

**REMOVAL/INSTALL OF VACUUM PUMP GASKET KIT (904-335)
Dodge Ram 2500 2002–1994, Dodge Ram 3500 2002–1994**

General Tech Tip:

- To start this project, make sure you have the right gasket kit in your hands. This is for fitting all Dodge 2500 and 3500 models with the Cummins 5.9l Diesel engine for 1994-2002.

**PLEASE WEAR
SAFETY GLASSES!**

Tools required for removal and installation of Vacuum Pump Gasket Kit:

- Press
- Oil

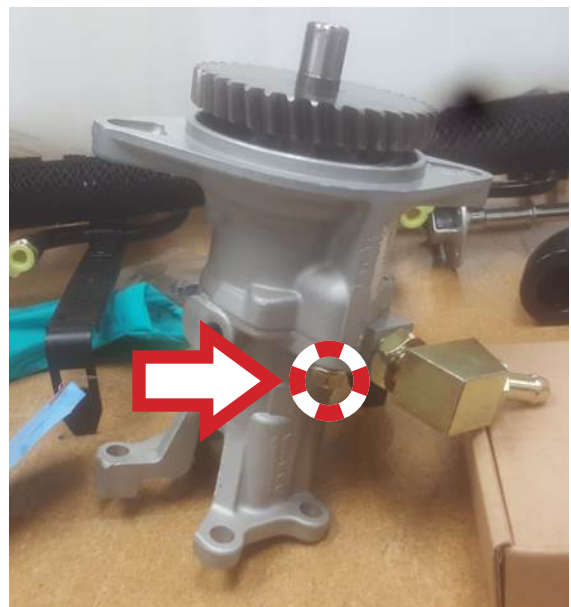
Removal Instructions

STEP 1: Open the box and make sure you have all of the gaskets. There should be 4 in this kit.



STEP 2: Remove the vacuum pump from the vehicle.

STEP 3: Remove the two bolts holding the pump halves together. One of the two bolts is shown.



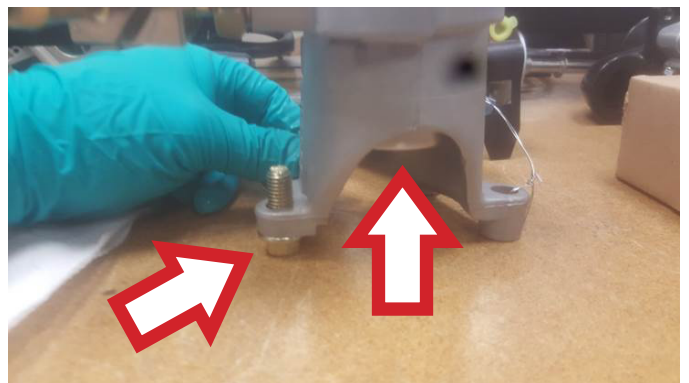
STEP 4: The upper half of the pump has a groove for the larger round o-ring.



STEP 5: Use this o-ring for the upper part of the pump.



STEP 6: The bottom half of the pump has two seals in it. Use the bolts as a space to make the bottom part of the pump stand up evenly.



STEP 7: At the top of the lower half of the pump, you will see a round opening with a floating "X" in it. You will need to press this part out of the pump. Take note that there is a square stamped into it.



STEP 8: The lower half of the pump in the press.



STEP 9: Once the cylinder is pressed out, you can see one of the additional O-rings from the kit.



STEP 10: The floating "X" key is not attached to the cylinder and can be set aside. The last seal is inside the cylinder.



STEP 11: The seal needs to be pressed out of the cylinder. Flip the cylinder over so the O-ring is at the bottom and press out the seal. You can see the seal has been removed.



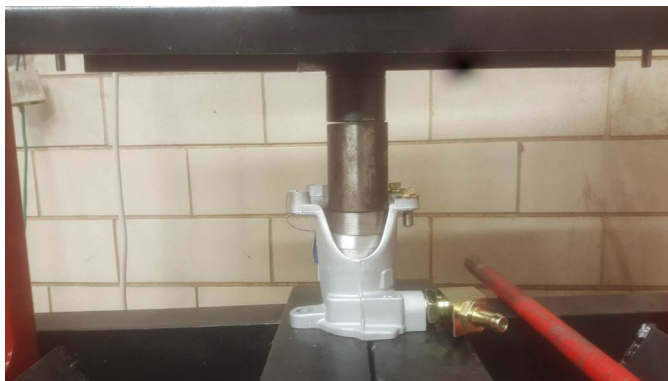
Installation Instructions

STEP 1: Press the new seal back in to the cylinder. Using a little bit of oil should help make the new seal go back in effortlessly.

STEP 2: Next, put everything back together. Before pressing the cylinder back in to the lower pump half, make sure you're putting the floating "X" key in correctly. Remember, the stamped square needs to be visible from the top of the unit. Only one side of the key has this stamp.



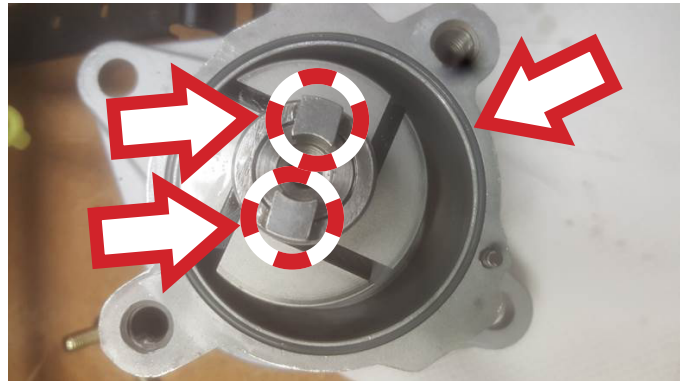
STEP 3: Press the cylinder back in to the lower pump half.



INSTALL/REMOVAL INSTRUCTIONS: VACUUM PUMP GASKET KIT

ATTENTION: Refer to the appropriate shop manual for your vehicle to obtain specific service procedures for this part. If you do not have a service manual or lack the skill to install this part, it is recommended that you seek the services of a qualified technician. Pay special attention to all cautions and warnings included in the shop manual. Read and follow all instructions carefully.

STEP 4: Bolt the two halves together, making sure the new O-ring on the upper half hasn't fallen out. Torque all bolts to factory specifications.



STEP 5: Make sure, as you're assembling the two halves, that the keys fit in to the floating "X" properly.

STEP 6: With everything all back together, you can put the vacuum pump back in the vehicle and finish the job.

