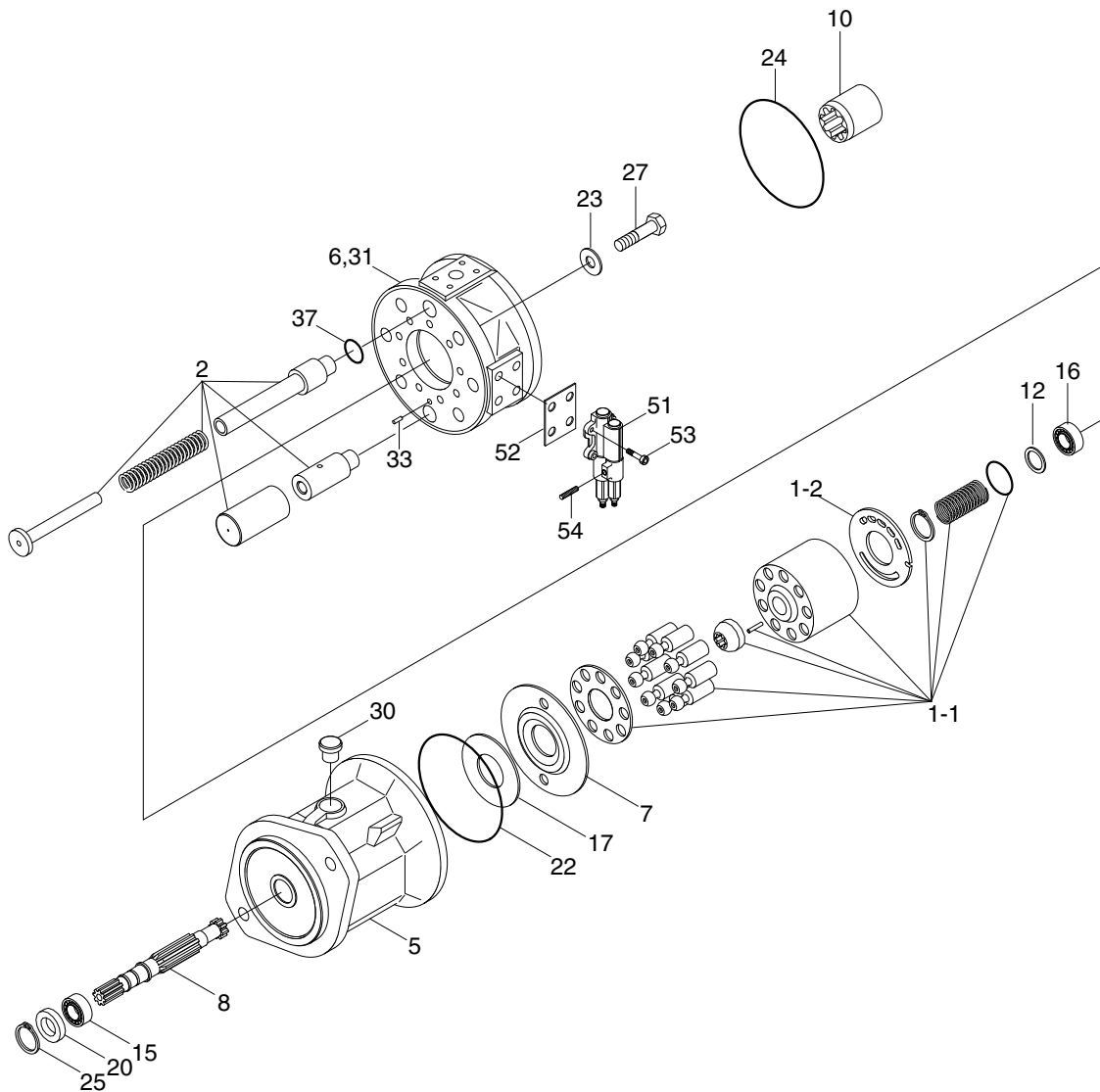


GROUP 4 DISASSEMBLY AND ASSEMBLY

