

## **Procedure to change rotation of a P16 Pump**

1. Clamp the pump in a vise or suitable device.
2. Loosen and remove the 4 bolts from the rear of the pump.
3. Set the pump on end.
4. Place some "scotch" type tape over the keyway or spline to prevent cutting the seals.
5. Remove the front flange.
6. Remove the top pressure plate along with the seal and back-up.
7. Remove and swap position of the drive and idler gears.
8. Replace the top pressure plate, seal and back-up, making sure it is in the same position as when it was removed. The pressure plate trap should be on discharge side. (ref: drawing 60900)
9. Assemble the shaft seal(s) into the new front flange. A new front flange is required for the opposite rotation.
10. Assemble the front flange assembly to the body, being careful not to cut the shaft seals on the keyway or spline.
11. Insert and tighten the 4 bolts to 70-75 ft.lbs. of torque, using the "across the corner" tightening technique.
12. Using a 12 inch wrench, check to see if the shaft will turn. It can seem tight, but should turn freely with a maximum of 15 lbs. of force on the wrench.