USER INSTRUCTIONS
The Pegasus Whirlpool system has been designed to be able to fit 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 manufacturers 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.

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 bar to the bath, base-board of bath be sure to check the length of the screws. The screws supplied are for 3/4” thick encapsulated baseboards.

BASIC OUTLINE OF FITTING PROCEDURE
1. Check the bath for damage and defects.
2. Fixing the legs and the pump to the bath.
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 pipework 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 glue is only applied to the external surfaces of the components - Not to the inside of the pipe or venturi. Ensure pipes are connected to the correct manifolds.

Please Note: When gluing the rigid suction pipe, joints can be glued on both surfaces to ensure adhesion.

Please Note: The supplied suction pipe has been supplied with one end pre-swaged. This is to facilitate gluing over the plain suction elbow.

8. Watertest the finished product before final installation.

Please Note: 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 or Wurth Solvent Cement.
2. MEK Solvent cleaner
3. Dow Corning 785 White silicone

TOOLS REQUIRED
You will require hole-saws of 27mm and 44mm, (may be purchased separately), along with a power drill, a silicone gun, a tape measure and a Phillips head screwdriver. We supply in the kit a tube of silicone sealant and a tub of Solvent Weld.

Please Note: If you use our hole saw kit to drill the holes for the jets, you will need to use the 1” hole saw and carefully enlarge the holes with a file to accomodate the jet.

Hole sizes are – 27mm for the Jets, and 44mm for the Suction and Controls.

DETAILED FITTING INSTRUCTIONS
1. Checking the bath for damage - before drilling!
   a) Carefully remove the manufacturer’s wrapping and any cautionary labels from the bath.
   b) Corners not cracked or broken.
   c) Check that the lip of the bath has been cut cleanly and is not chipped.
   d) 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.
   e) Check that the waste hole is central in the recess.
   f) Check that the tap-holes are correct.
   g) Check that the bath is true and not warped.
   h) Check that all the legs and fixing brackets are present - including screws.

2. Fixing the legs and the pump to the bath.
   a) Read through the manufacturers installation instructions for the bath
   b) 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.
   c) Assemble the threaded bar to the Pump Mounting Plate and Pump bar using the nuts provided.
   d) Glue and assemble the pump outlet manifold which comprises of three 4 branch manifolds, 2 stop-ends, a pump Tee and an “O” ring seal. Care should be taken to ensure the “O” ring is seated correctly in the groove under the pump Tee before it is screwed onto the pump outlet. Two of the 4 branch manifolds will have stop-ends glued in them, then glue them into the pump Tee once the pump is correctly located on the bath. Glue both the male and female parts of all joints to be made. Now fit the suction union to the inlet of the pump, ensuring the “O” ring is seated correctly as before. When gluing pipes to the manifolds, ensure you glue only the manifolds, being careful not to block them with glue.

Please Note: On a 10 jet system you will need to ‘loop’ out two of the spigots on the water and air manifolds. (See Fig. 16).
f) 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's and any wooden panels which may be subsequently fitted to the bath.

g) Secure the pump and bar to the bath using the five screws provided.

Important Note: The screws have been designed to secure the pump-stand 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.

Important Note: Under no circumstances attempt to fit the Pumpstand to a bath manufactured from GRP - GRP Baths do not have baseboards.

Hint: 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.

3. Position the jets, suction and controls.
   a) The number of jets to be fitted and the shape of the bath will usually determine the jet positions.

   b) Jets are normally equally spaced along each side of the bath but can be fitted on any flat surface. 10 and 12 jet systems are usually fitted with back jets and feet jets. These jets can be positioned lower in the bath than the side jets. Back jets are usually positioned as low as possible.

   c) 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.

   d) The suction is best fitted toward the pump, fixing battens, etc. will not obstruct the plain suction elbow, what we are looking for is a slight, gentle angle from the pump to the elbow, this ensures that water flows downhill as the bath is emptied, into the elbow and out. If the pump is too high, it will not prime and if it is too low, it will not drain the water.

   i) Mark all the positions with a felt-tip pen, possible on a flat surface. (See Fig. 05).

   g) The centre line of the jets should be 55-60 mm. above the centre line of the suction. (See Fig. 05).

   h) Note that the water level will need to be some 35mm. above the centre line of the jets. Check that the water level will be below the overflow. (See Fig. 05).

   i) Position the on/off button and air control should be fitted to the top surface of the bath.

   b) 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.

5. Position the controls.
   a) The on/off button and air control should be fitted to the top surface of the bath.

   b) Check that there is enough space underneath the proposed location of the On/Off and Air Control for the back-nut and air manifold to seat properly on the underside of the bath. Remember that the air hose is to be connected to the manifold. Glue the manifold spigot only, making sure not to block the hole with glue. (See Fig. 06).

   Important Note: Always allow for access to the controls, especially the On/Off control.

