

Figure 3-20. Hose Clamp Connection

gear key (7) and idler gear (6). Loosen relief valve plug (15) and check valve spring cover screw (16). Remove two oil pump body mounting stud nuts (9) and slip pump body (10) off studs and gear drive shaft (11). Remove drive gear (12), key (13) and idler gear (14).

Turn ratiof valve plog (15) put of pump body and remove ratiof valve spring (16) and valve (17). Remove check valve spring sover screw (18), valve spring (19) and ball (20). Turn in adjusting screw (21). Count the turns necessary to bottom screw, then remove. Bottom and turn out same number of turns when assembling Oil pump elbows (22) may be turned out of pump cover to facilitate cleaning.

To namove all pump unit from gearcise with gearcise cover removed, remove ignition timer parts, gearcise cover screws, cover and pasket. (See "Gearcise Timing Gears.") Use a right angle lock ring pilets to remove lock ring from groove in pump drive gear shaft and remove africe gear and key. Remove pump body nuts and bolts (2 and 5) and slip pump with drive shaft (11) out of gearcase. Pump is then discountiled as above.

#### CLEANING AND INSPECTING

Thoroughly clean all perts in cleaning solvent and blow pump body passages clear with compressed air. Inspect valves and valve seats for pitting and wear. Replace pump having worn or damaged valve seat. Inspect keys and keyways. Inspect scavenger and feed pump gear treth for gouging or cracking caused by foreign meterials going through pump. Pump shafts and bushings normally last for lifetime of engine.

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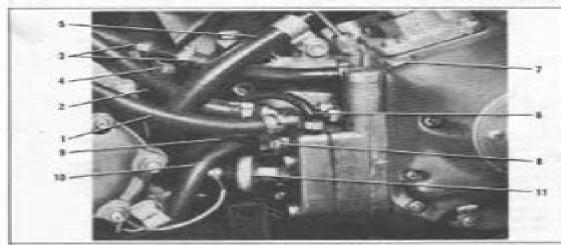
Oil pump is assembled in reverse order of disassembly. Do not mix gears and keys — retain to correct location. Oil pump gaskets should always be replaced. Use only "factory made" gaskets. Lock rings are often damaged when removing them. It is advisable to install a new lock ring using a lock ring pliers when assembling pump. Make sure ring is engaged and seated in retaining groove.

If pump is assembled with plastic gaskets, botts and nuts must be drawn down evenly to approximately 45 inibs, but no more than 50 in-ibs torque (4 to 5 ft-ibs). If pump is assembled with paper gaskets, tighten botts and nuts to 90-100 in-ibs torque.

This is important because the oil pump cover gasket and body gasket if overtightened, will be squeazed out of place and eliminate pump gear side clearance which may seize and damage the pump parts.

If leakage problem exists, disassemble pump and inspect all gasket surfaces making sure they are flat and smooth. Install new gaskets and reassemble pump, tightening four bolts and two nuts as specified.

Oil hose connections have one piece band type clamps and must be replaced each time hoses are connected. Use Hose



- 1. Oil supply line from tank
- 2. Oil return line to tank
- 3. Vent line to oil tank
- 4. Vent line to chain housing
- 5. Crankovse breather hose
- 6. Front chain offer line to chain housing
- 7. Tappet oil screen plug
- 8. Repr chain oiler adjusting
- 9. Rear chain oiler line
- 10. Chain housing return line
- 11. Oil pressure switch

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