

Transfer Case Pump Plate

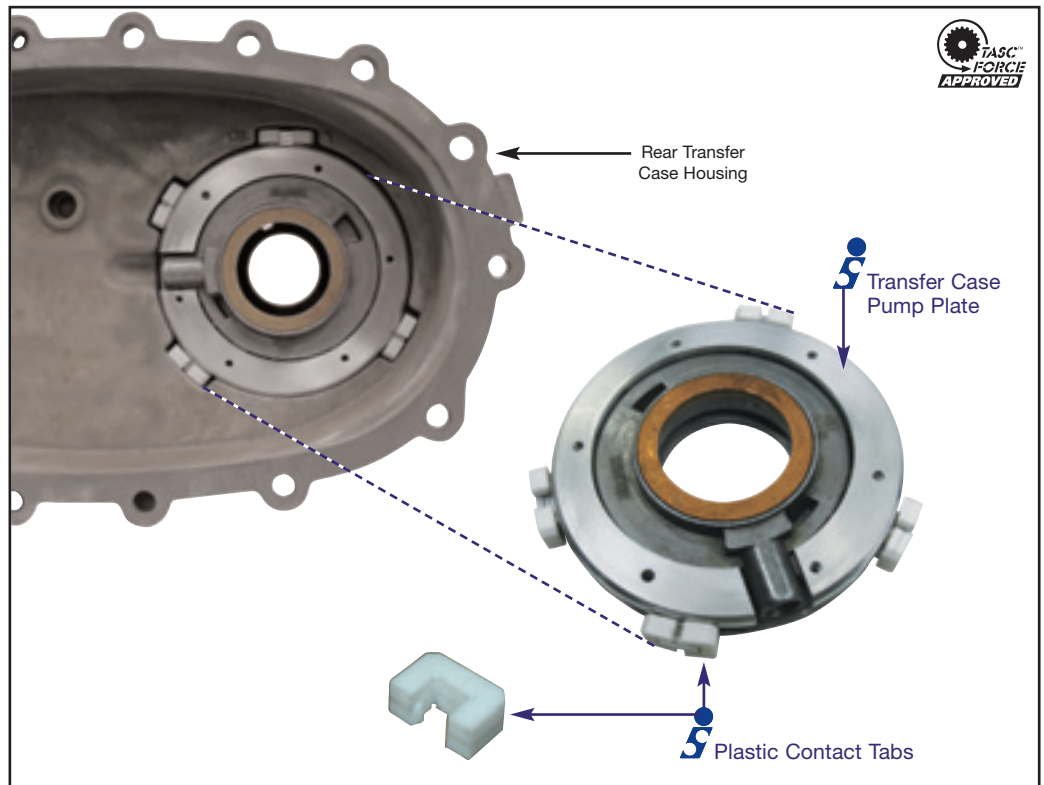
100246-02K

1 Plate
8 Plastic Tabs
6 Screws

Patent pending

Notes:

- If the magnesium rear housing has a hole worn through from the pump lugs, it is best to replace the housing.
- Welding magnesium requires specialized procedures. Contact welding suppliers in your area to locate welding shops that are familiar with welding magnesium.
- Patching holes with epoxy is risky, but has been done successfully when applied with care.



Disassembly:

1. Remove the pump assembly from the transfer case. Discard the U-shaped steel wear insert.
2. Disassemble the pump and discard the OEM screws.
3. Drill through the six tapped holes on the pump cover with a 11/64 (#19) drill bit to remove threads.
4. Use a hacksaw and cut the tabs off from the OEM pump. File or grind the pump so the curvature matches the rest of the casting.

Installation:

1. Assemble and realign (without screws) the modified pump cover, pump body and gears.
2. Place the pump plate over the pump cover, with the four lugs protruding toward the pump body.
3. Use the six enclosed screws to secure the pump plate to the pump assembly. The screws should have thread locker applied and be installed from the bottom of the pump body.
4. Attach two of the plastic tabs to each of the new pump tabs.
5. Install into transfer case using normal assembly procedures.

Note: Do NOT install U-shaped steel inserts.

