



**Walbro 450 & 525
Single Pump Assembly**





Walbro 450 & 525 Single Pump Assembly

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Tools Required:

Flathead Screwdriver
1/8 Allen Wrench
3/16 Allen Wrench
1" Socket

5/32 Wrench
Jaw Pinchers
Measuring Tape
Blade or Hose Cutter



Walbro Filter



1 Ricks Tank's Pump Hat



1 MP5044 Hose Clamp



1 - 7 1/2" Fuel Line



Walbro 450 Fuel Pump



Walbro 525 Fuel Pump



Walbro 450 & 525 Single Pump Assembly

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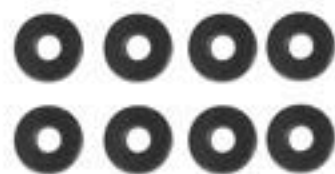
8 Stainless Steel Washers



8 Delrin Washers



8 Viton Washers



8 Stainless Steel 10/32 Nuts



2 Hose Clamps 5/8



Vibration Resistant Pinch Clamps



1 Steel Plug 1/8 NPTF



Walbro 450 and 525 Fuel Pump

2 Ring Lug Terminals



2 Terminal Isolators



2 - 1 1/4 Stainless Steel
Cap Screws



2 - 1 1/2 Stainless Steel
Cap Screws



1 Duckbill fitting



3 Barb Hat Fittings w/ O-rings



1 - 10/32 x 1/4 Button Head w/ O-ring



1 Pump Hanger Bracket



1 Pump Bracket



2 - 3/8 x 10/32 Button Heads



1 ORB Plug -8 w/ Washer



2 Plastic Round Plugs





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 1 Steel Plug 1/8 NPTF

Step 1



Step 2
Dab some Loctite 567 Thread Sealer or preferred sealer that you use.



Step 3
Tighten the Steel Plug till flush with pump hat.



Step 4
Clean off thread sealer



Step 5
Install O-rings on to barb hat fitting, then install on to pump hat.



Step 6
Tighten with socket



Step 6
Install O-ring on to 10/32 x 1/4 Button Head



Step 7
Install 10/32 x 1/4 Button Head to by pass hole



Step 8
Tighten till O-ring seats.



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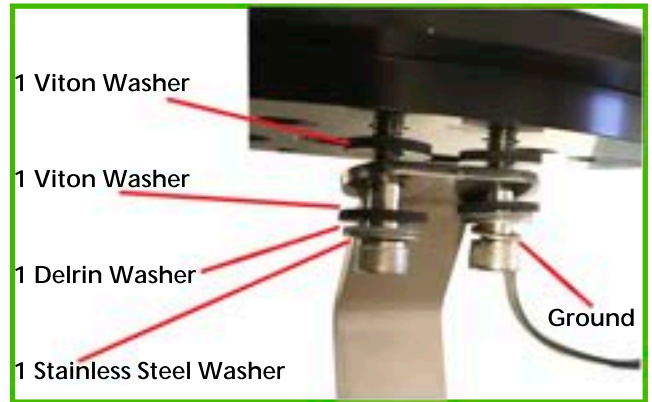
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2 Terminal Isolators

Step 9

Install 2 terminal isolators thru the pump hat

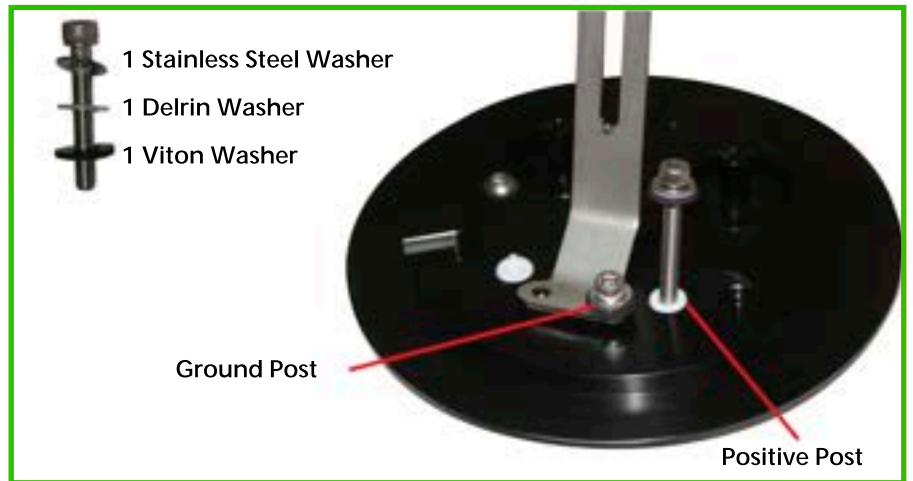


- 1 Viton Washer
- 1 Viton Washer
- 1 Delrin Washer
- 1 Stainless Steel Washer
- Ground

