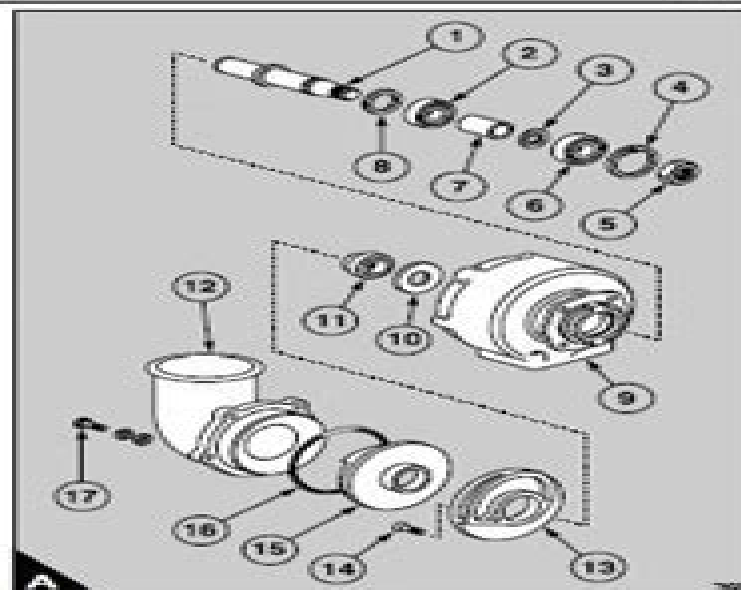


To assemble

- 1 Fit the backplate (A13) into the casing (A9). Apply some 'Loctite 242' to the screw (A14), fit the screw and tighten it securely.
- 2 Fit one of the bearings into the recess of the special tool, 21825 898, and use a hand press to press the shaft (A1) through the bearing until the bearing is against the shoulder of the shaft. Fit the distance piece (A7), complete with any shims (A3), over the shaft and fit the second bearing into the special tool, 21825 898. Use the hand press to press the shaft through the bearing until it is in full contact with the distance piece (A7) or shims (A3).
- 3 With the impeller end of the casing at the top, use the special tool, 21825 899, to press in the counterplate (A10). The rubber side of the counterplate **MUST** be fitted against the casing.
- 4 Rotate the casing so that the drive end is at the top. Slide the oil seal onto the guide, 21825 903, with the lip toward the drive end of the pump. Press the oil seal fully into its location. Remove the tool.
- 5 Use the press to fit carefully the assembly of the shaft and bearings into the casing. Ensure that the assemblies are correctly aligned during the operation.
- 6 Rotate the casing so that the impeller end is at the top and fit the coolant seal (A11). With the coolant pump drive shaft on the bed of a press, fit the impeller over the top of the drive shaft and locate the large end of the thrust pad, part of 21825 897, on the centre of the impeller. Ensure that the slot in the thrust pad is correctly aligned with the protrusion on the end of the shaft.
- 7 Use the press on the thrust pad to press the impeller onto the shaft. Press down the impeller boss onto the shaft until the upper face of the impeller boss is aligned precisely with the shoulder of the shaft.

Continued

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