

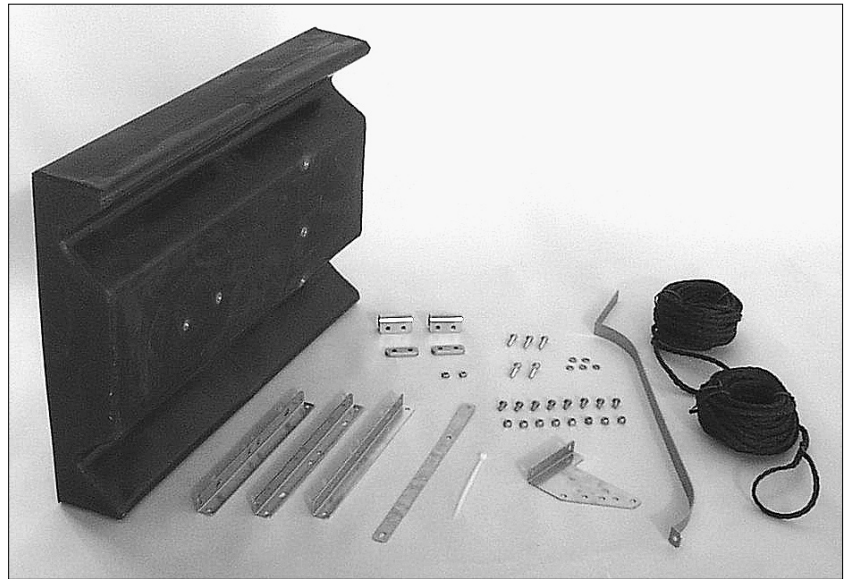


# Assembly Instructions for Kasco Horizontal Float Assembly

## Parts Included:

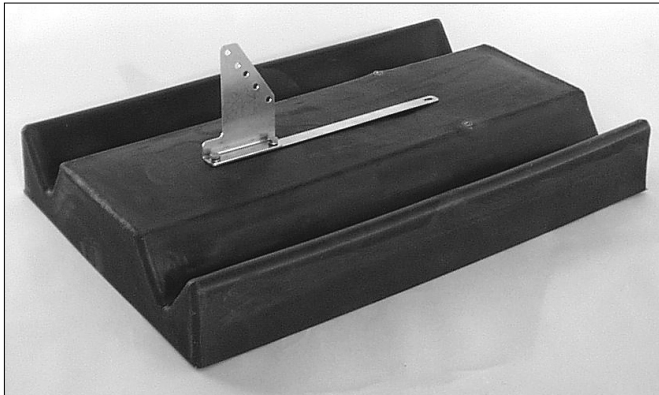
1. Float (1)
2. HF Base Strap (1)
3. HF Adjustment Bracket (1)
4. HF Angle Bracket (3)
5. HF Draw Band (1)
6. HF U-Bracket (2)
7. HF Spacer Bracket (2)
8. 1/4" x 1/2" Stainless Steel Bolt (8)
9. 1/4" x 1" Stainless Steel Bolt (3)
10. 1/4" x 1-1/4" Stainless Steel Bolt (2)
11. 1/4" Stainless Steel Lock Nut (8)
12. 1/4" Stainless Steel Hex Nut (2)
13. 1/4" Stainless Steel Lock Washer (5)
14. Nylon Tie (1)
15. 50' Black Ropes (2)

**Warning:** Keep Kasco motor unit disconnected from power source through the entire assembly procedure.

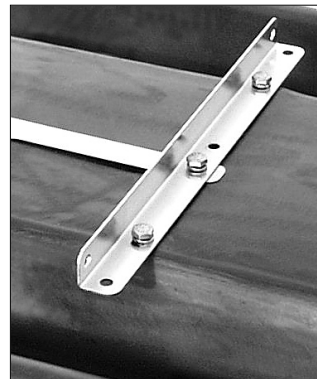


## Step One:

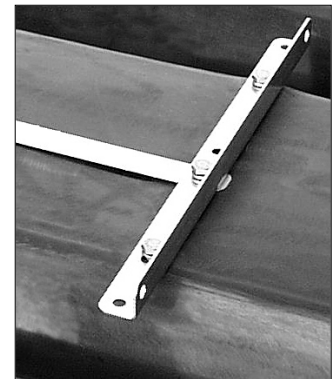
Position the float upside-down (lengthwise channels facing up) and place the base strap so that the three holes in the strap align with the three threaded holes that comprise the lengthwise midline of the float.



and three stainless steel lock washers. (See photos below for specific instructions based on the circulator model.) Tighten all hardware.



