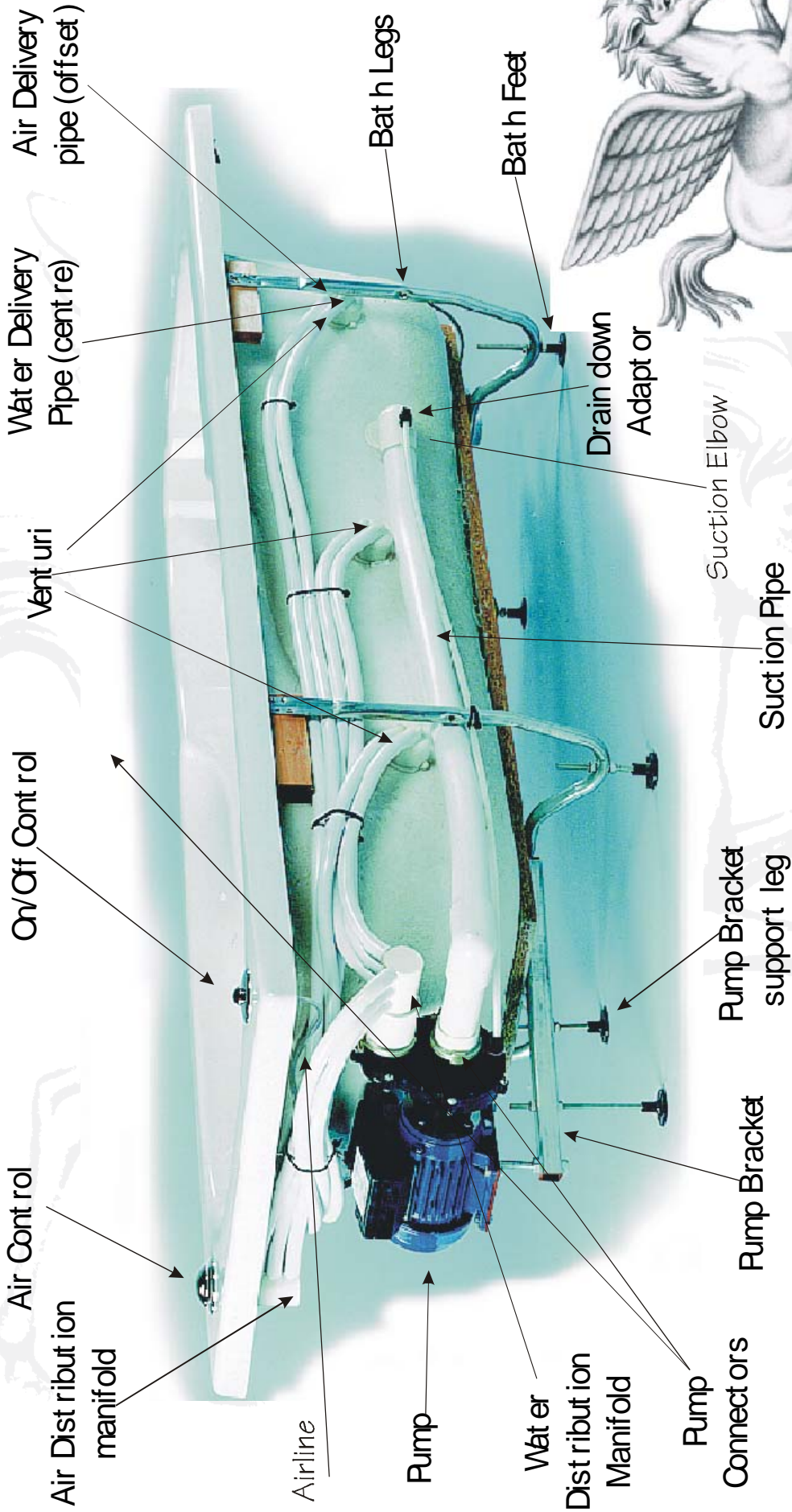


**Pegasus self fit whirlpool kit fitting instructions for 6/8 jet (retro venturi)**

# Pegasus Whirlpool Components



**Better Whirlpool Systems from Whirlpool Express (UK) Ltd**

# Pegasus self fit whirlpool kit fitting instructions for 6/8 jet (retro venturi)

The Pegasus Whirlpool system has been designed to be able to fit to any bath without putting any stress on the bath whatsoever. Jets can be placed to give the customer both aesthetic appeal and maximum hydromassage. To achieve this jets will usually be located laterally within 1.5" of the desired position, even when up against obstructions such as bath legs - something which can not be achieved with conventional whirlpool systems without placing a lot of stress on the bath or modifying the manufacturer's legs.

## IMPORTANT NOTES

To ensure that you get the best out of your whirlpool system, please take the time to read these instructions fully before attempting to start to fit the kit.

NB The Pegasus fitting tool (definitely needed for in-situ conversions) is available at £10.00 Plus VAT

When gluing pipe to venturi and manifolds be sure that only the exterior surface of the plastics are glued and not the pipework. Take care not to allow glue to get into the interior surfaces or the pipework as this will seriously reduce the performance of the whirlpool system.

