



Fig. 39 - Remove Pressure Filtration Pipe Plug

If the pump is equipped for remote pressure filtration or is not equipped with an integral charge pump, a plug will be installed in the threaded hole in the end cap gasket cavity. This plug must not be installed if the pump is used with auxiliary filtration. The plug may be removed with a 1/4" internal hex wrench. When reinstalling, use a thread locking compound on the plug and torque to 40 to 50 ft-lbs. (5 to 6.8 Nm).

Each part should be inspected separately if they are to be reused. If either of the gasket assembly parts needs to be replaced, they must both be replaced. Always replace the O-Rings.

Prior to assembly, lubricate the gasket assembly with clean hydraulic oil.

Slide the gasket assembly into position on the shaft sleeve.

NOTE: The charge pump rotation is determined by the position of the gasket spacer and locating pin in the pump end cap.

Install the gasket spacer (with locating pin) over the gasket assembly and into the pump end cap, starting from the primer input shaft rotation direction. The pin in the gasket spacer should be located in the end cap hole furthest away from the the charge pump inlet port for clockwise (CW) input rotation, and closest to the inlet port for counterclockwise (CCW) input rotation.

Install the two (2) O-rings into the grooves of the gasket spacer.

Install the steel check ball into the gasket spacer. The ball must always be located next to the inlet side of the charge pump to allow balance pressure to build up on the gasket spacer.

Reinsert the charge pump cover or auxiliary port adapter, and torque the screws to 35 to 45 ft-lbs. (4.7 to 6.1 Nm).

If the unit is equipped with an auxiliary pump mounting pad, install the driving coupling (if used), and torque cover or auxiliary pump.

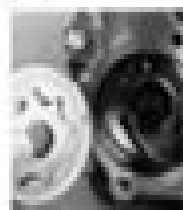


Fig. 40 - Orienting Gasket Spacer and Pin (CW)

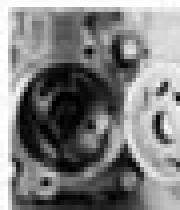


Fig. 41 - Orienting Gasket Spacer and Pin (CCW)



Fig. 42 - Location of Check Ball in Gasket Spacer

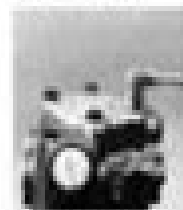


Fig. 43 - Installing Charge Pump Cover



Fig. 44 - Installing Auxiliary Drive Coupling and O-Ring



Fig. 45 - Separate Pump Sections



Fig. 46 - Remove O-Rings



Fig. 47 - Remove Gasket Assembly



Fig. 48 - Charge Pump Components



Fig. 49 - Remove Pressure Filtration Pipe Plug

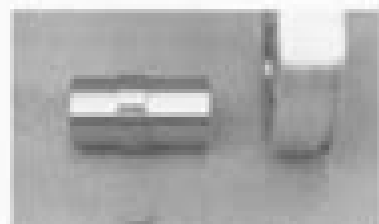


Fig. 50 - Charge Pump Drive Pin and Coupling

Integral Charge Pump (Tandem Pump)

NOTE: Tandem Pumps without an integral charge pump have driving screws and a shaft sleeve coupling installed between the sections. In addition, the end cap for the front pump section is thicker and is not machined to install a charge pump. Procedures for separating and checking the front and rear pump sections are similar to those for units with an integral charge pump.

Remove the four (4) screws (using an 8 mm tapered hex wrench) which secure the front and rear pump sections together. Separate the front and rear sections of the pump. Remove the two (2) alignment pins.

Remove the two (2) small O-rings from the front section end cap. Remove the single large O-ring from rear charge section, or the two (2) gasket spacer O-rings (units with charge pump).

For units with charge pump, remove the shaft coupling. For units with charge pump, remove the shaft coupling with the gasket assembly, gasket spacer and locating pin, from the front section. Note the orientation of the gasket spacer and pin for reassembly.

Separate the shaft coupling and gasket assembly from the gasket spacer. Remove the drive pin from the coupling.

If the pump is equipped for remote pressure filtration, a plug will be installed in the threaded hole in the end cap gasket cavity. This plug must not be installed if the pump is used with auxiliary filtration. The plug may be removed with a 1/4" internal hex wrench. When reinstalling, use a thread locking compound on the plug and torque to 40 to 50 ft-lbs. (5 to 6.8 Nm).

Each part should be inspected separately if they are to be reused. If either of the gasket assembly parts needs to be replaced, they must both be replaced. Always replace the O-rings.

Prior to assembly, lubricate the gasket assembly with clean hydraulic oil.

Install the gasket drive pin in the groove in the coupling and clean with petroleum jelly.

Install the gasket assembly into the gasket spacer, install the assembled gasket and spacer into the coupling, being certain the drive pin engages the slot in the gasket. The larger portion of the coupling must be installed toward the spacer (toward the rear pump section).

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