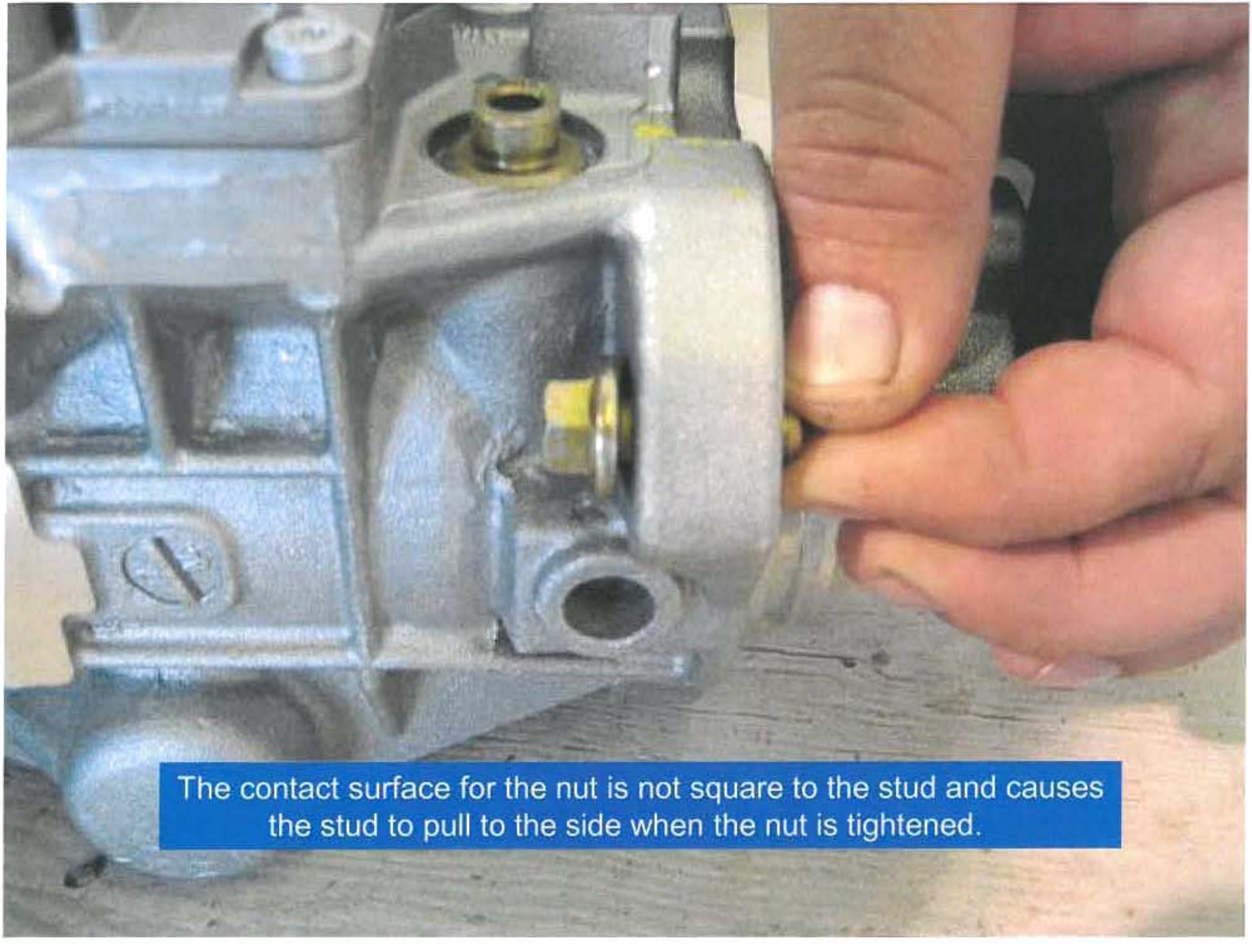
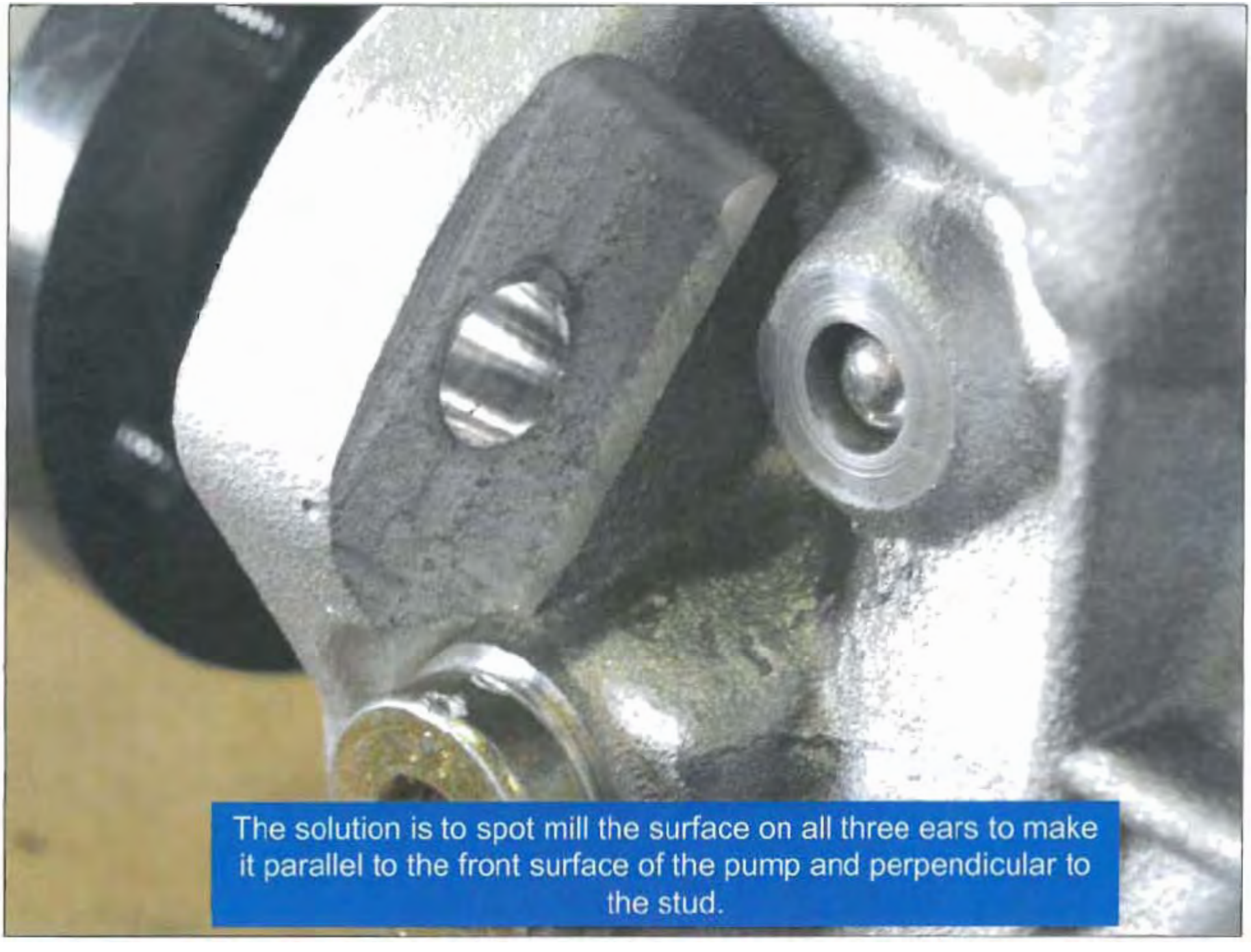
