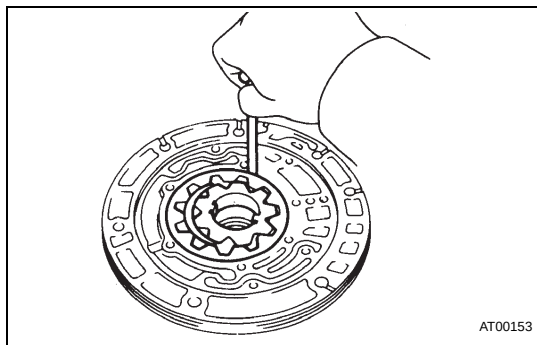
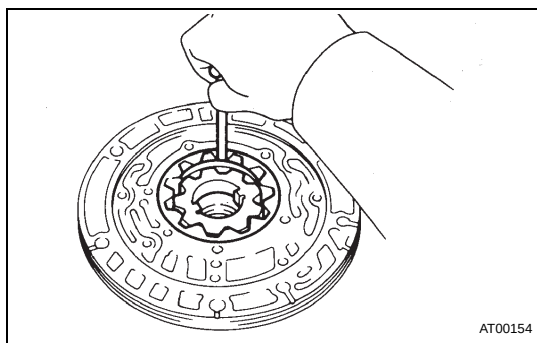




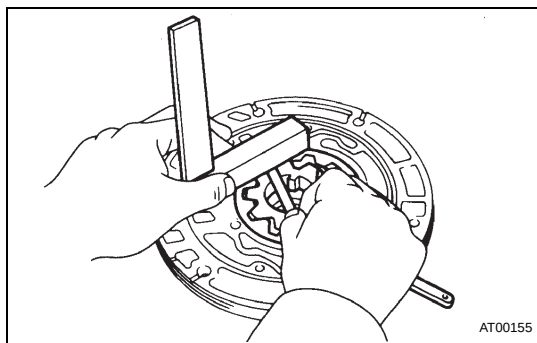
INSPECTION

1. INSPECT OIL PUMP ASSEMBLY

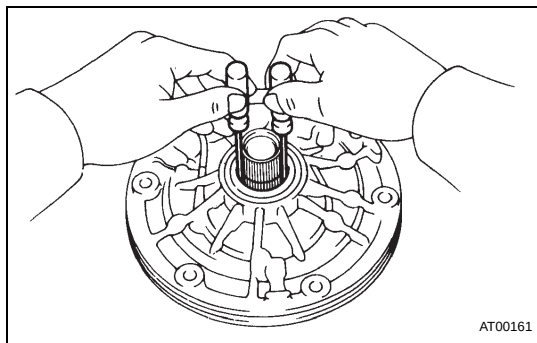
- (a) Inspect body clearance
- (1) Push the driven gear to one side of the body. Using a feeler gauge, measure the clearance.
- Standard body clearance:**
0.075 to 0.150 mm (0.00295 to 0.00591 in.)
- Maximum body clearance:**
0.3 mm (0.012 in.)
- If the body clearance is greater than the maximum, replace the oil pump body sub-assembly.



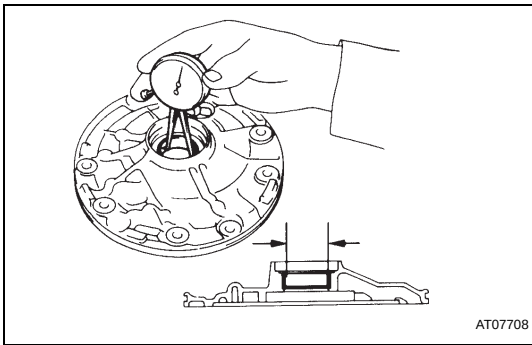
- (b) Inspect tip clearance
- (1) Measure the tip clearance between the driven gear teeth and crescent-shaped part of the pump body.
- Standard tip clearance:**
0.004 to 0.248 mm (0.00016 to 0.00976 in.)
- Maximum tip clearance:**
0.3 mm (0.012 in.)
- If the tip clearance is greater than the maximum, replace the oil pump body sub-assembly.



- (c) Inspect side clearance
- (1) Using a steel straight edge and feeler gauge, measure the side clearance of both gears.
- Standard side clearance:**
0.02 to 0.05 mm (0.0008 to 0.0020 in.)
- Maximum side clearance:**
0.1 mm (0.004 in.)
- If the side clearance is greater than the maximum, replace the oil pump body sub-assembly.



- (d) Turn the drive gear with 2 screwdrivers and make sure it rotates smoothly.
- NOTICE:**
Be careful not to damage the front oil pump oil seal lip.



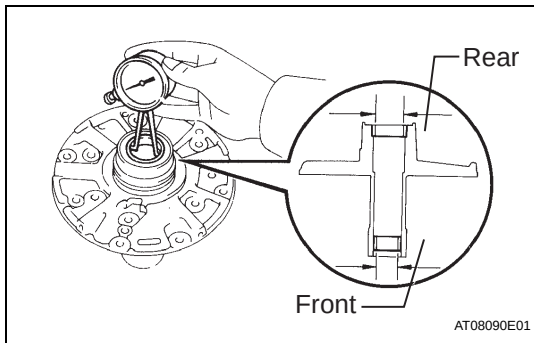
2. INSPECT FRONT OIL PUMP BODY SUB-ASSEMBLY

- (a) Using a dial indicator, measure the inside diameter of the front oil pump body sub-assembly bushing.

