

**Alternate Pump Location
Field Assembly Supplement**

A careful review of this special supplement for units with an alternate pump location in addition to the normal whirlpool guidelines is important in avoiding unnecessary problems.

NOTE: All drawings in this publication are typical, and may appear different than the actual items being installed.

Inspection Guidelines

A unit produced with an alternate pump position will require field assembly of various components, as shown in Figures 1 and 2. Locate and carefully check for the required items listed, in addition to the items listed on the regular whirlpool installation guidelines. Notify your supplier immediately if any questions or problems become evident during this process.

**DO NOT INSTALL WHIRLPOOL
SYSTEM WITHOUT FIRST ADDRESSING
QUESTIONS WHICH ARISE
DURING THE INSPECTION!**

Alternate Position - Pump Only

- ✓ Check separately packaged pump for damage.
- ✓ Check separately packaged pump stand for damage, fasteners and three (3) pump stand legs.

**Alternate Pump Location with Optional
In-Line Heater**

- ✓ Check separately packaged in-line heater for damage.

System Assembly Guidelines

For shipping purposes, the factory installed unions for the attachment of the field installed components have been covered to avoid the loss of the o-ring seals and to keep loose debris from lodging in the system piping. Unwrap the unions and make sure an o-ring is present and securely seated in recessed channel before continuing.

Figure 1 - System With Alternate Pump Only Location

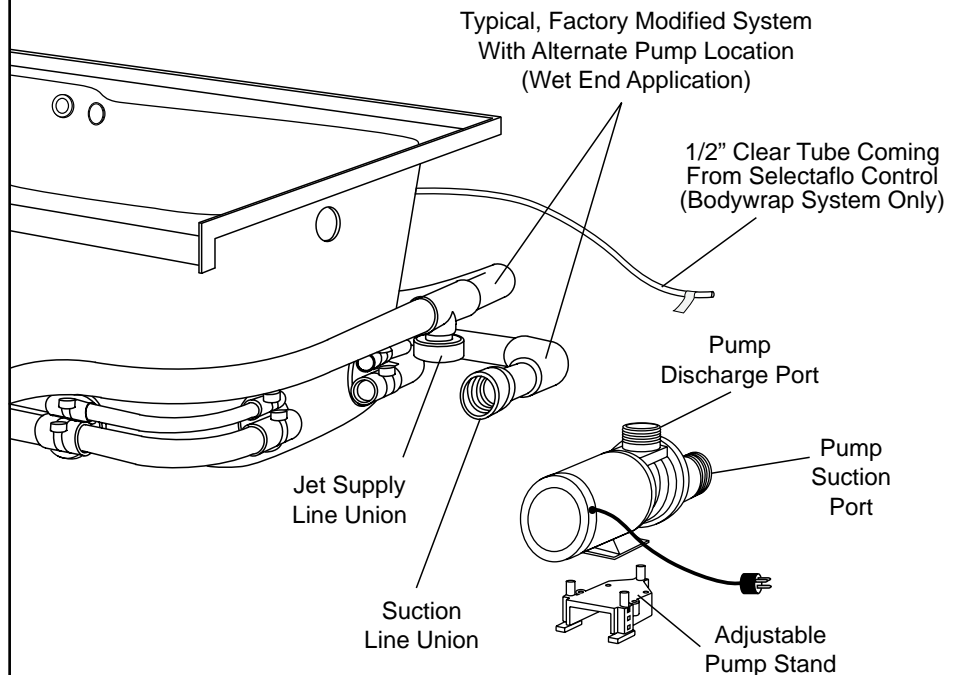
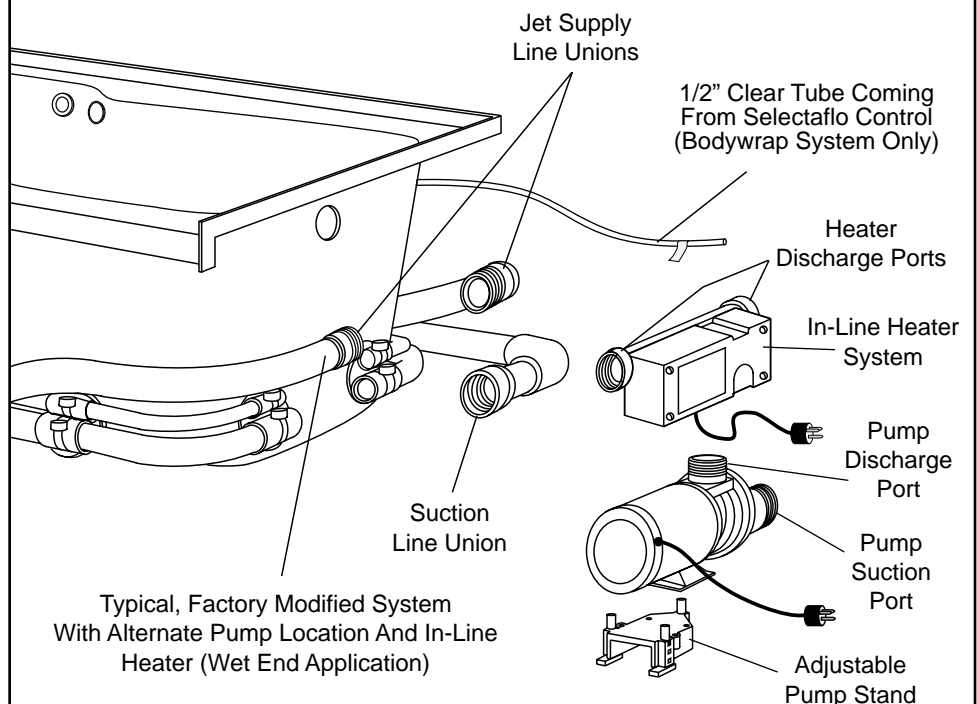


