

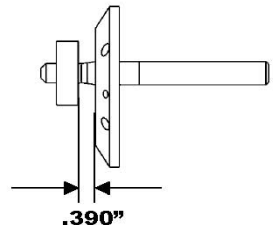
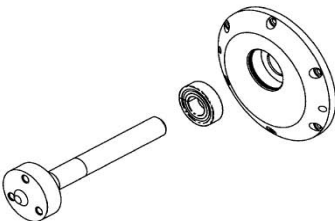


## VACUUM PUMP REBUILD KIT P/N 97642 & 97644

### Rebuilding Procedure

1. Remove the pulley from the Vacuum Pump and then take the Pump off of engine.
2. Starting at the back of the Pump, remove the Bearing Cap and then the Rear Cover.
3. Remove the Vanes from the Rotor slots noting that the notches on the bottom and top of the Vanes face towards the shaft and the worn in edge of the Vane curves to match the shape of the Rotor.
4. Remove the Front Cover, Rotor, and Shaft assembly. Slide Rotor off shaft.
5. Using a mild part cleaning solvent or soap and water, clean the Housing, Rotor, Shaft, Front & Rear Covers and Bearing Cap. Inspect parts for wear or damage.
6. To change Bearing in the Rear Cap, first remove the Snap Ring located on the outside of the Cap.
  - Press Bearing out from the bottom / inside of the Cap. Inspect and clean bore.
  - Set new Bearing into place. **On a flat, clean surface press in Bearing. Note: To prevent damage, press on the outer race of the Bearing and do not use excessive force. Install Snap Ring.**
7. To change Bearing in the Front Cap, press the Shaft out of the Bearing.
  - Remove Snap Ring, press Bearing out from bottom / inside of Cap. Inspect and clean bore.
  - Set new Bearing into place. **On a flat, clean surface press in Bearing. To prevent damage, press on the outer race of the bearing and do not use excessive force. Install Snap Ring.**
  - Next, press the Shaft / Hub into bearing. The distance of the Hub to the surface of the Front Cover should be .390". See diagram below. Note: Pumps built on or after 11/26/03 have a Hub Spacer that sits between the bearing and hub that sets this distance.
8. When all pieces are ready for assembly, place the Rotor Shaft Keys onto the Shaft and install Rotor onto Shaft.
9. Next, place the Rotor, Shaft and Front Cover assembly into the Housing.
10. Place the new Vanes into the Rotor making sure the Vane notches are facing the Shaft.
11. Replace Rear Cover and Bearing Cap. Install and tighten Front and Rear Cover hardware and Bearing Cap Screw. Re-install Pump onto your engine and re-install pulley and belt.

Contact Moroso Performance Technical Service Dept. at (203) 458-0542 for information on how we can service your pump for you.



**For Technical Assistance, Call Moroso's Tech Line at  
(203) 458-0542, 458-0546 8:30am – 5:00pm Eastern Time**

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