When fitting the pump fixing bracket to baseboard of bath be sure to check the length of the screws. The screws supplied are for 3/4" thick encapsulated baseboards

If you need help fitting this kit, Please contact our hot-line **BEFORE YOU START!**

## Basic outline of fitting Procedure

1. Check the bath for damage and defects.
2. Fit legs & pump to bath using fixing bracket and screws.

3. Determine position of jets, suction & controls taking care to look for obstructions.
4. Determine the position of the On/Off button and Air control. Ideally the Air control needs to be mounted on a corner of the bath to allow the pipes to be fitted easily.
5. Drill the holes - slowly and carefully.
6. Install all the fittings onto the bath.
7. Connect the pipework between the manifolds and venturi ensuring that all fittings are cleaned with MEK and that glue is only applied to the external surfaces of the Manifolds and Venturi - Not to the inside of the pipe or venturi. Ensure pipes are connected to the correct manifolds. NB when gluing the rigid suction pipe, joints can be glued on both surfaces to ensure

adhesion.

8. Watertest the finished product before final installation of the bath.

**If you have any doubts about any aspect of fitting this system to any bath, ring our installation support line 01633 244555 before you start - We are there to help you get it right - first time.**

## RECOMMENDED ADHESIVES

1. Weld.on 725 WET 'R DRY plastic pipe cement.
2. MEK Solvent cleaner
3. Dow Corning 785 White silicone

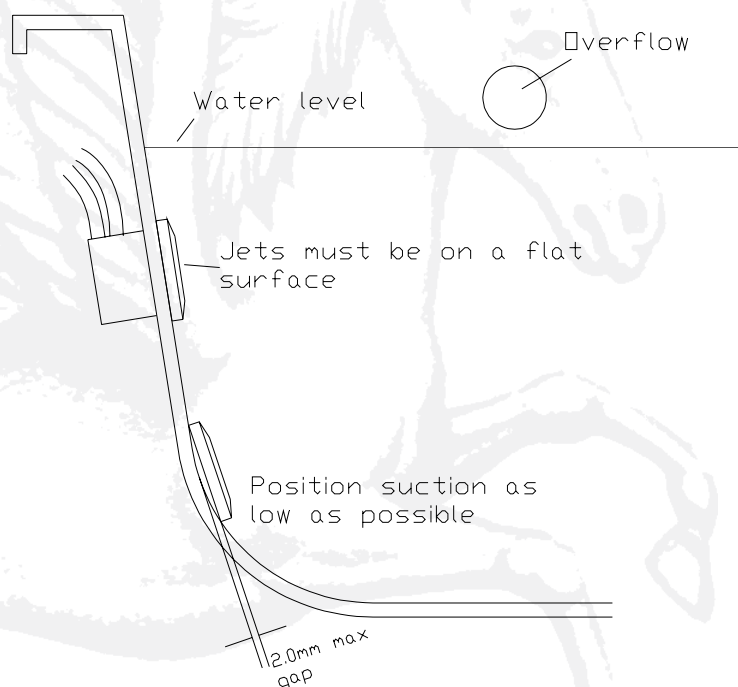
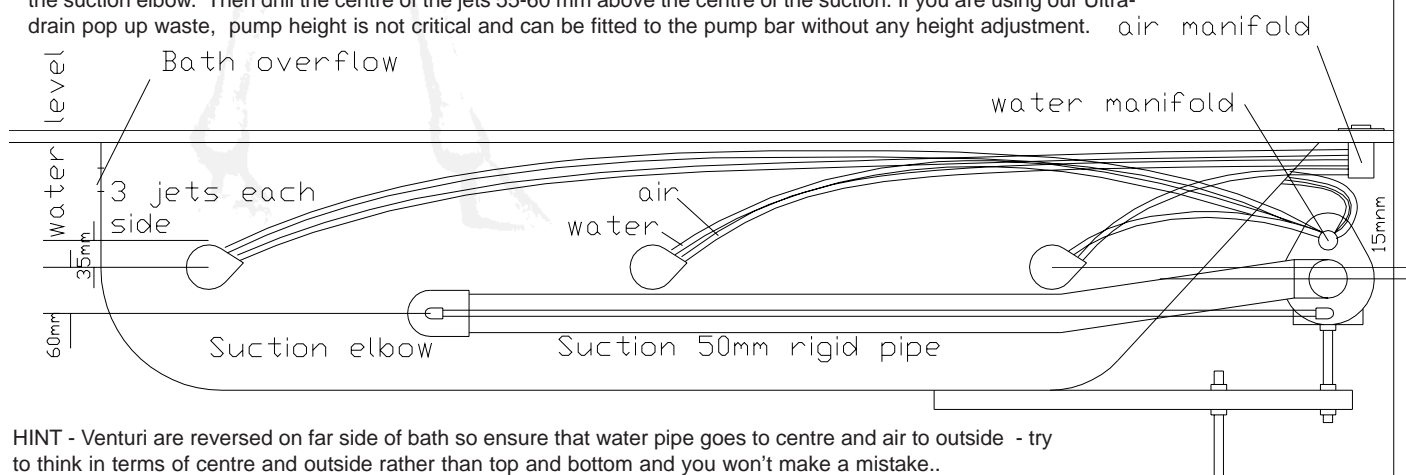


FIG 2

HINT - To get the suction at the correct height for drainage, measure and drill the suction hole, fit the suction elbow and then turn the bath upside down on a level surface, fit the pump so that the drain on the pump is level with the drain on the suction elbow. Then drill the centre of the jets 55-60 mm above the centre of the suction. If you are using our Ultra-drain pop up waste, pump height is not critical and can be fitted to the pump bar without any height adjustment.



