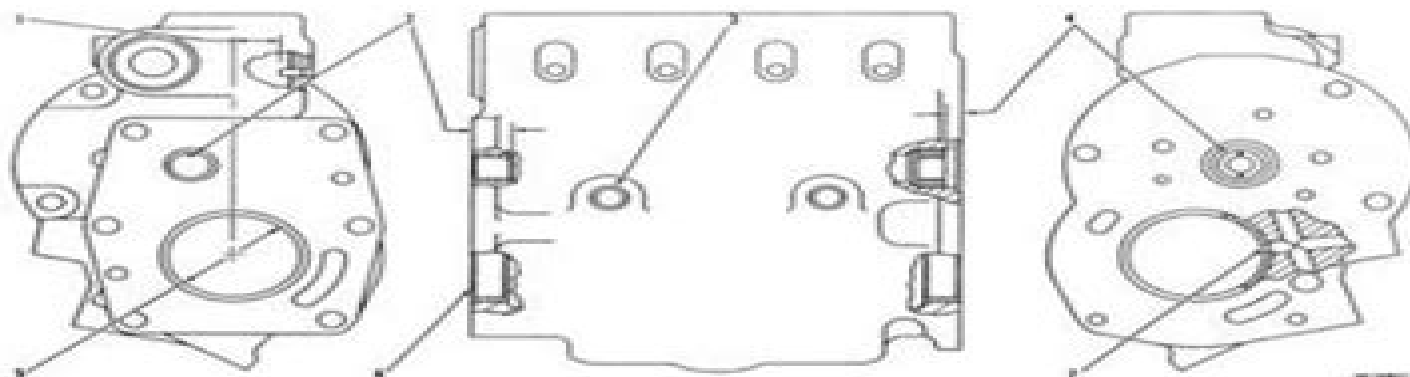


FUEL INJECTION PUMP HOUSING



- (1) Install dowel to get a dimension from centerline of fuel injection pump bore to dowel (install dowel hole with aluminum babb). $5.84 \pm .002$ in. (148.63 ± 0.05 mm)
- (2) Rack bearing alignment — the center of the rack bearing tab must be within .002 in. (0.05 mm) of a vertical line that:
 - (a) goes through the center of the rack bearing.
 - (b) is parallel to the vertical centerline thru the injection pump bore and camshaft bearing bore.

NOTE: The following tools are available to position the rack bearings correctly: SP1685 Alignment Plate and SP6329 Driver.

The correct bearing depth is controlled when driver is stopped by plate.

- (3) Install pins until they contact bottom of housing casting.

- (4) Install rear rack bearing to a depth of $.195 \pm .005$ in. (4.95 ± 0.13 mm)

NOTE: Small holes in bearing must be positioned as shown (parallel to the vertical centerline thru the pump).

- (5) Bore in bearings for the camshaft (new) $1.8775 \pm .0005$ in. (47.638 ± 0.013 mm)

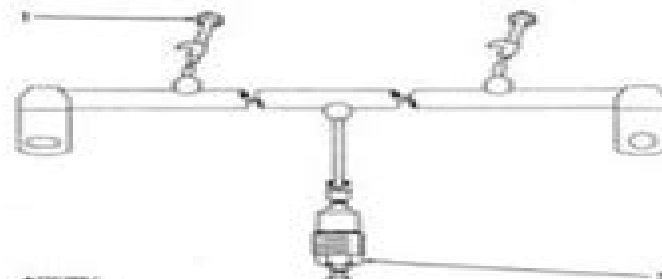
Diameter of bearing surfaces of the camshaft (new) $1.8730 \pm .0005$ in. (47.574 ± 0.013 mm)

Maximum permissible clearance between the bearings and the camshaft $.010$ in. ($.25$ mm)

- (6) Install camshaft bearings flush with front and rear face of housing.
- (7) Camshaft bearing oil hole. Position front bearing with oil hole in alignment with drilled oil passage in block.

GLOW PLUG CONNECTION
(IPC ENGINES)

- (1) Torque for the glow plugs (put SP3931 Anti-Seize Compound on threads) $1.20 \pm .24$ lb. in. (13.6 ± 2.8 N·m)
- (2) Torque for the plug for electrical connection (put SP3931 Anti-Seize Compound on threads):
 - Step 1: Tighten the plug by hand.
 - Step 2: Tighten the plug 2½ to 2¾ turns beyond hand tight.



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