Applies to both 4 and 6 cylinder

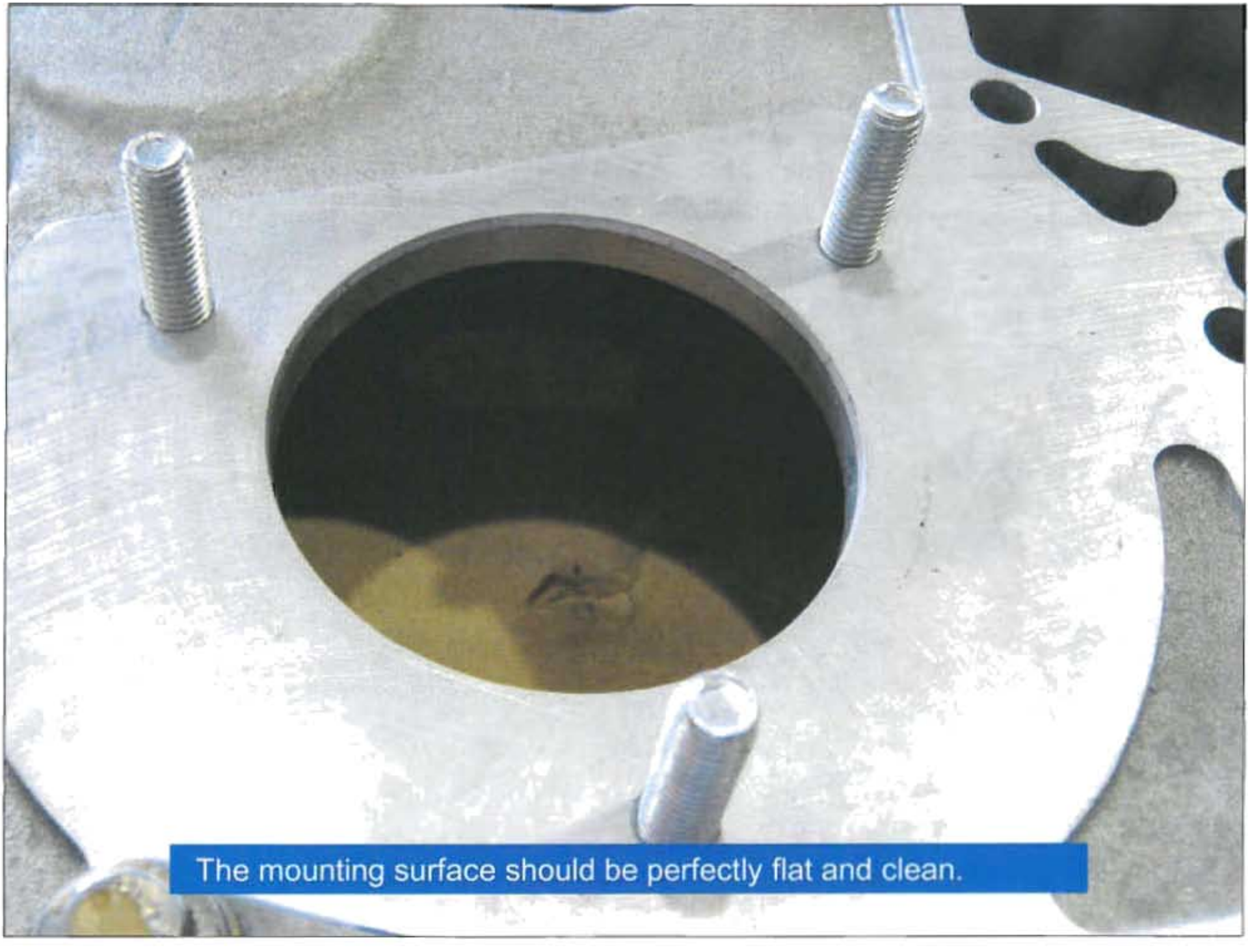
3056E Fuel Pump