

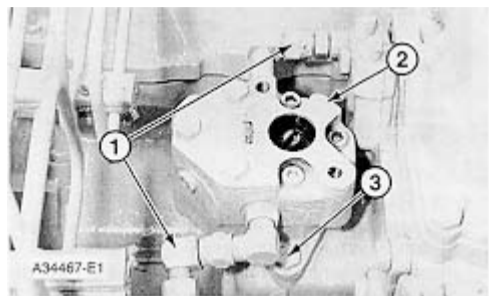
SMCS - 1256

SENR74100016

Remove Fuel Transfer Pump

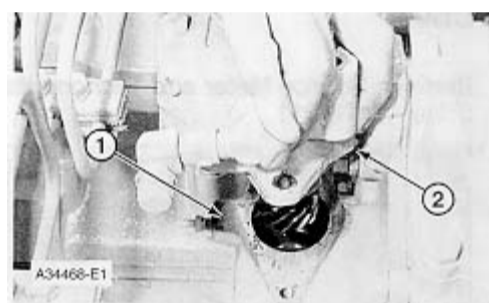
Start By:

- a. Remove service meter and tachometer drive



1. Disconnect two fuel lines (1) from fuel transfer pump (2).
2. Remove two bolts (3). Remove fuel transfer pump (2).

Install Fuel Transfer Pump



1. Put fuel transfer pump (2) into position on housing (1). Install two bolts that hold pump (2) to housing (1).
2. Connect two fuel lines to the transfer pump.

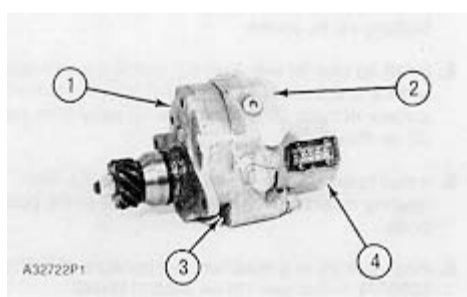
End By:

- a. install service meter and tachometer drive.

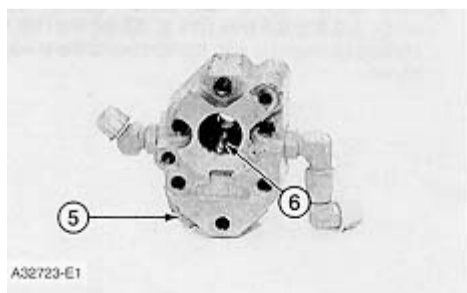
Disassemble Fuel Transfer Pump

Start By:

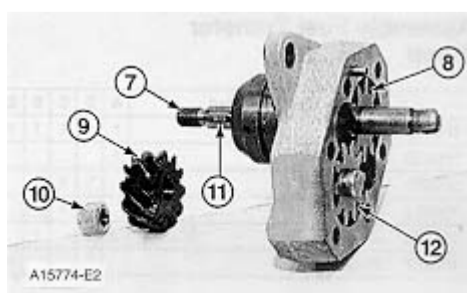
- a. remove fuel transfer pump



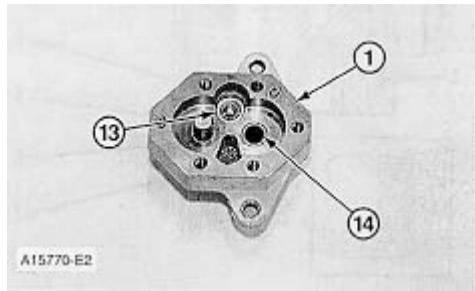
1. Remove service meter (4) and/or tachometer drive from transfer pump cover (3).
2. Remove bolts (2). Make a separation between cover (3) and pump body (1).



