

**BAYSTAR™**

HELM PUMPS HH4311 AND HH4314

Mounting the Helm

Determine desired mounting position of the BayStar Helm pump. Ensure that the steering wheel will not interfere with any other functional equipment. Check for adequate space behind the dash. The BayStar 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

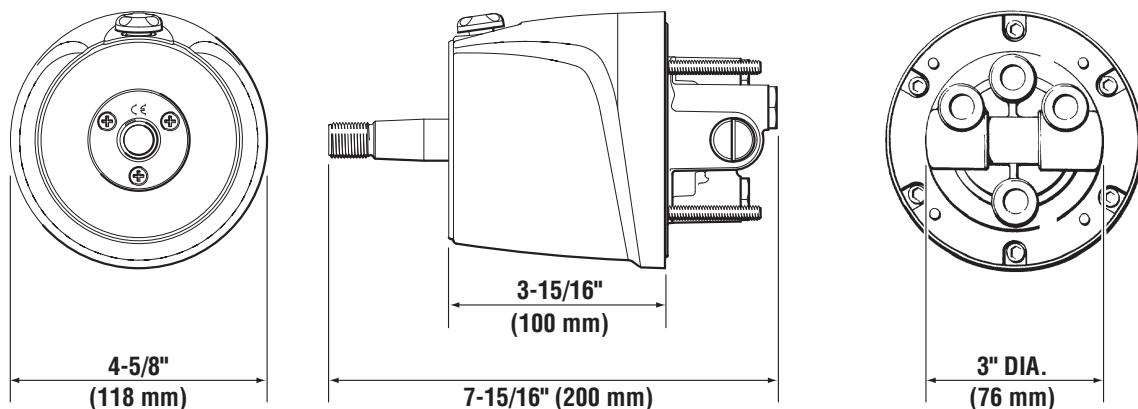
Using the mounting plate on page 2, use the following steps to make an accurate and clean cut into the dash.

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.



NOTICE

To ease installation, it is recommended that you install the hose fittings into the rear of the helm pump prior to mounting. **See NPT fitting installations on page 2.**



NPT Fitting Installations

Apply a liquid, Teflon based pipe sealant onto the threads going into the helm pump.

- Tighten fitting **HAND-TIGHT**.
- Using a wrench, tighten and additional 1.5 turns.
- Continue to tighten until desired orientation is achieved.

WARNING

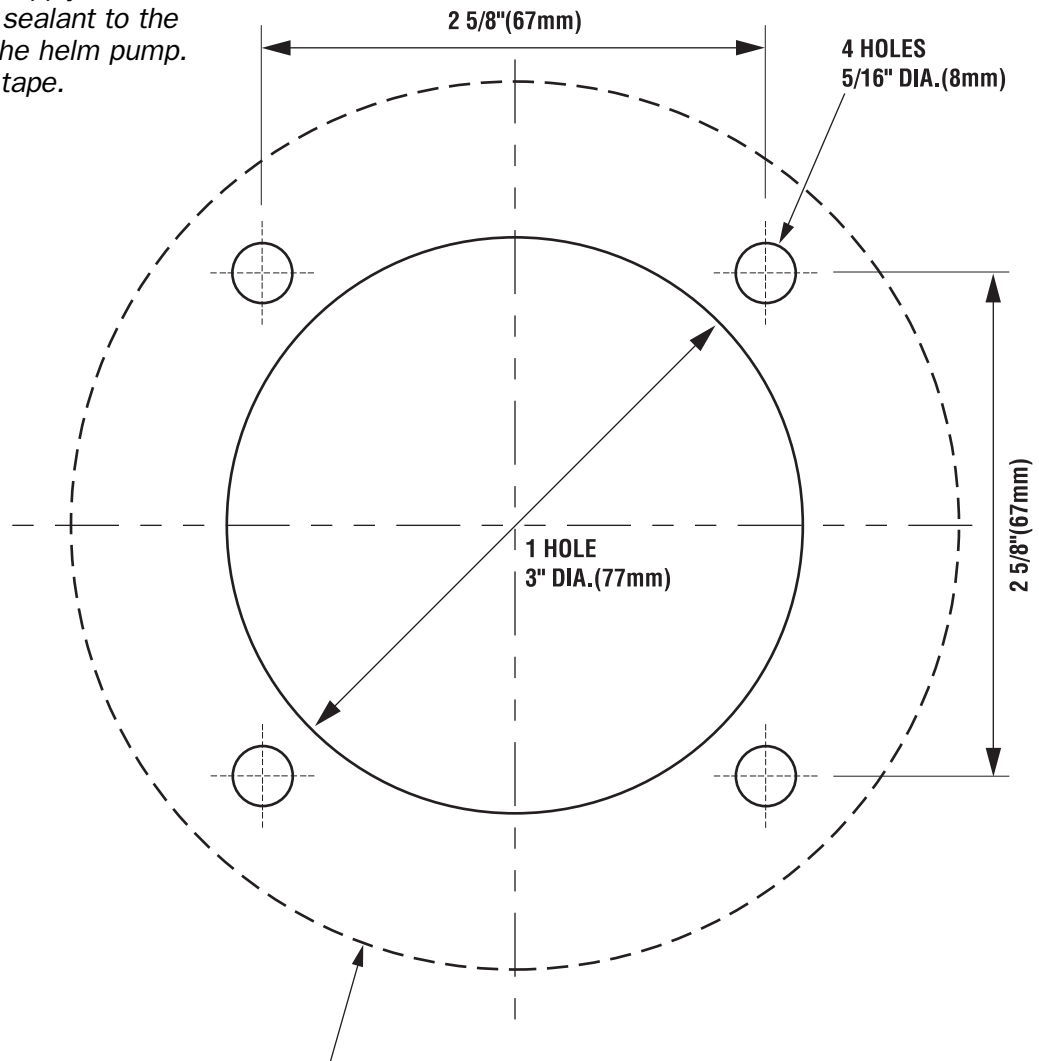
DO NOT use Teflon Tape.

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.

NOTICE

Ports marked R are for the connection of additional steering stations and/or an autopilot. Apply a Teflon based, 'liquid' pipe sealant to the threads going into the helm pump. **DO NOT** use Teflon tape.



HELM FLANGE OUTLINE (for reference only)
4-5/8" (118mm) DIA. MAXIMUM COVERAGE