Mounting Instructions for the Field

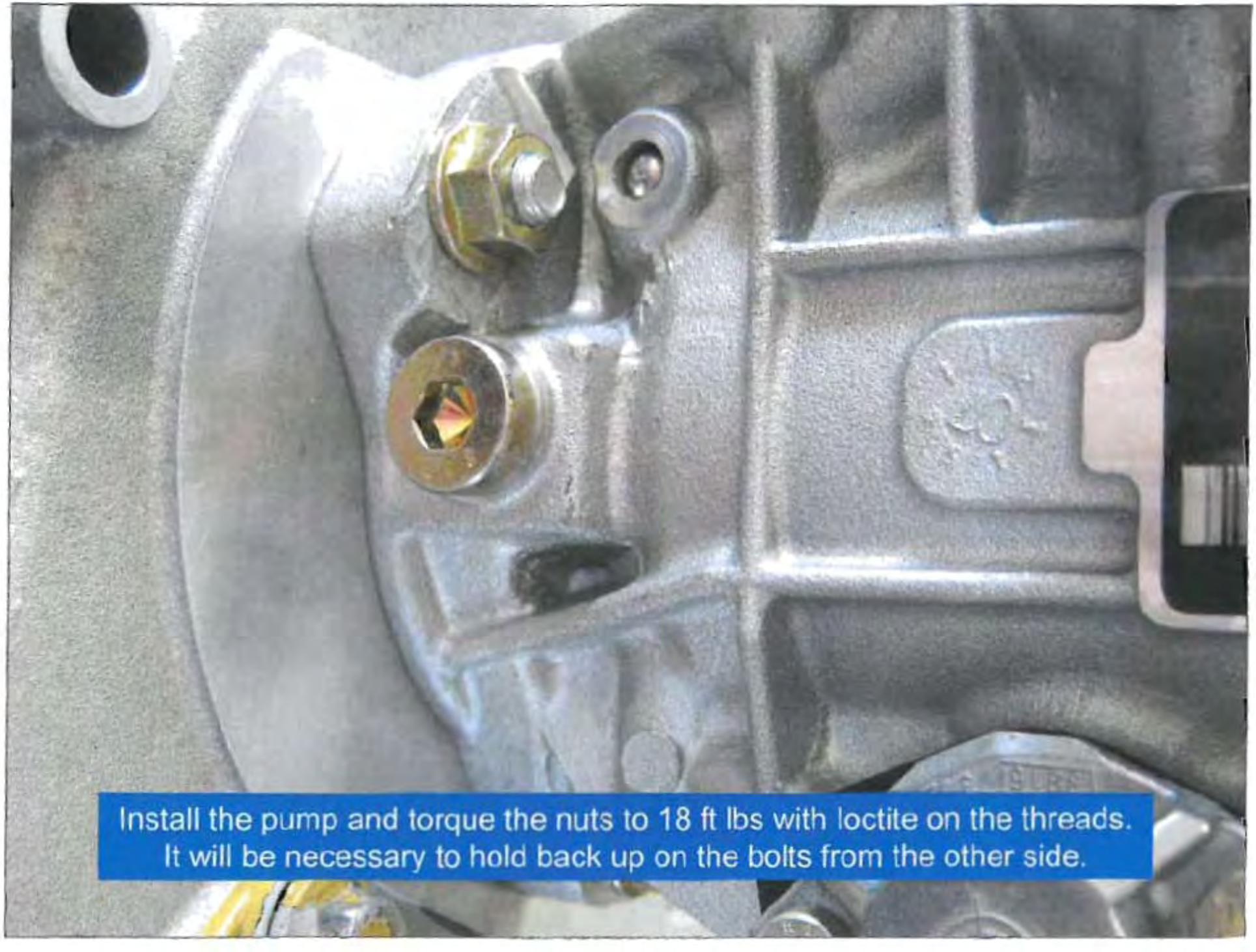
(Perkins VP30)

