INSTRUCTIONS

99TA516001 D

Instruction Sheet Number: **99TA516001 D**

99TA516001 D (for RCD use only)

Description: OIL PUMP PACKAGE

Author: R.D'aversa

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Part Number: 06LA660008

This oil pump package can be used as a replacement for oil pump packages 6L120-150 and 6L120-252.

Read these instructions completely in order to avoid damaging the pump, bearing head, or compressor.

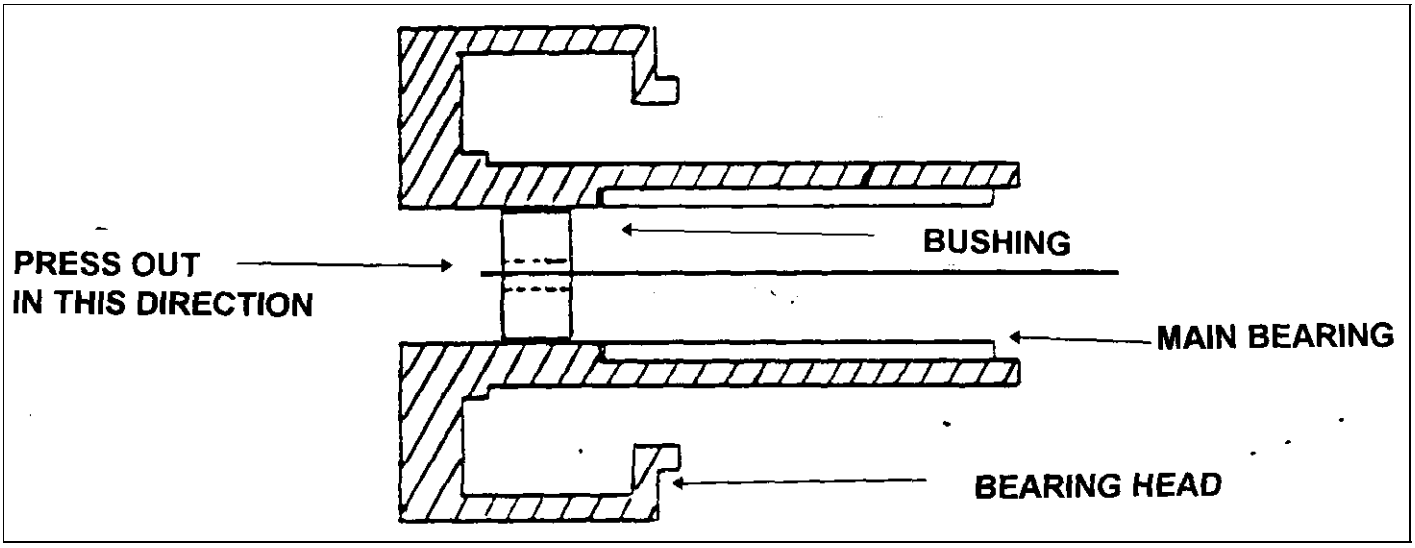
CONTENTS:

QTY	PART NUMBER	DESCRIPTION
1	6L120-397	Oil Pump Assembly
2	6L120-2672	Gaskets
1	6L120-2632	Adapter
6	AA44AA176	1/4 - 20 x 2 - 1/4 Cap Screw
6	AA44AA197	5/16 - 18 x 5/8 Cap Screw
6	AU11AS171	Lock Washer
1	.02 oz. Tube of CPF20-41	* Loctite 601

* Caution: May irritate sensitive skin. Contains methacrylic ester. Wash after skin contact.

DISASSEMBLY:

1. Drain the oil below the level of the bearing head.
2. Remove the bearing head from the compressor; make sure the main bearing is not damaged.
3. Remove the oil pump cover and gasket.
4. Remove the oil pump from the bearing head.
5. PRESS OUT the oil pump bushing. This must be done in the direction of the main bearing. DO NOT press the bushing out in the opposite direction to keep from raising burrs in the housing.



INSPECTION:

Inspect the bearing head for scoring. If the bearing head pump bore is scored, the bearing head must be replaced. If the main bearing head shows excessive wear, the compressor must be overhauled.

ASSEMBLY:

1. Mount the bearing head and new gasket (5H120-1653, not included in kit) on the compressor. Tighten the bolts to 80 1B-ft.

2. Place the gasket (6L120-2672 and adapter (6L120-2632) on the bearing head. Adapter is attached to bearing head with (6) 5/16 - 18 x 5/8 cap screws. Clean screw threads adequately and apply Loctite 601 to threads. DO NOT tighten the screw until the adapter is aligned (see Step 4).

3. Install the oil pump assembly through the adapter and gasket and halfway into the housing bore. (The halfway position allows for the use of an Allen wrench between the pump body and adapter.)

   NOTE: The clearance between the oil pump assembly and the bearing head bore is very close.
   DO NOT force the pump assembly into the bearing head; it must be slid in place.
   DO NOT attempt to alter the clearance since this will adversely affect pump capacity.

4. To achieve the proper clearance, rotate the oil pump assembly as the adapter cap screws (AA44AA197) are tightened. There should be no binding between the oil pump assembly and the bearing head. If there is, the adapter is not properly aligned and realignment is necessary.

5. Remove the oil pump assembly from the bearing head and adapter assembly.

6. Place several drops of refrigerant oil in the oil pump cavity (cloverleaf) and rotate the oil pump tang manually.

7. Place the remaining gasket (6L120-2672) on the oil pump assembly. Line up the tang on the end of the oil pump shaft with the slot provided in the crankshaft. Install the pump assembly fully into the bearing housing; the tang must engage the crankshaft.

8. Turn the pump housing until the word “TOP” on the pump end cover is at the top of the pump

housing.

9. Pump is attached to adapter using (6) 1/4 - 20 x 2 - 1/4 cap screws. Clean screw thread adequately and apply Loctite 601 to threads.

10. Install the 6 cap screws (AA44AA176) with lock washers (AU11AS171) through the oil pump assembly and gasket and into the adapter. Tighten the cap screws.

11. Start the compressor and check the oil pressure. This oil pump will develop oil pressure in either direction of rotation. The correct oil pressure for compressors using this pump is 45 to 55 psi above suction pressure.

