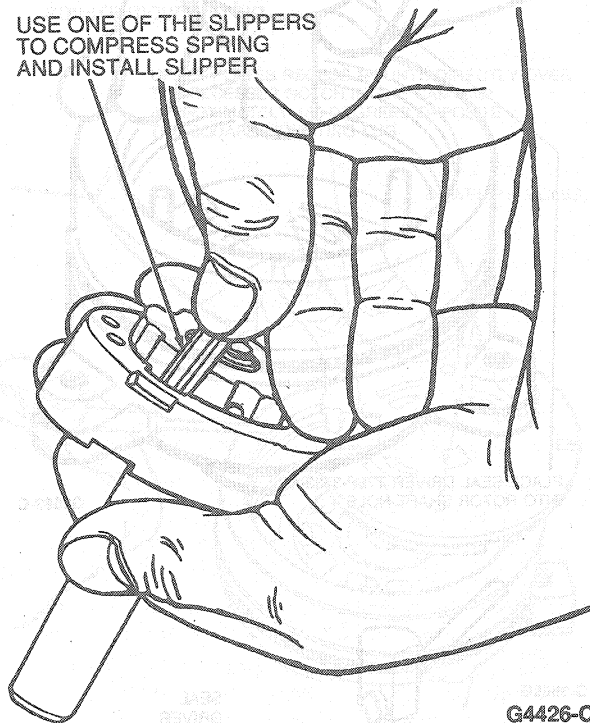


DISASSEMBLY AND ASSEMBLY (Continued)

5. Use one of the slippers to compress spring, and install slipper with groove facing cam profile. Repeat Steps 4 and 5 on slipper cavity beneath opposite inlet recess.

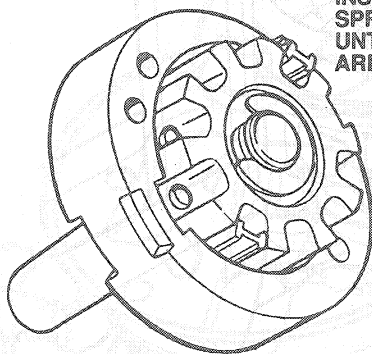
USE ONE OF THE SLIPPERS TO COMPRESS SPRING AND INSTALL SLIPPER



G4426-C

6. Holding cam stationary, index rotor either right or left one space and install another spring and slipper until all 10 rotor cavities have been filled. Turn rotor carefully so that springs and slippers already installed do not fall out.

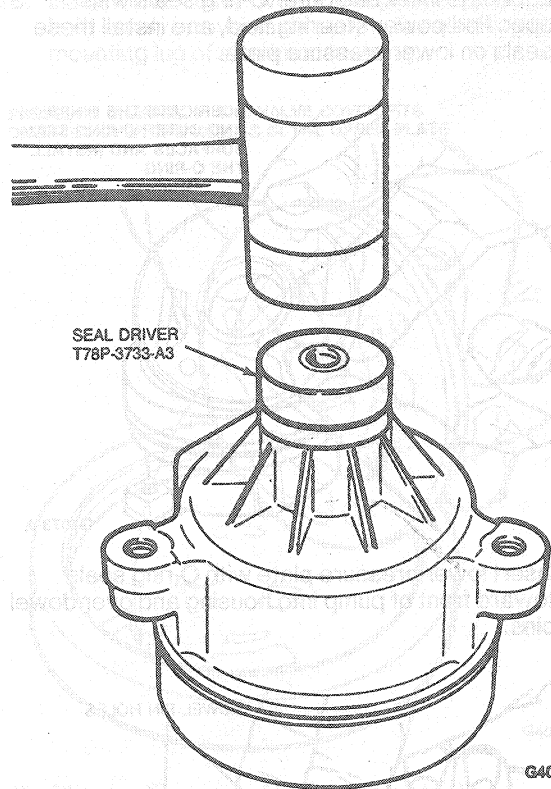
INDEX ROTOR EITHER RIGHT OR LEFT TO NEXT CAVITY AND INSTALL ANOTHER SPRING AND SLIPPER UNTIL ALL 10 CAVITIES ARE FILLED.



G4427-D

7. Install a rotor shaft seal using Seal Driver T78P-3733-A3. Using a plastic mallet, drive seal into bore until it bottoms. Install seal retainer in same manner.

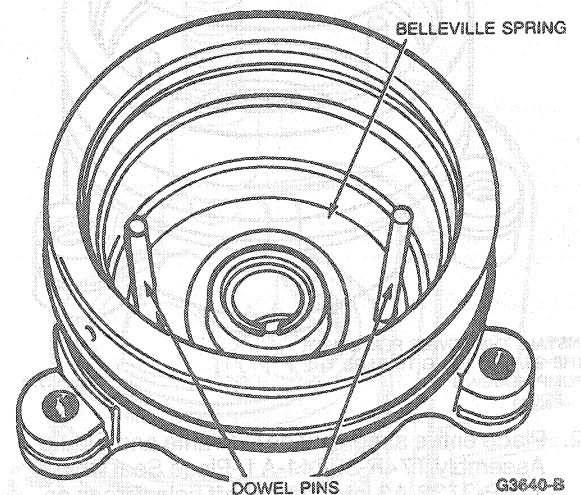
DISASSEMBLY AND ASSEMBLY (Continued)



SEAL DRIVER
T78P-3733-A3

G4056-B

8. Place pump housing plate on flat surface with pulley side facing down.
NOTE: The Belleville spring must be inserted with the dished surface upward.
9. Insert two dowel pins and Belleville spring into housing.



BELLEVILLE SPRING

DOWEL PINS

G3640-B