

## Transfer Case Pump Plate Kit



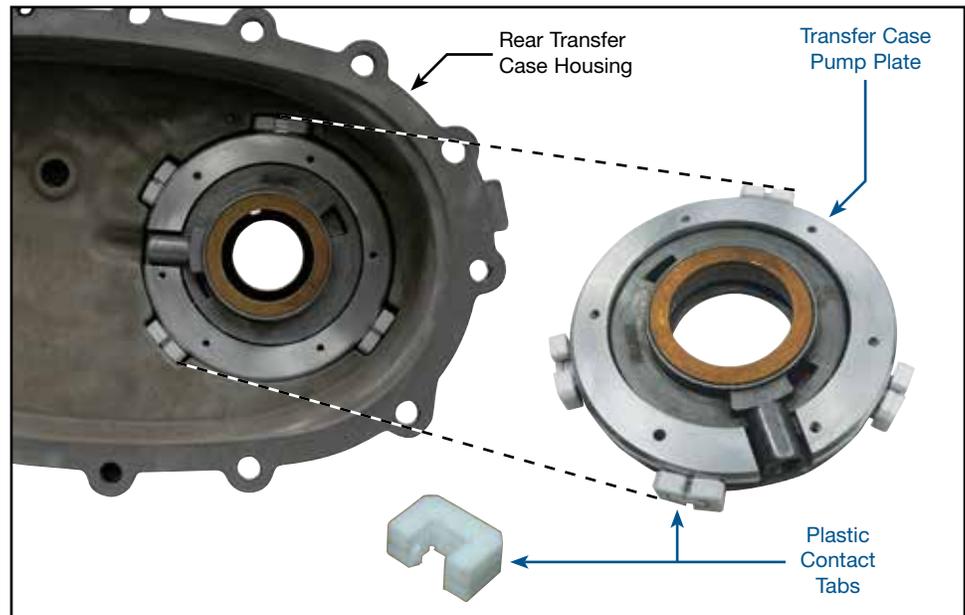
**Part No.**  
**100246-02K**

- Transfer Case Pump Plate
- Plastic Contact Tabs (8)
- Screws (6)

Patent No. 8,024,859

**NOTE:** Fits NP 136, 149, 236, 246, 261, 263.

## New Process 230 & 240 Series



### CAUTIONS:

- If magnesium rear housing has a hole worn through from pump lugs, its best to replace it.
- Welding magnesium requires specialized procedures. Contact welding suppliers in your area to locate welding shops which are familiar with welding magnesium.
- Patching holes with epoxy is risky, but has been done successfully when applied with care.

### 1. Disassembly

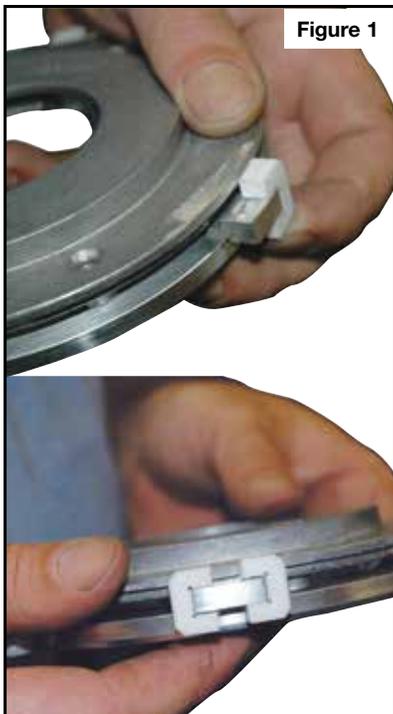
- Remove OE pump assembly from transfer case, discard U-shaped steel wear insert.
- Disassemble pump and discard OE screws.
- Drill through six tapped holes on OE pump cover with 11/64 (#19) drill bit to remove threads.
- Use a hacksaw to cut the tabs off from OE pump. File or grind pump so curvature matches rest of the casting.

### 2. Installation & Assembly

- Assemble and realign (without screws) modified pump cover, pump body and gears.
- Place Sonnax pump plate over OE pump cover, with four lugs protruding toward OE pump body.
- Apply Threadlocker to six Sonnax screws and install screws from bottom of OE pump body to secure Sonnax pump plate.
- Attach two Sonnax plastic contact tabs to each of the four Sonnax pump plate tabs (**Figure 1**). Verify retention barbs on Sonnax plastic contact tabs face towards pump plate. Failure to do so may cause tabs to come loose or hinder transfer case stack-up assembly.
- Install into transfer case using normal assembly procedures.



**NOTE:** Do NOT install U-shaped steel inserts.



**Figure 1**