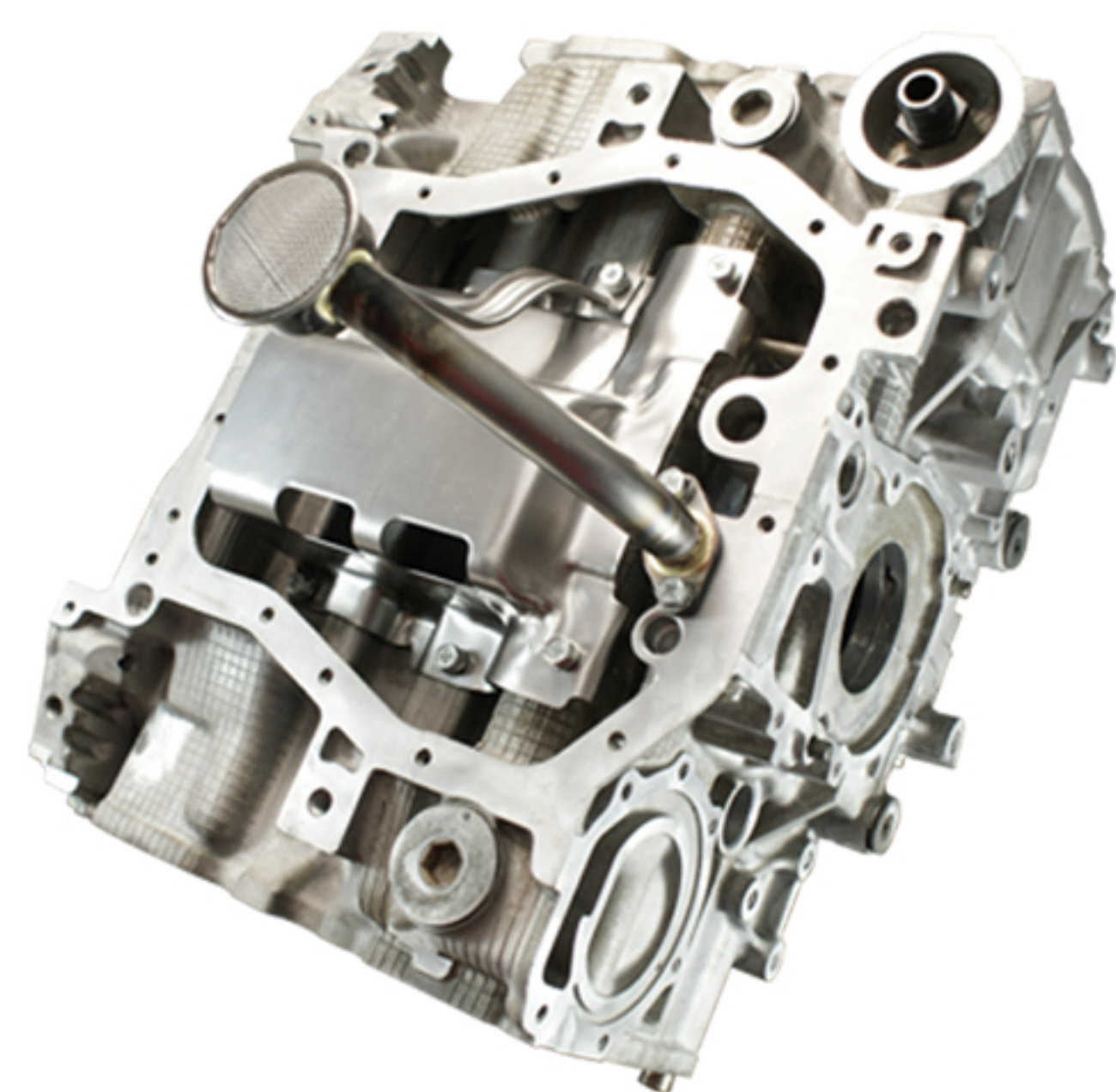


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— Stage 01

Remove the x14 sump bolts from the base of the existing sump pan.

With the sump oil pan removed you will be able to view both the internal oil control baffle and the oil pick up tube.



— Stage 02

Whilst every effort is taken to ensure this product is supplied clean and grease free it is the responsibility of the engine builder to thoroughly inspect the product prior to installation. (To remove the baffle tray undo the x4 M6 bolts and lift out. When refitting the baffle tray re-torque the bolts to 8NM).

Apply a liberal bead of sealer around the top edge of the sump (highlighted in red). Please ensure sealant goes around the bolt holes as opposed to over them. See the image opposite as a guide.

Remember to add the sump "O-ring" as per the diagram.



— Stage 03

Ensure the sump oil pan is at the correct rotation for the block and gently rest in place, keeping any movement to a minimum once contact has been made with the sealer.

Insert all x14 bolts that hold the sump oil pan to the engine and tighten opposing bolts in a rotational sequence to ensure an equal spread of sealer.

Torque bolts to 10NM.

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