1. MAIN PUMP

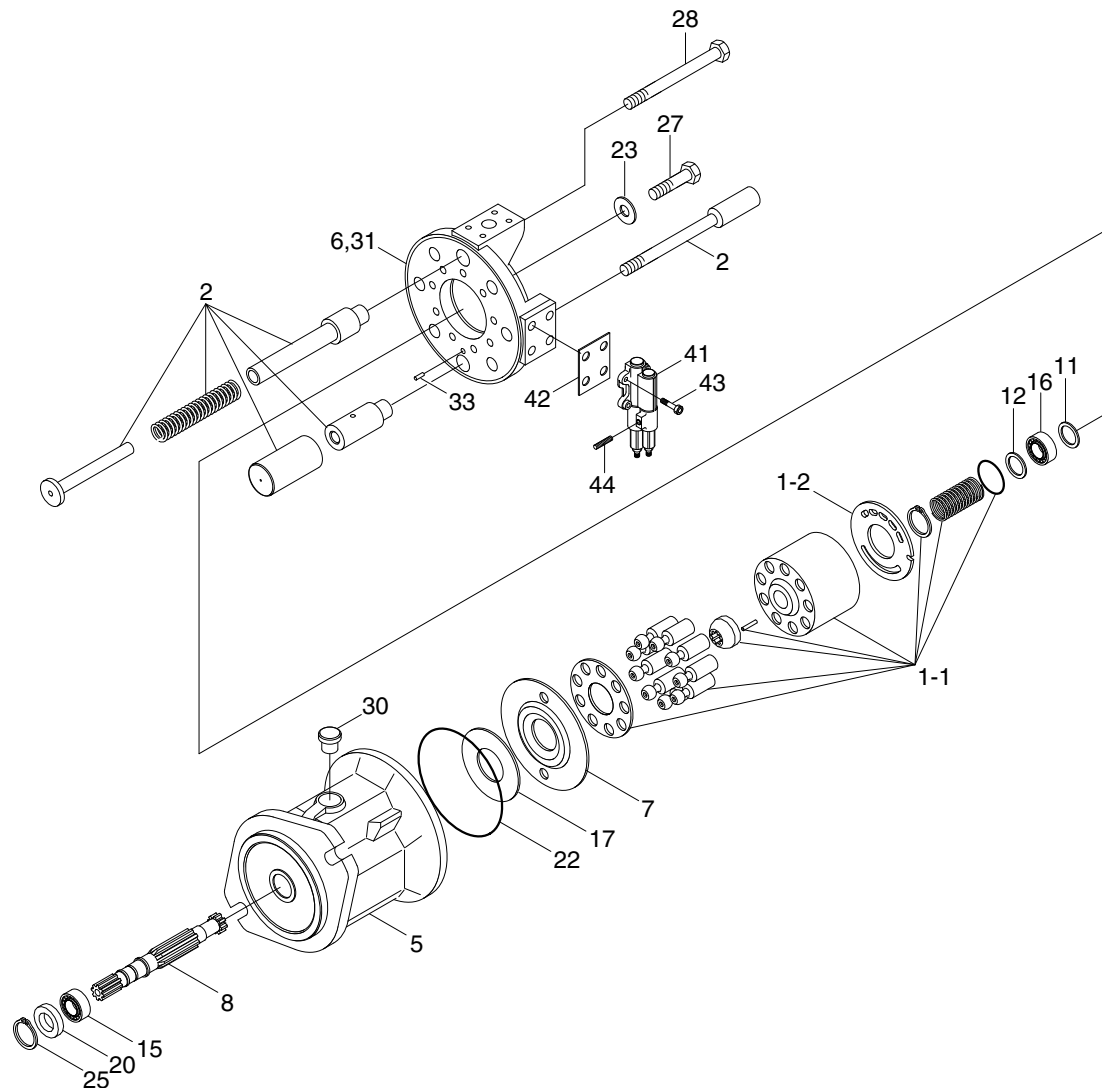
1) STEERING (1/2)