6. Drill the holes.
   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 the correct size hole cutter, drill the jet and suction holes from the front of the bath. Always drill away from your body, if this is not possible, a body shield must be used. Drill slowly and carefully, taking care not to let the drill slip and ensuring the correct size hole-saw is being used. Once all the holes are drilled, go round each one with a file and remove any burrs that may have been left by the drilling process. Wipe off any excess pen marks and dust using a Meths moistened piece of tissue.

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

c) Back file the holes with a small round hand-file 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 siliconing the wall fittings to the bath!

7. Install the whirlpool fittings onto the bath.
   a) The clearwater fixing tool and the 8mm allen key are now required to install the fittings to the side of the bath.

   b) Apply a band of silicone sealant around the wall fitting shoulder of the venturi and the wall fitting, (See Fig. 13).

   c) Using the allen key, fit the Venturi to the bath with the pipes at 45 degrees approximately above horizontal pointing towards the pump.

   Important Note: Do not overtighten as damage to the Venturi could result.

   d) Repeat the above operation for the remaining wall fittings and clean off any excess silicone sealant.

   Please Note: The wall fitting with two holes in the face is the suction wall fitting.

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 clearwater fixing tool, assemble the suction fitting. (See Fig. 08).
b) Measure and cut to length the suction pipe and glue to the suction elbow and pump elbow using a recommended adhesive. You may heat the pipe with a heat gun if necessary in order to achieve a specific bend. Make sure this is done away from the bath. Do NOT leave the heat gun focused on one area for too long, or scorching may occur, and run the risk of completely melting the pipe. Note that with the supplied rigid suction pipe, one end is pre swaged in order to fit and glue over the plain suction elbow.

9. Connect the pipework to the 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, gluing around the spigot only, using a recommended adhesive.

Important Note: Only glue the exterior of the venturi - not inside the pipe!

b) Hose should be taut but not stretched and with a fall either to Venturi or pump without sagging. (See Fig. 11).

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

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

11. Connect on/off button to pump.
b) Push 3mm bore clear hose onto button and to switch in terminal box on top of pump.

Important Note: Do not allow pump to run without water in the bath as costly damage may occur.

12. Fit the jet covers.
a) Push the jet covers onto the venturi.

Please Note: You may need to file the ridges on the spigot if you find them difficult to fit.

13. 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.

14. 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 the bath, 50mm. above floorboard level to prevent ingress of water should flooding or water leaks occur. (See Fig. 03).

Important Note: Complete instruction 10 before switching on mains supply.

SUPPLEMENTARY NOTES
1. When fitting a 10 jet system simply glue a loop of pipe between the two unused branches. This can be cut off should you wish to upgrade your system to a 12 jet.

2. Most baths nowadays are moulded from Acrylic which is then back sprayed with chopped strands of GRP. 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 you are not sure ring us before fixing.

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

Important Note: Do not allow silicone sealant to come into contact with the gold plating.
Pegasus self fit whirlpool kit fitting instructions for 10/12 jet (retro venturi)

TECHNICAL DIAGRAMS

**Fig. 04**
- Bath overflow
- Water manifold
- Air manifold
- Suction elbow
- Suction 1.5 inch rigid pipe

**Fig. 05**
- Water level
- Overflow
- Jets must be on a flat surface
- 55mm centre to centre
- Position the suction as low as possible
- 2mm max gap

**Fig. 06**
- Ensure that manifold & back nut will seat
- WALL FITTING
- AIR CONTROL KNOB
- SEALANT
- MAKE UP WASHER
- Air Manifolds
- Stopend
- SEALANT
- BUTTON
- BACKNUT
- 3MM BORE CLEAR PIPE

**Fig. 07**
- Bath
- Sealant
- 4mm dia hole
- Suction wall fitting
- Suction cover screws

**Fig. 08**
- Suction elbow
- Suction cover
Pegasus self fit whirlpool kit fitting instructions for 10/12 jet (retro venturi)

INSTRUCTIONAL DIAGRAMS

Above: The finished pipework should look like this - note the constant downward slope and the use of the cable ties.

Left: Note the direction of the air and water manifolds.

Below right: It is usually easier to push the wall fitting through the bath and screw the venturi on from the back.

Bottom right: Finally, gently tighten the fitting with an allen key.

Bottom Left: Silicone both surfaces of the venturi before fixing to bath.
INSTRUCTIONAL DIAGRAMS

Above: Note the method of blanking

**Micro-jet holesaw sizes:**
- Suction: 1 3/4”
- Controls: 1 3/4”
- Jets: 1”

Above: Note the bottom two spigots of the air manifold should always feed the back jets to ensure the air manifold drains after use!

Above: Always glue the manifold not the pipe - Take care not to block any spigots with glue - especially when glueing the stopend

Above: The design of the Pegasus system will always allow jets to be placed unobstructed in the back