HINT - Venturi are reversed on far side of bath so ensure that water pipe goes to centre and air to outside - try to think in terms of centre and outside rather than top and bottom and you won't make a mistake..

# Pegasus self fit whirlpool kit fitting instructions for 6/8 jet (retro venturi)

## DETAILED FITTING INSTRUCTIONS

### 1. Checking the bath for damage - before drilling!

- Carefully remove the manufacturer's wrapping and any cautionary labels from the bath.
- Corners not cracked or broken.
- Check that the lip of the bath has been cut cleanly and is not chipped.
- Rub the bath over with a dirty, wet duster looking carefully at places where the dust collects in lines. Determine if these lines are scratches which can be easily polished out, or worse, cracks caused by transit damage.
- Check that the waste hole is central in the recess.
- Check that the tapholes are correct.
- Check that the bath is true and not warped.
- Check that all the legs and fixing brackets are present - including screws.

### 2. Fixing the legs and the pump to the bath

- Read through the manufacturer's installation instructions for the bath
- Place a dust sheet on a table turn the bath upside down on this sheet and fit the legs and feet to the bath carefully following the manufacturer's instructions. Leave the bath upside down on the sheet and;
- Assemble the threaded bar to the Pump Mounting Plate and Pumpstand using the nuts provided.
- Assemble the pump to the baseplate using the four nuts and bolts provided.
- Glue and assemble the pump outlet manifold which comprises of two manifolds, a stopend and a pump connector - care should be taken to glue both the male and female parts of all joints to be made. Once the manifold has been glued together, fit this and the suction inlet to the pump using the special fixing brackets provided. (NB on a six jet system you will need to 'loop' out two of the spigots on the water and air manifolds<sup>(1)</sup> - these can be cut off at a later date if you wish to upgrade your system to 8 jets - see photo on page 6)
- Offer the pump up to the bath (still-upside-down) and find a position where the pump is central and within the confines of the bath. Be careful to take into account the length of the outlet manifold and any wooden panels which may be subsequently fitted to the bath.
- Secure the pump and bracket to the bath using the five screws provided. **Important:** the screws have been designed to secure the Pumpstand to baseboards with a thickness of 3/4" - check the length of the screws against the thickness of the baseboard before attempting to fix the pump stand to the baseboard. A good guide to the thickness of the baseboard is the length of the screws supplied to fix the legs to the bath! - if in doubt use shorter screws. Under

ENSURE MANIFOLD AND BACK NUT WILL SEAT

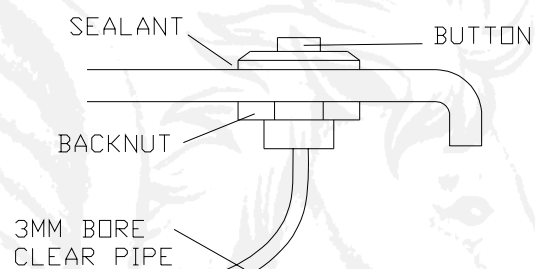
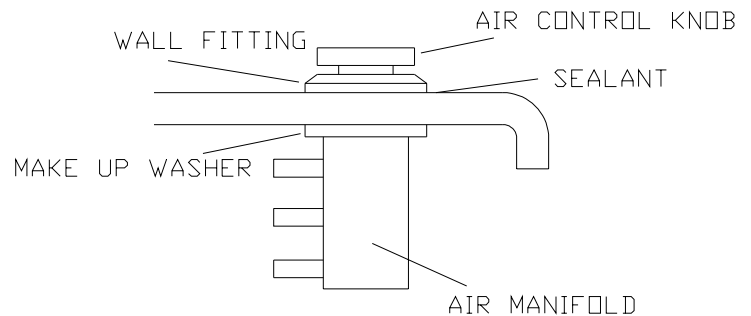


FIG 3

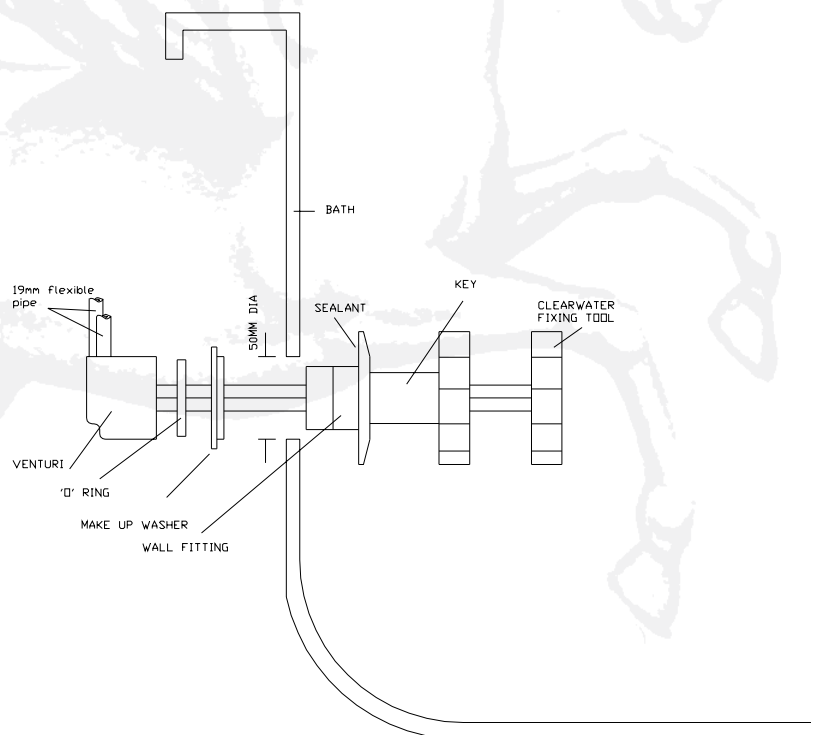


FIG 4

# Pegasus self fit whirlpool kit fitting instructions for 6/8 jet (retro venturi)

no circumstances attempt to fit the pumpstand to a bath manufactured from GRP - GRP baths do not have baseboards.<sup>(2)</sup>

