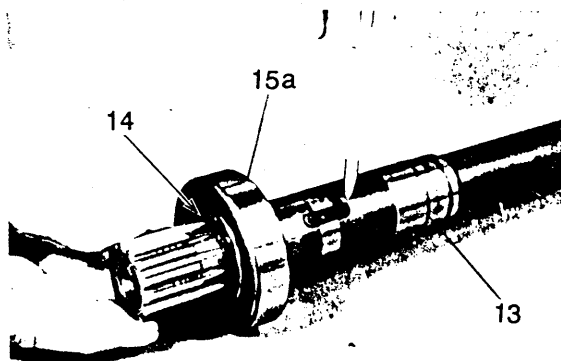


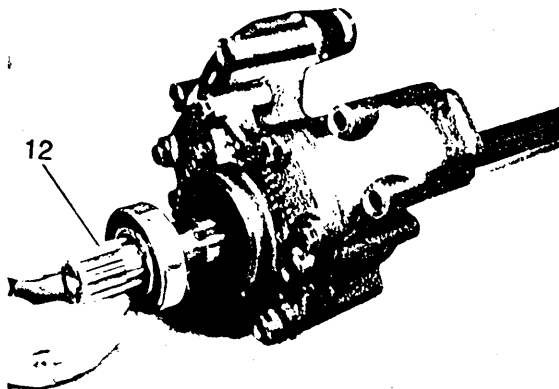
7) Engage snap ring (14) into the pump drive shaft (13).

Heat ball bearing (15a) (RS) and place it against snap ring until contact is obtained. Insert fitting key into the groove.

★Pay attention to the installation position  
– closed bearing face showing towards the snap ring!

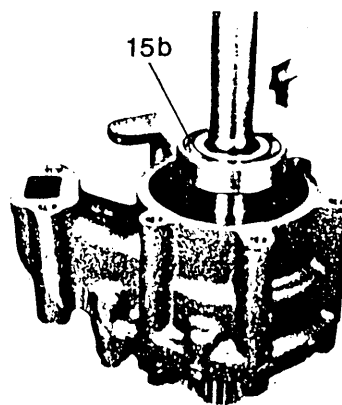


8) Introduce pre-assembled drive shaft (12) into the pump. During this step the internal rotor will be received together with the fitting key.



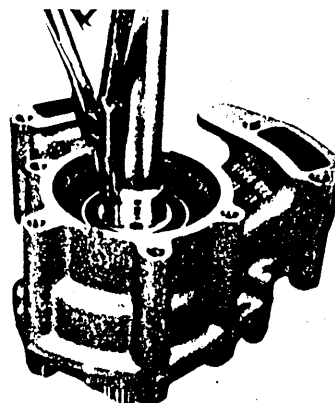
9) Guide heated ball bearing (15b) upon the end of the drive shaft until contact is obtained.

★Closed bearing seat side towards above!

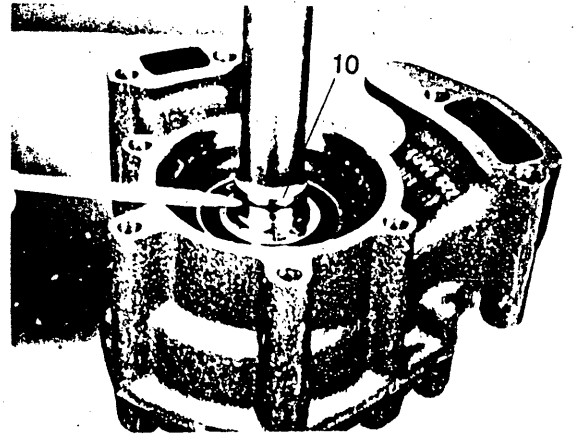


10) Engage snap ring (11) and release the tension from the pump drive bearing of the pump drive shaft by tapping.

★Check that snap ring is fitted securely in the groove.



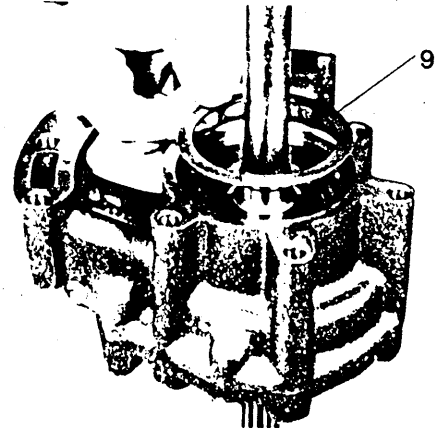
11) Squeeze in and engage seal ring (10).



12) Determination of the shim (9).

Measure dimension A from flange facing to contact area/bearing,

e.g. 7.15 mm



13) Place gasket upon the oil supply flange (19).

Determine dimension B from bearing to gasket (=flange facing),

e.g. 6.50 mm

★Example:

Dimension A 7.15 mm

Dimension B 6.50 mm

gives 0.65 mm

In order to obtain the required end play, a shim of e.g. 0.30 mm thickness will be necessary.

★End play: 0.30 to 0.50 mm

14) Make determined shim e.g. 0.30mm adhere with grease.

