1. **Disassemble**
   Remove bearing and any loose material on surface of stator and impeller.
   
   **NOTE:** It is recommended to replace the OE bearing with Sonnax GM-N-11 upon reassembly.

2. **Impeller Modification**
   Turn bearing surface on impeller from a dia. of 2.25" outward. Take no more than .015" of material from impeller surface. Ensure surface is flat, free of burrs and has a smooth surface finish.

3. **Assembly**
   a. Center Sonnax bearing retainer using either a weld bead (Step 4, Page 2) or fixture, onto the new impeller surface.
   b. Weld Sonnax bearing retainer in place in at least 6 locations, equally spaced around the O.D.
   c. Turn I.D. of Sonnax bearing retainer to allow the bearing to drop into place (nominal O.D. of bearing is 3.38").

   **REQUIRED:** Ensure the top bearing face sits at least .020" above FD-WS-42, when installed in the impeller. No material is allowed above the top surface of FD-WS-42.

   **CRITICAL:** Outer weld bead should not interfere with stator or rotation of the stator.

   **OPTIONAL:** Turn the bearing surface of the stator to remove any rough surfaces. Do not remove more than .010" of material.
4. Weld Bead Instructions
   a. Place weld bead centered on impeller roughly the size of Sonnax bearing retainer (Figure 1).
   b. Machine pocket in the weld bead for O.D. of Sonnax bearing retainer (3.61” nominal O.D.) to drop into (Figure 2).
   c. Weld in place (Figure 3).