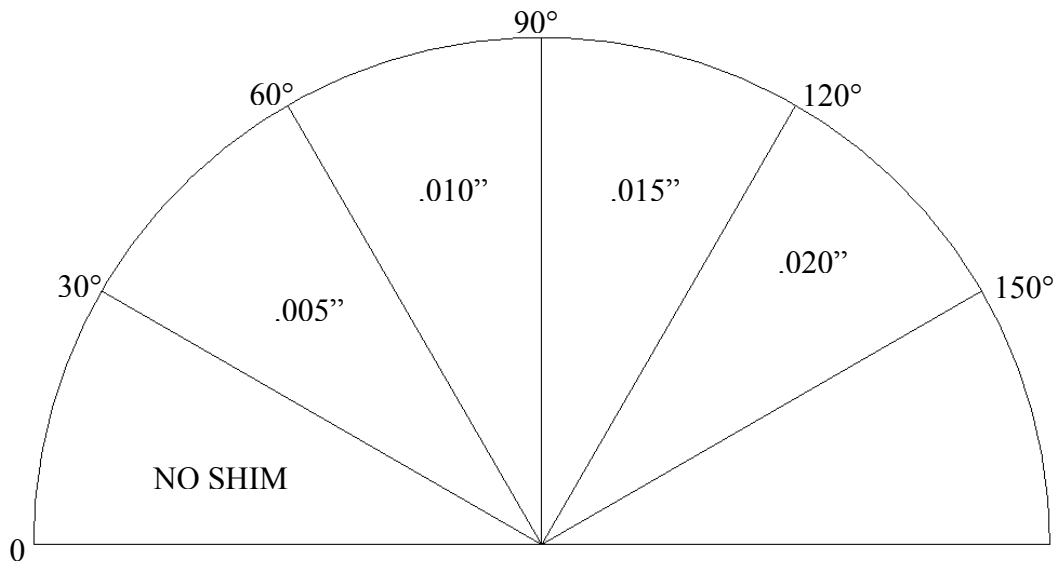


Instructions for changing a grinder pump cutter / cutter ring.

1. Thread impeller onto motor shaft and hand tighten holding the shaft with screwdriver.
2. Thread cutter onto shaft and seat on impeller – **do not tighten**.
3. Check for alignment of the cutter to the impeller (per Picture). Remove cutter and shim as necessary to align cutter blades with impeller vanes (per Table and/or Template). Use screwdriver to hold shaft and tighten cutter by tapping with plastic hammer.
4. Place casing on bearing housing and locate discharge opposite cord set entry, secure w/ cap screws.
5. Check cutter to cutter ring clearance using .002" shim stock. Adjust casing position with plastic hammer to ensure cutter rotates freely. as
6. Run dry for 10 seconds and recheck cutter to cutter ring clearance as performed above.



SHIM	ANGLE OFFSET (DEG.)	SHIM THICKNESS (IN.)
	0 - 30°	NO SHIM
BLUE	30 - 60°	.005"
BROWN	60 - 90°	.010"
PINK	90 - 120°	.015"
YELLOW	120 - 150°	.020"