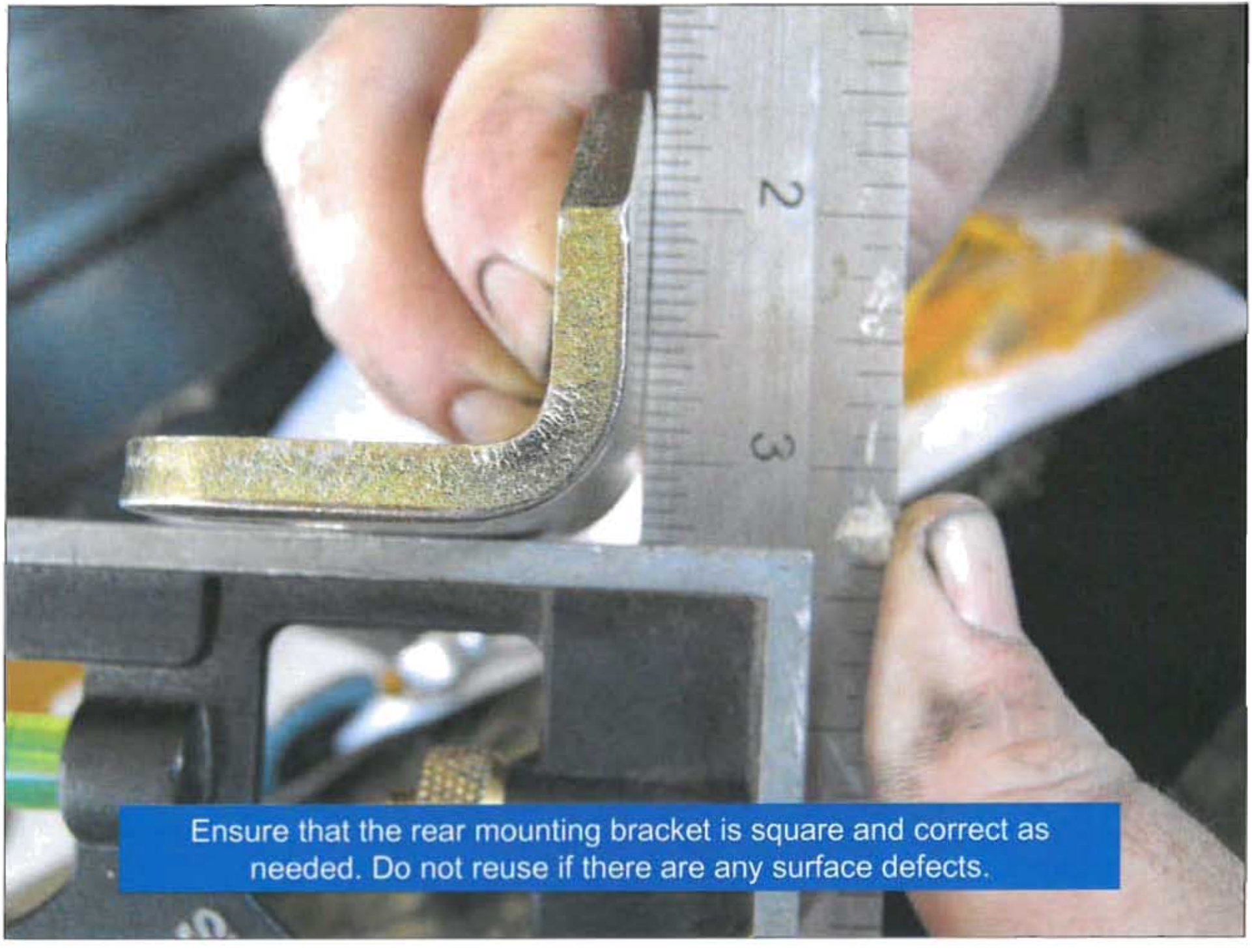

The contact surface for the nut is not square to the stud and causes the stud to pull to the side when the nut is tightened.

