

## REASSEMBLY

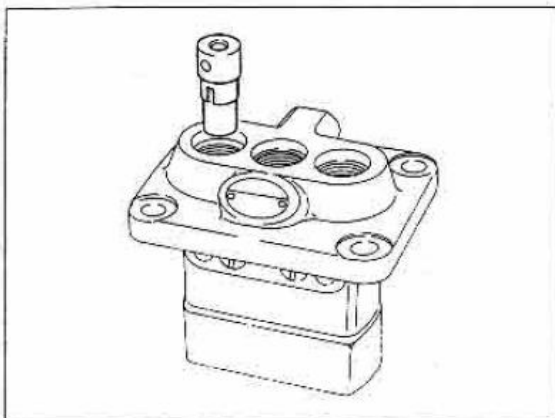


Fig. 57 Plunger barrel and eccentric pin

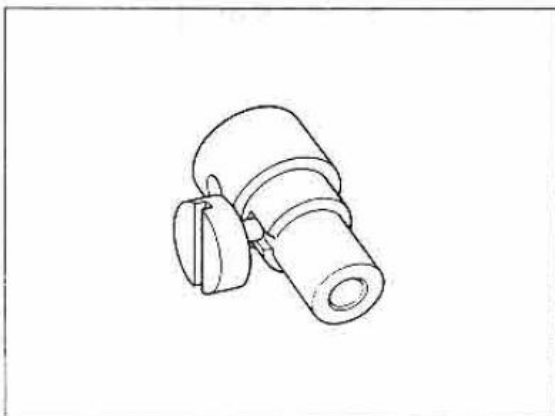


Fig. 58 Attaching plunger barrel

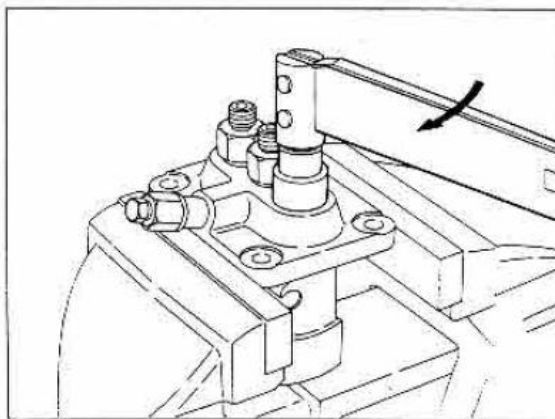


Fig. 59 Tightening delivery valve holder

Reassembly of the injection pump is performed in the reverse order of disassembly. Special care must be taken on the following points:

### PFR-KD TYPE INJECTION PUMP

1. Attach the plunger barrel to the pump housing, checking that the end of the eccentric pin or guide pin fits the plunger barrel alignment groove.

2. Tighten the delivery valve holder to the specified torque.

Specified tightening torque: 4 to 4.5 kg-m

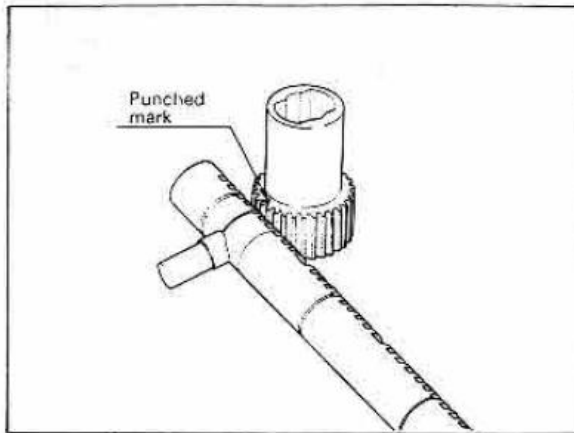


Fig. 60 Fitting the control sleeve to the control rack

3. Fit the control sleeve to the control rack by aligning the marks (a line for the control rack and a punched mark for the control sleeve).

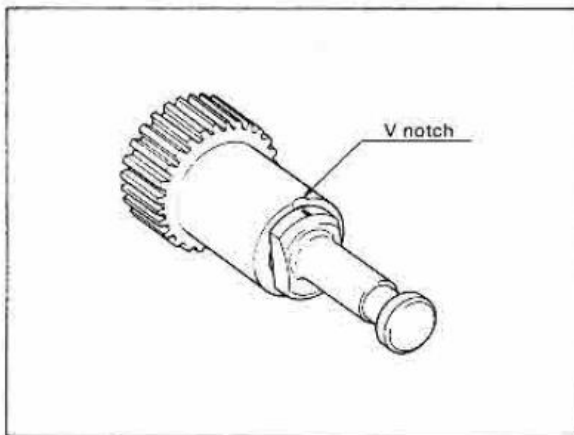


Fig. 61 Fitting the plunger

4. When the plunger is inserted into the plunger barrel, align the line on the plunger with the V notch of the control sleeve. This is to ensure the plunger helix correctly aligns with the suction and discharge port of the plunger barrel.

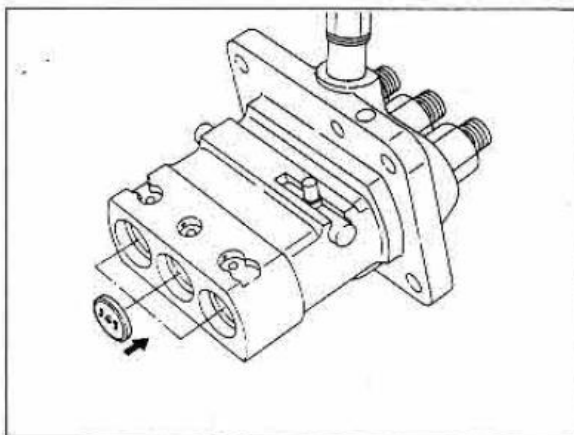


Fig. 62 Fitting the plate

5. Fit with the chamfered side of the plate facing the tappet side.

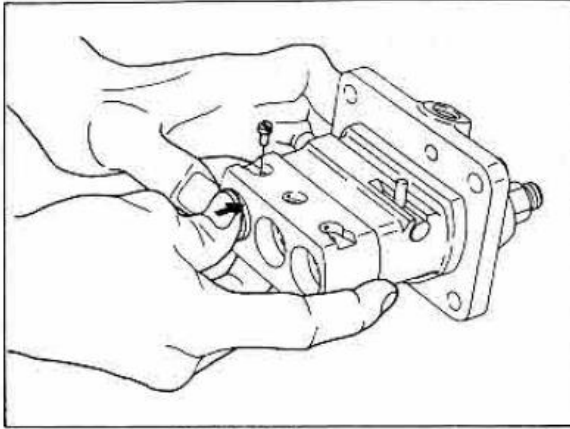


Fig. 63 Fitting tappet

6. When the pin (44) is inserted into the tappet, slowly move the control rack, pressing the tappet to find where the plunger flange fits the control sleeve groove.

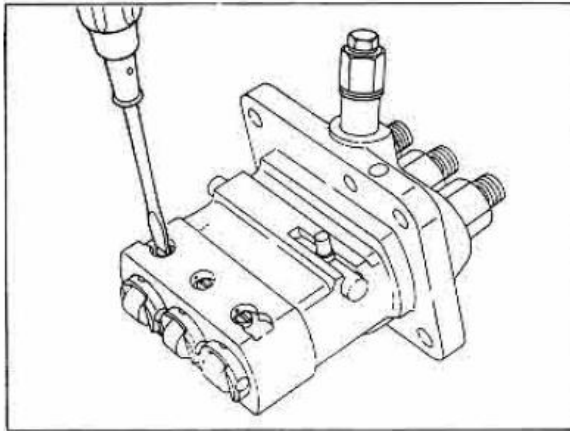


Fig. 64 Setting pin position

7. After the pin grooves are set horizontally with a screwdriver, attach the wire.

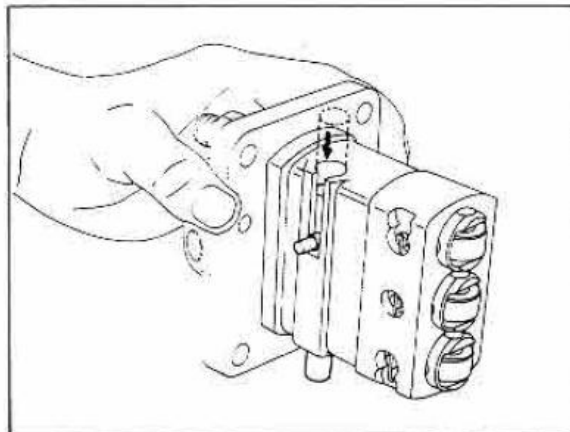


Fig. 65 Control rack movement inspection

8. After reassembly, tilt the injection pump as shown in Fig. 65 and check that the control rack slides under its own weight. If the control rack does not move smoothly disassemble to find the cause.