

**Note:** Do not lubricate the new O-ring (10). The O-ring should be installed dry.

2. Install the new O-ring (10) onto the fuel injection pump. Position the fuel injection pump onto the front housing. Install the setscrews (13). Tighten the setscrews (13) to a torque of 25 N·m (18 lb ft).
3. Install the setscrew (15) and the bracket (11) onto the cylinder block if the bracket was previously removed. Ensure that the bracket (11) supports the fuel injection pump without applying any other external force on the fuel injection pump. Tighten the setscrew (15) to a torque of 44 N·m (32 lb ft).
4. Install the bolt (12) and the nut (14).

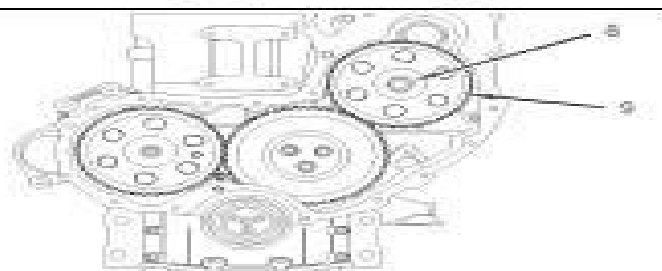


Illustration 19

g01011305

Typical example

**Note:** Ensure that the mating surfaces of the fuel injection pump gear and the shaft of the fuel injection pump are clean. Lubricate the threads of the shaft for the fuel injection pump. The nut (8) must turn freely until contact is made with the fuel injection pump gear.

5. Position the fuel injection pump gear (9) onto the shaft of the fuel injection pump. Install the washer and the nut (8). Rotate the fuel injection pump gear (9) in a counterclockwise direction in order to remove the backlash. Tighten the nut (8) to a torque of 24 N·m (17 lb ft).

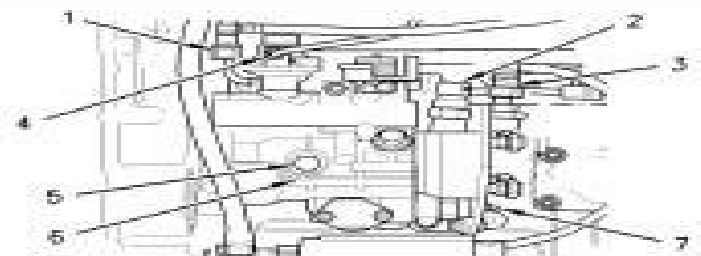


Illustration 20

g01002004

Typical example

6. Connect the harness assembly to the timing advance solenoid (7).
7. Connect the harness assembly (2).
8. Remove all of the dust caps from the connectors on the fuel injection pump. Remove all of the plugs from the fuel hose assemblies and from the tube assemblies.
9. Connect the fuel line (3), the fuel return line (1), and the tube assembly (4) to the fuel injection pump.
10. Loosen the locking screw (5). Move the spacer (6) in order to prevent the locking screw (5) from tightening against the shaft of the fuel injection pump. Tighten the locking screw (5) to a torque of 12 N·m (106 lb in).

**Note:** The spacer (6) must be correctly positioned and locking screw (5) must be tightened in order to prevent the locking screw from contacting the shaft of the fuel injection pump.

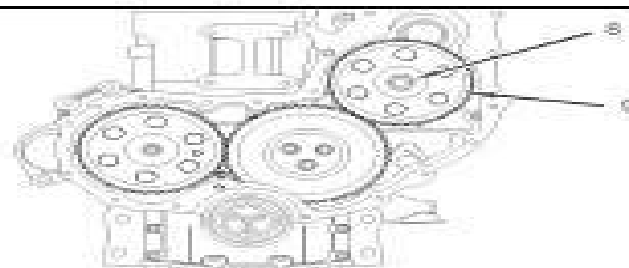


Illustration 21

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Typical example

# Perkins 1103 And 1104e Disassembly And Assembly Manual

**R Sandford**



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