

9. INSPECTION AND REPAIR

Inspect the gears, shafts, and pump body for nicks, burrs, scoring or unusual wear. Parts which do not meet specifications or which are damaged will require replacement.

10. REASSEMBLY AND INSTALLATION

1. Old Style: Insert the drive shaft through the front cover of the pump and secure it with the snap ring (Fig. 12). Place the two Woodruff keys into the slots on the drive shaft and slide the oil pump driving gear onto the shaft. Install the mating gear into the body and put the rear cover of the oil pump into place tapping it lightly with a plastic hammer to seat it.

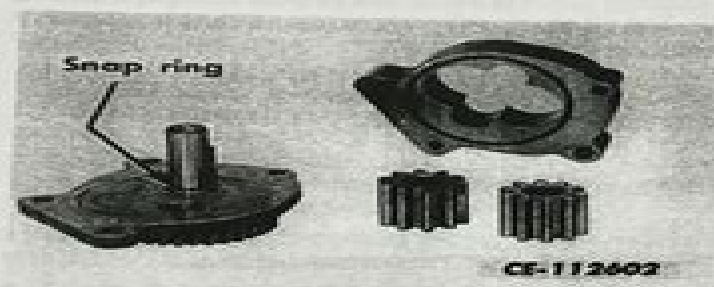


Fig. 12. Removing or Installing Old Style Drive Shaft

1. New Style: Insert the drive shaft through the front cover of the pump. Insert a 0.10mm (0.004 in.) feeler gauge between the gear on the shaft and the housing. Heat the oil pump driving gear to 180° to 200°C (360° to 390°F) and slide it on the shaft, maintaining the 0.10mm (0.004 in.) clearance between the shaft gear and housing. Install the mating gear into the body and put the rear cover of the oil pump into place tapping it lightly with a plastic hammer to seat it.

Relief Valve Assembly

2. Install the relief valve, square end first, into its bore followed by the spring, gasket and retaining oil plug. Tighten the plug securely. If the lubricating oil pump is not to be reinstalled onto the engine immediately it is suggested that one or two bolts be used to retain the assembly until it is reinstalled.

**ENGINE BALANCER
(Four Cylinder Engines)****11. DESCRIPTION**

The engine balancer is mounted to the underside of the engine. Lubrication is provided by a drilled oil passage in the crankcase from the engine main oil gallery that lines up with a passage in the balancer when it is installed.

The balancer consists of two eccentric weights located below the crankshaft in the exact center of the engine. The weights are driven by a ring gear, which is shrunk on to the crankshaft.

The ring gear drives the weights in opposite directions at twice crankshaft speed because the vertical shaking forces occur at twice engine speed. The balancer gears are matched and timed to each other (Fig. 18) by means of timing marks stamped on the gears. They are also timed to the engine by means of a marked tooth on the balancer drive gear which is indexed between two marked teeth on the ring gear.

Mechanical shaking forces in 4 cylinder engines with large bores and heavy pistons make it necessary to use a balancer. The function of the balancer is to reduce engine vibration, providing a smoother running engine.

All I.H. 4 cylinder engines have a single plane crankshaft with throws 1 and 4 displaced 180 degrees from the 2 and 3 throws. With this arrangement, the 1 and 4 pistons move in an opposite direction from the 2 and 3 pistons. At constant engine speed, the pistons travel faster and have higher accelerations during the upper half of the stroke than they do during the lower half of the stroke.

The inertia force acting on the pistons is a product of the weight of the piston and the acceleration of the piston. Thus when pistons 1 and 4 are at the top, their inertia force is greater than the opposing inertia force of the 2 and 3 pistons. The resultant force is in the upward direction and it is this force that the balancer counteracts.

At the crankshaft angle of 90 degrees from TDC, the inertia forces of the 1 and 4 pistons and the 2 and 3 pistons combine to produce a resultant force in the downward direction.

This unbalance in the inertia force of the pistons changes direction every 90 degrees of crankshaft rotation. To balance these forces, the balancer has to make two revolutions.

The unbalanced inertia force of the reciprocating weights (pistons, etc.) act only in the vertical direc-

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