Figure 2 - System With Alternate Pump Location And Optional In-Line Heater



THE FOLLOWING PROCEDURE IS FOR SYSTEMS WITH FACTORY-FITTED, ALTERNATE PUMP LOCATIONS.

SECURE UNIT BASE TO FLOOR AS DIRECTED IN UNIT INSTALLATION BEFORE ASSEMBLING THE FOLLOWING SYSTEM COMPONENTS.

Step 1: Secure the pump to the pump stand as directed on stand (see Figure 3). Do not over-tighten fasteners (packaged with stand).

Step 2: Insert the legs into the pump base. Adjust the legs to place the pump end (suction) port at the same height as suction line. Rotate stand legs out, positioning tabs in slots, to lock legs in position (see Figure 4).

WARNING!
 THE SUCTION LINE IS POSITIONED AT THE FACTORY FOR COMPLETE PUMP DRAINAGE. MATCH PUMP HEIGHT TO THE SUCTION LINE HEIGHT.

If the system includes an optional in-line heater, proceed to Step 3. For systems without heater, proceed to Step 4.

Step 3: IN-LINE HEATER MOUNTING

Position in-line heater on the top pump (discharge) port, and attach union.

HAND TIGHTEN ONLY!

DO NOT use wrench on union. DO NOT apply sealants or other materials to threads (see Figure 5). Face heater controls away from tub. **Proceed to Step 4.**

Step 4: Align pump port end with the suction line and attach union.

HAND TIGHTEN ONLY!

DO NOT use wrench on union. DO NOT apply sealants or other materials to threads (see Figure 6).

WARNING!
 USE EXTREME CAUTION WHEN POSITIONING END PUMP PORT TO SUCTION LINE FITTING. EXCESSIVE PRESSURE ON SUCTION LINE MAY DAMAGE SUCTION FITTING SEAL AT TUB RESULTING IN LEAKAGE.

