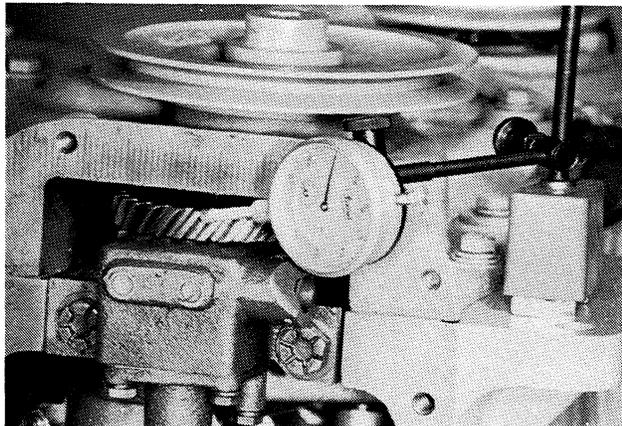
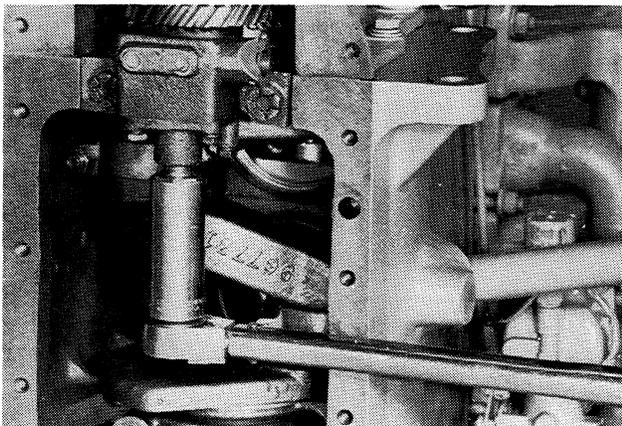
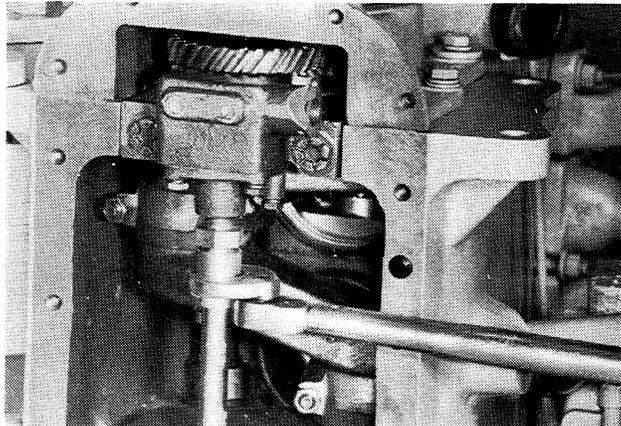


STEP 45

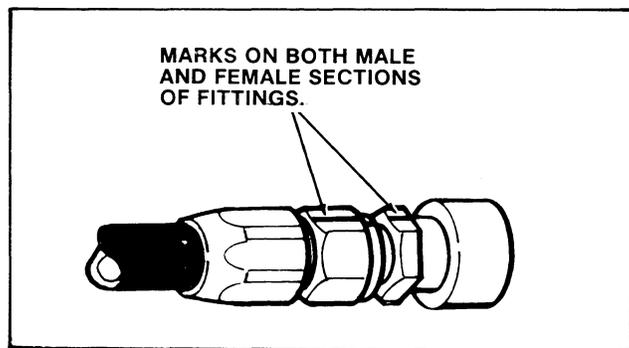
Check the backlash between the pump gear and the crankshaft gear before finishing the pump installation. Put a dial indicator on the oil pump drive gear. Backlash must be 0.002 to 0.008" (0.0508 to 0.2032 mm). If the backlash is not in the given range, add or remove shims between the oil pump and the Number One bearing cap to get the correct backlash.

STEP 46

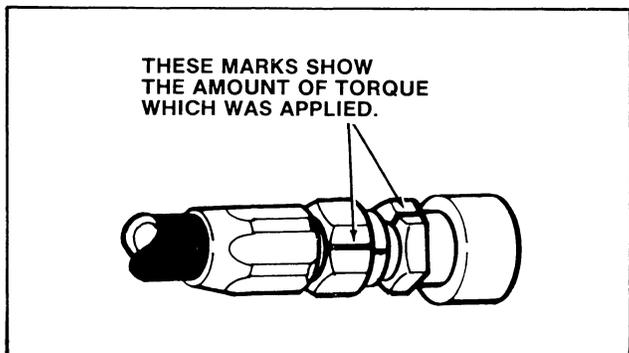
Install the inlet fitting into the oil pump. Tighten the fitting.

