

ASSEMBLY INSTRUCTIONS

CHAIN SAW 630 / 640 / 633

Installation of Oil Pump

Correct centering of the oil pump can only be guaranteed with the use of a special **Engine Centering Gauge, part no. 00 80 535** and **Oil Pump Centering Gauge, part number 00 80 536**.

Use Oilpump Repair-Set part number 06 10 533!

It is **very important** to check the engine position whenever there has been some damage to the oil pump ! It is quite possible for the engine block to shift slightly in the main housing after receiving a sharp knock that would lead to oil pump damage.

It is also important to ensure the support strip (**Fig. 3**) is definitely fitted under the oil pump on **model 630 to machine number 3650, model 640 to machine number 3032** and **model 633 to machine number 14493**.

Additional instructions

On model 630 as of serial no. 4721 and model 640 as of serial no. 3433 the oilpumpsystem includes the location pin (Fig.1A).

Previous produced chainsaws can be retrofitted with the new **oilpumpsystem 06 10 533** with some minor modifications on the crankhousing. On earlier units the location pin inside the crankhouse must be pulled off it's seat with an appropriate plier such a edge cutter.

Procedure of installation

Remove the location pin off it's location with an edge cutter, take attention not to damage the guiding lugs at the crankhouse (**Fig.1 B**).

Adjustment

Always check the position of the engine before installing a new oil pump. Any adjustment to the engine position is possible only after all 4 engine mounting screws (Torx 25) have been loosened ! (**Fig.1**).
Loosen engine mounting screws and push the **engine centering gauge, part no. 00 80 535** over the crankshaft to the base of the housing. (**Fig.2**).

Oil Pump Installation

The following hints and recommendations are provided for the correct installation of the pump: -

For easier installation, grease the rubber block on the pre-assembled oil pump (**Fig. 4**).

Use fast drying glue (Super Glue, Kwik Grip or similar) to attach support strip (**Fig.3**) to main housing. The strip will balance possible gaps between the main housing and the pump body.

Fig. 1

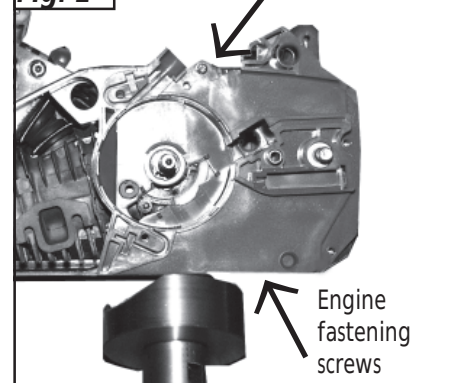


Fig. 1A

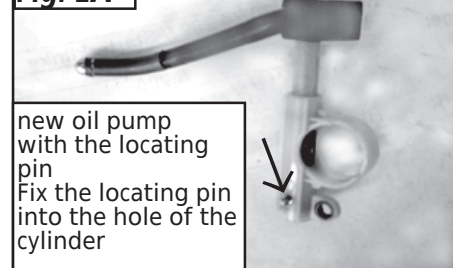


Fig. 1B

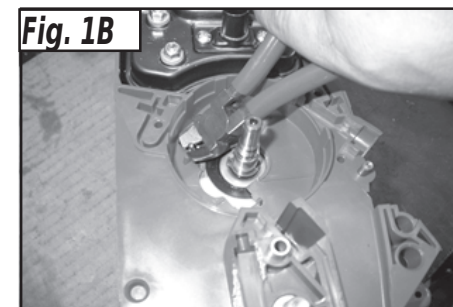


Fig. 2

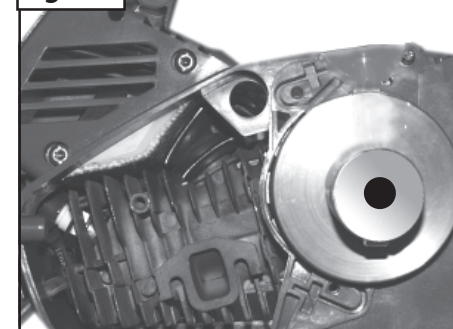
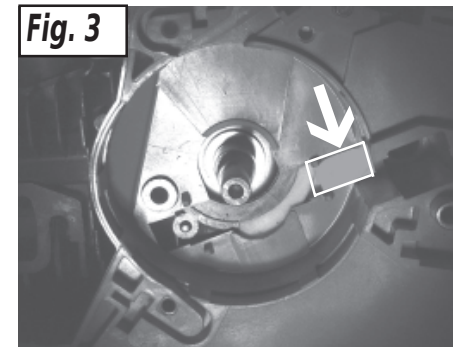


Fig. 3

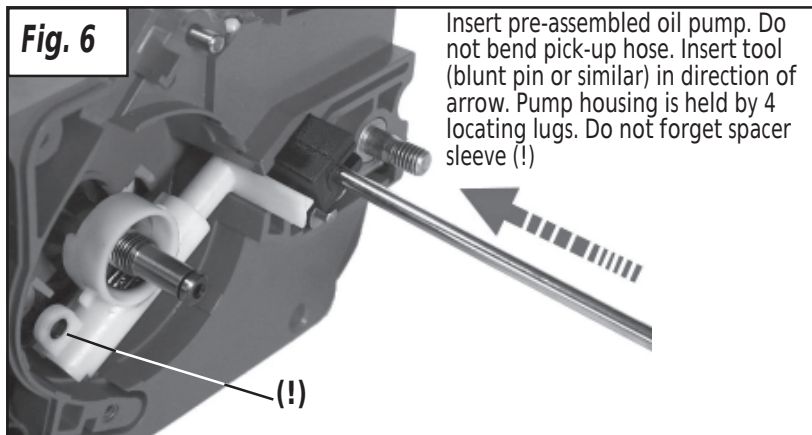


Before placing the oil pump, check and remove a possible casting burr (see arrow) on the main housing. The pump should seat neatly in the housing (**Fig.5**).

Hint: The oil pump has to be placed within the 4 guide lugs and spacer sleeve (**A**) (**Caution - only use black spacer washers**) in the main housing. The pump piston must be turning freely after the pump is fitted.

When installing the pump, also ensure the oil pick-up hose is not bent. We recommend the use of a wire loop through the oil tank filler inlet to straighten and correctly place the pick-up hose in the oil tank.

The pump is easily fitted into the main housing if a blunt tool (such as a Torx Key T-25) is inserted in the oil channel of the rubber block. (**Fig.6**).



The next step is the centering of the oil pump with the help of the **oil pump centering gauge, part no. 00 80 536 (Fig. 7 + 10)**.

Apply Loctite 243 to the oil pump fastening screw and tighten with a torque rating of 2.5 Nm.

Caution ! There is only one position to push the oil pump centering gauge into the oil pump. The recess has to be parallel to the teeth of the pump piston.

Please take note of the hints and notes in the attached pictures.