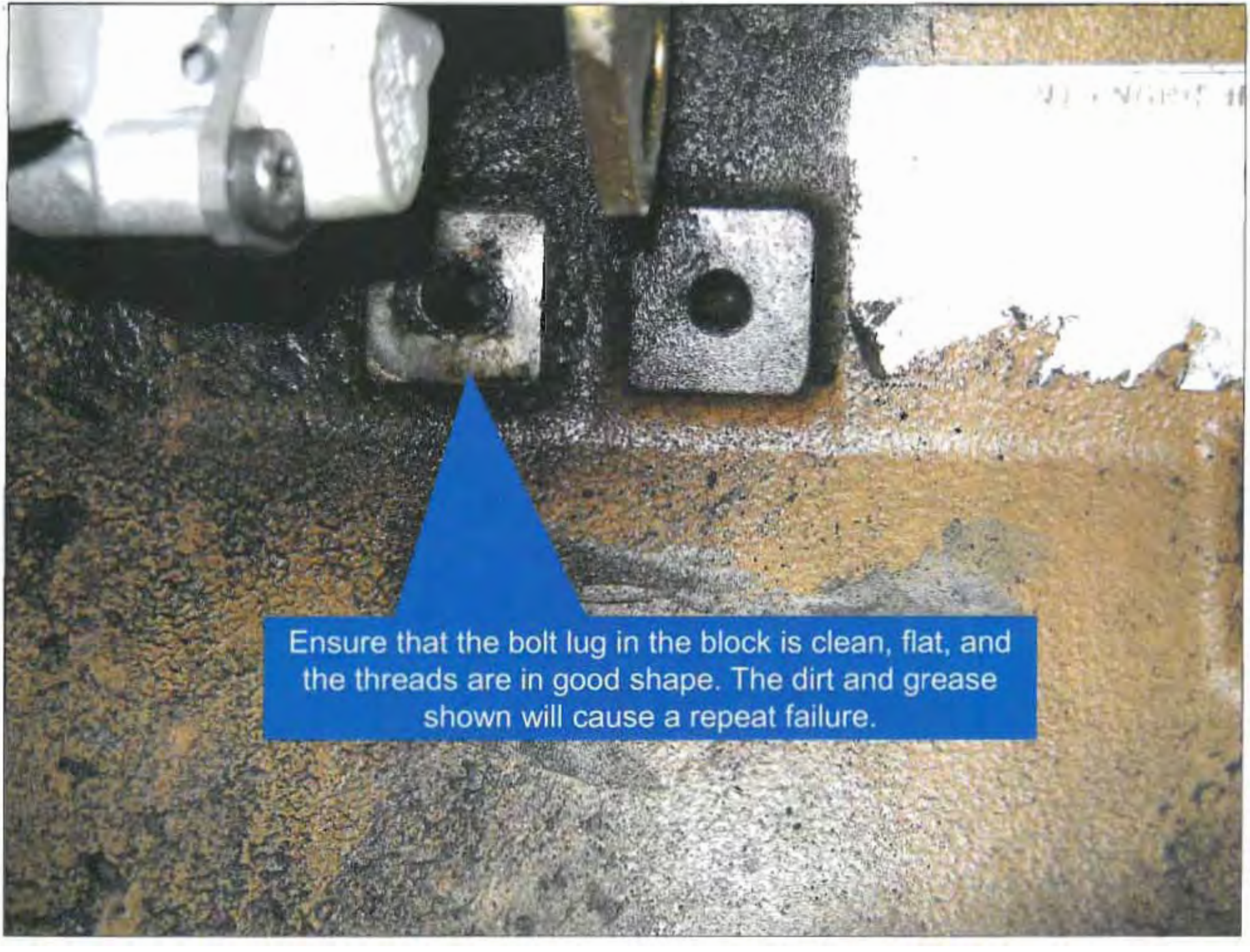

The solution is to spot mill the surface on all three ears to make it parallel to the front surface of the pump and perpendicular to the stud.