### 3. Determine the position of Jets, Suction and controls.

- The number of jets to be fitted and the shape of the bath will usually determine the jet positions.
- Jets are normally equally spaced along each side of the bath but can be fitted on any flat surface. See Fig. 1.
- Ensure positions chosen allow sufficient room for the Venturi (watch out for bath support legs) and that the Venturi will not interfere with the sitting of the pump.
- The suction is best fitted toward the foot end of the bath (away from the seat area). See Fig.1
- The difference between the jets and suction fitting is important to ensure that the maximum amount of water drains from the system after use. See Fig. 1.
- The suction is the lowest fitting in the bath and should be placed as low as possible on a flat surface. See Fig. 2.
- The centre line of the jets should be 60mm. above the centre line of the suction. See Fig.1.
- Note that the water level will be some 35mm. above the centre line of the jets. Check that the water level will be below the overflow. See Fig. 1.
- Mark all the positions with a felt-tip pen.

### 4. Position the height of the Pump.

- The centre line of the pump suction must be 15mm. below the centre line of the jets See Fig.1.
- If the pump is too high, it will not prime. Too low and it will not drain when the bath is emptied. Remember that the water hose is to be connected to the water manifold. See Fig.1.

### 5. Position the On/Off Button and Air Control.

- The on/off button and air control should be fitted to the top surface of the bath.
- Check that there is enough space underneath the proposed location of the On/Off and Air Control for the backnut and air manifold to seat properly seat on the underside of the bath. Remember that the air hose is to be connected to the manifold. See Fig. 3. Important : - Always allow for access to the controls, especially the On/Off control.

