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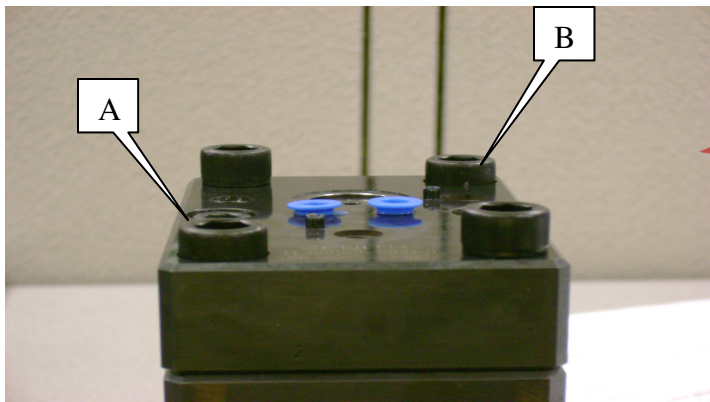
## SERVICE INSTRUCTION

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**Attention Installer/Customer:** The mounting bolts (9946-xx) in the RCS pump kit (77844-xx) used to retain the RCS pump (Resin or Catalyst) onto the manifold have changed. Shown below is the process for installing the new bolts and required spacers.

Figure 1-1 represents the “Incorrect” assembly process. Note that bolts “A” & “B” are sunk into the pump top plate, resting on the pump’s dowel pins. This is incorrectly assembled. See figure 1-2 for correct installation of bolts “A” & “B”.

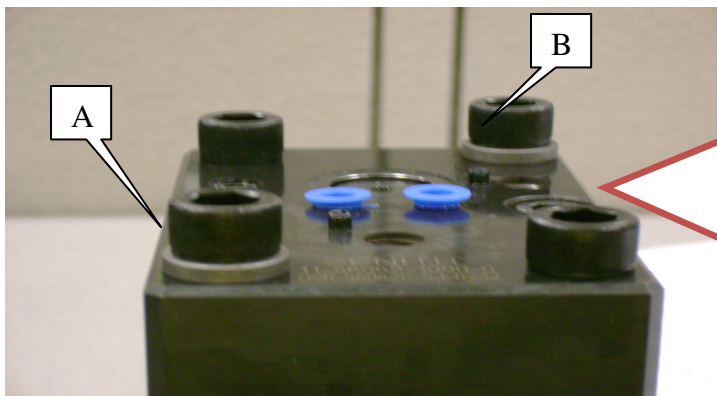
**Figure 1-1 “Incorrect Assembly Process”**



Counter-sunk appearing (“A” & “B”) bolts at diagonally opposite pump corners. There is no counter-sink in these locations, rather the bolts are resting on hollow locating pins (not visible here).

Stepped washers (A12304-00 Resin Pump; A12304-01 Catalyst pump) have been added to allow bolts at corners “A” & “B” to clamp down on pump corners instead of merely clamping down on the hollow locating pins at these locations.

**Figure 1-2 “Correct Assembly Process”**



Note: Use the longer bolts supplied in kit with the stepped washers. The smaller diameter of the stepped washer is inserted into the dowel hole.

**CAUTION: Maximum torque specification for all four bolts is 44 ft-lb. Do not exceed torque specification or the washers may crack.**

**Figure 1-3 Stepped Washer**



The addition of the stepped washer (**A12304-00 Resin Pump; A12304-01 Catalyst pump**) in figure 1-3 requires the corresponding bolts to be longer. Ultimately this results in two different length bolts on opposite corners for clamping / mounting of the pump. Make sure the longer bolts are used with the stepped washer only as shown in figure 1-2.

If you are unsure of proper installation, contact Ransburg Technical Service Department (1.800.233.3366) for assistance.

**Manufacturing**

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**Technical Support Representative will direct you to the appropriate telephone number for ordering Spare Parts.**