Step 10 A

Installing washers

NOTE: Viton washer must be installed between pump bracket and hat.



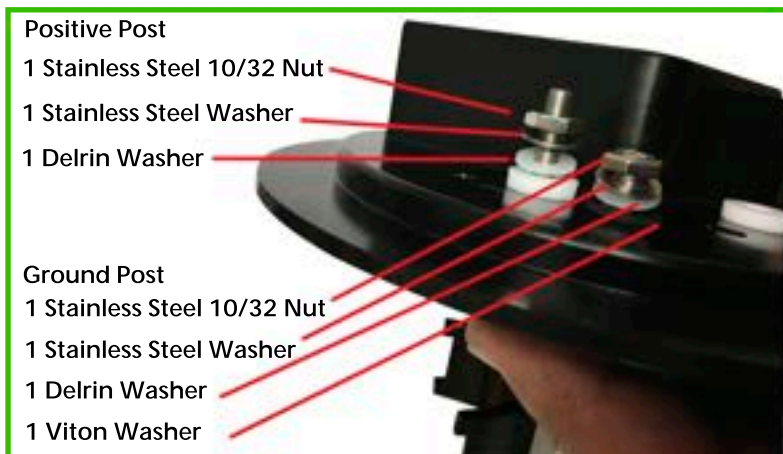
- 1 Stainless Steel Washer
- 1 Delrin Washer
- 1 Viton Washer

Ground Post

Positive Post

Step 10 B

Install ground and positive stainless steel cap screws thru the terminal isolators.



- Positive Post
- 1 Stainless Steel 10/32 Nut
- 1 Stainless Steel Washer
- 1 Delrin Washer
- Ground Post
- 1 Stainless Steel 10/32 Nut
- 1 Stainless Steel Washer
- 1 Delrin Washer
- 1 Viton Washer

Step 11

Install hardware, its important to install them in order. It may cause pump failure if not installed correctly.



Step 12

Hand tighten for now.



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Step 13

Cut pump hose 2 1/4" Cut return hose 5"
For universal applications cut pump hose to length, measure tank depth.



Step 14

Install return hose on center fitting only with 3/8 Vibration Resistant Pinch Clamp



Step 15

Use Jaw Pincer tool to pinch the clamp correctly



Step 16

Install the pump bracket thru the return hose



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Step 17
Tighten button heads with 1/8 allen wrench



Step 18
Install the Duckbill



Step 19
Install the 5/8 Vibration Resistant Pinch Clamp



Step 20
Use Jaw Pincers to correctly pinch the clamp.



Step 21
Install the 1 3/4" Fuel Line on to the fuel pump

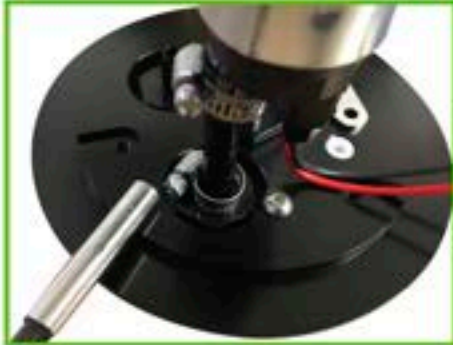


Step 22
Install the 2 Hose Clamps 5/8 and fuel pump harness



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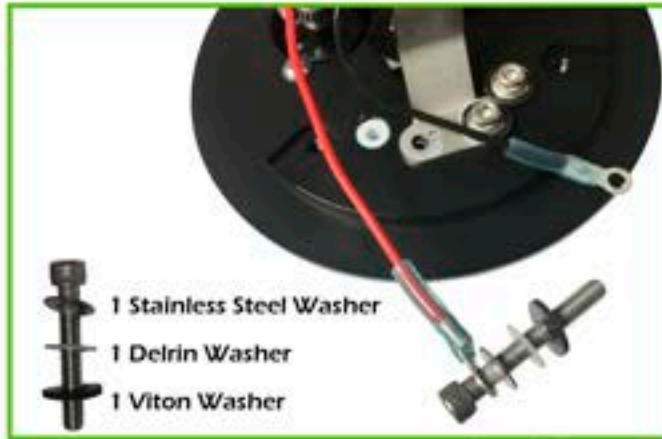


Step 23
Tighten the 2 Hose Clamps

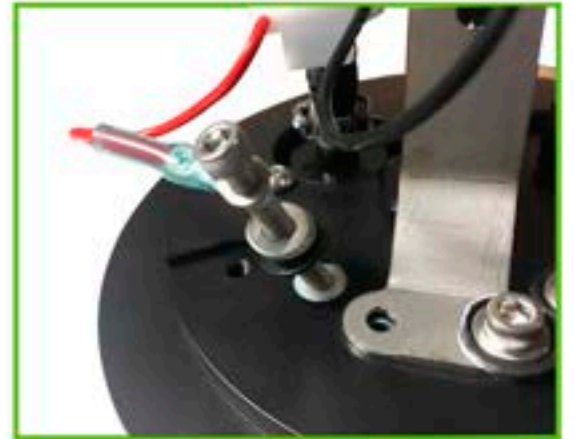


Step 24
Cut the harness to the desired length and install terminals.
Apply heat to the heat shrink terminals.

Positive Post
1 - 1 1/2 Stainless Steel
Cap Screw



1 Stainless Steel Washer
1 Delrin Washer
1 Viton Washer



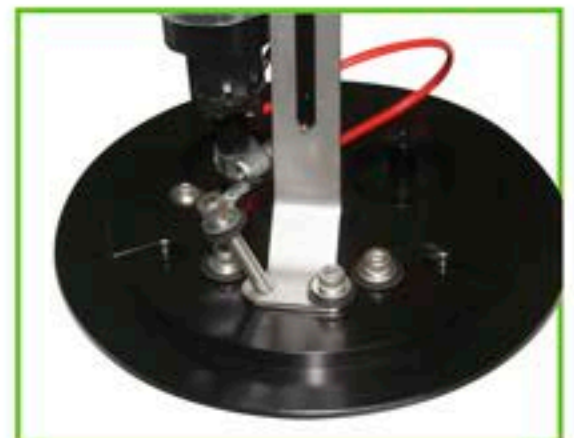
Step 25

Install the positive post thru thr terminal isolator. First with the terminal, stainless steel washer, delrin washer then viton washer last. Its important to install them in order. It may cause pump failure if not installed correctly.

Ground Post
1 - 1 1/4 Stainless Steel
Cap Screw



1 Stainless Steel Washer
1 Delrin Washer
1 Viton Washer



Step 26

Install the ground post thru the pump bracket. First with the terminal, stainless steel washer, delrin washer then viton washer last. Its important to install them in order. It may cause pump failure if not installed correctly.

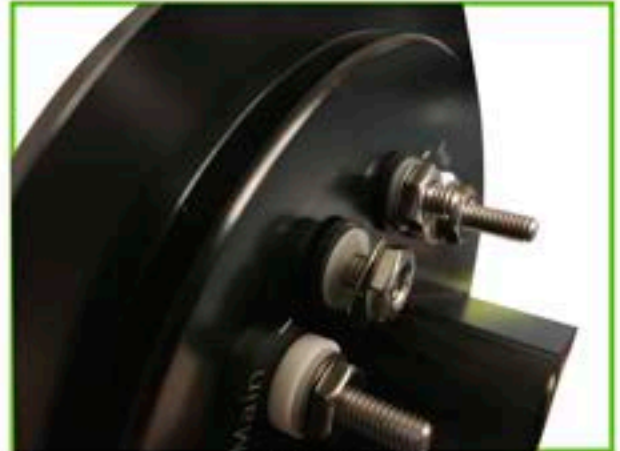


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Step 27
Install one delrin washer, one stainless steel nut
on the positive terminal isolator



Step 28
Install one viton washer, one delrin washer, one stainless steel
washer one stainless steel nut on the negative terminal isolator



Step 29
Tighten all 4 till viton washer seats.



