

# Gear Servicing Instructions

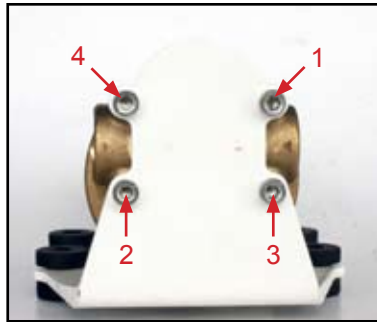
The following instructions are for servicing gear pumps or oil change systems and fuel primers that contain the gear pump in the assembly.

## Notes:

- Disconnect power to the system before servicing and isolate lines.
- It is recommended to remove the pump and conduct repairs on a workbench to reduce the chance of losing small parts.

## Step 1

Unscrew evenly in the sequence shown. Remove cover plate. Also remove the bypass and mounting bracket (depending on the model).



## Step 2

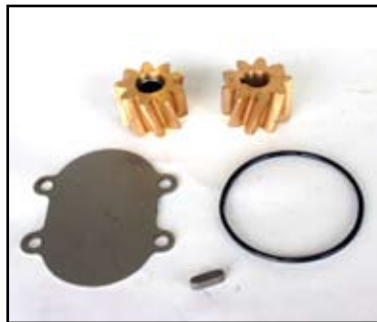
Use pliers to remove the gears and shaft key.



## Step 3

Clean gears, cover plate, and pump chamber with a non-aggressive degreaser.

- Gears
- O-ring
- Shaft key
- Cover Plate



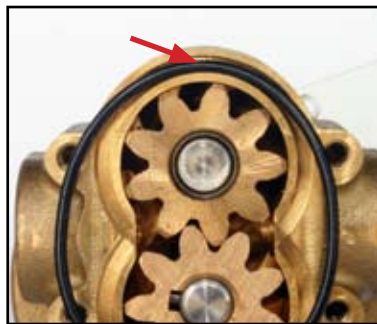
## Step 4

Reinstall shaft key into the drive shaft groove.



## Step 5

Replace the gears. To install the o-ring, start at the top of the pump head.



## Step 6

Place the cover plate on the o-ring and into the groove. Slide the cover plate from the top of the pump head to the bottom. Hold cover plate in place for a few seconds.



## Step 7

With the o-ring now in place, remove the cover plate and inspect positioning. The o-ring should be in the proper position. You may need to reapply silicone or a compatible o-ring lubricant.



## Step 8

Reposition cover plate, mounting bracket, and bypass. Tighten screws evenly in the sequence shown.

