

# **Component Procedures: Fluid Pump**

## **Table of Contents**

1. Parts and Labor (itype\_189)
2. Service Procedures (Article 2085157)
3. Disassembly and Assembly (Article 2085163)
4. Cleaning and Inspection (Article 2085161)
5. Mechanical (including Torque) (itype\_28)

# Component Procedures: Fluid Pump

## Parts and Labor (itype\_189)

### Parts

Qualifier	Part #	Name	Price	Note
30RH/31RH/32RH > Bushing > A?	2466796	2 - Bushing	0.00	
30RH/31RH/32RH > Bushing > A?	4058635	11 - Reaction Sha	0.00	
30RH/31RH/32RH > O-Ring > A9?	2204709	3 - Seal	0.00	
30RH/31RH/32RH > Ball > A904?	104918	5 - Reaction Sha	4.50	
30RH/31RH/32RH > Reaction Sh?	52118267	9 - Oil Pump With Reac?	0.00	
30RH/31RH/32RH > Gasket > A9?	52118266	10 - Gasket	0.00	
30RH/31RH/32RH > Seal Ring >?	4471874	12 - Ring	21.00	
30RH/31RH/32RH > Thrust Wash?	4617786	13 - Washer	0.00	

### Labor

Operation	Qualifier Path	Skill	Std Hrs	Wty Hrs
Replace	30RH/31RH/32RH > Front Pump	B	5.3	3.7
Replace	Bushing > 30RH/31RH/32RH	B	5.3	3.7
Replace	Reaction Shaft > 30RH/31RH/32RH	B	5.3	3.7
Replace	Reaction Shaft Bushing > 30RH/31RH/32RH	B	5.5	3.8

## Service Procedures (Article 2085157)

### OIL PUMP VOLUME CHECK

After the new or repaired transmission has been installed, fill to the proper level with MOPAR ATF

+4 (Type 9602)

automatic transmission fluid

. The volume should be checked using the following procedure:

1. Disconnect the FROM cooler line at the transmission and place a collecting container under the disconnected line.

CAUTION:

With the fluid set at the proper level, fluid collection should not exceed

(1) quart

or internal damage to the transmission may occur.

2. Run the engine at curb idle speed with the shift selector in neutral.

3. If fluid flow is intermittent or it takes more than

20 seconds

to collect

one quart

of ATF+4, disconnect the TO cooler line at the transaxle.

4. Refill the transaxle to proper level and recheck pump volume.

5. If flow is found to be within acceptable limits, replace the cooler. Then fill transmission to the proper level, using MOPAR ATF+4 (Type 9602)

automatic transmission

fluid.

6. If fluid flow is still found to be inadequate, check the line pressure using the Transaxle Hydraulic Pressure Test procedure.

## Disassembly and Assembly (Article 2085163)

For information regarding the Service and Repair of this component and the system that it is a part of, please refer to

Automatic Transmission

/Transaxle; Service and Repair.

## Cleaning and Inspection (Article 2085161)

### OIL PUMP AND REACTION SHAFT SUPPORT

1. Clean pump and support components with solvent and dry them with compressed air.

2. Check condition of the seal rings and thrust washer on the reaction shaft support. The seal rings do not need to be replaced unless cracked, broken, or severely worn.
3. Inspect the pump and support components. Replace the pump or support if the seal ring grooves or machined surfaces are worn, scored, pitted, or damaged. Replace the pump gears if pitted, worn chipped, or damaged.
4. Inspect the pump bushing. Then check the reaction shaft support bushing. Replace either bushing only if heavily worn, scored or damaged. It is not necessary to replace the bushings unless they are actually damaged.
5. Install the gears in the pump body and measure pump component clearances as follows:
  - a. Clearance between outer gear and reaction shaft housing should be 0.010 to 0.063 mm (0.0004 to 0.0025 inch)
    - . Clearance between inner gear and reaction shaft housing should be .
    - . Both clearances can be measured at the same time by:
      - (I) Installing the pump gears in the pump housing.
      - (II) Position an appropriate piece of Plastigage across both gears.
      - (III) Align the plastigage to a flat area on the reaction shaft housing.
      - (IV) Install the reaction shaft to the pump housing.
      - (V) Separate the reaction shaft housing from the pump housing and measure the Plastigage following the instructions supplied with it.
  - b. Clearance between inner gear tooth and outer gear should be 0.08 to 0.19 mm (0.0035 to 0.0075 inch)
    - . Measure clearance with an appropriate feeler gauge.
  - c. Clearance between outer gear and pump housing should also be 0.010 to 0.19 mm. (0.0035 to 0.0075 inch)

### **Mechanical (including Torque) (itype\_28)**

Oil Pump Gear Tip Clearance 0.0035 - 0.0075 in  
Bolt, Oil Pump 15 ft.lb