placed as shown in Figure 4.

After the cleaned area has completely dried, peel the protective covering off the back of the plastic tie mount and adhere it to the back of your SVS Base as pictured in Figure 4.



FIGURE 4

Place the cord and bring the provided plastic tie together as shown in Figure 5. The purpose of this is to insure the plug cannot fall into the oil reservoir. The plastic tie does not have to be tight to the cord.



FIGURE 5

If you haven't already done so, remove the drain plug from the side under the electrical box as shown in Figure 6 using a 9/16" wrench.



FIGURE 6

Locate the provided drain pipe and apply a pipe thread sealant to prevent possible leaks. Then install the provided drain pipe in the location where you just removed the drain plug.

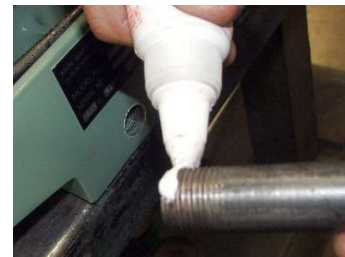


FIGURE 7

Placing the drain pipe elbow in a downward pointing position is the best position. But if your machine is on a bench that does not allow for this and it must be laid sideways, insure that it is angled slightly downward. This will help keep the fluid flowing down to the external container.



FIGURE 8 - SIDWAYS POSITION OR DOWNWARD POSITION

Push the larger clear plastic tubing onto the provided connector as shown in Figure 9 to complete the drain assembly.



FIGURE 9

Remove the old pump feed tube from the black plastic "T" connector. Be careful not to damage the black plastic "T".



FIGURE 10

Connect the pump feed tube from your new External Pump Assembly to the Black Plastic "T". And finally, plug your external pump into the newly added female plug to complete your External Pump Assembly installation.



FIGURE 11

Remove the lid from your new External Pump Assembly and fill the container with clean grinding oil to approximately 3 inches from the top. Replace the lid and secure it. Now fill the reservoir of your machine until it's just starting to flow into the drain area section. Reattach your airline and plug the machine into the wall receptacle. You are ready to begin using your valve refacer again. It will operate the same as it did before and the oil will not need to be replaced as frequently.

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