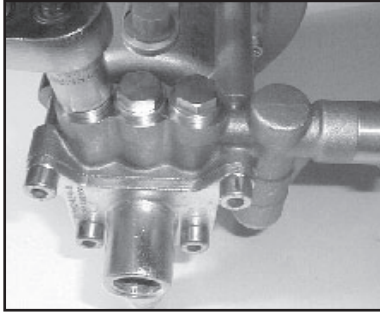
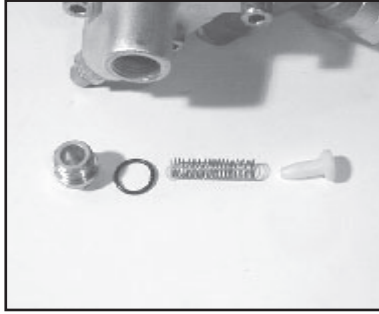


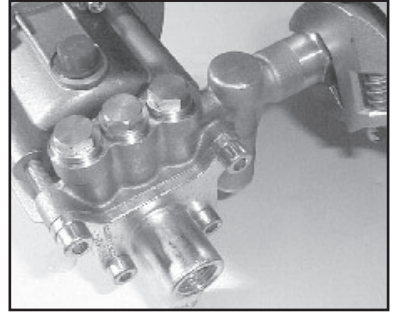
REPAIR INSTRUCTIONS - GXR2525



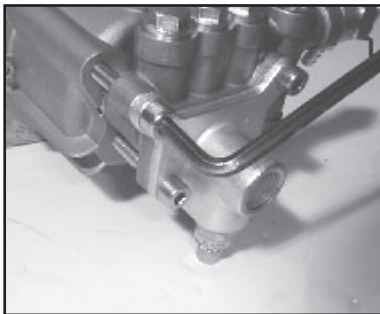
1. With a 14mm socket wrench, remove the three discharge valve plugs (22). Inspect the valve plug o-rings (23) for wear, and replace as necessary.



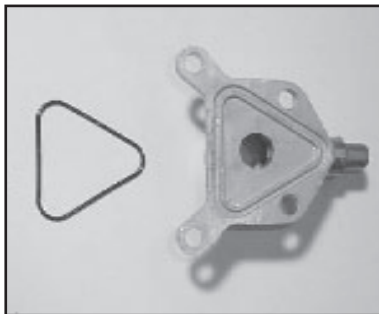
2. Remove the valve spring (18) and valve cone (36) from the manifold (35). Inspect the parts for wear and replace as necessary.



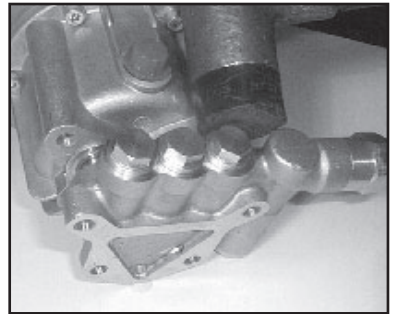
3. With a crescent wrench, remove the injector retainer (47). Inspect the o-ring (46) for wear and replace as necessary.



4. Next, remove the four manifold bolts (40) with a 6mm allen wrench.

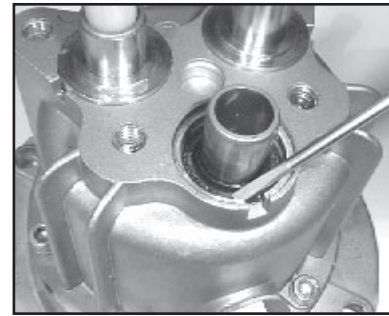
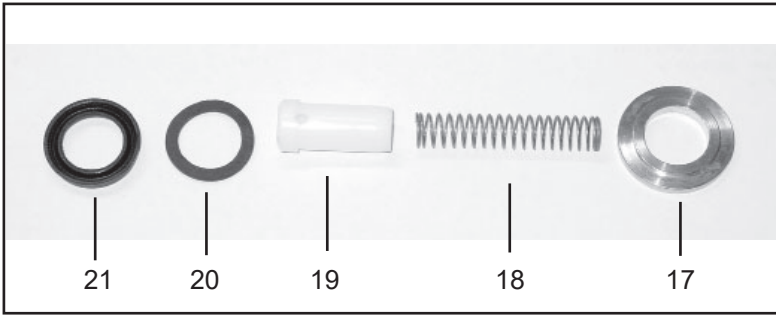


5. Remove the suction flange (39) and flange o-ring (38). Inspect the o-ring for wear and replace as necessary.



6. Tap the back of the manifold (35) with a rubber mallet to dislodge, and slide off the plungers. (8). Take note of the position of the discharge port so as to place the manifold in the same position during reassembly.

REPAIR INSTRUCTIONS - GXR2525



7. Remove the guided p-valve, (19), valve springs (18), v-sleeves (21) and pressure rings (20). Inspect for wear and replace as necessary. Remove the spacer ring (17) from the plungers (8).
8. If the crankcase oil seals (15) are to be replaced, they can be removed by prying loose with a screwdriver. Take care not to make contact with the plunger (8) and pry out the oil seals from their housing.
9. Reassemble in reverse order. Fill the crankcase with 4.1 fluid ounces (121 mL) of oil. The pump is now ready for operation.

For maintenance of the gear end of your pump, contact your local distributor or Giant Industries at: 419/531-4600

**NOTE: Contact Giant Industries for Service School Information.
Phone: (419)-531-4600**

GX and HR Pump Part Numbering System

GX or HR Series	Flow	Pressure (in 100 psi increments)		Injector Size	Thermal Relief Valve	Wobble Plate Shaft Bore
Vertical	20=GPM	25=2500 PSI		1=2.1mm	1=1/2"	2=7/8"
Horizontal	23=GPM			2=1.8mm		1=3/4"
	25=GPM			3=2.3mm		3=1"
						4=5/8"
GX or HR	2.5	25	-	1	1	1

For example, a GXV2525-112 is a GX pump that produces 2.5 GPM @ 2500 PSI, has a injector with a 2.1mm Oriface, 1/2" thermal relief valve and 7/8" wobble plate bore.