



PICKUP INSTALLATION

CHEVY SMALL BLOCK AND BIG BLOCK

Part #18200, 18201, 18202, 18300, 18301, 18302, 18305, 18306, 18307, 18308,
18309, 18310, 18311, 18312, 18313, 18314, 18315, 18316, 18317, 18465

This Milodon [oil pump](#) pick-up is specially designed with a Milodon exclusive CNC billet steel bung going into the pump. This bung is precision machined for a tight press fit, which insures that the pick-up will stay secure in the pump at all times and have a 100% seal.

All Milodon pickups use a clearance bracket on the bottom of the pickup. This bracket will assure that the oil pump always has an adequate flow of oil to keep oil pressure constant and prevent bearing damage. The pickup being inadvertently too close to the floor of the oil pan will cause poor oil pressure. This can not happen with a Milodon pickup. Care **MUST** be taken however to be sure that there is no constant contact between the bracket and floor of the pan. This will over stress both the pan & pickup during operation and one or the other will break. Any sustained contact between the pan and pickup will void any and all warranty for the pan and / or pickup breaking.

To install pick-up into pump, place the oil pump in a bench vise with the pick-up hole facing up. Make sure you do not overtighten vise, as you could distort or crack the pump housing. Also, never install pick-up while pump is mounted to motor - this may cause neck of pump to crack and break while in use later.

Once pump is mounted in vise, place the pick-up in hole. Placing the pickup overnight in the freezer will make installation a lot easier. For round bung style pickups, use an open-end 5/8" or 3/4" wrench (depending on tube size) put on the outside edge of bung. With a hammer, strike the wrench to drive the tube into pump. For square style bungs it is acceptable to strike the bung itself to drive it in. The bung must be pressed in completely, flush up against pump. The bung will not be easy to press in, but then the intent is for it to seal positively and not fall out in use!

You may now install bottom bracket using the washer supplied in the kit. Due to the precise press fit, there is no need and recommended not to weld the pick-up. Use the supplied flat washer to properly spread the bolt load and prevent tab breakage. Once the pump and pickup are installed on the motor you must check for the proper pan to pickup clearance. All applications require 3/8" clearance to the pickup face. There should be about 1/8" between the clearance bracket and the floor of the pan. Measure the inside of the pan then the pickup face to the block pan rail. There must be 1/4" minimum to 3/8" maximum clearance. The pickup height can be adjusted slightly by rotating the pickup in the pump, which will either lower or raise the pickup to the correct position.