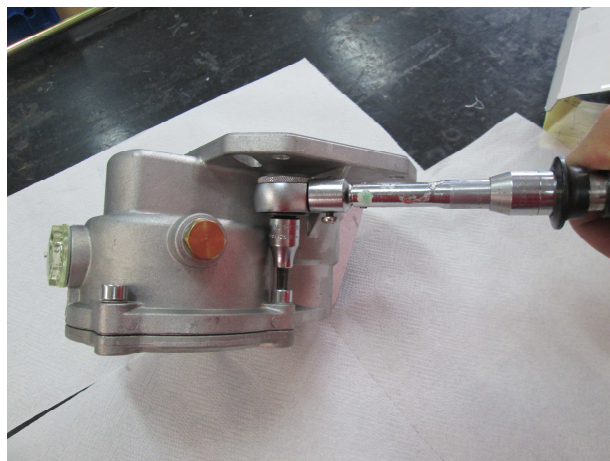


ASSEMBLY INSTRUCTIONS

ASSEMBLY OF THE GEARBOX ON PUMPS:

- Having the pump shaft on vertical position loosen the four bolts which keep the bearing cover to the pump housing leaving it in its position.
- After having set the O Ring 10.3210.56 in its seating, fix the flange 50.0002.44 with the bolts 16.1958.31 with the pertinent seal washers, setting on the threaded part LOCTITE 242 and fix it with 25 Nm (221 in.lbs.) MAX.
- Make sure that the key is correctly set on the keyway, assemble the toothed crown 50.0003.65 on the pump shaft pushing it on the suitable shoulder and clamp it with the screw 16.2223.00 with a torque of 20 Nm (177 in.lbs.) MAX (**use LOCTITE 242**).
- Complete the assembly of the body (preassembled gear box with pinion, bearings and oil seal) with the oil level pilot light 15.3734.00 and the discharge plug 60.0028.31 with pertinent gasket.
- Insert the O Ring 10.3211.11 on the flange already fixed to the pump, and proceed to the assembly of the body on that same flange using the bolts 16.1958.26 and pertinent elastic washers with a torque of 25 Nm (221 in.lbs.) MAX. To use a torque wrench with a hex key insert with a ball head as shown in the picture attached.
- At this stage it is possible to proceed to the filling of the housing with oil (type gear-differential SAE 90) up to the level shown at the center of the pilot light, locking it with the vented plug 15.3726.00. In case the unit gearbox-pump is not immediately coupled to the engine, and should it be transported, it is advised to use temporarily the plug 15.3725.00 and gasket, which are supplied for this utilization.



ASSEMBLY THE UNIT GEARBOX-PUMP ON ENGINE:

- Check that the key of the Engine shaft is correctly set on the keyway **then apply on the same shaft a good lubricating antiscruff (type LOCTITE 8150) to facilitate the possible disassembly.**
- Proceed to the coupling of the gearbox to the engine utilizing for the fixing the bolts and the washers supplied.
- Torque to apply on screws for assembly. MAX
 - Screw 16.2010.00 3/8" torque 40Nm (354in.lbs.);
 - Screw 16.2009.00 5/16" torque 25Nm (221in.lbs.);
 - Screw 16.2035.00 M10 torque 40Nm (354in.lbs.);
 - Screw 16.1957.30 M8 torque 40 Nm (221in.lbs.).**If the engine has a short shaft, lock the feather key axially. For instance: screw washer or set screw, etc...**