

## **MILODON**

2250 Agate Court, Simi Valley, Ca 93065  
(805) 577-5950

### **Small Block Chevy Oil Pump**

#18750 and #18755

This Milodon oil pump has been flow tested at the factory to assure proper pressures and operation. The oil pump pickup you use will press into the pump more securely than other brands of pumps, so there is no need to weld the pickup into the housing. Welding is actually strongly not recommended. If the pickup fits very snugly, place the pickup in the freezer for 2-3 hours. This will shrink it slightly allowing easier installation. Do not sand the pickup end down. Do not grip the housing tightly in a vise. Check that there is 1/4" to 3/8" clearance between the pickup face and the floor of the oil pan to assure adequate inlet oil flow to the pump. Fill the pump with oil before installing it on the engine.

Milodon oil pumps also allow movement of the oil pump on the main cap alignment dowels. Due to the 45 years or so of block production, both GM and the aftermarket, the ability to properly align the oil pump drive shaft in the main cap hole has become very important. Install oil pump onto main cap with the mounting bolt only snug. Align intermediate shaft by rotating the oil pump, so the pump drive shaft is centered in the main cap hole. Then torque the oil pump mounting bolt to 50 ft/lbs.

2-06

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### **Small Block Chevy Oil Pump Installation**

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