

Service Repair Kits for Cummins Celect Fuel Pumps

DIPACO has available three service repair kits for Cummins Celect fuel pumps, **D3803476**, **D3803477**, and **D3803478**. The **D3803476** and **D3803477** kits are front cover seal kits. The **D3803478** kit contains all the seals, o-rings, gaskets, and other parts needed to rebuild the fuel pump.

The **D3803476** seal kit consists of two **D3084713** oil seals, red in color. This kit is used with fuel pumps using the 3068760 front support. This support is machined from bar stock aluminum and has a straight seal bore. The **D3803477** seal kit consists of one **D3084713** oil seal (red) and one **D3071643** fuel seal (blue). This kit is used with either the 3070149 or 3074318 front support, which are cast from aluminum and have a rougher appearance than the 3068760 support. These supports have a stepped seal bore. The stepped bore helps to avoid any damage being caused to the fuel seal when it is pushed by the weep hole. The seals used in the **D3803476** and **D3803477** seal kits have teflon lips and each comes with a cardboard spindle supporting the lip. These supports must not be removed from the seals until they have been installed and the gear pump installed as well.

The **D3803478** repair kit is for rebuilding the Celect pump and includes the following:

D3803477	Seal Kit	1 each
D100099	Seal Ring	1 each
D110855	Gasket	1 each
D129888	Shut Off O-Ring	1 each
D139988	Seal Ring	1 each
D146483	Fuel Screen	1 each
D151900	O-Ring	1 each
D160514	Nylon Gasket	1 each
D202897	Diaphragm	1 each
D213079	O-Ring	1 each
D3021123	O-Ring	1 each
D3034412	Check Valve O-Ring	1 each
D3037537	O-Ring	1 each
D3056415	O-Ring	1 each
D3069017	Pump Mount Gasket	1 each
D3069103	Pump Mount Gasket	1 each
DPE99020	Instruction Sheet	1 each

DIPACO has the **DPE5001** gear pump shaft insertion tool, which guides the gear pump drive shaft into the front support to avoid damage to the seal lips. Place the tool over the end of the gear pump drive shaft when installing the gear pump. Do not lubricate the tool or the drive shaft. Remove the tool after the gear pump is mounted.

Following are basic seal installation instructions. For additional information please refer to Cummins Service Topic 92T5-24.

- Heat the front support to 275°F for ½ hour.
- Install the two seals into the support housing from the drive coupling side. If you are installing the seals into a 3074318 front support, you also need to install the seal spacers.
- Use a 3823240 driver to install the fuel seal first. Use the cardboard support in the seal to support the driver. The seal lip must be toward the gear pump. Press the seal in until it seats against the front support.

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- If appropriate, install the small seal spacer.
 - Using the driver, install the oil seal. The seal lip must be away from the gear pump side. Use the cardboard support in the seal to support the driver. Press the seal in until it seats.
 - If appropriate, install the large seal spacer and retaining ring.

Do not leave the seal lips unsupported for more than 5 minutes. Either install the gear pump immediately or make sure the cardboard support is in place in the seals.