

Jet Body Removal and Replacement Procedure

Tools required:

#2 Phillips
screwdriver



1/8" slotted
screwdriver



5/16"
slotted
Screwdriver



Pliers



Hack
saw



Garden
hose



Materials required:

Sand
Paper
#200



Clean
Rags



PVC
Glue
Rigid to
Flex



PVC
Glue
Rigid to
Rigid





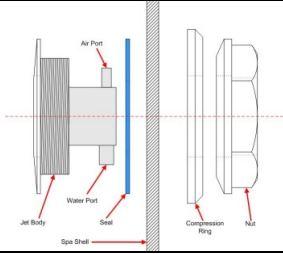
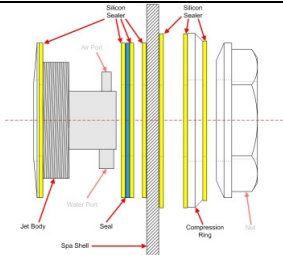
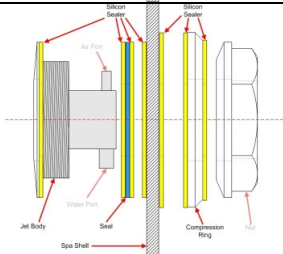
Primer
For Rigid to
Rigid only




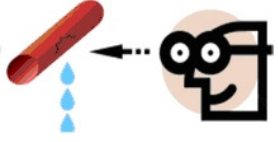


This is a general procedure on repairing a jet body. Before you begin, read and understand all steps of the procedure before beginning so as to familiarize yourself with what is required. Use common sense and always work safe. There is a separate procedure for repairing generic plumbing problems available on the website.

1	<p>Turn electrical power off to your spa by turning off its GFCI breaker.</p> <p>Note: It is recommended that you lock this GFCI breaker box so that no one can accidentally turn the power back on while you are working.</p>	
2	<p>Behind trim buttons¹ there are eight #2 Phillips screws holding this panel on: 3 on the left trim piece, 3 on the right trim piece, and 2 on the bottom. Remove the trim pieces and then the bottom screws. As you remove the bottom screws, this panel will fall. Lift the panel out of the way and store all parts in a safe place.</p> <p>CAUTION: This panel weighs at least 10 pounds and will fall down to the ground as the bottom screws are removed. Keep your feet clear of the bottom of the panel and be prepared for this to happen.</p>	

¹ Some spas do not use trim buttons to cover the screws.

3	<p>Unplug the black spa pack power cord from its receptacle in the grey box.</p>	
4	<p>Remove the access panel to the problematic jet body for your spa. Store the hardware in a safe place.</p>	
5	<p>Drain the spa completely. To do this:</p> <ul style="list-style-type: none"> • Remove the protective cap from the drain bib • Connect a garden hose to the drain bib fitting • Put the other end of the hose downhill from the drain • Open the drain bib by turning the outer ring counter-clockwise • Pull out on the drain bib to fully open the drain • Allow the water level to drain down completely 	
6	<p>Each jet body consists of several pieces: the hose clamps, jet body, seal, compression ring, and nut. To remove the old jet body, mark the current position of the air and water ports on the spa with a pen (used later in step 9 to properly align the replacement jet body). Remove air and water lines (hose clamps), remove the glue surrounding the nut, and then remove the nut. The jet body will pull out from the bathing side of the spa.</p>	
7	<p>Remove all remaining glue from around the hole on both the inside and the outside of the spa shell.</p>	
8	<p>Apply a liberal layer of waterproof silicon sealer to the clean surfaces at the locations shown in yellow in the drawing to the right.</p>	
9	<p>Assemble the jet body with the air port at the top as shown in the above drawing aligned with the pen marks you made in step 6 on the side of the spa. Tighten the nut until snug (do not over tighten). Allow at least two hours for the silicon sealer to properly dry (preferably overnight).</p>	
10	<p>Reconnect the air and water lines to the jet. Make sure that the tubing is all the way on the ports and secured in place with the clamps removed in step 6.</p>	

11	<p>Make sure that the drain valve is closed and fill the spa with cold tap water through the filter area so the water level is just below the pillows and at least 1/4" above all jets.</p>	
12	<p>Plug in the spa pack.</p>	
13	<p>Turn power back on to the spa by turning on the GFCI breaker. Test the blower for normal operation.</p>	
14	<p>Turn all pumps on high, wait at least one hour, and check again for leaks. If a leak is found, turn off the GFCI breaker and repair as needed.</p> <p>Once you are convinced that there are no leaks, proceed to the next step.</p>	
15	<p>Replace the silver insulation and the panel(s). Replace the trim buttons over the screws (if present).</p> <p>Note: It is safest to have two people install these panels: one holding the panel in place while the other puts in the screws.</p>	