3. Remove lip type seal (6) from cover. Remove plug (5), seal, spring and plunger (bypass valve) from the cover.



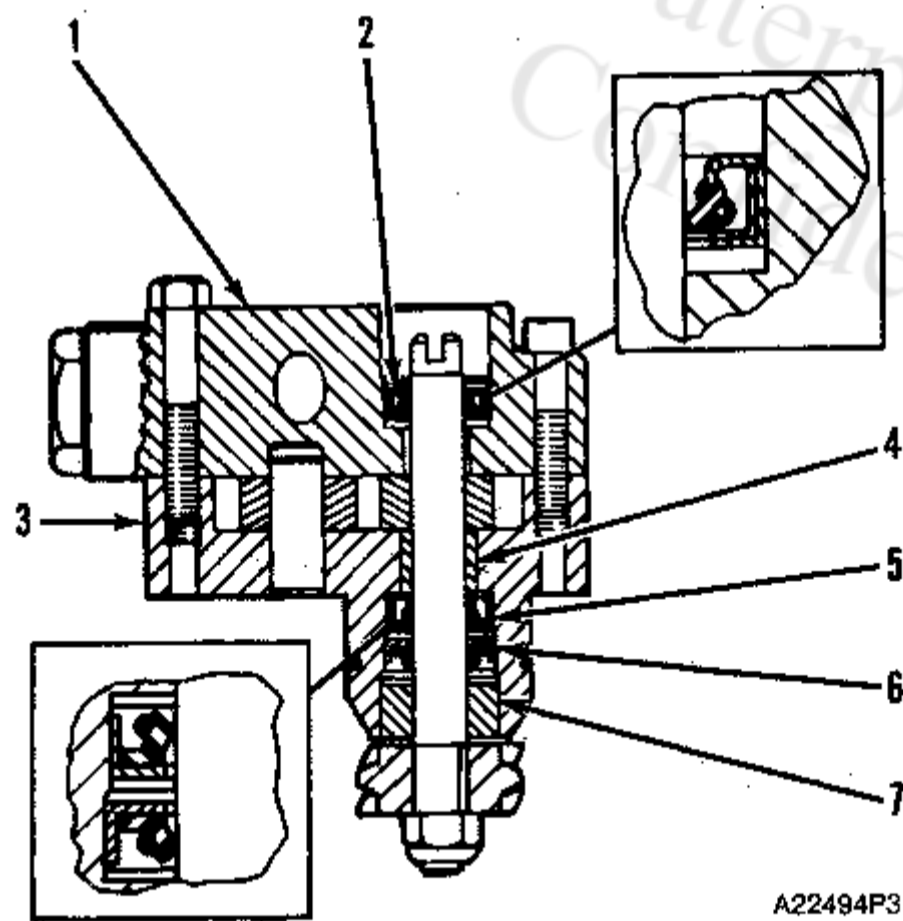
4. Remove nut (10) from shaft (7). Remove gear (9) and key (11).
5. Remove shaft (7) and gear (8) as a unit. Remove gear (8) from drive shaft (7) with a press.
6. Remove idler gear (12).



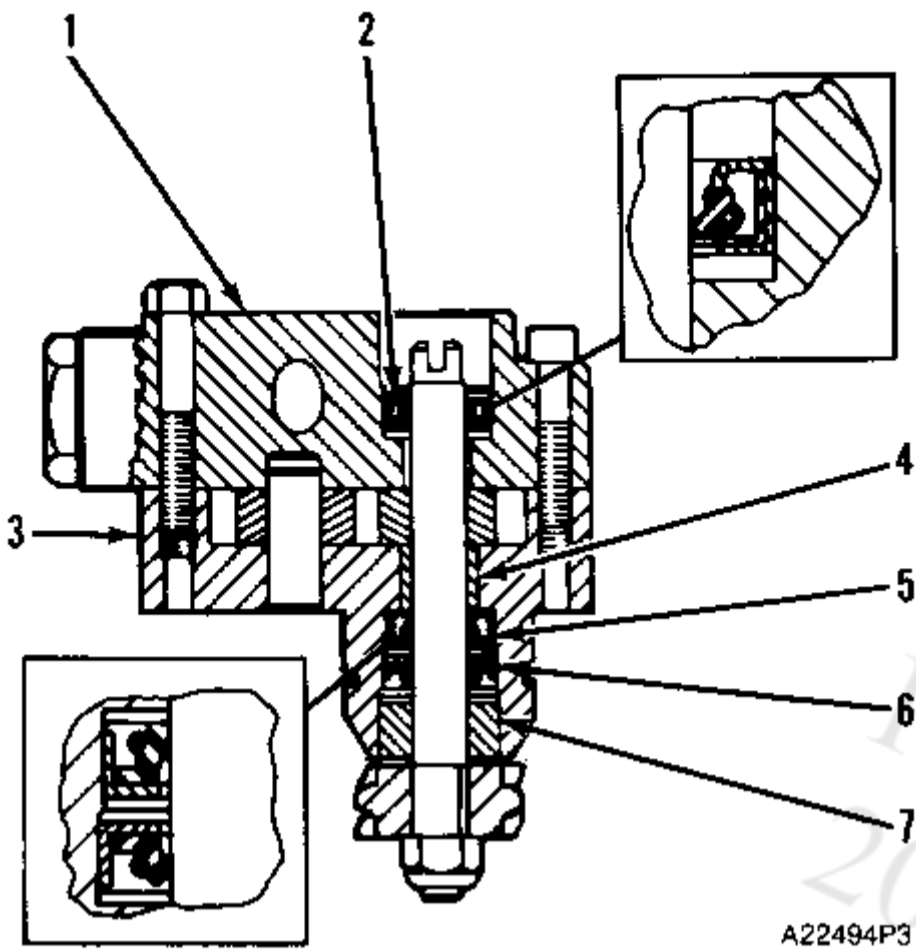
7. Remove bushing (14), two lip type seals and the bottom bearing from pump body (1).
8. Remove check valve (13).