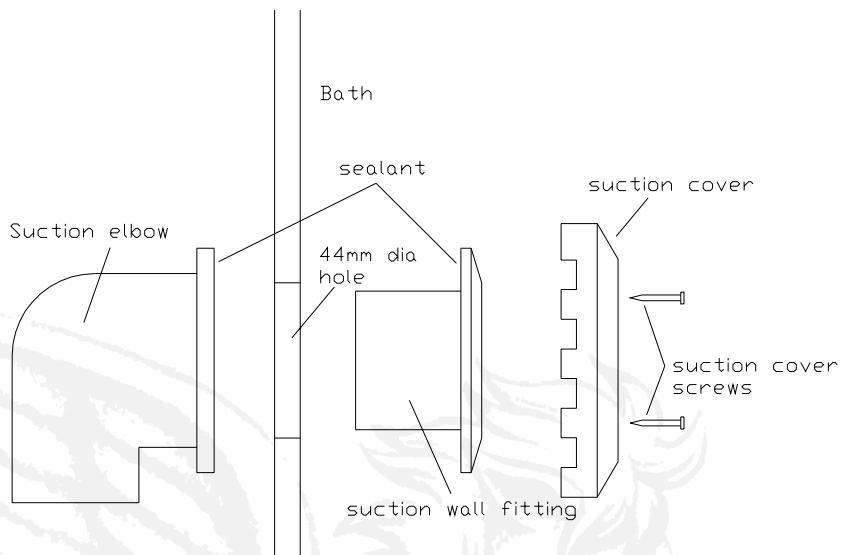


FIG 5

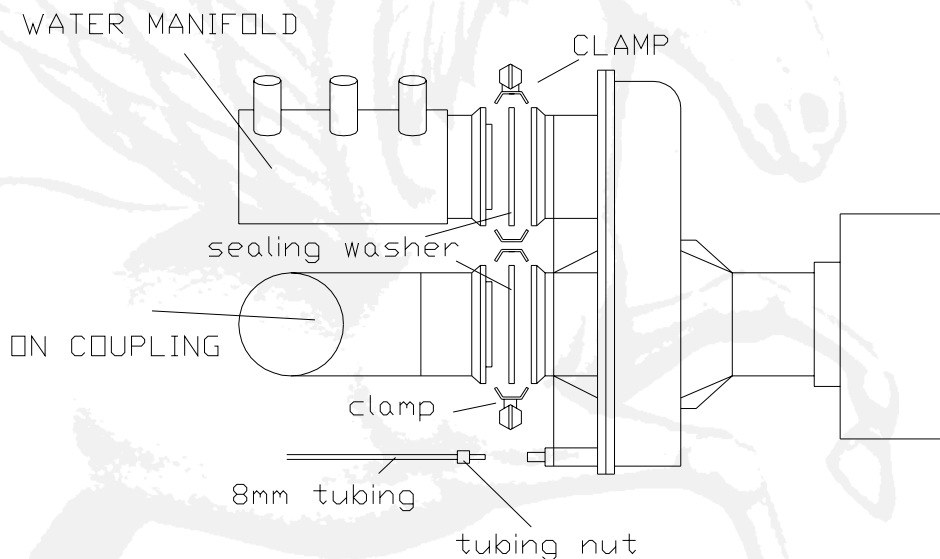


FIG 6

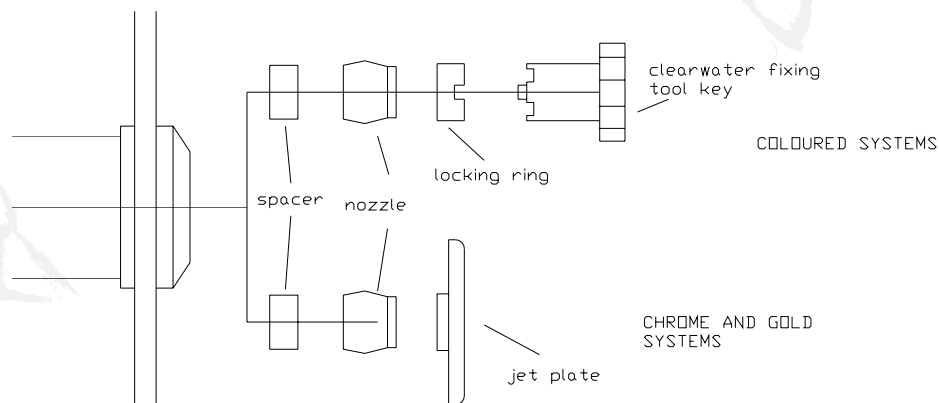


FIG 7

Revised: 06/05/2003

### 6. Drill the Holes.

# Pegasus self fit whirlpool kit fitting instructions for 6/8 jet (retro venturi)

a) Before drilling the holes, re-check all positions, ensure that the bath legs, panel, pump, fixing battens, etc. will not obstruct fittings or indented hose runs.

b) Using a 50mm hole cutter, drill the holes from the inside of the bath,<sup>(3)</sup> tacking care to prevent the drill from slipping.

**Important Safety Note:** Always point the drill away from the body when drilling holes - never drill towards you body without a body shield.

c) Back file the holes with a small round handfile to clear any burrs and unevenness left by drilling the hole.

d) Clean off the excess pen marks and dust using a tissue dampened with meths. Pay particular attention to clean immaculately around the holes as dust may hinder the effectiveness of silconing the wall fittings to the bath!

## 7. Installing the whirlpool fittings onto the bath.

a) The clear water fixing tool is now required to install the fittings to the side of the bath.

b) Assemble an 'O' ring to each of the Venturi and place a band of silicone sealant around the wall fitting shoulder. See Fig. 4. Using the fixing tool, fit the Venturi to the bath with the spigots at approximately 45 degrees above horizontal pointing towards the pump, ensure the make-up washer is in position and tighten wall fitting into Venturi. **Important Note: - Do not overtighten as damage to the venturi could result.**

c) Repeat the above operation for the remaining wall fittings.

d) (The wall fitting with two holes in the face is the suction wall fitting.)

e) Clean off any excess silicone sealant.

## 8. Install Suction Elbow and Hose.

a) Place a bead of sealant around the shoulder of the suction wall fitting and the flange of the suction elbow. Using the key from the Clear water fixing tool, assemble the suction fitting. **Important Note: Do not overtighten.** See Fig. 5.

b) Measure and cut to length the suction pipe and glue to the suction elbow and pump elbow using a recommended adhesive

c) Clean off any excess sealant.

## 9. Connect Water and Air Hoses to Manifolds.

a) Starting at the jet closest to the pump, measure the length of water and air hose required to connect the Venturi to the water and air manifolds. Glue the hose to the Venturi using a recommended adhesive.

**Important Note: - Only glue the exterior**

**of the Venturi - not the inside of the hose!**

b) Water to the centre and air to the outside - remember this (rather than top and bottom) when you move from one side of the bath to the other as otherwise system will not work correctly<sup>(4)</sup>.

c) Hose should be taut but not stretched and with a fall either to Venturi or pump without sagging. See picture on Page 1

d) Ensure water hose is connected to pump manifold and air hose to air manifold.

## 10. Fix Drain Line.

a) Cut the drain line to length

b) Fit it to the pump using tubing nuts and olives provided. See Fig. 6.

c) Cut the tube to length and secure the loose end to the suction elbow

## 11. Install Eyeballs and Locking Rings.

a) Place the spacers in each of the jet fittings on the bath

b) Place the Eyeballs on top of these

c) Using the Pegasus fixing tool secure the Eyeballs in position with the retaining rings. See Fig. 6.

## 12. Fit Suction Cover.

a) Secure the suction cover to the wall fitting using the two screws provided.

