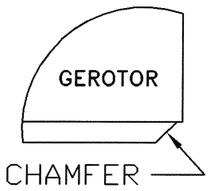
M19606
REV. B

INSTALLATION INSTRUCTIONS

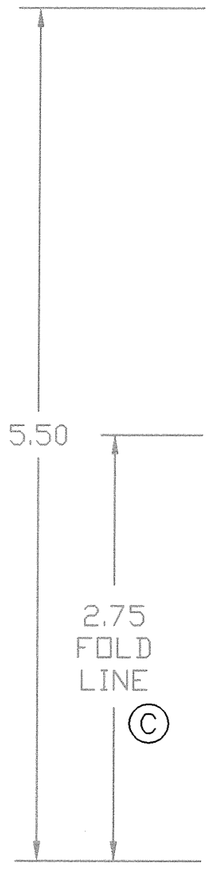
1.9L SATURN SOHC & DOHC



THE GEROTOR OUTSIDE DIAMETER HAS A CHAMFER ON ONE SIDE ONLY. THIS CHAMFER MUST BE INSTALLED INTO THE OIL PUMP POCKET.

INSTALL NEW COVER SCREWS SUPPLIED. USE A THREADLOCKING ADHESIVE AND TIGHTEN SCREWS TO 8 ft–lbs.

FAILURE TO PROPERLY INSTALL THIS GEROTOR SET AND COVER SCREWS WILL RESULT IN ENGINE DAMAGE, AND VOID ALL WARRANTIES.

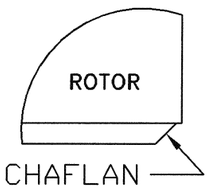




FRONT

INSTRUCCIONES DE INSTALACION

Arbol de levas sencillo y arbol de levas doble para Saturno 1.9L



EL DIAMETRO EXTERIOR DEL ROTOR TIENE UN CHAFLÁN ÚNICAMENTE EN UN LADO. ESTE CHAFLÁN DEBE DE INSTALARSE EN LA CAVIDAD DE LA BOMBA DE ACEITE.

INSTALAR LOS NUEVOS TORNILLOS DE LA CUBIERTA SUMINISTRADOS. USAR UN ADHESIVO PARA TORNILLOS Y APRETAR A 8 LIBRAS–PIÉ.

EL NO INSTALAR ADECUADAMENTE ESTE JUEGO DE ROTOR Y LOS TORNILLOS DE LA CUBIERTA CAUSARÁ DAÑOS AL MOTOR Y ANULA TODAS LAS GARANTÍAS.

BACK

Ⓒ FOLD NOTE:

TO BE FOLDED WITH FRONT (ENGLISH) SIDE OUT.
REFERENCE FOLD DIMENSION SHOWN ABOVE.

SUPERSEDES ALL PRINTS PRIOR TO THIS DATE: _____

MATERIAL:

White Paper: 4.25" Wide x 5.50" High

LTR	DATE	REVISION	ECN	LOC
C	5/3/04	ADDED FOLD NOTE AND DIM	3019	–
B	4/6/04	REMOVED IDENTIFICATION MARK REFERENCE	3001	–
A	9/24/98	ADDED SCREW NOTE	1935	–
–	8/31/98	RELEASED	1935	–

THE FOLLOWING ITEMS APPLY UNLESS OTHERWISE SPECIFIED: FOR FEATURES OF SIZE, PERFECT STRAIGHTNESS NOT REQUIRED AT MMC. FOR DIAMETRAL FEATURES, ROUNDNESS, MUST BE WITHIN THE MMC. AND LMC(LEAST MATERIAL CONDITION) BOUNDARY. TRUE POSITION TOLERANCES, AND RELATED DATUMS(EXCEPT PLANE SURFACES), APPLY AT MMC. OTHER GEOMETRIC TOLERANCES, AND RELATED DATUMS, APPLY AT RFS. SEPARATE TRUE POSITION CALLOUTS MAY BE GAGED SEPARATELY, REGARDLESS OF DATUM REFERENCE.

GEOMETRIC DRAWING SYMBOLS

▱ FLAT	⊕ TRUE POSITION	○ ROUND	⌭ CYLINDRICAL
— STRAIGHT	↗ RUNOUT	∠ ANGULAR	◎ CONCENTRIC
⊥ SQUARE	⌀ DIAMETER		⌯ SYMMETRICAL
// PARALLEL	⌓ PROFILE OF SURFACE		⌒ PROFILE OF A LINE
Ⓜ MAXIMUM MATERIAL CONDITION(MMC)			[XXX] BASIC DIMENSION
Ⓢ REGARDLESS OF FEATURE SIZE			‹XXX› REFERENCE
Ⓟ PROJECTED TOLERANCE ZONE			

MELLING TOOL COMPANY
P.O. BOX 1188, JACKSON, MICHIGAN 49204
ENGINE COMPONENTS
PRODUCT ENGINEERING

MUST BE FREE OF BURRS WHICH MAY BE DETRIMENTAL TO SATISFACTORY ASSEMBLY. SAFE HANDLING OR FUNCTION.

ENGINEERING APPROVAL OF FIRST PRODUCTION SHIPMENT FROM EACH SUPPLIER IS REQUIRED PRIOR TO AUTHORIZATION FOR USE ON MELLING PRODUCTION. NEW SAMPLES REQUIRED BEFORE ANY CHANGE IN PRODUCTION PROCESSING FOR ENGINEERING FUNCTIONAL TEST AND APPROVAL.

DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED THE FOLLOWING TOLERANCES APPLY:

METRIC DIMENSIONS
±.25 ALLOWED ON ONE PLACE DECIMALS
±.13 ALLOWED ON TWO PLACE DECIMALS
±.013 ALLOWED ON THREE PLACE DECIMALS
±0°30' ON ANGULAR DIMENSIONS.

ENGLISH DIMENSIONS
±.015 ALLOWED ON ONE PLACE DECIMALS
±.010 ALLOWED ON TWO PLACE DECIMALS.
±.005 ALLOWED ON THREE PLACE DECIMALS.
±.0005 ALLOWED ON FOUR PLACE DECIMALS
±0°30' ON ANGULAR DIMENSIONS.

PROJ. M196 SATURN — SHT. 1 OF 1

DRAWN BY	COMPLETED	CHECKED	APPROVED	SCALE
MJO	8/31/98		5/3/04	FULL

DO NOT SCALE — TOLERANCES NOT OTHERWISE SPECIFIED
MACHINED DIM.± STAMPED DIM.±
ANGULAR DIM.± DIM.±

MATERIAL: SEE NOTE — APP. — DATE 5/3/04

NAME: INSTRUCTION SHEET

PART NO. M19606