



5R110W Vent

Corrects/Prevents/Reduces
Accidental Venting of Fluid

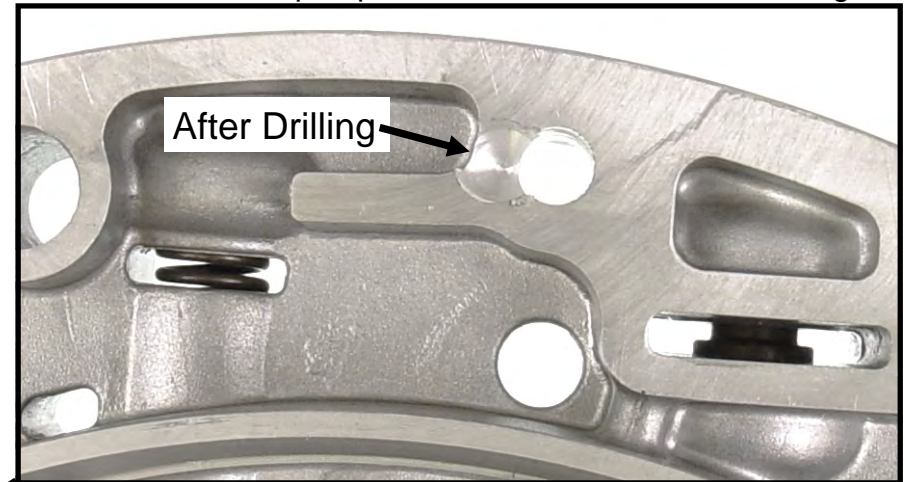
Making New Vent Circuit

Step 1:

Using suitable bolts **and** washers, bolt the **Guide Plate** to the rear side of the stator. Line up the center hole of the guide plate with the left side of the vent hole as shown below. Using the plate as a guide use a 1/4" drill (.250) and remove approx. 1/2 of the left side of the vent wall. When done, it will look like the picture on the right. It's not fussy. Remove burrs with a small file.

Great News!

After you remove 1/2 of the left vent wall as shown below and plug the connection to the pump internal circuit (next page), the vent in the case will now be separated from the cross leaks in the pump that cause the accidental venting!

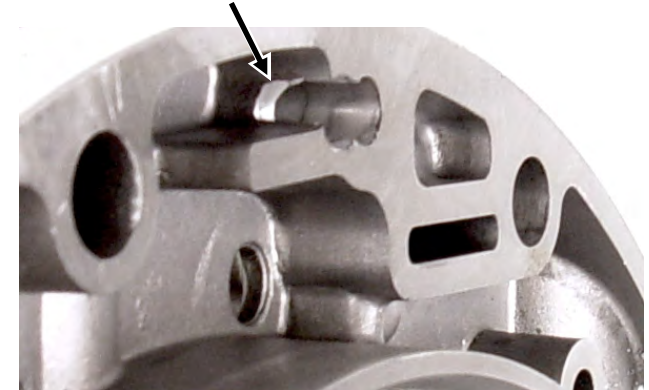


Rear of Stator

Protect the Stator, use flat washers on opposite side!



Half of left side of vent wall removed.

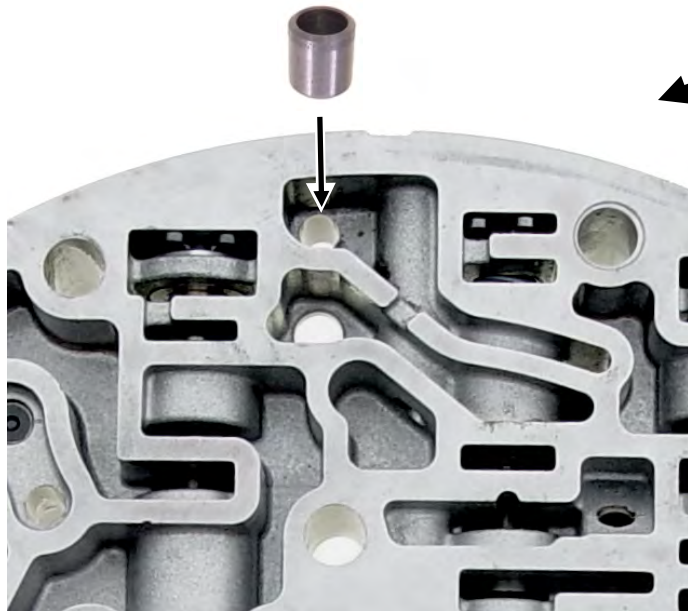


Plugging Original Vent Circuit

Step 2:

Disassemble pump and install tapered plug provided into the Stators original vent hole shown below. See location area on right.

Tip: Use a flat punch ON TOP of the plug.



This product is designed to relocate the vent away from the normal cross leaks within the pump while still allowing for a functional vent.

Time and heat are the usual culprits for warped pumps. Over tightening can cause a variety of issues. Torque pump bolts to no more than 23 ft/lbs.

Thanks for listening!



Mr. Shift



You're Done!