



Fig. 1. View of the pump assembly from the side.

- a) Insert the piston rod into the right-hand crankshaft and make it level with the center of the crankshaft.
- b) Insert the piston rod into the left-hand crankshaft and make it level with the center of the crankshaft.
- c) Insert the piston rod into the right-hand crankshaft and make it level with the center of the crankshaft.
- d) Insert the piston rod into the left-hand crankshaft and make it level with the center of the crankshaft.

## RE ASSEMBLING

### PREPARATION OF THE PUMP

After the pump has been disassembled, check that the parts that should be fitted on the crankshaft and into the cylinder block (Fig. 1) are correctly fitted. Insert the piston rod into the crankshaft and make it level with the center of the crankshaft. Check that the piston rings are in place.



Fig. 2. View of the pump assembly from the side.

- a) Insert the crankshaft 4 in the right-hand crankcase.
- b) Fit the primary shaft 8 along with the guide pin with the chain and the timing sprocket 7, making sure that the timing is correct. The guide pin is not used.
- c) Fit the left crankcase with the right one, using as follows:
  - a) Make sure that the crank pin chain and the timing sprocket are in place.
  - b) Tighten the nut on the crank pin, which is to be turned towards the rear position.
  - c) Fit the two crankcases in place and then fit them together with the timing sprocket 7. Make sure that the timing is correct.
  - d) Fit and tighten the cover timing screw.
  - e) Check that the crankshaft, the primary shaft and the guide pin are perfectly free with no axial play of more than 0.2 mm.

# Garelli Katia Service Manual

**Michael Brown**



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