



Instructions for SB Billet Performance Oil Pumps

This Small Block billet performance pump is supplied with a chrome-moly intermediate shaft with a pinned steel collar. The collar has a machined rib which will snap into the groove on the end of the pump shaft. Firmly tap the collar into the pump drive shaft taking care not to damage the pump or the intermediate shaft. When properly installed the intermediate shaft will have axial movement relative to the pump drive shaft.

This pump will provide oil pressure between 60 psi and 80 psi. But engine clearances may require changing the pressure relief spring. To increase the oil pressure by 10 psi install the dark orange spring. To decrease the pressure by 10 psi install the pink spring. To do this remove the valve plug and spring, install either of the optional springs and torque the valve plug to 10 ft lbs (13.5 Nm) minimum.

Before final installation be sure to test fit the oil pump on the block to verify crankshaft and connecting rod clearances. Check the oil pump drive shaft clearance to the main cap and engine block. Also check to verify proper clearance from the stand-offs at the bottom of the oil pump to the bottom of the oil pan of 1/4" to 3/8" (6.5 mm to 9.5 mm). The stand-offs assure that the oil supply to the pump will not be cut-off in the event the oil pan comes in contact with the oil pump.

The stud kit supplied with this pump was designed specifically for this pump. Install the coarse threaded end of the stud into the rear main cap. Before installing the pump submerge the pump pickup in oil and rotate the driveshaft by hand. Rotate the drive shaft in a clockwise direction until oil is pumped out the top of the pump. Install the pump, the 7/16" washer and nut, and torque to 65 ft lbs (88 Nm).

Before starting a newly assembled engine its lubrication system requires priming. Use an oil primer shaft or the modified end off an old distributor connected to an electric drill to spin the oil pump drive shaft in a clockwise direction. This will assure that pressurized oil will be readily available during initial engine start-up.

For technical assistance please call the Melling technical support department at (517) 787-8172, 8am to 5pm Eastern Time.

M55157
Rev. B