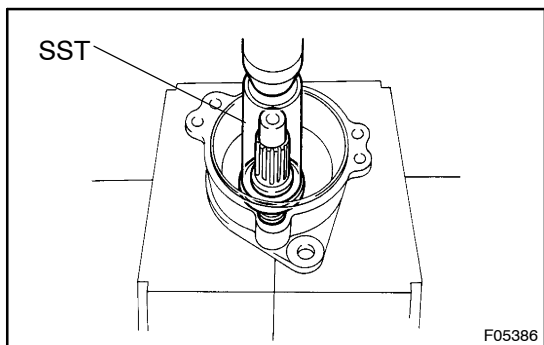


REASSEMBLY

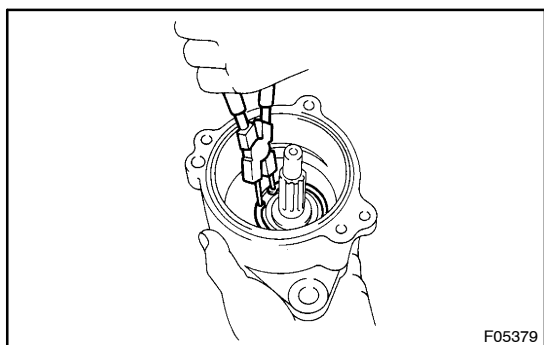
1. INSTALL BEARING TO ROTOR SHAFT

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



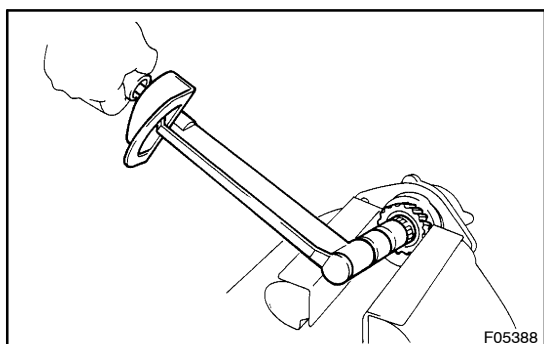
2. INSTALL ROTOR SHAFT

Using SST and a press, install the rotor shaft to the casing.
SST 09608 -30012 (09608 -04030)



3. INSTALL SNAP RING

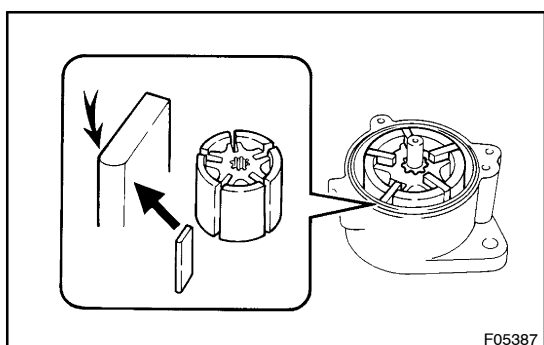
Using snap ring pliers, install the snap ring.



4. INSTALL GEAR

- Temporarily install the woodruff key, gear and lock nut to the pump.
- Using soft jaws on the vise, clamp the gear in the vise.
- Tighten the gear lock nut.

Torque: 110 N·m (1,125 kgf·cm, 8 1 ft·lbf)



5. INSTALL ROTOR INTO CASING

HINT:

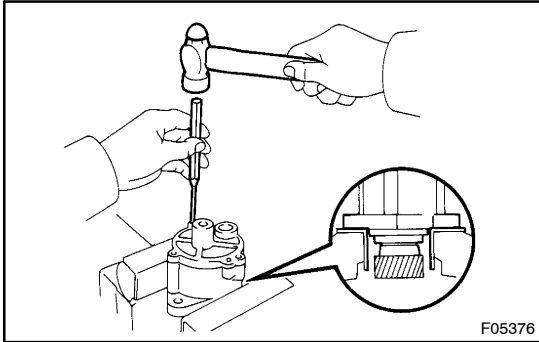
Apply engine oil to the rotor and install it to the rotor shaft.

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.

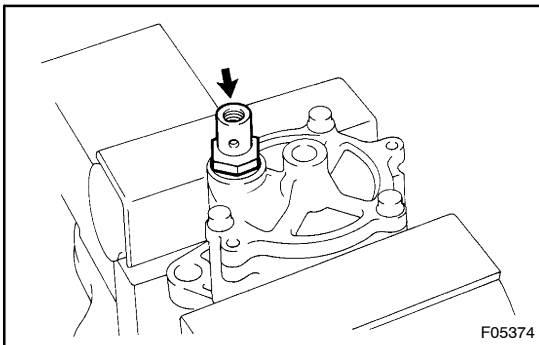
- (b) Install the new O-ring.
 (c) Install the end cover and temporarily install the 3 bolts.
 (d) Using a pin punch and hammer, drive in the 2 straight pins.
 (e) Using soft jaws on the vise, place the vacuum pump in the vise.

NOTICE:

Do not tighten the vise too tightly.

- (f) Tighten the 3 bolts.

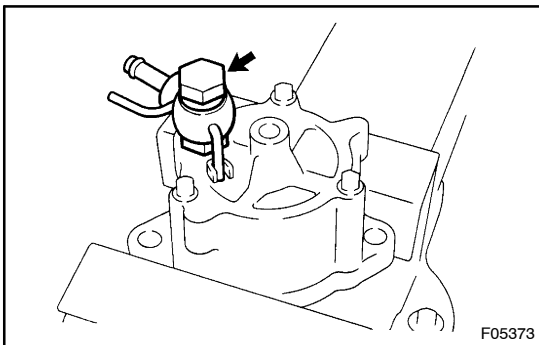
Torque: 7.8 N·m (80 kgf·cm, 69 in·lbf)



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.