Step 30
Install clamp over the pump hanger and
bracket then tighten



Step 31
Install fuel pump filter



Step 32
Measure the base of the pump hat to the bottom of the filter.
That will measure 6 1/2

Revised 1/25/2021



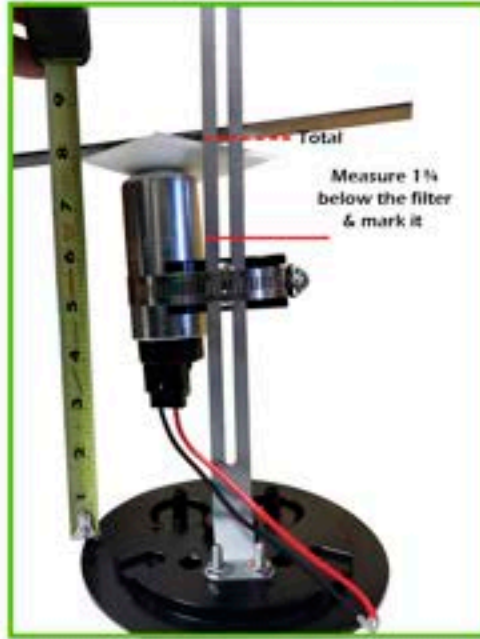
Walbro 450 & 525 Single Pump Assembly Addendum

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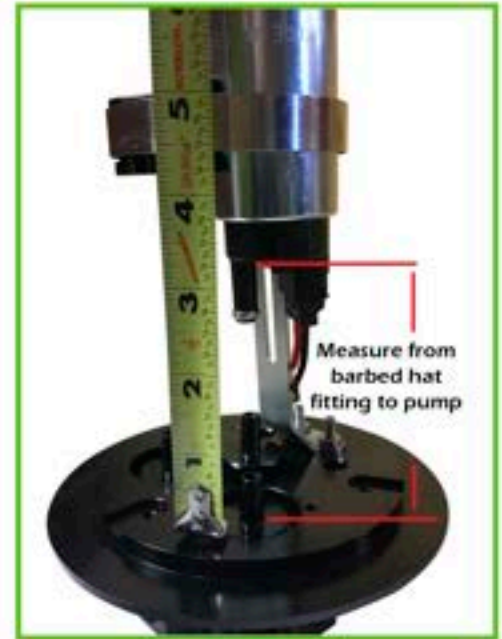
Measuring for the Fuel Pump



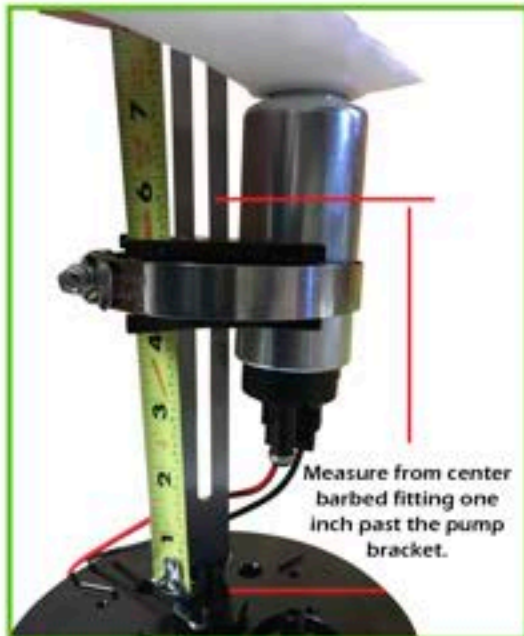
Step 1
Measuring the depth of the tank using a straight edge.



Step 2
Install fuel filter to the pump. Install the pump snug on the pump hanger bracket. Use the measurement from the depth of the tank. Measure from the lowest flat spot on the pump hat to the fuel filter, use a straight edge if need. After you get the total measurement, measure 1 1/4 below the filter & mark it



Step 3
For the fuel line hose, measure from barbed hat fitting to pump



Step 4
For the return line hose, measure from center barbed fitting one inch past the pump bracket. This will give it room for the duckbill fitting.

12"
Pump Hanger Bracket

Step 4
Using the measurement 1 1/4 below the filter cut the pump hanger bracket. Now go back to Step 10 in the instructions

