

Figure 3-20. Hose Clamp Connection

gear key (7) and idler gear (8). 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 relief valve plug (15) out of pump body and remove relief valve spring (16) and valve (17). Remove check valve spring cover 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 remove oil pump unit from gearcase with gearcase cover removed, remove ignition timer parts, gearcase cover screws, cover and gasket. (See "Gearcase Timing Gears.") Use a right angle lock ring pliers to remove lock ring from groove in pump drive gear shaft and remove drive gear and key. Remove pump body nuts and bolts (2 and 9) and slip pump with drive shaft (11) out of gearcase. Pump is then disassembled as above.

CLEANING AND INSPECTING

Thoroughly clean all parts 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 teeth for gouging or cracking caused by foreign materials going through pump. Pump shafts and bushings normally last for lifetime of engine.

ASSEMBLING

Oil pump is assembled in reverse order of disassembly. Do not mix gears and keys — return 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, bolts and nuts must be drawn down evenly to approximately 45 in-lbs, but no more than 50 in-lbs torque (4 to 5 ft-lbs). If pump is assembled with paper gaskets, tighten bolts and nuts to 90-100 in-lbs torque.

This is important because the oil pump cover gasket and body gasket if overtightened, will be squeezed 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

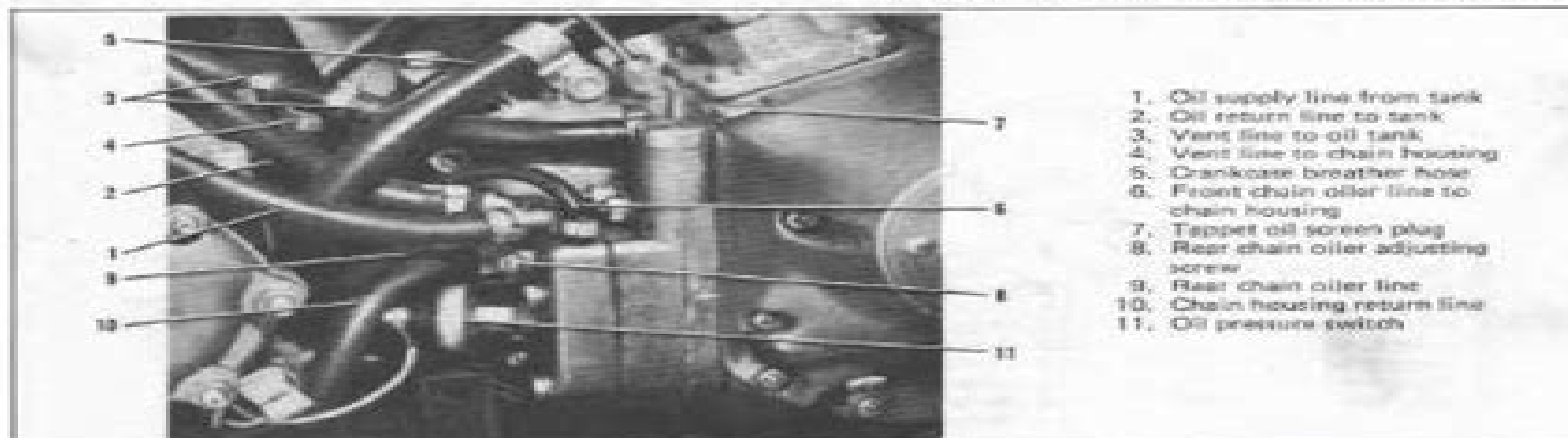


Figure 3-21. Oil Pump and Connecting Lines

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**Curt Choate, Tom Schauwecker, John
Harold Haynes**



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