



# OBSELETE PERFORMANCE ASSEMBLY SOLUTIONS

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<b>Operation Number:</b> 30A <b>Description:</b> Engine Assembly Procedure	<b>Prepared By:</b> Quality <b>Approved by:</b> Manufacturing
<b>Revision Date:</b> 02/11/03 <b>Revision Level:</b> 07	<b>Issue Date:</b> 12/05/02 <b>Issued by:</b> Quality
<b>Document Number:</b> PAS-WI-IMC-112002-6A	<b>Document Tier:</b> 3
<b>Title: Oil Pump Installation</b>	

## OIL PUMP INSTALLATION




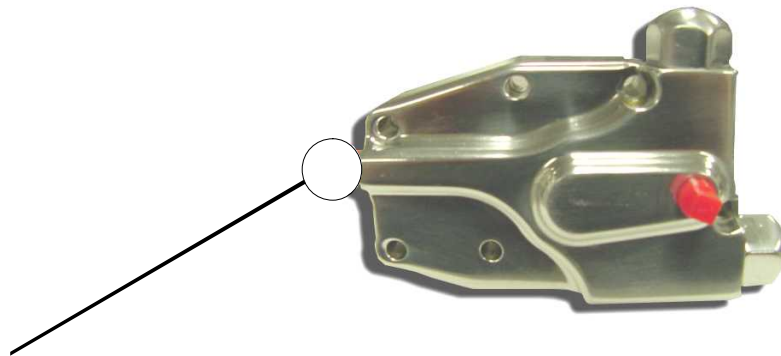
1. Inspect all components for scratches, dents, dirt, oil, debris, etc.
2. Record Oil Pump (PN01-243) Serial Number on the Assembly Traveler.
3. Remove the red plugs from the oil pump. Set these aside to be used in subsequent operations.
4. Install oil pump gasket (PN01-262) onto the oil pump.





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5. Carefully insert the oil pump and gasket into the oil pump feature on the case. You may have to adjust (rotate) the crank assembly in order to seat the pump correctly.
6. Apply a small amount of blue thread lock to six (6)  $\frac{1}{4}$  - 20 x 1  $\frac{3}{4}$  inch socket head screws, and using Tool # I-09, torque to 8-12 foot pounds. 
7.  Verify there is no binding or interference once the pump is installed.
8.  Carefully insert the oil pump and gasket into the oil pump receiver on the case. You may have to adjust the crank assembly slightly in order to seat the pump.



9. Install the brass fitting (PN01-262) onto the oil pump.
10. Lubricate the O-Ring with silicone and insert the tappet screen plug and O-Ring and torque at 8-12 ft lbs.  Ensure that the O-Ring is not extruded beneath the head of the plug.
11. Lubricate O-Ring with silicone. Install timing plug and O-Ring and torque at 8-12 ft lbs.  Ensure that the O-Ring is not extruded beneath the head of the plug.
12. Insert hose fitting in the rear of the case. Snug and orientate as shown on visual aides provided by the customer.  REFER TO VISUAL AID FOR PLUG ANGLE AND ORIENTATION!
13. Complete all relative portions of the assembly traveler.



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