Figure 3 - Pump-To-Stand Assembly

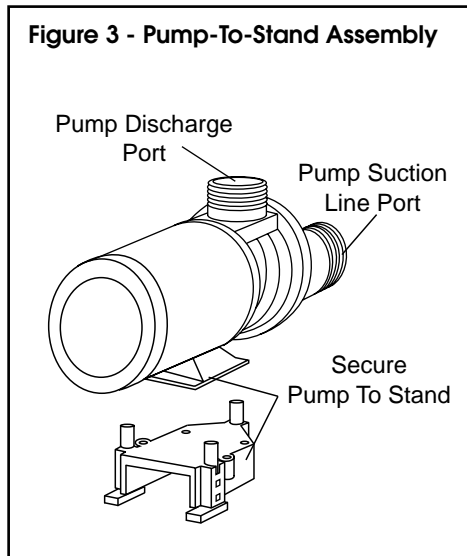


Figure 4 - Pump Height Adjustment

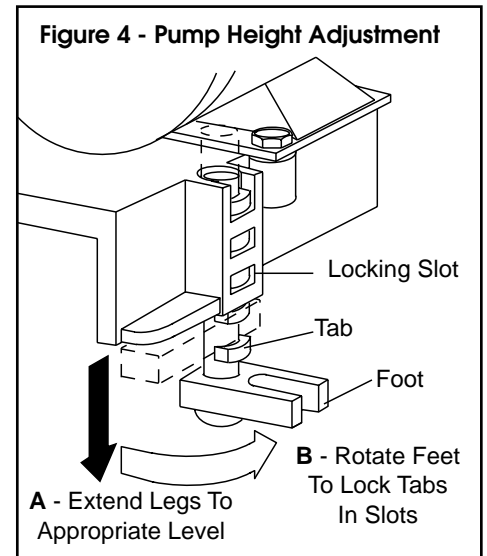


Figure 5 - In-Line Heater Mounting (Optional Equipment)

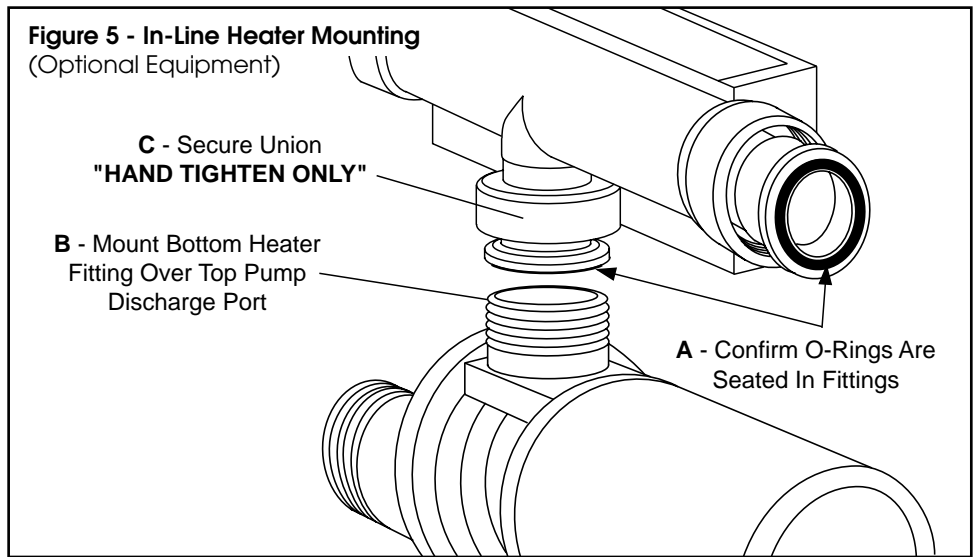
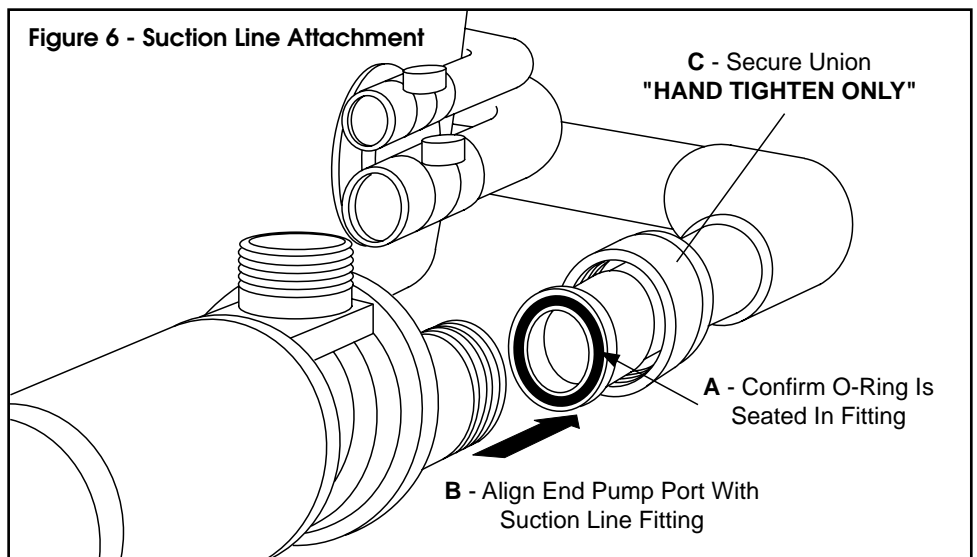