Maximum inside diameter:

38.18 mm (1.5031 in.)

If the inside diameter is greater than the maximum, replace the front oil pump body sub-assembly.



3. INSPECT STATOR SHAFT ASSEMBLY

- (a) Using a dial indicator, measure the inside diameter of the stator shaft assembly bushings.

Maximum inside diameter:

Front side:

21.57 mm (0.8492 in.)

Rear side:

27.07 mm (1.0657 in.)

If the inside diameter is greater than the maximum, replace the stator shaft assembly.

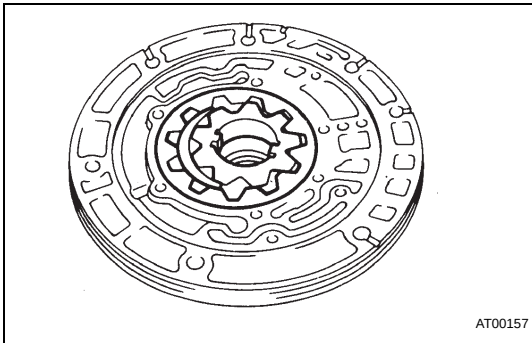
REASSEMBLY

1. INSTALL FRONT OIL PUMP DRIVEN GEAR

- (a) Make sure the top of the front oil pump driven gear are facing upward.

2. INSTALL FRONT OIL PUMP DRIVE GEAR

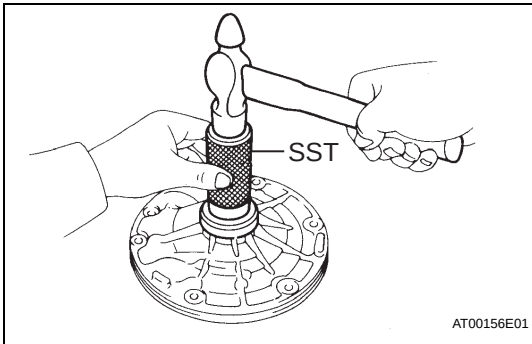
- (a) Make sure the top of the front oil pump drive gear are facing upward.



3. INSTALL FRONT OIL PUMP OIL SEAL

- (a) Using SST and a hammer, install a new front oil pump oil seal. The seal end should be flush with the outer edge of the pump body.

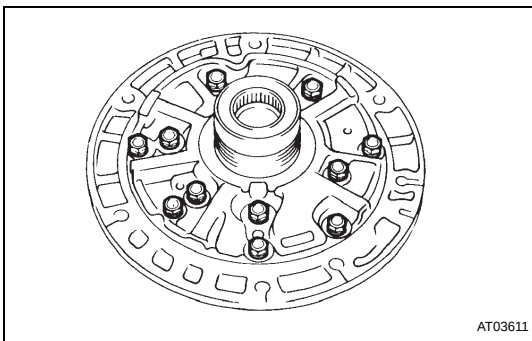
SST 09350-32014 (09351-32140)

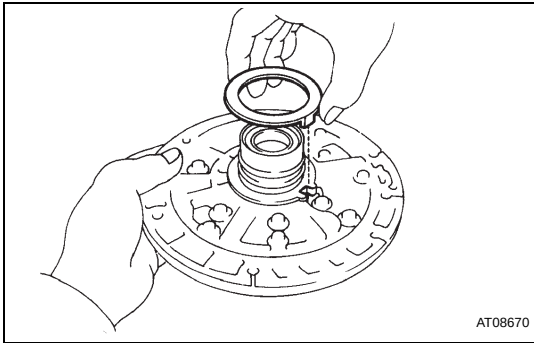


4. INSTALL STATOR SHAFT ASSEMBLY

- (a) Align the bolt holes of the stator shaft assembly with those of the pump body.
- (b) Torque the 11 bolts.

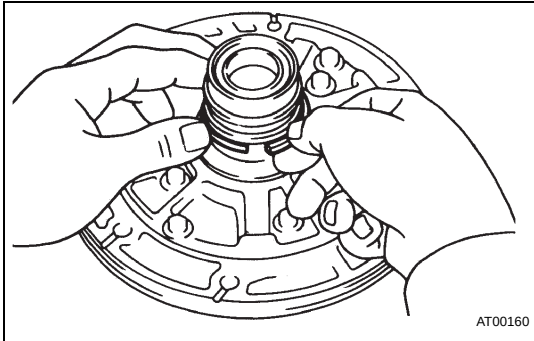
Torque: 9.8 N*m (99 kgf*cm, 86 in.*lbf)





5. INSTALL STATOR SHAFT CLUTCH DRUM THRUST WASHER

- (a) Coat the stator shaft clutch drum thrust washer with petroleum jelly.
- (b) Align the tab of the stator shaft clutch drum thrust washer with the hollow of the front oil pump body.



6. INSTALL CLUTCH DRUM OIL SEAL RING

- (a) Install the 2 clutch drum oil seal rings to the stator shaft back side.

NOTICE:

Do not spread the ring ends more than necessary.

HINT:

After installing the clutch drum oil seal rings, check that they move smoothly.

7. INSPECT OIL PUMP ASSEMBLY (See page [AX-201](#))