

PUMP

1. Remove the cover plate (1), seal ring (2) and spacer (3) from the adapter (4).



2. Remove the two (2) oil seals (5) from the adapter (4).



3. Remove the eight (8) needle bearings (6) from the adapter and bearing.



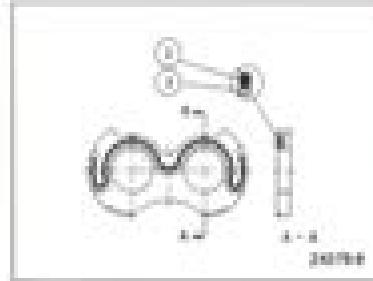
Assembly of Pump Body

1. Press (7) the eight (8) needle bearings (6) into the adapter and bearing.

2. Align the stamp on the end of each needle bearing (6) to face toward the bottom of the hole.

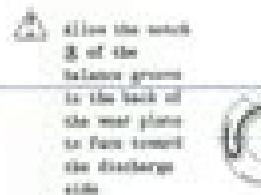
Assembly of Bearing Pump

3. Install bearing (8) and back up cover (9) to the cover plate (1).



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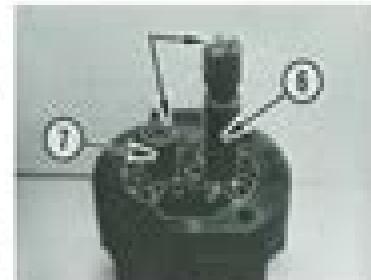
1. Install the cover plate (1) to the bearing (2).



2. Align the mark (3) of the balance groove to the back of the cover plate to face toward the discharge side.

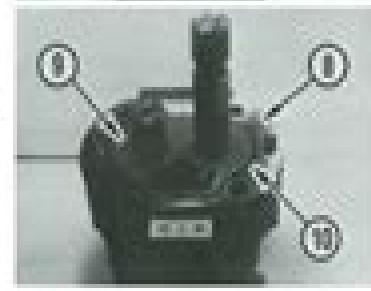


3. Insert the drive gear (4) and driven gear (5) with the alignment marks aligned.



4. Install the adapter (6) and tighten the bolts (7).

Torque: 10-14 kgf·m



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# Alpha 1 Shop Manual

**Brendan G. Carr**

**Alpha 1 Shop Manual:**

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