STEP 47

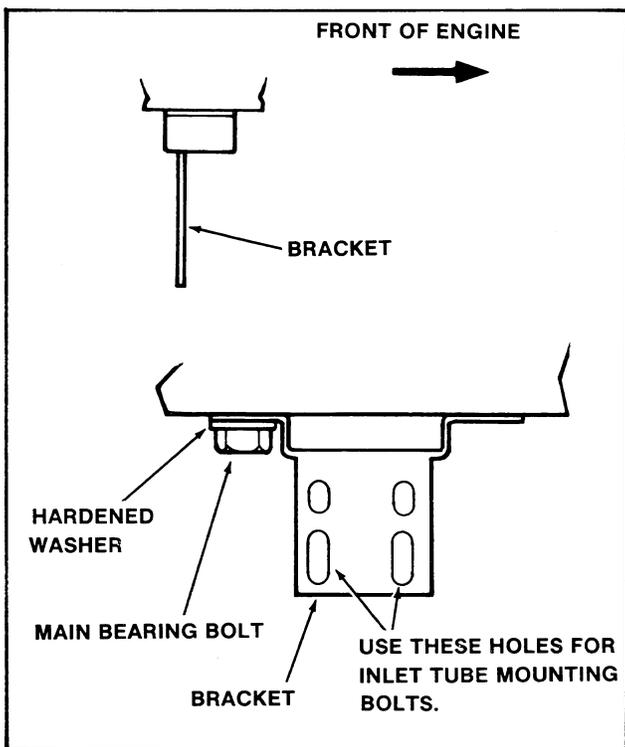
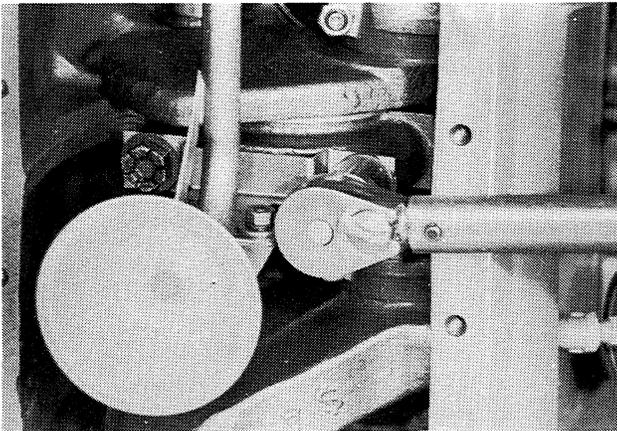
Install the pump inlet tube. Use a 1.00" Crow's foot wrench to turn the swivel nut on the inlet tube, 1/5 to 1/4 of a revolution beyond the first seat contact. Then, loosen the swivel nut and again, turn the swivel nut until the nut is seated.

STEP 48

Put a mark on the flats of both sections of fittings. See the inset.

STEP 49

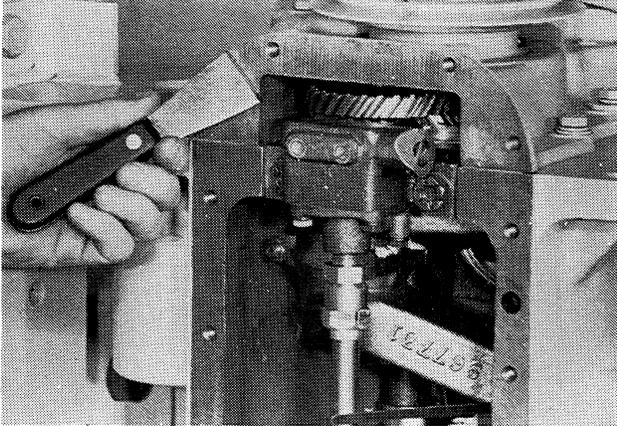
Turn the swivel nut 1-1/2 hexagon flats as shown in the inset. This adjustment of the nut is equal to 45 ft. lbs. (61 Nm)(6.1 kgm).

STEP 50

The support bracket for the inlet tube is fastened to the center main bearing cap. Install the bracket as shown in the inset. Install the bolts and washers. Lubricate the threads and the washers. Tighten the bolts to a torque of 165 to 185 ft. lbs. (224 to 251 Nm)(22.4 to 25.1 kgm).

