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## HARDIN MARINE BILLET BOWL STUFFER 620-SF2000 INSTALLATION INSTRUCTIONS

To prevent any interference with the impeller the shoulder on the shaft that stops the impeller needs to be cut back .040 to .090 inches. This moves the impeller forward into the suction piece, which closes up the end clearance creating a tighter seal. Try to keep the end clearance no closer than .035 if you are running an aluminum impeller. If the impeller is stainless steel this clearance can go closer. If the clearance is to close then shims are needed to move the impeller back until the proper clearance is attained.

The billet stuffer installs into the bowl around the seal area, it is attached with the four 5/16" socket head bolts that are included. Center the stuffer in the bowl and mark one of the holes using a transfer punch, drill and tap to 5/16". Install the stuffer using the one bolt making sure to center it in the bowl. Install the stuffer bolts using a thread lock sealer to lock the bolts into place. Install the bowl onto the pump and check to make sure that the impeller does not contact the stuffer when the shaft is rotated.

### **IMPORTANT**

This bowl stuffer cannot be used with a shouldered wear ring under any circumstances.

If you any questions, please contact our technical support staff at 707-585-9006.