

BayStar™

Helm Pumps HH4311 & 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:

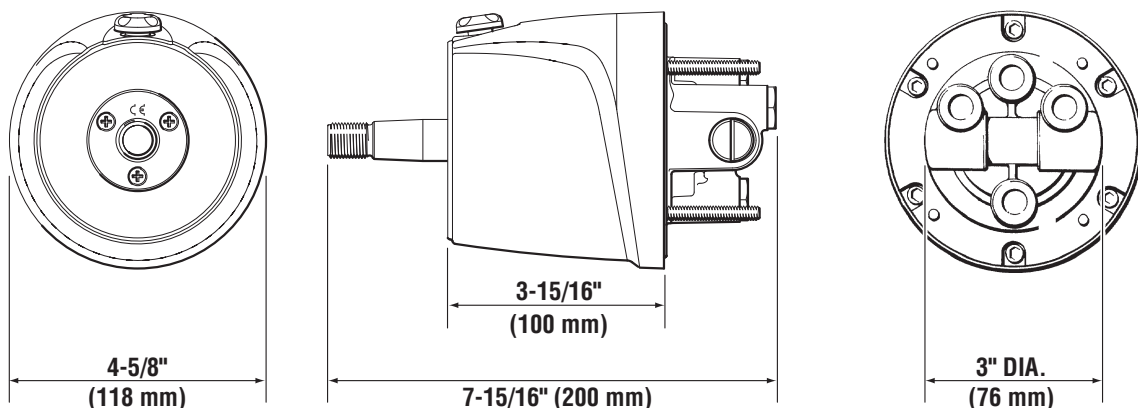
Using the mounting plate on page 2, use the following steps to make an accurate and clean cut into the dash.

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



⚠ CAUTION

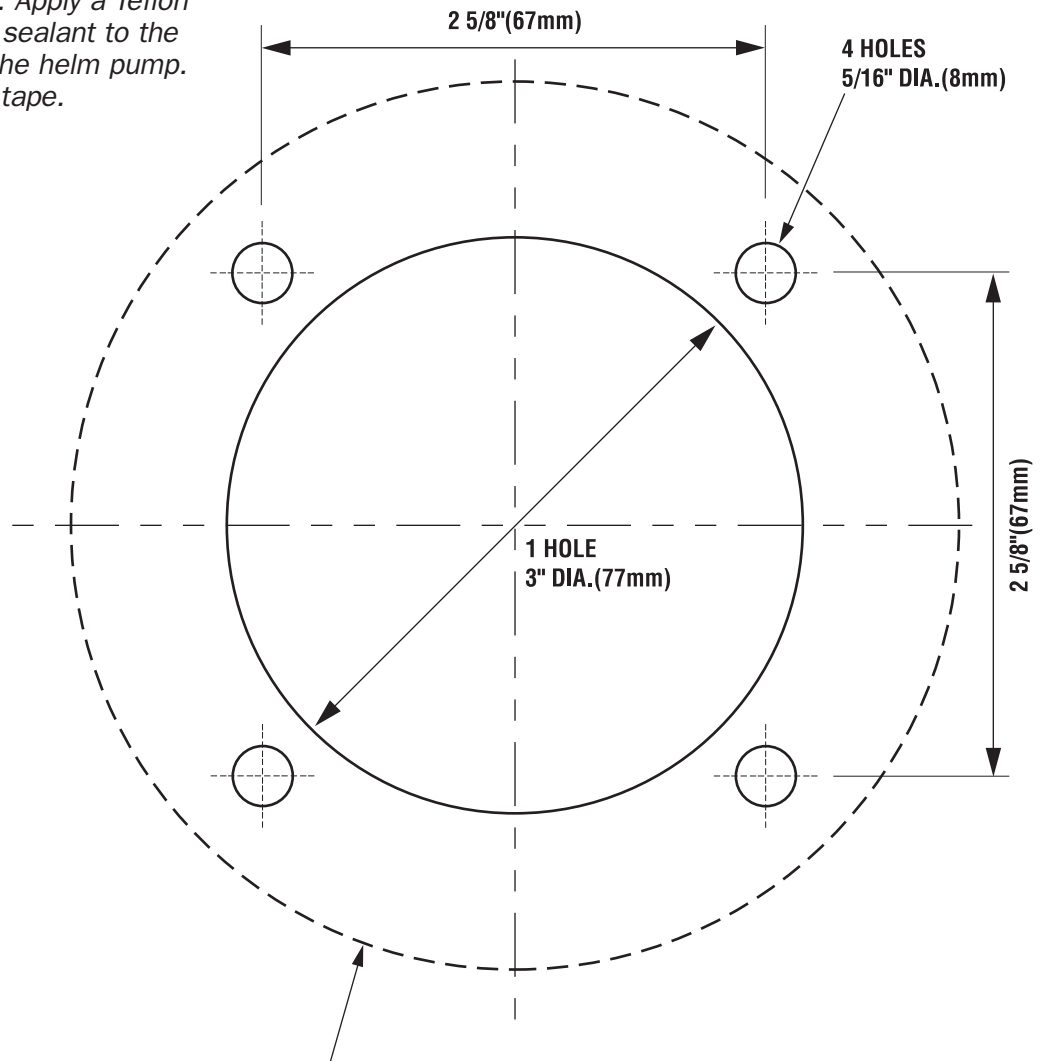
When installing the fittings into the rear of the helm pump apply a Teflon based, liquid type pipe sealant to the threads going into the helm, **DO NOT** use Teflon Tape, **DO NOT** apply any pipe sealant of any kind onto the threads of the fitting that the hose/tube will thread onto. Tighten fitting until finger tight, then turn an additional 1-1/2 to 2-1/2 turns depending on the desired orientation. **DO NOT** exceed 156 in. lb. (17.6Nm). **DO NOT** use steel fittings in the helm, **ONLY** use Brass fittings.

⚠ 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**