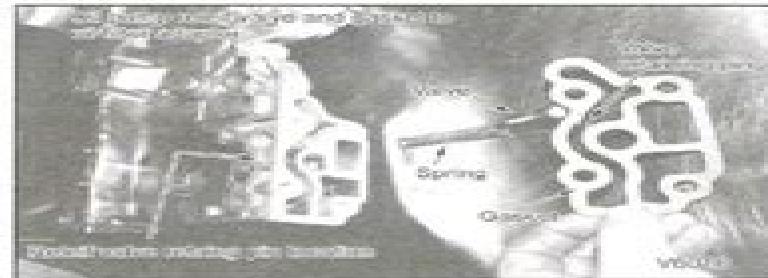


8. Remove power steering pump pulley and bolts.
9. Disconnect battery earth loom.
10. Disconnect the auto trans cooler pipes to the radiator.
11. Remove the beamng brace from the front of the sump area.
12. a) Remove the 3 bolts at the front of the sump to timing gear cover.
- b) Loosen sump bolts to engine block.
13. Remove the timing gear cover and gasket, 7 bolts and 3 studs.
- a Note: The water pump and camshaft sensor are removed with the timing gear cover and will only need separating if necessary.
- Oil Pump**
14. Remove oil filter.
15. Remove the oil filter adapter and gasket, 4 bolts. The oil pressure regulator spring and valve will also be released.
16. Remove the oil pump rear cover from inside the timing gear cover, 5 screws (Torx T30).
17. Remove front oil seal with a seal remover tool or screw driver.

#### Clean and Inspect

Clean any sludge from inside oil pump and around oil pump rotors. Inspect the inside of the pump housing and the outer gear and inner rotor for damage or excessive wear. Install the outer gear and the inner rotor shaft assembly with



the timing marks on the gear and rotor towards the pump cover. Inspect clearances of outer gear and rotor gear, replace if not within specification.

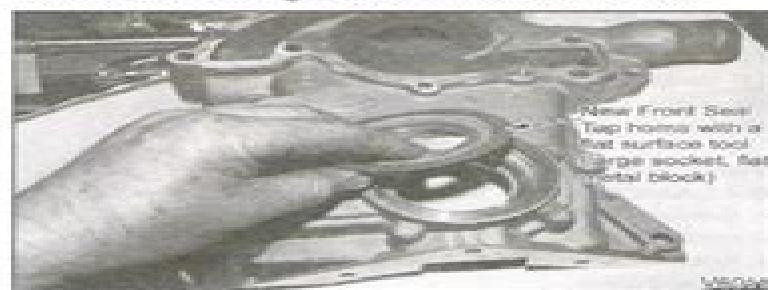
**Inner gear tip to outer rotor tip specified clearance:**  
Max: 0.22mm

**Outer rotor to pump housing clearance:** 0.05-0.13mm  
The inner rotor and outer gear are serviced as an assembly. One part should not be replaced without replacing the other. Check the clearance between the oil pump cover and gear / rotor is within specification with a straight edge.

**Oil Pump Cover Clearance:** 0.025-0.089mm  
Check the clearance between the oil pressure relief valve and bore is within specification.

**Oil Pressure Relief Valve Clearance:** 0.038-0.076mm  
**Install**

1. Install a new front seal into the timing gear cover, use a seal insertion tool or a large socket that is the correct size.



2. Install the oil pump gear and rotor into the timing gear cover, install cover and 5 screws, (Torx T30).

**Oil Pump Cover Screws:** 8-14Nm

a Note: Inner gear chamfered edge is facing towards the engine block.

#Tip: Fill in around oil pump rotor and gear with petroleum jelly.

3. Install oil pressure regulator spring and valve, oil filter adapter and new gasket with sealant, 4 bolts. Use Loctite 242 on the thread of the long bolt.

**Oil Filter Adapter Bolts:** 2.3-3.5Nm

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**Camilla Rothe**

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