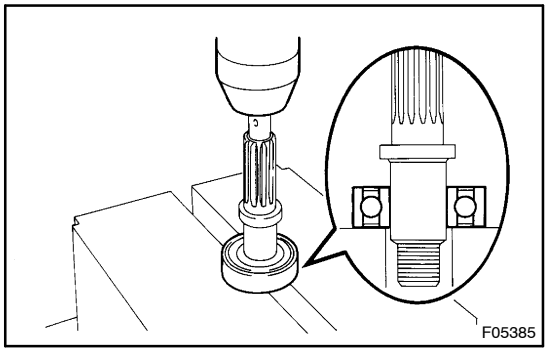
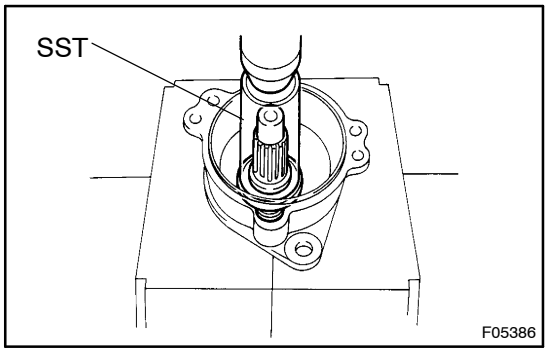
BR0V7–02

REASSEMBLY



1. INSTALL BEARING TO ROTOR SHAFT

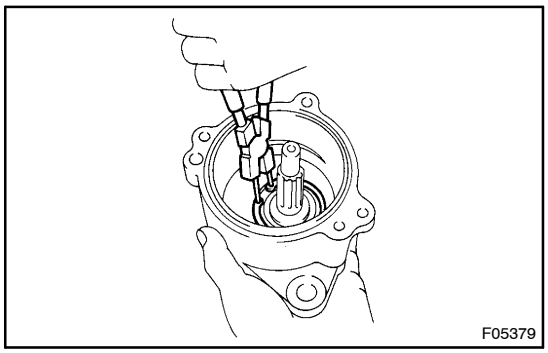
Using a press, install the new bearing to the rotor shaft.



2. INSTALL ROTOR SHAFT

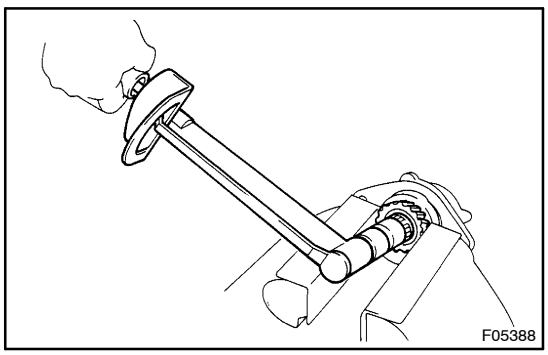
Using SST and a press, install the rotor shaft to the casing.

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3. INSTALL SNAP RING

Using snap ring pliers, install the snap ring.



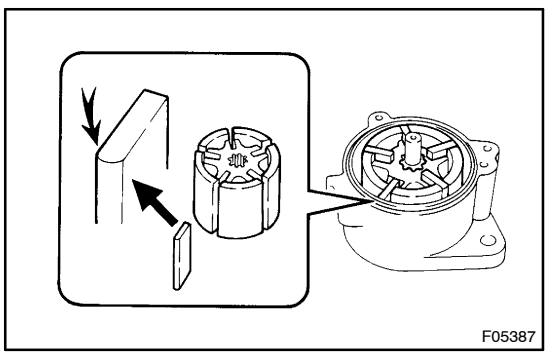
4. INSTALL GEAR

(a) Temporarily install the woodruff key, gear and lock nut to the pump.

(b) Using soft jaws on the vise, clamp the gear in the vise.

(c) Tighten the gear lock nut.

Torque: 110 N·m (1,125 kgf·cm, 81 ft·lbf)



5. INSTALL ROTOR INTO CASING

HINT:

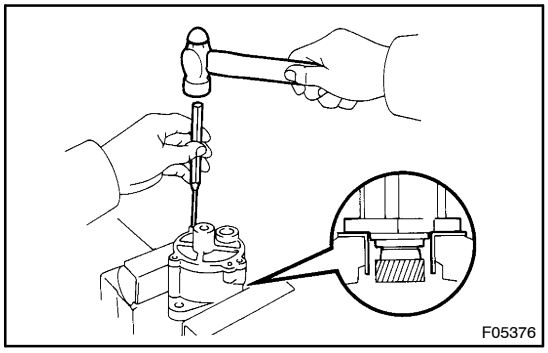
Apply engine oil to the rotor and install it to the rotor shaft.

6. INSTALL 5 BLADES

Install the 5 blades with the round end facing outward.

HINT:

- Apply engine oil to the blades.
- Be sure that the blades and rotor surfaces are even.



7. INSTALL END COVER

(a) Place the vacuum pump on the vise, as shown in the illustration.

NOTICE:

Do not tighten the vise.

(b) Install the new 2 O–rings.

(c) Install the end cover and temporarily install the 3 bolts.

(d) Using a pin punch and hammer, drive in the 2 straight pins.

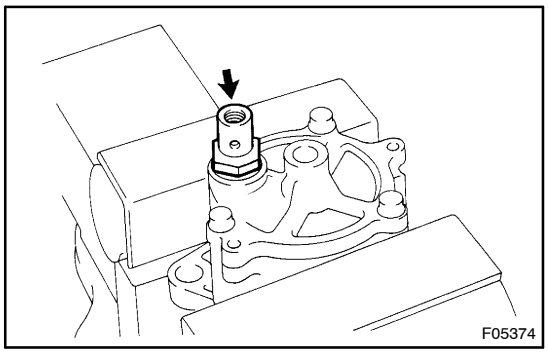
(e) Using soft jaws on the vise, place the vacuum pump in the vise.

NOTICE:

Do not tighten the vise too tightly.

(f) Tighten the 3 bolts.

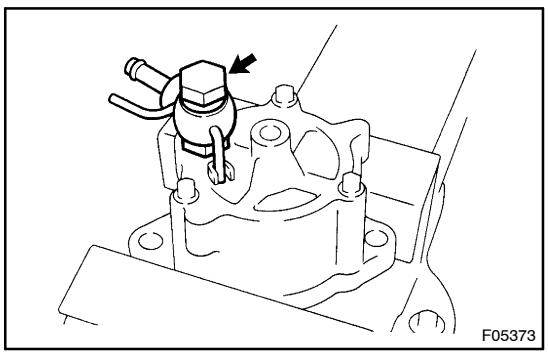
Torque: 7.8 N·m (80 kgf·cm, 69 in.·lbf)



8. INSTALL CHECK VALVE

Install the check valve with a new gasket.

Torque: 74 N·m (750 kgf·cm, 54 ft·lbf)



9. INSTALL VACUUM HOSE UNION

Install the vacuum hose union with 2 new gaskets and install and torque the union bolt.

Torque: 14 N·m (140 kgf·cm, 10 ft·lbf)

HINT:

Align and insert the union pin into the matching hole of the casing.