

D06300

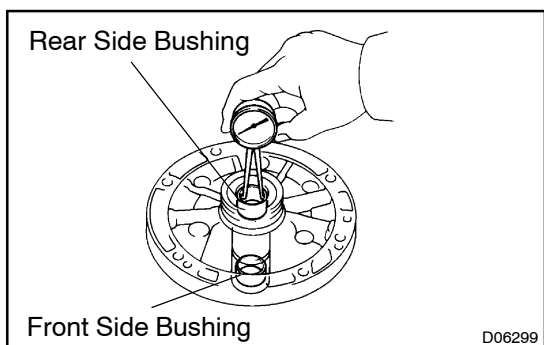
## INSPECTION

### 1. CHECK OIL PUMP BODY BUSHING

Using a dial indicator, measure the inside diameter of the oil pump body bushing.

**Maximum inside diameter: 38.19 mm (1.5035 in.)**

If the inside diameter is greater than the maximum, replace the oil pump body.



D06299

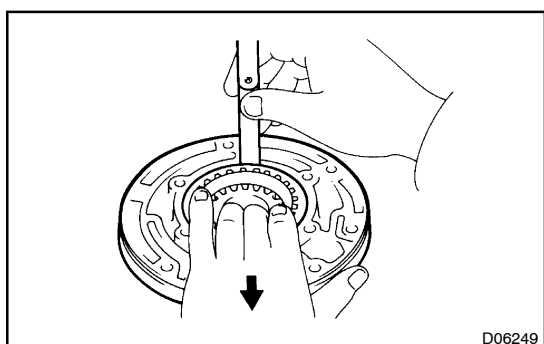
### 2. CHECK STATOR SHAFT BUSHING

Using a dial indicator, measure the inside diameter of the stator shaft bushings.

**Maximum inside diameter:**

**Front and Rear side: 23.11 mm (0.9098 in.)**

If the inside diameter is greater than the maximum, replace the stator shaft.



D06249

### 3. CHECK BODY CLEARANCE OF DRIVEN GEAR

Push the driven gear to one side of the body.

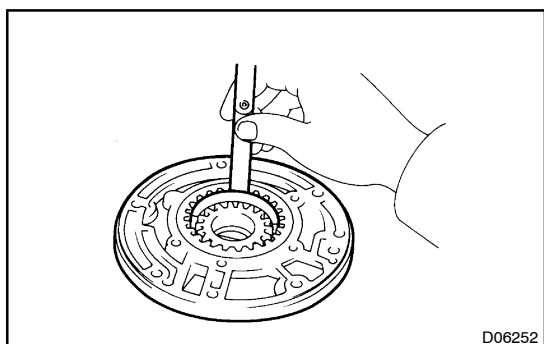
Using a feeler gauge, measure the clearance.

**Standard body clearance:**

**0.07 – 0.15 mm (0.0028 – 0.0059 in.)**

**Maximum body clearance: 0.3 mm (0.012 in.)**

If the body clearance is greater than the maximum, replace the drive gear, driven gear or pump body.



D06252

### 4. CHECK TIP CLEARANCE OF DRIVEN GEAR

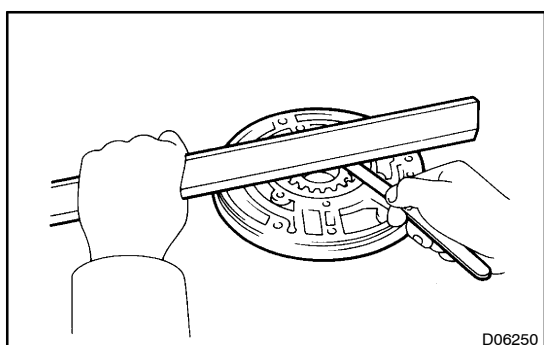
Measure between the driven gear teeth and the crescent shaped part of the pump body.

**Standard tip clearance:**

**0.11 – 0.14 mm (0.0043 – 0.0055 in.)**

**Maximum tip clearance: 0.3 mm (0.012 in.)**

If the tip clearance is greater than the maximum, replace the drive gear, driven gear or pump body.



D06250

### 5. CHECK SIDE CLEARANCE OF BOTH GEARS

Using a steel straight edge and a feeler gauge, measure the side clearance of both gears.

**Standard side clearance:**

**0.02 – 0.05 mm (0.0008 – 0.0020 in.)**

**Maximum side clearance: 0.1 mm (0.004 in.)**

There are 5 different thicknesses for drive and driven gears.

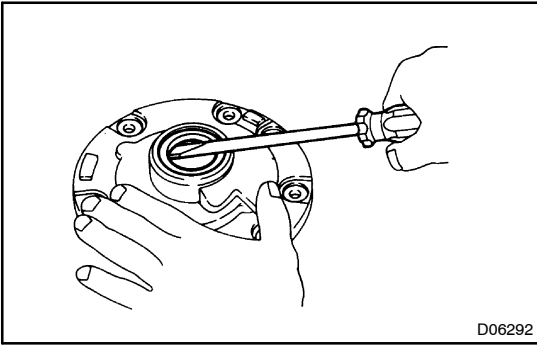
**Drive and driven gear thickness:**

Mark	Thickness	mm (in.)
1	17.235 - 17.244	(0.6785 - 0.6789)
2	17.245 - 17.254	(0.6789 - 0.6793)
3	17.255 - 17.265	(0.6793 - 0.6797)
4	17.266 - 17.275	(0.6798 - 0.6801)
5	17.276 - 17.285	(0.6802 - 0.6805)

If the side clearance is greater than the maximum, replace the drive gear, driven gear or pump body.

**6. IF NECESSARY, REPLACE OIL SEAL**

(a) Using a screwdriver, pry off the oil seal.



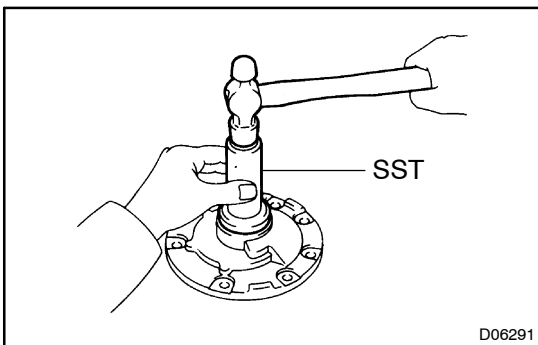
D06292

(b) Using SST and a hammer, install a new oil seal.

The oil seal end should be flushed with the outer edge of the pump body.

SST 09350-20015 (09388-20010)

(c) Coat the oil seal lip with MP grease.



D06291