



# HELM PUMP # HH4514

## Mounting the Helm

Determine desired mounting position of the BayStar Plus Helm pump. Ensure that the steering wheel will not interfere with any other functional equipment. Check for adequate space behind the dash. The BayStar Plus Helm Pump can be installed with the shaft in the horizontal, vertical or any angle in between. The filler plug must always be in the uppermost position.

## Drilling the Hole

Using the mounting plate on page 2, use the following steps to make an accurate and clean cut into the dash.

1. Tape the template to the dash and use a center punch for locating the holes on dash, or photocopy if required to use as a drilling template. **If a photocopy is required check ALL MEASUREMENTS as per the template to ensure that the photocopied template is true and correct.**
2. Before drilling the holes, check that the helm location will allow unrestricted movement of the steering wheel.
3. Drill the 3" diameter center hole and the four 5/16" diameter mounting holes, positioned as shown.

## ⚠ WARNING

**Cleaning fluids containing ammonia, acids or any other corrosive ingredients MUST NOT be used for cleaning any part of this Hydraulic Steering System. Failure to comply will cause serious damage to the steering system, resulting in possible loss of steering, causing property damage, personal injury and/or death.**

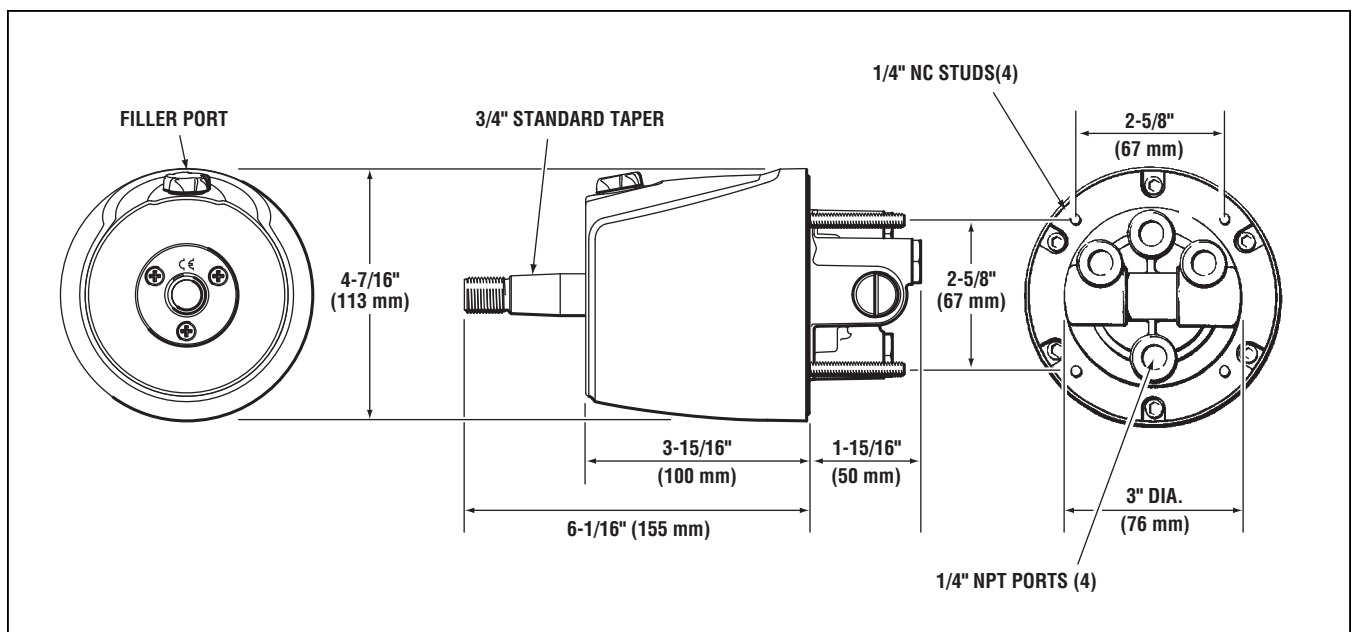


Figure A.



