

Pump Tab Stop Repair Kit

Part No.

100912-01K

- Pump Tab Stop
- Bolts (2)
- Washers (2)
- Spring Pin

BorgWarner 4405, 4411

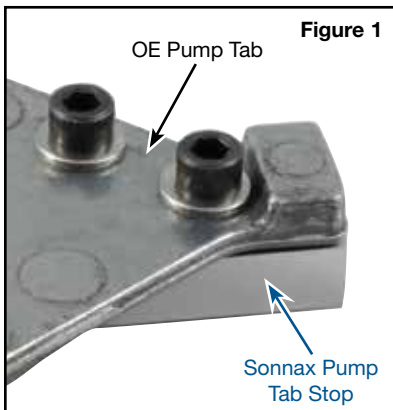
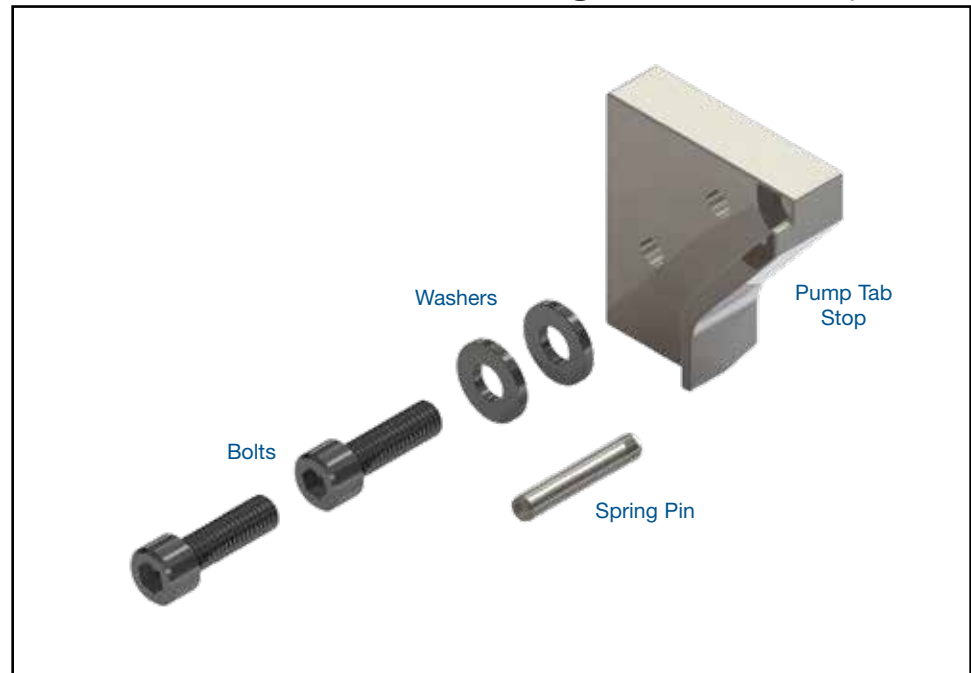


Figure 1

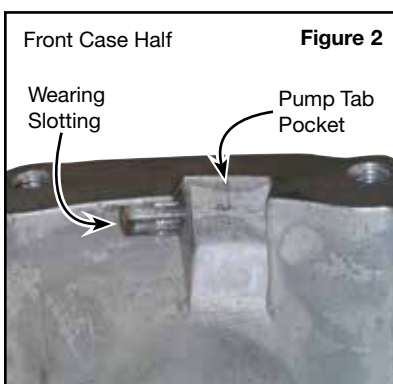


Figure 2

1. Preparation

- Sonnax pump tab stop is designed to nest against and beneath OE pump tab (**Figure 1**).
- Position pump tab stop and clamp it in place with a small c-clamp or vise-grip pliers. The stop will rest against cast text on the bottom side of pump arm. There is no reason to remove the cast text when attaching the stop to the pump tab.
- Insert Sonnax spring pin into one of the threaded holes on Sonnax pump tab stop.
- Using Sonnax spring pin as a drill guide, drill through the pump tab with a 1/8" dia. bit. The spring pin will guide the drill bit and prevent damage to the aluminum threads of Sonnax pump tab stop.
- Remove spring pin from the first tapped hole, repeat steps c and d on the second tapped hole.
- Remove Sonnax spring pin and clamp. Separate pump tab and tab stop.
- Using a 3/16" drill bit, drill through pump tab to enlarge the two 1/8" diameter pilot holes.
- Deburr the drilled holes.

2. Installation & Assembly



NOTE: The front case half has a pocket near the sealing flange that locates and prevents pump body rotation (**Figure 2**). Wear appears as a narrow slot that can be mistaken for a machined feature in case.

- Assemble the stop to the pump tab with two supplied #10-32 x 5/8" hex socket head cap screws and washers. Use Loctite™ (or preferred brand) threadlocker on screw threads.
- Torque the hex socket head cap screws to 90 in-lb.