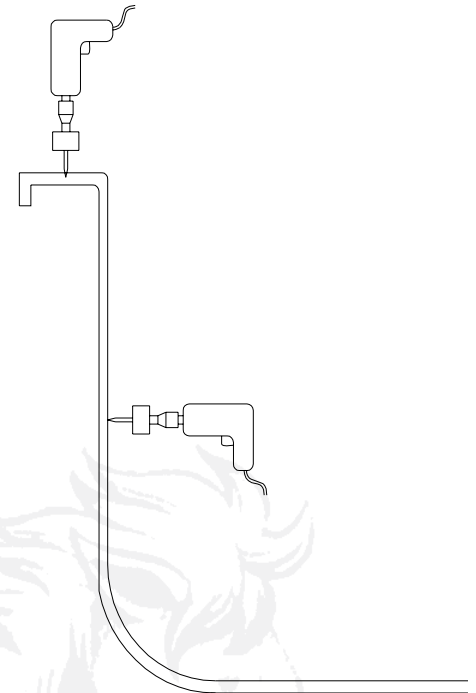


FIG 12

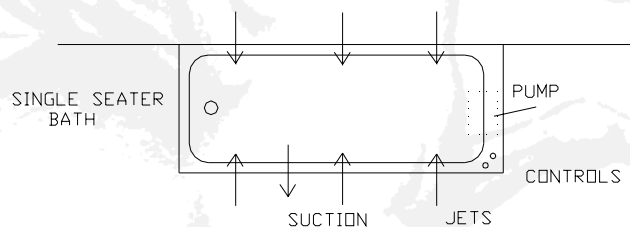


FIG 9

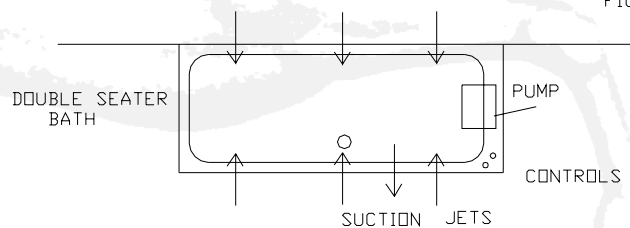


FIG 10

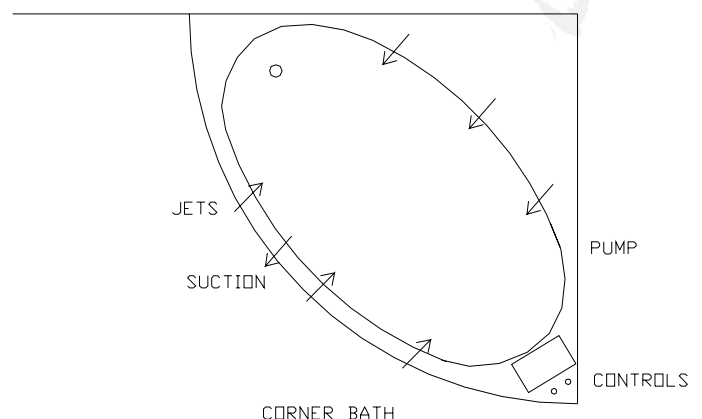


FIG 11

## Pegasus self fit whirlpool kit fitting instructions for 6/8 jet (retro venturi)

### 13. Connect On/Off Button to Pump.

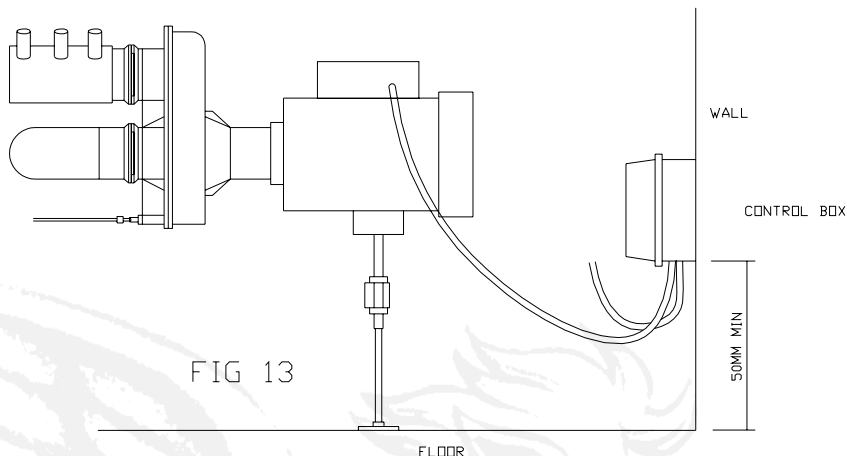
a) Push 3mm bore clear hose onto button and to switch in terminal box. **Important Note: - Do not allow pump to run without water in the pump as costly damage may occur.**

### 14. Clean and Test.

a) Ensure all debris is cleared from bath.  
b) Fill with water to a level of three inches above the jets.  
c) Allow to stand for five minutes and then check to ensure that all joints are watertight.  
d) Activate pump and re check all joints.  
e) Leave pump running for 20 minutes.  
f) Turn pump off and continue to fill bath up to the level of the overflow. Leave the bath stand for 30 minutes again.

### 15. Connecting to Mains Supply.

a) Connection should always be entrusted to a suitably qualified electrician and carried out in accordance with Wiring Regulations.  
b) The pump should be connected into a waterproof junction box under the bath, 50mm above floorboard level to prevent ingress of water should flooding or water leaks occur. See Fig. 13.  
c) **Important Note: - Complete Instruction 13 before switching on mains supply.**



### SUPPLEMENTARY NOTES

(1) We now supply the same manifolds for both 6 and 8 jet systems. This is because it is easier to fit a straight manifold rather than the original manifold. When fitting a six jet system simply glue a loop of pipe between the two unused branches (see diagram opposite).

