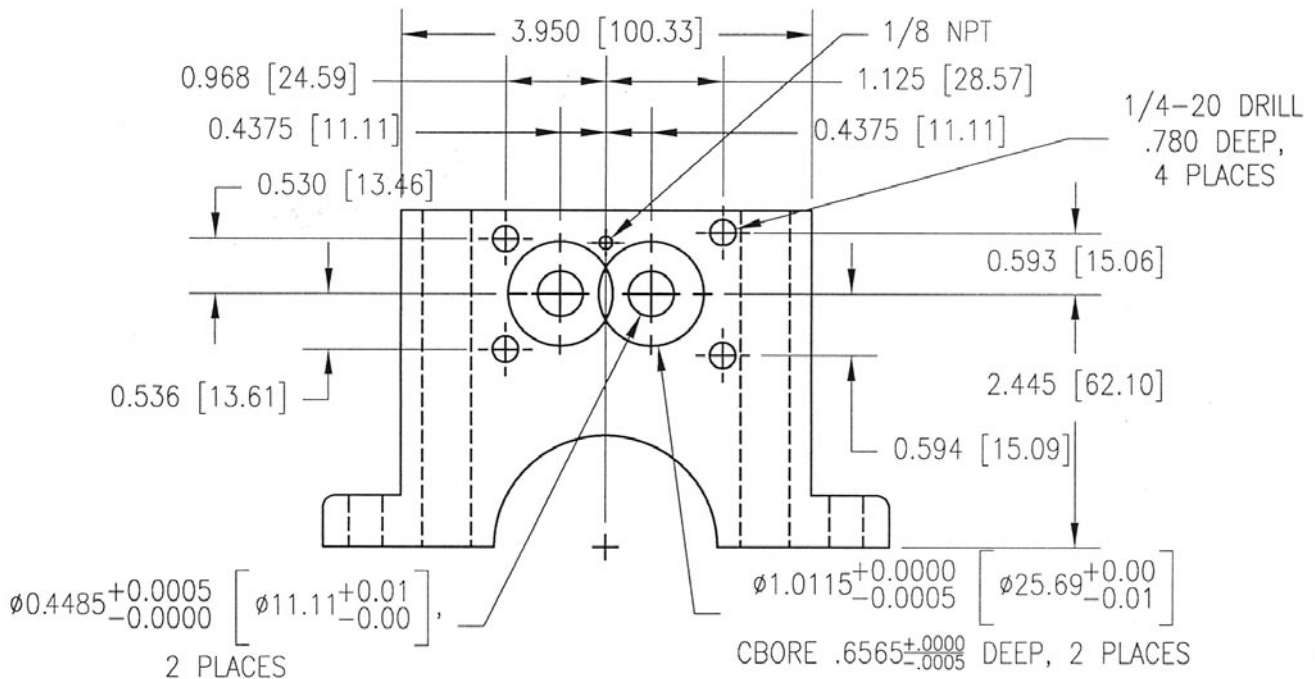


- 1) Remove the small roll-pin which secures the large forged drive gear from the oil pump drive gear shaft and tap the large forged gear from the shaft.
- 2) Remove the 4 back plate retaining screws and remove the back plate and the oil pump gears and shafts.
- 3) Mill the inside face of the back plate if it has wear marks from the oil pump gears.
- 4) Re-machine the oil pump gear cavities to the new diameter and depth as shown on the attached shop drawing.
- 5) Reassemble pump using new gears and the gasket with a nominal thickness of .005".

NOTE 1: If the hub of the gear rubs against the front of the back plate, remove it and file a small amount of material from the hub of the gear to provide .002" to .003" clearance between the hub of the drive gear and the back-plate.

NOTE 2: If the pump does not turn freely after reassembly, use the gasket with a nominal thickness of .009".

Kit contents: (1) set of new oil pump gears, (1) gasket .005, (1) gasket .009, (2) roll pins.



REAR MAIN BEARING CAP W/OIL PUMP
FRONT VIEW: