



**SBC HI-VOLUME "TOUGH-NECK" OIL PUMP**  
**P/N 22109**  
**INSTALLATION INSTRUCTIONS**

The following precautions should be followed when installing a new oil pump:

**1. CLEANLINESS**

Be sure to thoroughly clean oil pump inside and out to eliminate any dust or dirt that might be present. Before installing on engine, submerge the pump in clean oil and rotate the gears by hand.

**2. CLEARANCE**

After the pump is installed on the engine, install the distributor and check end play of the oil pump drive shaft. If no end play is present, corrective measures must be taken or the pump drive gear will score the pump cover causing premature pump failure and possible bearing problems. Before the final installation of the oil pan, check the clearance between the pump pickup screen and the pan bottom. Ideal clearance is 1/4" to 3/8" to ensure adequate oil supply at all speeds.

**NOTES:**

- A.** Check the Moroso Product Catalog for the proper pickup for your pan.
- B.** On high volume pumps, a new intermediate shaft with a pinned steel sleeve must be used. Moroso and other manufacturers offer driveshafts with steel sleeves. If the steel sleeve is not used, the driveshaft of the oil pump can be damaged, resulting in failure of the pump. Failure to follow this warning voids any warranty of the product.