76096WE11

1	Rotary group	12	Adjustment shim	27	Socket screw
1-1	High speed rotary group	15	Taper roller bearing	30	Locking screw
1-2	Control plate	16	Taper roller bearing	31	Double break-off pin
2	Adjusting piece	17	Bearing liner	33	Cylinder pin
5	Pump housing	20	Shaft seal ring	37	Side mark ring
6	Port plate	22	O-ring	51	Control valve
7	Swash plate	23	O-ring	52	Gasket
8	Drive shaft	24	O-ring	53	Socket head screw
10	Splined hub	25	Retaining ring	54	Locking screw

LOADER (2/2)



76096WE12

- | | | | | | |
|-----|-------------------------|----|----------------------|----|----------------------|
| 1 | Rotary group | 12 | Adjustment shim | 28 | Locking screw |
| 1-1 | High speed rotary group | 15 | Taper roller bearing | 30 | Locking screw |
| 1-2 | Control plate | 16 | Taper roller bearing | 31 | Double break-off pin |
| 2 | Adjusting piece | 17 | Bearing liner | 33 | Cylinder pin |
| 5 | Pump housing | 18 | Shaft seal ring | 41 | Control valve |
| 6 | Port plate | 22 | O-ring | 42 | Gasket |
| 7 | Swash plate | 23 | O-ring | 43 | Socket screw |
| 8 | Drive shaft | 25 | Retaining ring | 44 | Locking screw |
| 11 | Adjustment shim | 27 | Socket screw | | |

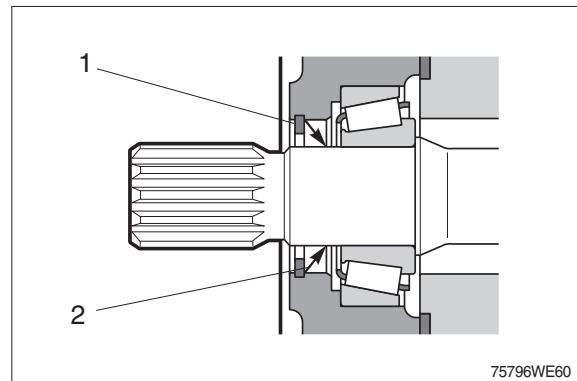
2) GENERAL REPAIR GUIDELINES

- ※ Observe the following guidelines when carrying out repairs on hydraulic pumps.
- (1) Close off all openings of the hydraulic unit.
- (2) Replace all of the seals.
Use only original spare parts.
- (3) Check all sealing and sliding surfaces for wear.
- ※ Re-work of the sliding surfaces by using, for example abrasive paper, can damage the surface.
- (4) Fill the hydraulic pump with hydraulic oil before commissioning.

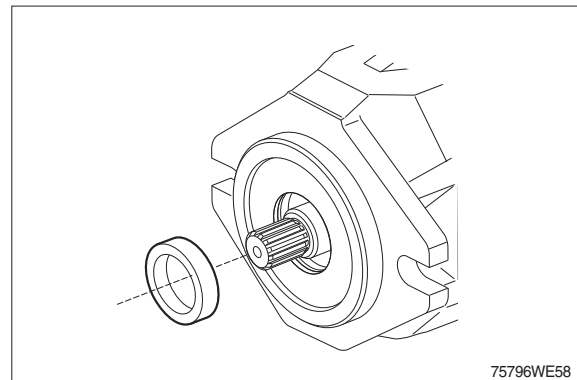
3) SEALING THE DRIVE SHAFT

- (1) Protect the drive shaft.
Remove the circlip.
Remove the shaft seal.