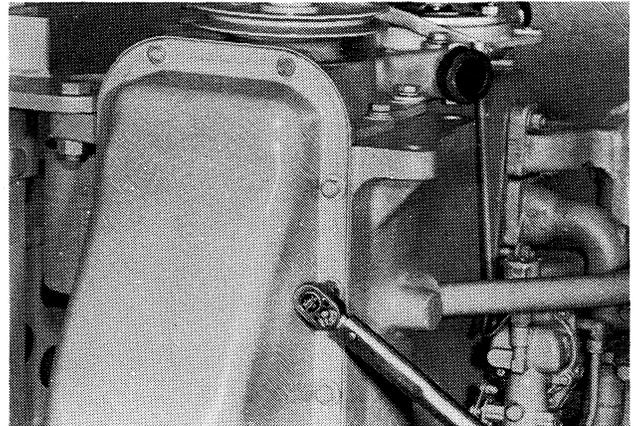
OIL PAN Installation

STEP 51



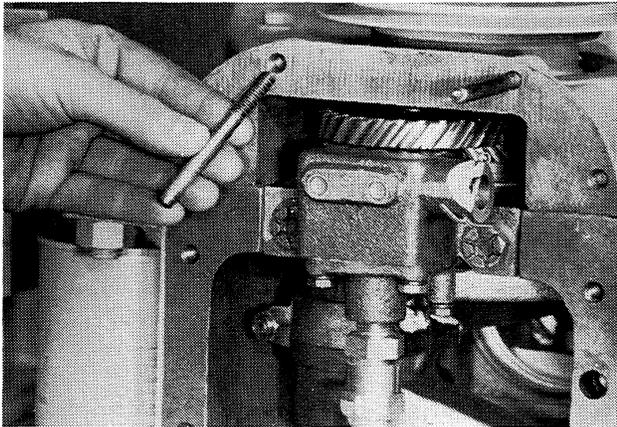
Remove all foreign material from the flange of the engine block and oil pan.

STEP 54



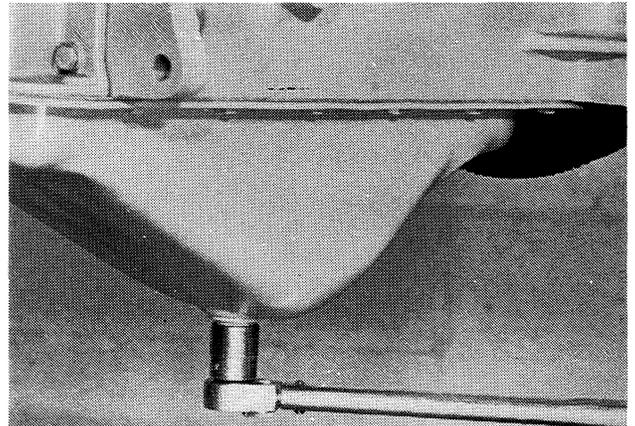
Install the oil pan bolts and tighten to a torque of 10 to 12 ft. lbs. (14 to 16 Nm)(1.4 to 1.6 kgm).

STEP 52



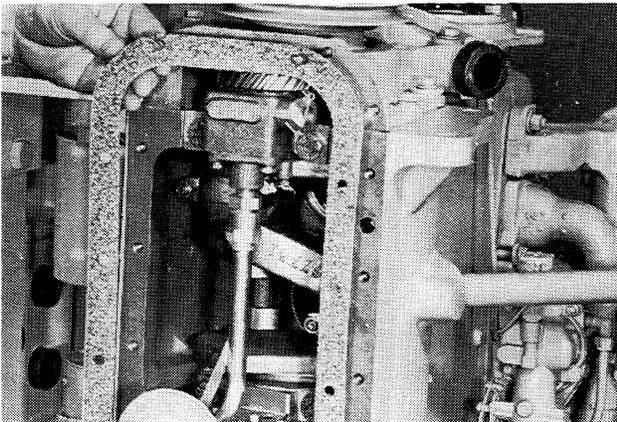
Install two 5/16" NC studs into the engine block to hold the oil pan gasket in position.

STEP 55



Install the drain plug and gasket and tighten the drain plug to a torque of 29 to 31 ft. lbs. (39 to 42 Nm)(3.9 to 4.2 kgm). Fill the oil pan with clean oil.

STEP 53



Install a new oil pan gasket.