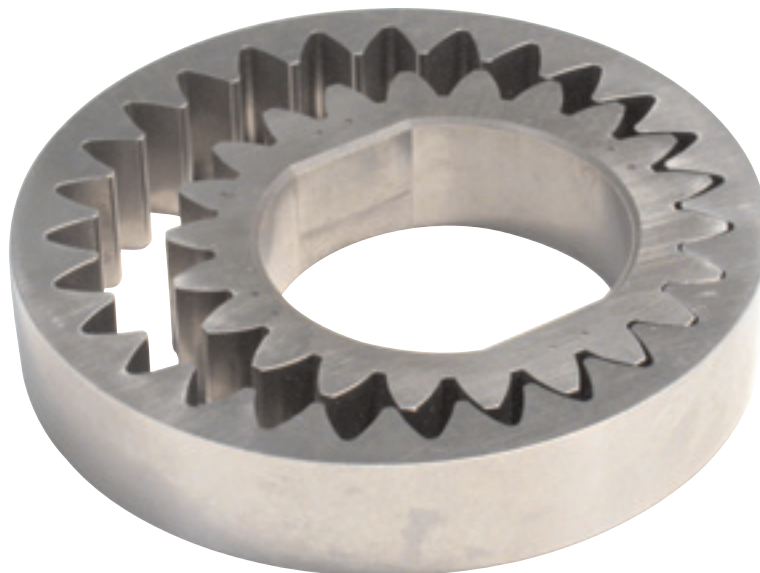




**Part No.**

**34201E-SP**

*1 Pump Gear Set*



**INSTALLATION INSTRUCTIONS**

Remove the worn gear set from the existing pump housing. (Note: Sonnax gears cannot be mated with either OEM gear. Gears must be used as a matched set.)

Clean the pump cavity and remove any existing burrs or rough surfaces by hand, using a ScotchBrite™ pad. Do not use an air buffer or other power tools to prepare the pump cavity.

Inspect pump gear pocket and crescent for scoring or wear.

Inspect and/or replace pump bushing if required.

Insert replacement gear set into pump housing. (Note: Be sure to assemble the drive gear with the identification dots up as shown in photo to ensure correct orientation of the drive flats.)

**Confirm critical dimensions:**

.001"-.002" between pump face and gears

**Radial clearance:**

Inner rotor to crescent .002" - .0095"

Outer rotor to crescent .003" - .009"

Outer rotor to housing .0017" - .0064"

Pump bushing to impeller hub clearance: .001" - .005"