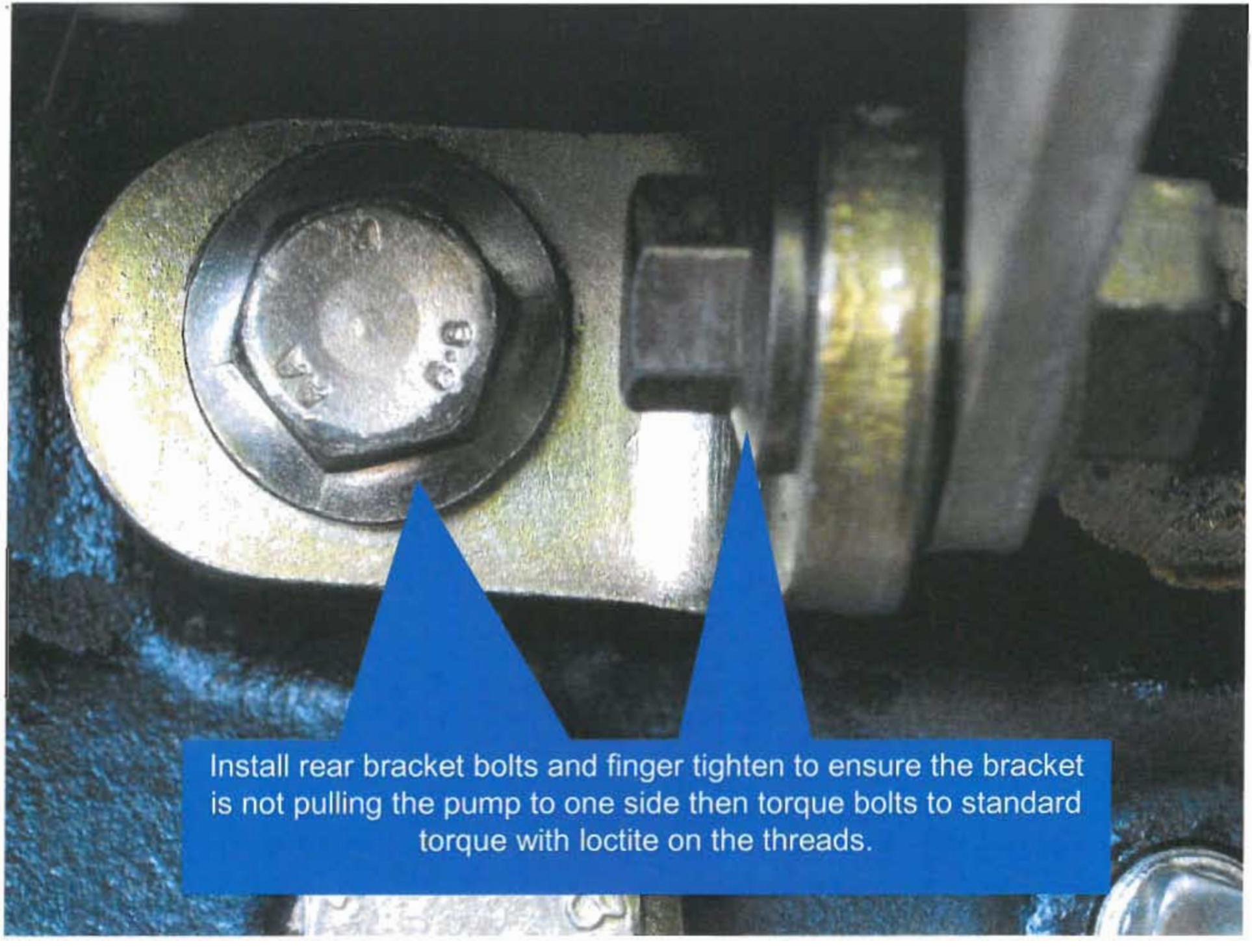
Install three 8T-4154 bolts into front housing instead of using the studs to prevent them from pulling out of the front housing. It will be necessary to chase the threads down to the head of the bolt with a die.


The mounting surface should be perfectly flat and clean.


Install the pump and torque the nuts to 18 ft lbs with loctite on the threads.
It will be necessary to hold back up on the bolts from the other side.


Ensure that the rear mounting bracket is square and correct as needed. Do not reuse if there are any surface defects.


Ensure that the bolt lug in the block is clean, flat, and the threads are in good shape. The dirt and grease shown will cause a repeat failure.


Install rear bracket bolts and finger tighten to ensure the bracket is not pulling the pump to one side then torque bolts to standard torque with loctite on the threads.