(2) Most baths nowadays are moulded from Acrylic which is then back sprayed with chopped strands of GRP to reinforce the acrylic. A length of chipboard is then stuck to the base to further increase the strength of the bath. This baseboard may be encapsulated by a further coating of chopped GRP. If in doubt as the material of the bath look carefully in the overflow and you should see a good 3 or 4mm thickness of acrylic with a nominal 2-3mm of acrylic reinforcing. If in doubt ring us before fixing.

(3) Always use a mask when drilling as the dust can irritate throats and may be harmful.

(4) When fitting pipes to the venturi, the water pipe from the pump must go to the centre and the air pipe from the mixing control must go to the outside spigot. When the venturi are fitted to the bath the air will be on top on one side and underneath the



**PEGASUS**  
HYDROMASSAGE

Office: 15 Cross Lane, Kingsway, Newport, South Wales, NP20 1ES  
Showroom: 151 Chepstow Road, Newport, South Wales, NP19 8GE  
Warehouse: 61-62 Lower Dock Street, Newport, South Wales NP201EF  
Telephone: (01633) 244555 Facsimile: (01633) 244881  
Email: sales@whirlpoolsexpress.co.uk Internet: www.whirlpoolsexpress.co.uk

Revised: 06/05/2003



# Pegasus self fit whirlpool kit fitting instructions for 6/8 jet (retro venturi)

## PACKING LIST - PEGASUS MIDI SIX

5/5/03

<b>K/ASSY/002A</b>	<b>STANDARD AP45 PUMP DELIVERY PACK (MIDI 6/8 JET)</b>	<b>1</b>
K0/13/1-STOPEND	Stopend / 1"	1
K0/16/40	Pump profile clamp / AP45	1
K0/16/41	Pump coupling flange / ABS / 33.5mm ID (1")	1
K0/16/43	Rubber pump washer 57mm OD x 44.5mm ID x 1mm	1
K0/20/2	Manifold / 4-Branch / 12mm OD / Multi C type	2
<b>K/ASSY/003</b>	<b>STANDARD PUMP TO SIDEWALL SUCTION PACK</b>	<b>1</b>
K0/12/10	Suction elbow / 1.25" with drain elbow	1
K0/12/21	Wall fitting for suction elbow (drilled)	1
K0/13/1.25-45	Elbow / 1.25" / 45 degree	1
K0/13/1.25-90	Elbow / 1.25" / 90 degree	1
K0/16/40	Pump profile clamp / AP45	1
K0/16/42	Pump coupling flange / ABS / suction / 1.25"	1
K0/16/43	Rubber pump washer 57mm OD x 44.5mm ID x 1mm	1
<b>K/ASSY/004A</b>	<b>SUB PACK - 12.5mm AIR MANIFOLD (MIDI 6/8JET)</b>	<b>1</b>
K0/13/1-STOPEND	Stopend / 1"	1
K0/13/AIRCTLADAPTOR	Adaptor / Multipoint control to manifold	1
K0/20/2	Manifold / 4-Branch / 12mm OD / Multi C	2
<b>K/ASSY/005</b>	<b>ASSEMBLY - PNEUMATIC SYSTEMS, ACRYLIC BATHS</b>	
K0/16/01	Pegasus hi-flow pump - 45 GPM	1
K0/16/11	PUMP STAND BAR	1
K0/13/1.25-PVCPPIPE	LENGTH OF SUCTION PIPE 1.25"	1
AW/TUBE/80D	METRE 8mm OD NYLON TUBE	1.5
R/CT1816	METRE LENGTH OF 1/8" PNEUMATIC TUBE FOR ON/OFF	1
<b>K/ASSY/006</b>	<b>ASSEMBLY - STANDARD PUMP FIXING</b>	<b>1</b>
K0/16/12	Pump height adjust threaded bar M10 STUD x 150m ZN	1
K0/16/13	Pump mounting plate	1
K0/16/15	Pump support foot (bath leg) M8 x 180	1
K0/16/24	M6 x 20 Hex bolts for securing pump to stand	4
K0/16/25	M6 nut for fixing pump to pump	4
K0/16/26	M6 plain washer ZN Plated	4
K0/16/27	M6 shake proof washer for pump	4
K0/16/23	M8 nuts for pump support	2
K0/16/28	M10 nuts for pump fixing	4
SC/7605	Quicksilver countersunk woodscrew 1.5" x 8	5
SC/7796	200 mm x 4.5 mm cable ties	12
<b>K/ASSY/008</b>	<b>ASSEMBLY - PEGASUS MIDI VENTURI 6 JET</b>	<b>1</b>
K0/10/C	Pegasus Midi venturi body	6
K0/10/D	Make-up washer, pegasus venturi	6
K0/10/E	O' ring seal for pegasus venturi	6
<b>R/CLT1225M/15/YELLOW</b>	<b>15M ROLL OF CANARY YELLOW 12.5mm TUBE</b>	<b>1</b>
<b>K0/.../...</b>	<b>COLOUR SET</b>	<b>1</b>
K0/12/..	Suction cover	1
K0/14/..	Air control	1
K0/17/..	Pneumatic On/off Button	1
K0/18/..	Midi jet wall fitting, spacer, eyeball and cover	6
<b>FREEBEE/1</b>	<b>COMPLIMENTARY PACK OF CLEANSERS &amp; AROMATHERAPY</b>	<b>1</b>
<b>K/ASSY/007</b>	<b>COMPLIMENTARY PACK OF SELF FIT KIT TOOLS</b>	<b>1</b>
I/725-400	Weld on Wet-R-Dry 725 solvent cement 250ml	1
RO/58129	12 piece holesaw set (.825-2.5inch) including arbours	1
X/BBDM103	Disposable mask set (50 pc)	1
X/BBSG102	Goggles / soft vinyl cover / non fogging	1
X/BBTM236	Hi glow power tape measure	1
S/SILICONE/DOW785	Dow corning 785 silicone sealant	1
K/SFKTOOL	Pegasus fitting tool	1

