

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 effort (22) may be turned out of pump cover to facilitate cleaning.

To remove oil pump unit from gearcase with gearcase cover removed, remove ignition circuit breaker 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 galling or cracking caused by foreign materials going through pump. Pump shafts and bearings normally last life-time 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. Install a new lock ring using a lock ring pliers when assembling pump. Make sure ring is engaged and seated in retaining groove.

Bolts and nuts must be drawn down evenly to approximately 45 in-lbs, but no more than 50 in-lbs torque. Make sure pump drive turns freely and does not bind.

This is important because the oil pump cover gasket and body gasket are made from plastic material. If overtightened, the plastic material will be squeezed out of place and eliminate pump gear side clearance which may seize and damage the pump parts.

If a 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 evenly to 45 to 50 in-lbs torque.

Oil hose connections have one piece band type clamps and must be replaced each time hoses are connected. Use Hose Clamp Tool, Part No. 97087-85 to squeeze clamps tight as shown in Figure 3-25.

NOTE

Certain changes were made to the oil pump during the 1973 model season requiring different parts. As an aid in identifying parts for proper assembly, consult service Bulletin No. 547.

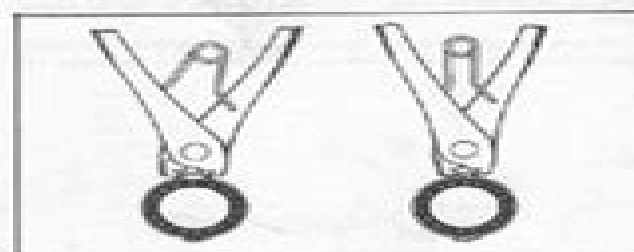


Figure 3-25. Hose Clamp Connection

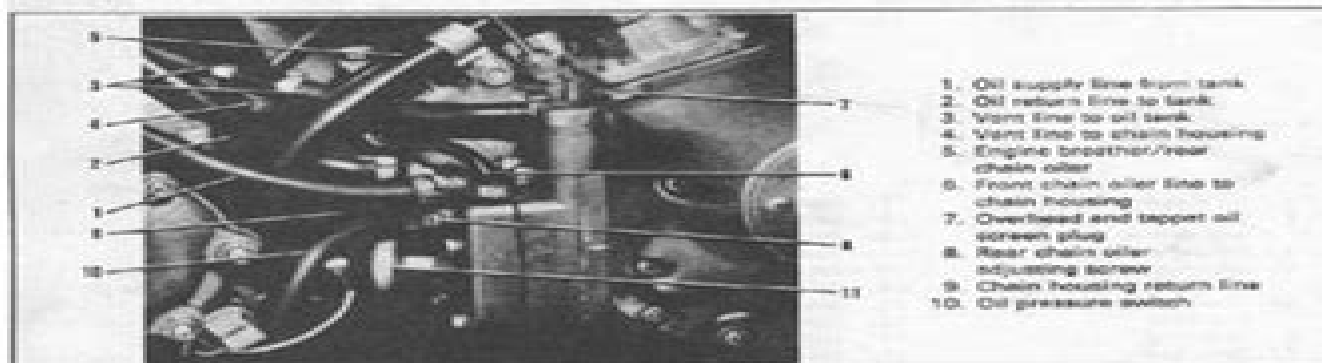


Figure 3-26. Oil Pump and Connecting Lines

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A red circular graphic with a gradient, appearing as a partial circle or a stylized arrow pointing to the right, located to the right of the Causey Enterprises, LLC text.

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