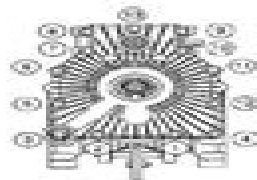


(1) Oil Seal	(9) Insert
(2) Cover Mounting Screw	(10) Pump Rotor Assembly
(3) Gasket	(11) Drive
(4) Control Shaft	(12) Gasket
(5) Dump Valve Bracket	(13) Cover
(6) Housing	(14) Oil Seal
(7) Dump Valve Nut	(15) Input Shaft
(8) Cam Ring	(16) Internal Snap Ring

**Tightening Sequence
(Cover Mounting Screw)**



8156P014

Cover, Cam Ring and Pump Motor

1. Use a 3/8 inch (9.5 mm) socket or end wrench to unscrew the mounting screws (2), and remove cover (13) from the housing (6). Do not forget the mounting screw in the drain port.

(When reassembling)

- Torque the cover mounting screw twice in sequence as shown in figure.

2. Remove the internal snap ring (16) and tap out the input shaft (15) from the cover.

3. Remove the drive (11), control shaft (4), insert (9) and cam ring (8).

(When reassembling)

- Install the cam ring into the housing with the flush side facing outward.

4. Carefully remove the pump rotor assembly (10) from the housing, making sure the ball pistons are not dislodged from their bores.

5. Unscrew the dump valve nut (7) and remove the dump valve bracket (5) from the housing.

Tightening torque	Cover mounting screw	14.0 N·m 1.4 kgf·m 10.3 ft·lbs
	Dump valve nut	17.0 N·m 1.7 kgf·m 12.5 ft·lbs

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