



## ASSEMBLY INSTRUCTIONS FOR ROTAX 618 WATER PUMP COVER

FOR INFORMATION ONLY. WITHOUT COMMITMENT TO ADVISE MODIFIKATIONS.

### 1) Introduction

This information is intended to assist the aircraft designer and manufacturer to achieve correct operating conditions and assembly for the engine and consequently optimum performance and reliability.

### 2) Technical data and general information

In addition to these installation instructions, please, refer to:

- ⇒ operators manual
- ⇒ engine data sheet
- ⇒ power, torque and fuel consumption curves
- ⇒ spare parts list

### 3) Placement of water pump cover on 618 Rotax engine

It is imperative that the water pump cover on the 618 Rotax be installed with the air bleed screw facing engine base (down position).

Any engines which have the air bleed screw facing towards the exhaust manifold (up position), must have the cover rotated into the correct position prior to the engine being run.

- ◆ **NOTE:** This bleeding screw is only needed if engine is mounted upside down (spark plugs down).

The water pump cover casting is designed to fit only in the air bleed screw down (towards engine base) position. The bottom left boss hole for the cover bolt has a thicker boss in this area, and does not allow the bolt to enter into the engine as deep, thus preventing the possibility of the bolt entering the mag. side crankcase cavity.

- ▲ **WARNING:** Failure to comply with this recommendation could result in engine damage!