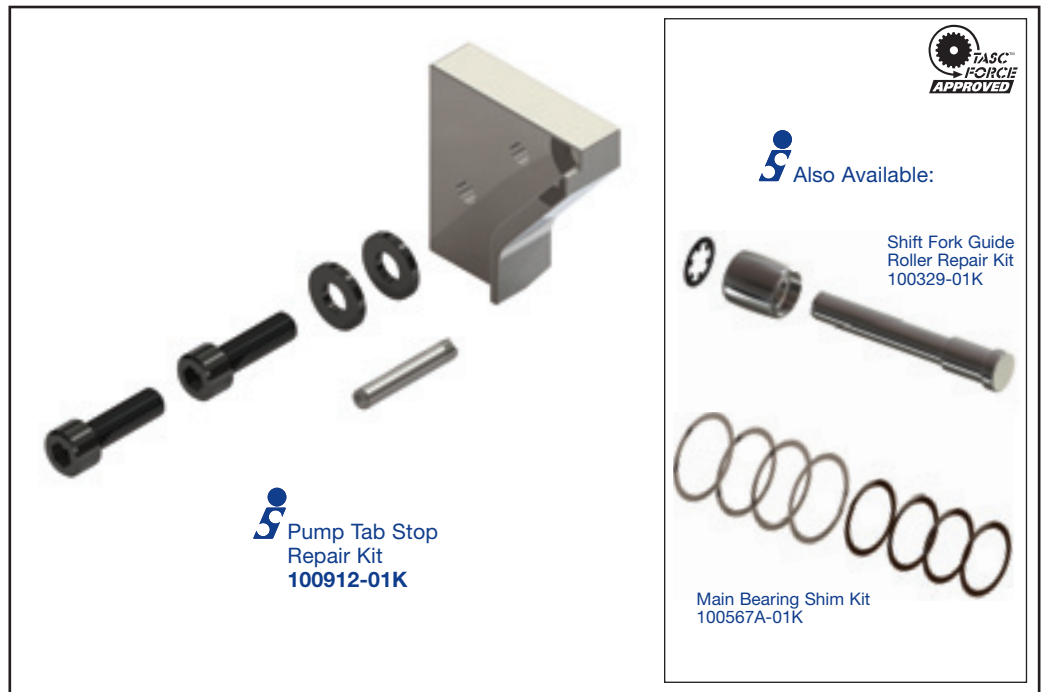


Pump Tab Stop Repair Kit

100912-01K

- 1 Pump Tab Stop
- 2 Bolts
- 2 Washers
- 1 Spring Pin



Pump Arm Stop Preparation:

1. The pump tab stop is designed to nest against and beneath the pump tab (*see Figure 1*).
2. Position the stop and clamp it in place with a small c-clamp or vise-grip pliers. The stop will rest against the cast text on the bottom side of the pump arm. There is no reason to remove the cast text when attaching the stop to the pump tab.
3. Insert the Sonnax hollow spring pin into one of the threaded holes on the stop.
4. Using the spring pin as a drill guide, drill through the pump tab with a 1/8" diameter bit. The spring pin will guide the drill bit and prevent damage to the aluminum threads of the pump stop.
5. Remove spring pin from the first tapped hole, repeat steps 3 & 4 on the second tapped hole.
6. Remove the spring pin and clamp. Separate the pump tab and the tab stop.
7. Using a 3/16" diameter drill bit, drill through the pump tab to enlarge the two 1/8" diameter pilot holes.
8. Deburr the drilled holes.

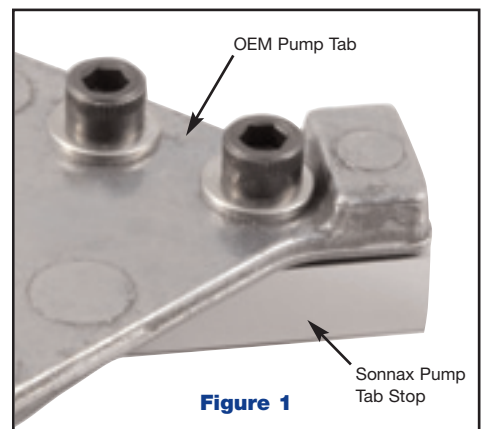


Figure 1

Installation of the Pump Tab Stop:

Note: The front case half has a pocket near the sealing flange that locates and prevents pump body rotation (*see Figure 2*). The wear appears as a narrow slot that can be mistaken for a machined feature in the case.

1. Assemble the stop to the pump tab with two supplied #10-32 x 5/8" hex socket head cap screws and washers. Use Loctite™ (or preferred brand) threadlocker on screw threads.
2. Torque the hex socket head cap screws to 90 inch-lbs.

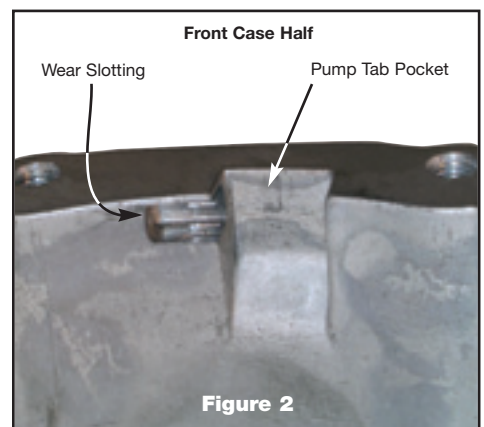


Figure 2