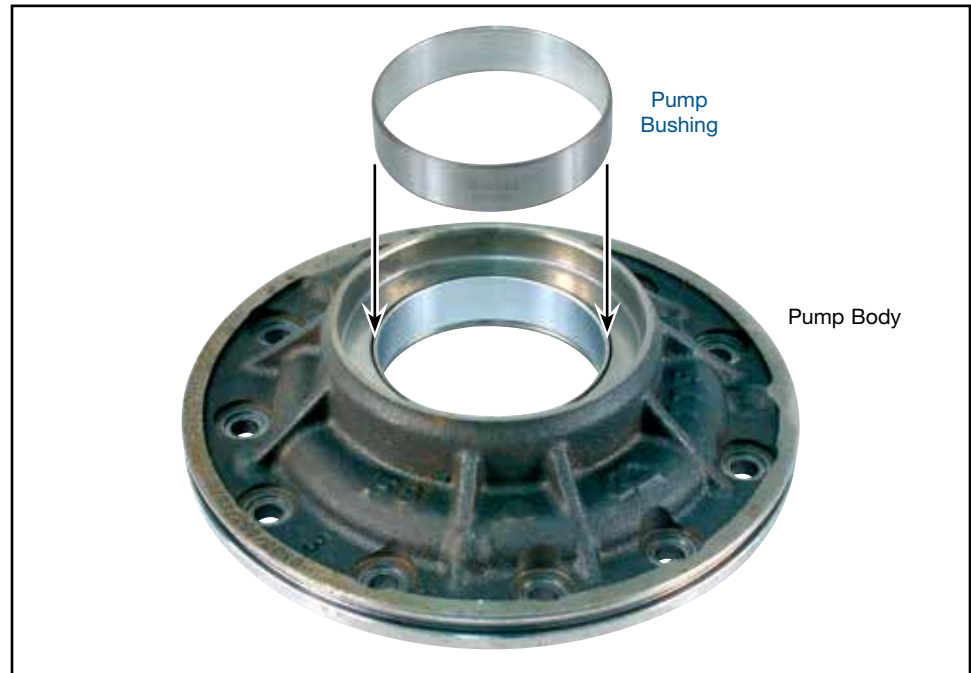


Pump Bushing

Part No.
120001A

NOTE: Finish-in-Place Bushing

Renault/Peugot AL-4, DPO



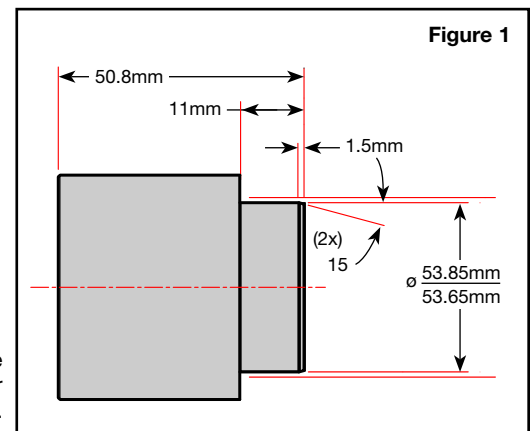
1. Tools Required for Machining Finish-In-Place Bushing

- Arbor press
- Shouldered arbor
- Lathe with a 3-jaw chuck that will open up to 152.4mm in diameter
- Magnetic indicator stand
- One-tenth indicator
- Carbide tipped boring bar
- Go/No Go plug gauge



NOTE: A Go/No Go gauge should be made to the following specifications: Go Diameter 54.465mm/No Go Diameter 54.485mm.

- A shouldered arbor should be made to the specifications shown (**Figure 1**).



2. Disassembly

- a. Remove seal from housing.
- b. Bushing must be removed toward seal pocket.



NOTE: Avoid damaging cavity bottom shoulder and bore surface.

3. Installation & Assembly

- a. Clamp on large O.D. being careful not to mark the surface.
- b. Indicate the I.D. of the seal bore where the seal is pressed into. This must run within 0.0127mm T.I.R.



NOTE: This diameter runs true with the I.D. where the bushing is pressed.

- c. Bore bushing I.D. to a size of 54.46/54.48mm; finish should be 0.4/0.8 micrometers surface finish or better. Verify with Go/No Go gauge.
- d. Install Sonnax seal.