Assemble Fuel Transfer Pump

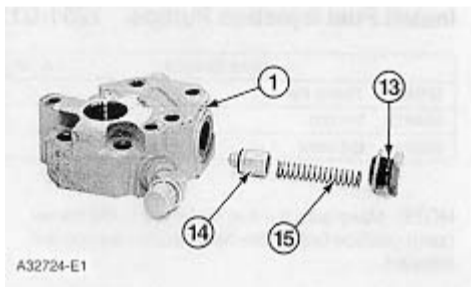
Tools Needed		A	B	C	D	E
1P0529	Handle	1	1	1	1	1
1P0459	Drive Plate	1				
1P0455	Drive Plate		1	1	1	
1P0462	Drive Plate			1		
1P0463	Drive Plate				1	
1P0467	Drive Plate					1



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1. Install bushing (4) in body (3) with Tool (B). The bushing must not be extended above the (gear) surface of the body.
2. Install the check valve in the body with Tool (A).
3. Install lip type seal (5) with Tool (C). Install the seal until it is $24.6 \pm 0.5 \text{ mm}$ (.97 \pm .02 in) from the bottom surface of body (3) and with the lip toward bushing (4) as shown.
4. Install lip seal (6) with Tool (D). Install the seal until it is $14.2 \pm 0.5 \text{ mm}$ (.56 \pm .02 in) from the bottom surface of body (3) and with the lip away from seal (5) as shown.
5. Install bearing (7) in body (3) with Tool (E). The bearing must be even with the surface of the pump body.
6. Heat gear (8) to a maximum temperature of 316°C (600°F). Install gear (8) on shaft (11) until dimension X is 49.71 ± 0.25 ($1.957 \pm .010$ in).
7. Install the drive shaft and gear in body (3). Install key, gear (10) and nut (9). Tighten the nut to a torque of $28 \pm 7 \text{ N}\cdot\text{m}$ ($22 \pm 5 \text{ lb ft}$).
8. Install idler gear (12) in body (3).
9. Install lip type seal (2) with Tool (C). Install the seal until it is $3.8 \pm 0.5 \text{ mm}$ (.15 \pm .02 in) from the top surface of cover (1) with the lip toward the inside as shown.



10. Install plunger (14) (bypass valve), spring (15), seal and plug (13) in pump cover (1). Tighten plug (13) to a torque of $38 \pm 4 \text{ N}\cdot\text{m}$ ($27 \pm 3 \text{ lb ft}$).
11. Apply Loctite 515 Gasket Eliminator on the surface of cover (1). Install cover (1) on pump body (3).

NOTICE

Do not let the liquid gasket enter the pump.

NOTE: The drive shaft must turn freely after the bolts that hold the transfer pump together are tightened.

12. Install the service meter and/or tachometer drive on cover (1).

End By:

- a. Install fuel transfer pump

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2022/11/30

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