Figure 6 - Suction Line Attachment



If the system includes an optional in-line heater, proceed to Step 5. For systems without heater, proceed to Step 6.

Step 5: IN-LINE HEATER CONNECTION

Align the jet supply lines with the discharge ports at each end of the in-line heater, and attach unions (see Figure 7).

HAND TIGHTEN ONLY!

DO NOT use wrench on unions. DO NOT apply sealants or other materials to threads.

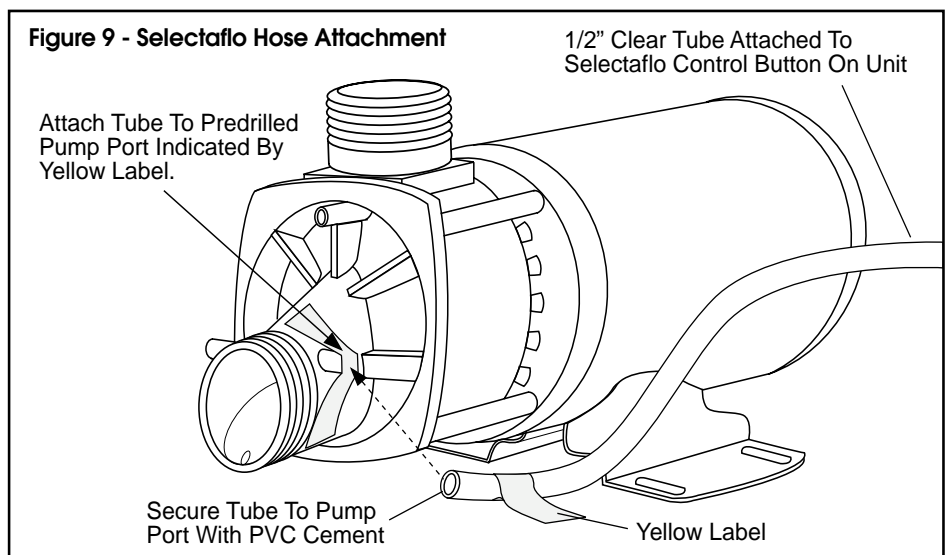
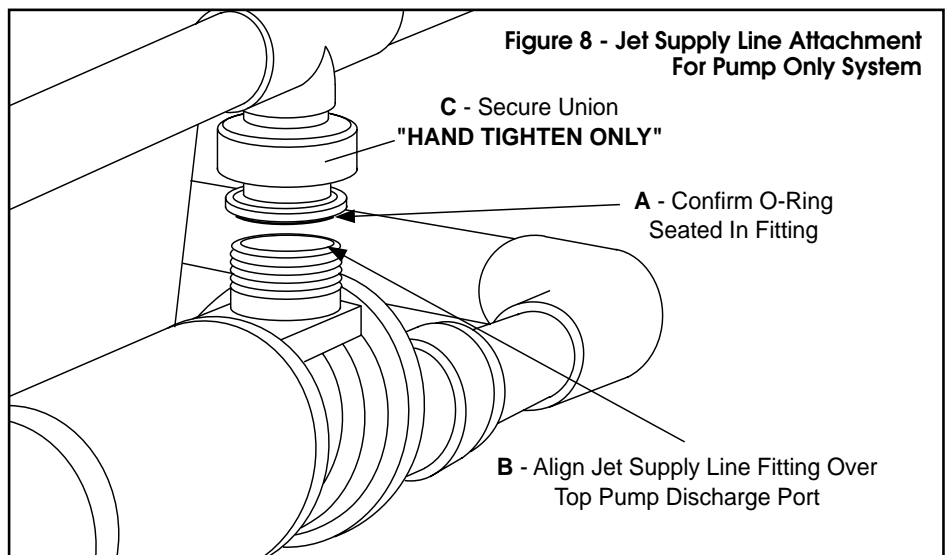
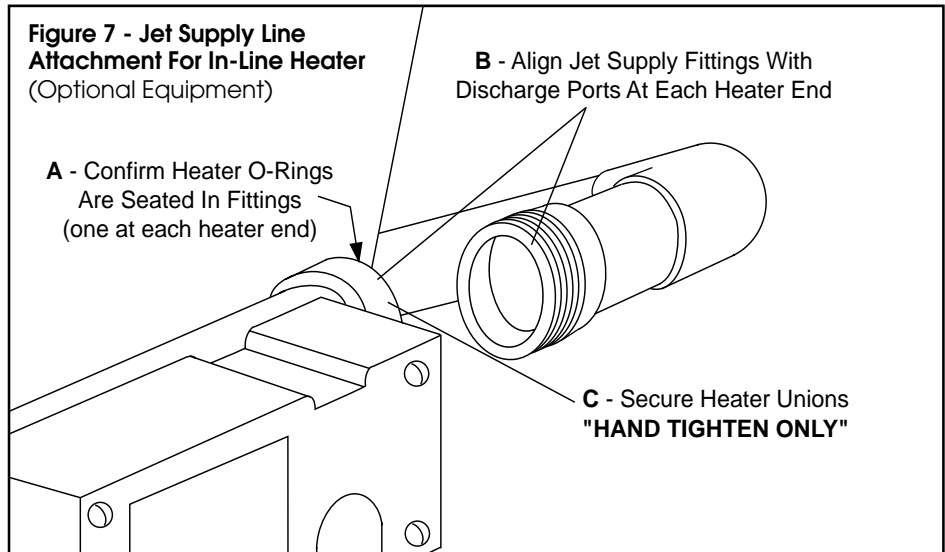
Step 6: Align jet supply line with the top pump (discharge) port, and attach union (see Figure 8).

HAND TIGHTEN ONLY!

DO NOT use wrench on union. DO NOT apply sealants or other materials to threads.

If the unit has a Bodywrap system a Selectaflo control is installed and must be connected.

Step 7: Secure the 1/2" clear tube (coming from the Selectaflo control knob on the unit) to the pump port covered with the yellow label, using a small amount of PVC cement. The covered port has been pre-drilled at the factory and must be used in order for the Selectaflo control to operate. (Figure 9)



WARNING!
CAUTION MUST BE USED TO ENSURE PVC CEMENT DOES NOT GET INTO THE PUMP PORT.

Do not fasten the pump stand to the floor or other structure. It is designed to be a free standing assembly.

Refer to the "Bodywrap" or "Single-Speed Whirlpool System Assembly and Operation Guide" for further installation guidelines.

