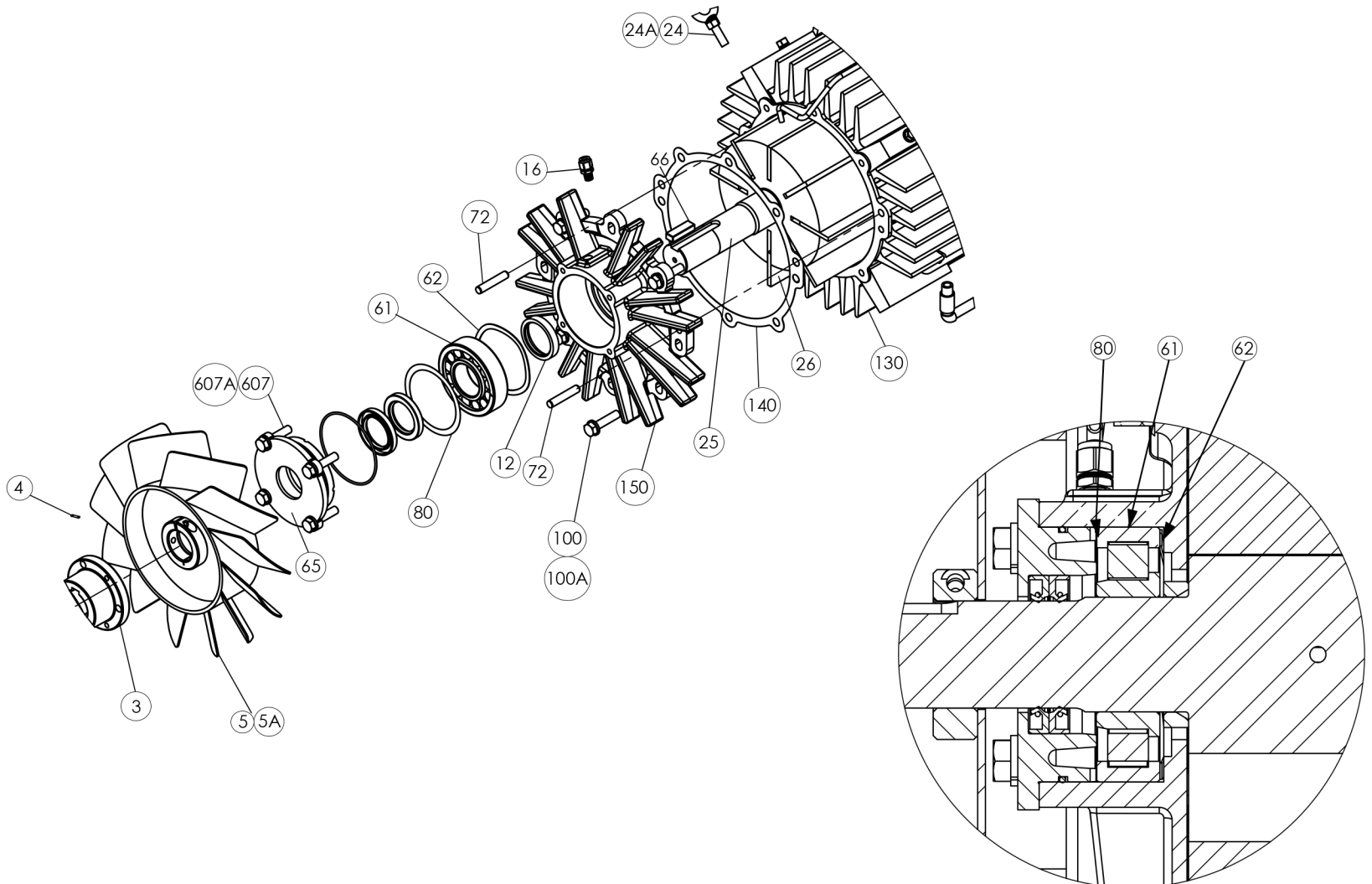


## FRUITLAND 870 PUMP REBUILD PROCEDURE



1. Save item 80, bearing shims. Keep right and left sides separate and do not mix and swap right and left sides.
2. Replace the shims with same thickness shims if they are damaged or need replacing.
3. Use item 72; 3/8" dowel pins supplied with rebuild kits to align the endplates.
4. Remove dowel pins, itm. 72 after assembly. Do not leave the dowel pins in the pump.
5. New housing Bore diameter is 8.450". Bore can be oversized upto 0.10" (Ø8.550"). It is recomended to adjust the radial gap between the rotor and housing bore at the tightest spot to 0.007"-0.009" if the housing is bored to maximum allowance, call Fruitland for instructions about gap adjustment.