Models F2400 & F3400 –  
Angle posterior to bolts.



Model 8400 – Angle  
anterior to bolts.

## Step Two:

Position the adjustment bracket over the two holes at the back end of the float and base strap. Loosely secure the adjustment bracket to the float using two 1/4" x 1/2" stainless steel bolts and two stainless steel lock washers. (See photo above for orientation.)

## Step Three:

Place one of the three angle brackets perpendicular to the base strap at the front end of the base strap. One of the two center holes of the angle bracket should be positioned over the hole in the base strap and the threaded hole in the float. Secure the angle bracket to the float using three 1/4" x 1/2" stainless steel bolts

## Step Four:

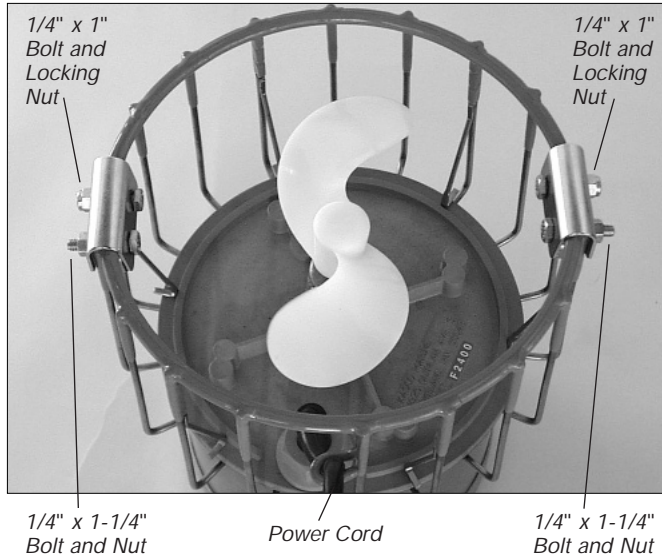
With a felt-tip marker, draw three to four marks around the circumference of the motor housing at the appropriate measurement from the back (or bottom) of the motor housing given below:

- Model F2400: 3/4"
- Model F3400: 3-3/8"
- Model 8400: 3-1/4"



**Step Five:**

Place the two U-brackets directly across from each other (180°) over the top ring of the motor cage. The cord clamp on the cage should be 90° from each of the U-brackets.



**Step Eight:**

Wrap the draw band around the motor housing and position so that the back of the draw band touches the marks drawn in the previous step. There is no front or back to the draw band – it is reversible. Orient the arm of the draw band so it aligns with the cord clamp on the cage of the motor housing and is parallel to the angle brackets attached in step seven. Secure using a 1/4" x 1" stainless steel bolt and a 1/4" lock nut.



**Step Nine:**

Attach the angle brackets on the motor to the angle bracket on the float using two 1/4" x 1/2" bolts and two 1/4" lock nuts (one set for each bracket). See photos for orientation based on model. Also, the cord clamp on the cage should be oriented towards the float.

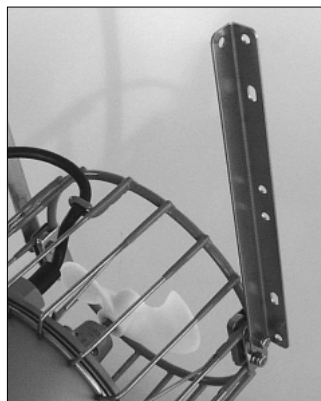
**Step Six:**

Insert the spacer bracket under the U-bracket and inside the cage. Secure this assembly using one 1/4" x 1" bolt and a 1/4" lock nut, and one 1/4" x 1-1/4" bolt and a 1/4" hex nut. The longer bolt should be on the side of the U-bracket that is closer to the cord clamp. Tighten the hardware until the U-brackets clamp firmly around the cage (U-bracket should pull together slightly).

