

Fig. 8 - Inlet Pipe and Screen Mounting

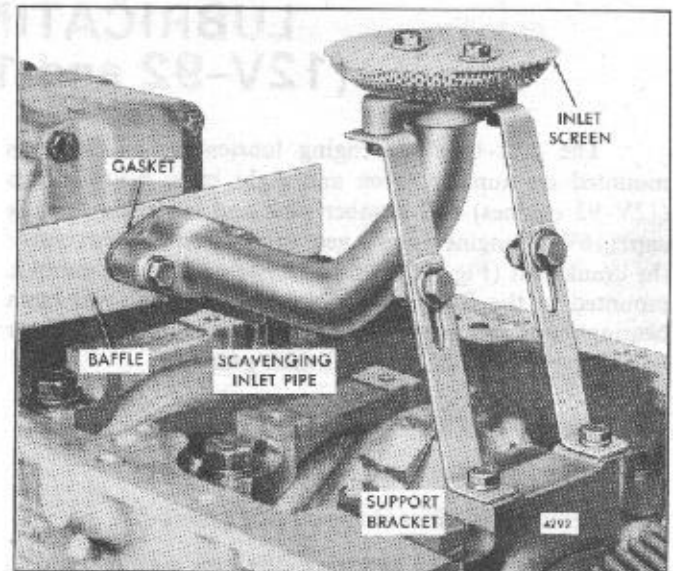


Fig. 9 - Scavenging Inlet Pipe and Screen Mounting

Install Oil Pump

1. Position the oil pump over the studs on the No. 1 and 2 main bearing caps so that the gear teeth mesh with the crankshaft oil pump drive gear teeth.
2. Fasten the oil pump to the main bearing caps with four nuts and lock washers.

NOTICE: Place the same number of shims between the oil pump feet and the main bearing caps as were removed. Removing or installing shims controls the gear tooth adjustment. The addition or removal of one set of .005" shims will change the gear tooth clearance by .0035".

3. With the engine in the running position, check the tooth clearance between the oil pump gear and the crankshaft gear. Use a feeler gage or a suitable indicator. The clearance should be .006" to .012".
4. Use two new gaskets and position the oil pressure relief valve on the cylinder block and against the oil pump body. Secure the oil pressure relief valve with four bolts and lock washers.
5. Use a new gasket and position the oil pump inlet pipe on the oil pump body. Secure the inlet pipe with two bolts and lock washers. Place the screen on the inlet pipe and fasten it with two self-locking bolts and two spacers (Fig. 8).
6. Place a new gasket between the scavenging pump body and baffle plate and between the baffle plate and the scavenging oil pump inlet pipe. Secure the pipe and baffle with two bolts and lock washers to the scavenging pump body (Fig. 9).
7. Attach the two support brackets to the scavenging inlet pipe. Secure the brackets to the main bearing cap with bolts and lock washers.
8. Place the screen on the scavenging inlet pipe and fasten it with two self-locking bolts and two plain washers.
9. Recheck all of the bolts for tightness to ensure there will be no leaks in the oil pump and pipe connections.
10. Use a new gasket and secure the oil pump pressure regulator valve to the cylinder block with two bolts and lock washers.
11. Place a new gasket on the oil pan and install the pan on the cylinder block. Start all of the oil pan bolts before tightening them. Tighten the bolts snugly but not excessively, starting with the center bolts and working toward each end of the oil pan. Excessive tightening of the bolts will crush the oil pan gasket unnecessarily.
12. Fill the oil pan to the proper level with the oil recommended in the *Lubrication Specifications* in Section 13.3.