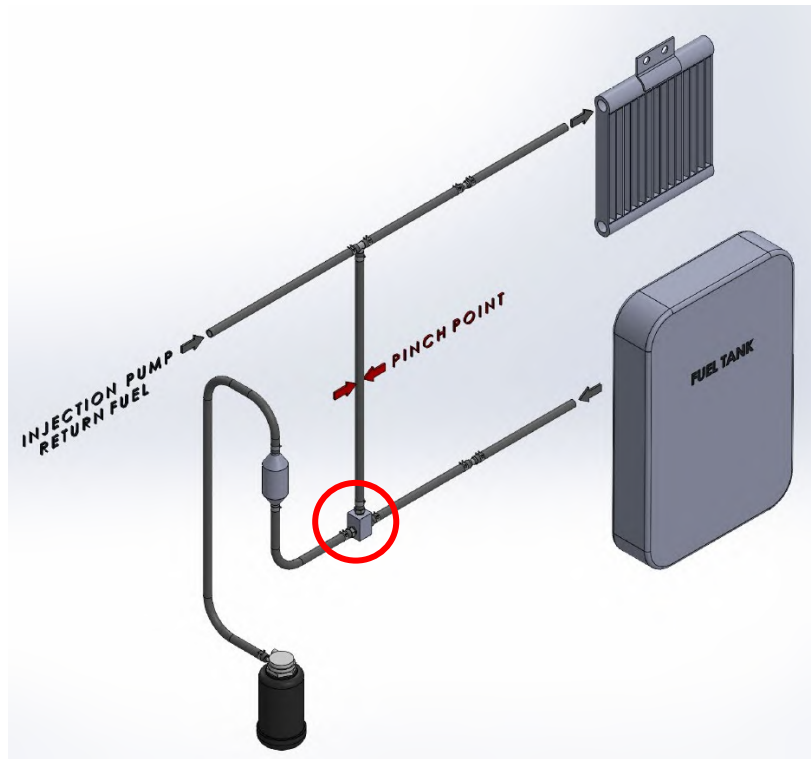


SUBJECT: Delphi Technologies® EX836100 & EX836101 High-Pressure Injection Pump Installation Instructions

When replacing the high-pressure injection pump for Bobcat® D18/D24/D34 engine applications, the following critical steps must be performed. Prior to commencing the injection pump removal process, ensure that the engine bay is free of any dirt/debris; failure to do so may result in the introduction of contaminants causing premature wear to the fuel system.

1. The [EX836100](#) & [EX836101](#) high-pressure fuel pumps are not supplied with the drive gear. The drive gear must be transferred from the core pump to the new pump. Drive gear nut must be torqued to 64 nm (47 ft-lb).
 - a. Timing of the pump to the engine is not critical. On the face of the drive gear there are two crank timing marks. Timing marks can only be matched to the crank if the engine front cover is removed.
2. Install the pump with drive gear onto the engine. Torque the pump to engine mounting bolts to 22 nm (16 ft-lb).
3. The high-pressure fuel line to the rail is a one-time use and must be replaced after removing the line. The torque for the line nuts is 30.4 nm (22 ft-lb).
4. Upon complete assembly, air must be removed from the fuel system.
5. Open the vent plug on the fuel filter assembly followed by squeezing the hand pump until fuel flows from the air vent plug with no air bubbles. Once that is completed, close the air vent plug on the filter.
6. Locate the fuel recirculation valve in the return circuit. Locate the fuel return line going to the recirculation valve coming from the pump return circuit. Pinch off the return hose with a suitable pinching plier. Squeeze the hand pump until hard. Start the engine and let it idle for 3 minutes with the line pinched. Shut down the engine and remove the pliers from the line to complete the bleeding procedure.
 - a. *See schematic on the following page.*
7. To complete the installation procedure, a high-pressure injection pump reset procedure must be carried out using a suitable diagnostic scan tool.



Note: Fuel priming schematic referenced in step 6