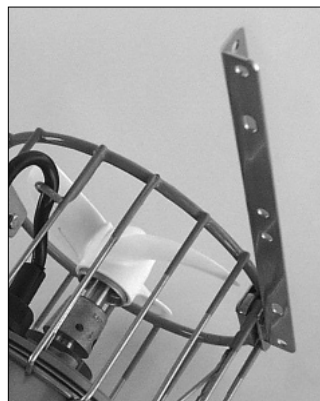


**Step Seven:**

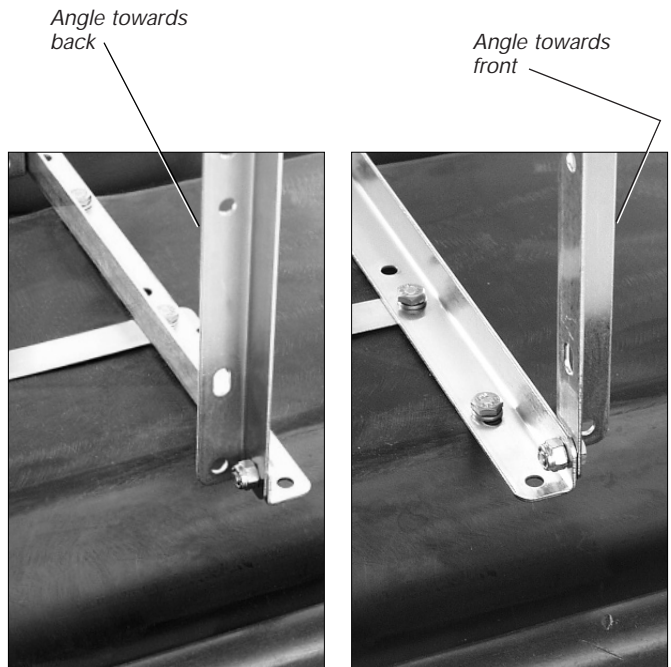
Attach an angle bracket to each of the longer (1-1/4") bolts on the U-brackets (see photo for orientation) with a 1/4" lock nut.



Models F2400 & F3400



Model 8400



Models F2400 & F3400

Model 8400



**Step Ten:**

Attach the draw band on the motor to the adjustment bracket on the float using a 1/4" x 1/2" bolt and a 1/4" lock nut. Select one of five possible positions to mount the draw band for your preferred direction of flow (three are pictured). We do not recommend the two outer (most upward and most downward) mounting positions for the 8400.



Horizontal



Angled up



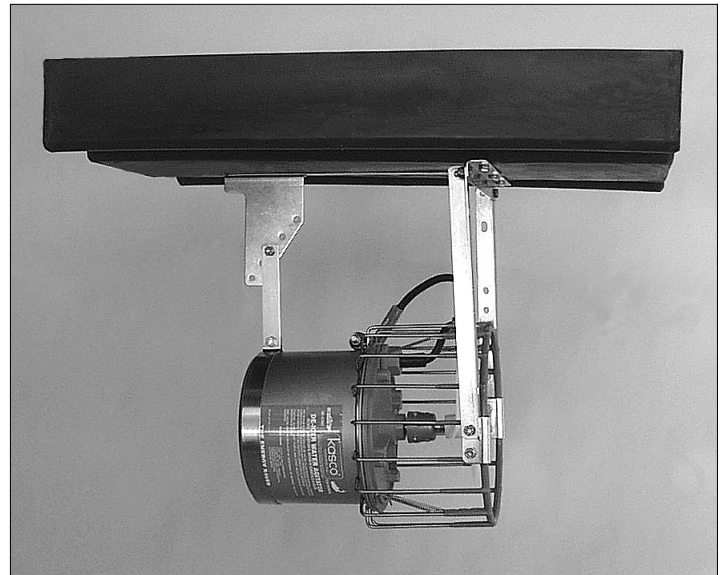
Angled down

**Step Eleven:**

Attach the ropes to the front (on the cage) and back (around the draw band) of the motor.



*Your Kasco Horizontal Circulator is now ready to be installed.*



*Thank you for purchasing from Kasco!*



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