**⚠ CAUTION**

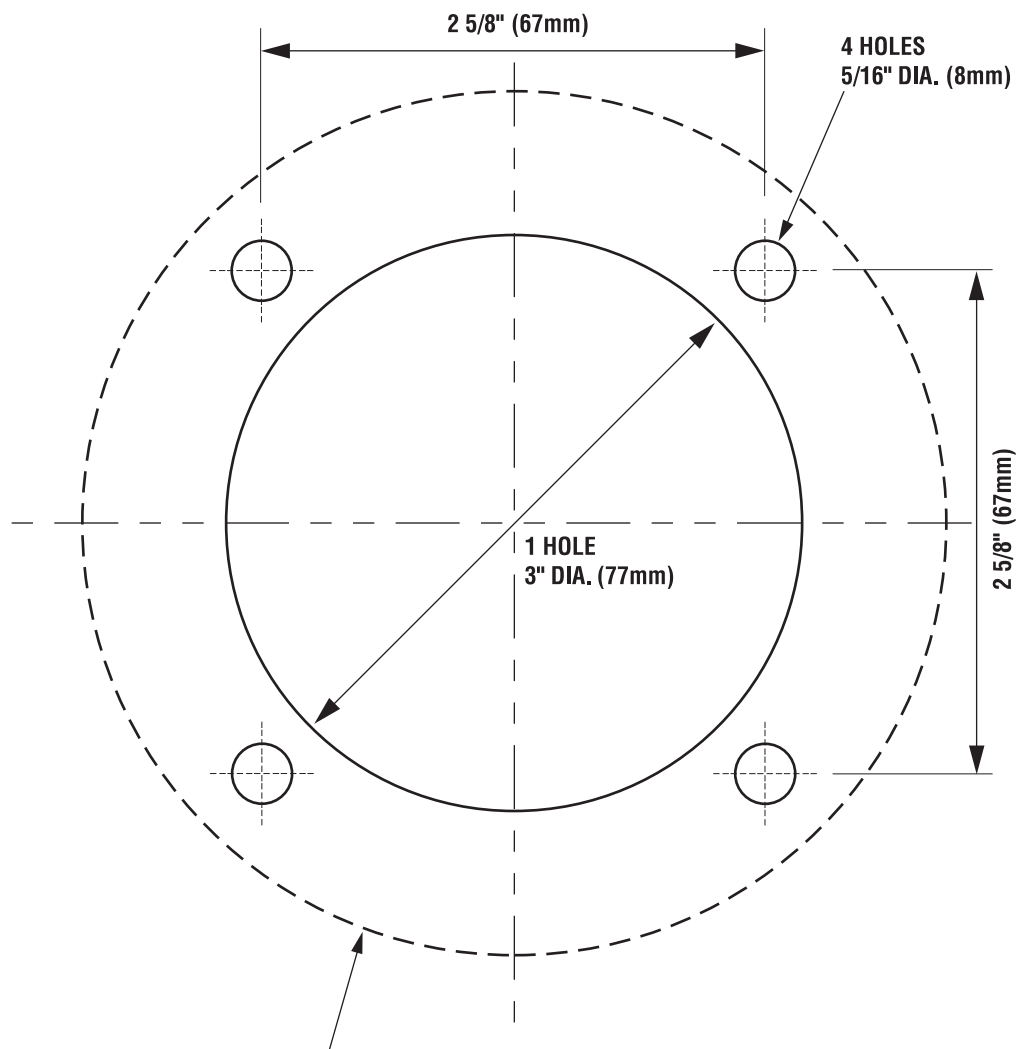
NPT fitting installations only. Apply a liquid, Teflon based pipe sealant onto the threads going into the helm pump and/or steering cylinder. Tighten fitting '**HAND-TIGHT**'. Using a wrench tighten an additional **1.5 turns**. Continue to tighten until desired orientation is achieved.

**⚠ WARNING**

Use self-locking type fasteners only; substituting non-self locking fasteners can result in loosening or separation of equipment and loss of steering control. **DO NOT** exceed **110 in./lbs. (12 Nm)** torque on helm and wedge nuts and bolts.

**⚠ CAUTION**

If printing or photocopying of this template is required, please check all measurements **BEFORE** you drill any holes to ensure that the template you have printed is true and correct.



**HELM FLANGE OUTLINE (for reference only)**  
**4 1/2" (115mm) DIA. MAXIMUM COVERAGE**