# Pegasus self fit whirlpool kit fitting instructions for 6/8 jet (retro venturi)

## PACKING LIST - PEGASUS MIDI EIGHT

5/2/03

<b>K/ASSY/002A</b>	<b>STANDARD AP45 PUMP DELIVERY PACK (MIDI 6/8 JET)</b>	1
K0/13/1-STOPEND	Stopend / 1"	1
K0/16/40	Pump profile clamp / AP45	1
K0/16/41	Pump coupling flange / ABS / 33.5mm ID (1")	1
K0/16/43	Rubber pump washer 57mm OD x 44.5mm ID x 1mm	1
K0/20/2	Manifold / 4-Branch / 12mm OD / Multi C type	2
<b>K/ASSY/003</b>	<b>STANDARD PUMP TO SIDEWALL SUCTION PACK</b>	1
K0/12/10	Suction elbow / 1.25" with drain elbow	1
K0/12/21	Wall fitting for suction elbow (drilled)	1
K0/13/1.25-45	Elbow / 1.25" / 45 degree	1
K0/13/1.25-90	Elbow / 1.25" / 90 degree	1
K0/16/40	Pump profile clamp / AP45	1
K0/16/42	Pump coupling flange / ABS / suction / 1.25"	1
K0/16/43	Rubber pump washer 57mm OD x 44.5mm ID x 1mm	1
<b>K/ASSY/004A</b>	<b>SUB PACK - 12.5mm AIR MANIFOLD (MIDI 6/8JET)</b>	1
K0/13/1-STOPEND	Stopend / 1"	1
K0/13/AIRCTLADAPTOR	Adaptor / Multipoint control to manifold	1
K0/20/2	Manifold / 4-Branch / 12mm OD / Multi C	2
<b>K/ASSY/005</b>	<b>ASSEMBLY - PNEUMATIC SYSTEMS, ACRYLIC BATHS</b>	1
K0/16/01	Pegasus hi-flow pump - 45 GPM	1
K0/16/11	PUMP STAND BAR	1
K0/13/1.25-PVCPIPE	LENGTH OF SUCTION PIPE 1.25"	1
AW/TUBE/80D	METRE 8mm OD NYLON TUBE	1.5
R/CT1816	METRE LENGTH OF 1/8" PNEUMATIC TUBE FOR ON/OFF	1
<b>K/ASSY/006</b>	<b>ASSEMBLY - STANDARD PUMP FIXING</b>	1
K0/16/12	Pump height adjust threaded bar M10 STUD x 150m ZN	1
K0/16/13	Pump mounting plate	1
K0/16/15	Pump support foot (bath leg) M8 x 180	1
K0/16/24	M6 x 20 Hex bolts for securing pump to stand	4
K0/16/25	M6 nut for fixing pump to pump	4
K0/16/26	M6 plain washer ZN Plated	4
K0/16/27	M6 shake proof washer for pump	4
K0/16/23	M8 nuts for pump support	2
K0/16/28	M10 nuts for pump fixing	4
SC/7605	Quicksilver countersunk woodscrew 1.5" x 8	5
SC/7796	200 mm x 4.5 mm cable ties	12
<b>K/ASSY/008</b>	<b>ASSEMBLY - PEGASUS MIDI VENTURI 6 JET</b>	1
K0/10/C	Pegasus Midi venturi body	6
K0/10/D	Make-up washer, pegasus venturi	6
K0/10/E	O' ring seal for pegasus venturi	6
<b>K/ASSY/008A</b>	<b>SUB PACK - PEGASUS MIDI VENTURI</b>	1
K0/10/C	Pegasus Midi venturi body	2
K0/10/D	Make-up washer, pegasus venturi	2
K0/10/E	O' ring seal for pegasus venturi	2
<b>R/CLT1225M/15/YELLOW</b>	<b>15M ROLL OF CANARY YELLOW 12.5mm TUBE</b>	1.5
<b>K0/.../...</b>	<b>COLOUR SET</b>	1
K0/12/..	Suction cover	1
K0/14/..	Air control	1
K0/17/..	Pneumatic On/off Button	1
K0/18/..	Midi jet wall fitting, spacer, eyeball and cover	8
<b>FREEBEE/1</b>	<b>COMPLIMENTARY PACK OF CLEANSERS &amp; AROMATHERAPY</b>	1
<b>K/ASSY/007</b>	<b>COMPLIMENTARY PACK OF SELF FIT KIT TOOLS</b>	1
I/725-400	Weld on Wet-R-Dry 725 solvent cement 250ml	1
RO/58129	12 piece holesaw set (.825-2.5inch) including arbours	1
X/BBDM103	Disposable mask set (50 pc)	1
X/BBSG102	Goggles / soft vynil cover / non fogging	1
X/BBTM236	Hi glow power tape measure	1
S/SILICONE/DOW785	Dow corning 785 silicone sealant	1
K/SFKTOOL	Pegasus fitting tool	1