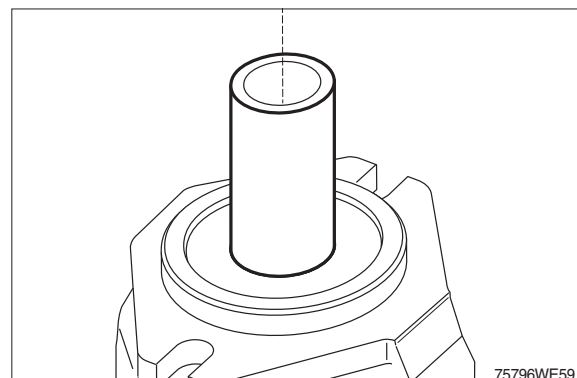
1 Circlip 2 Shaft seal



- (2) Change the shaft seal and check its sliding surface (drive shaft) and housing, grease the sealing ring.

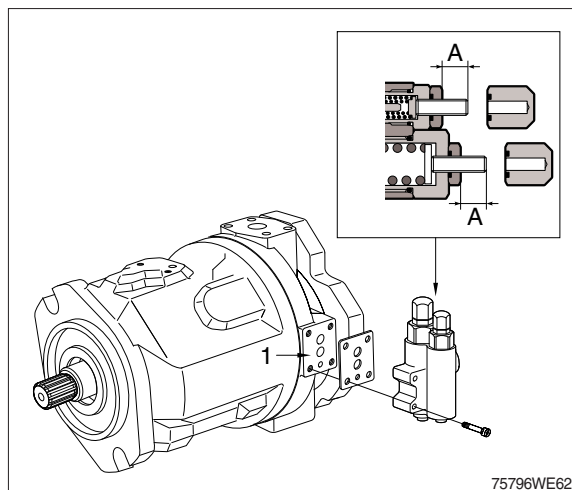


- (3) Assemble the sealing ring, fitting tool holds the correct position of the sealing ring in the pump housing.
Assemble the circlip in the correct position.



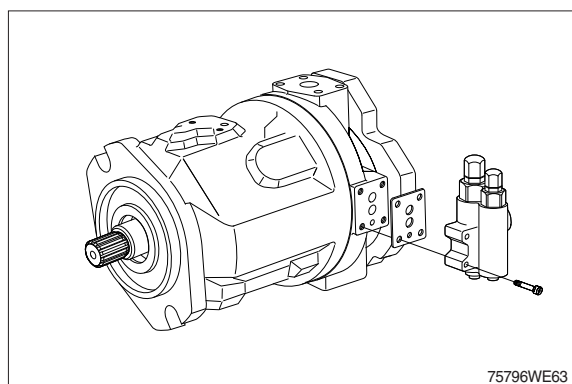
4) SEALING / CLEANING THE CONTROL VALVE

- (1) Disassemble the control valve.
- ※ Measure dimension A and note down.
Check sealing surface (1).

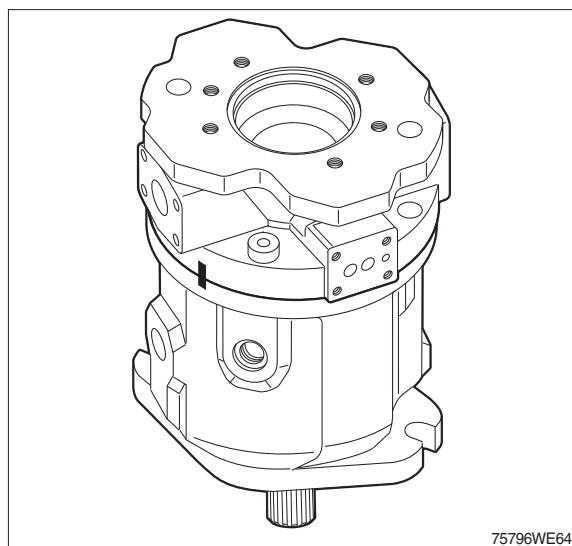


5) DISASSEMBLE THE PUMP

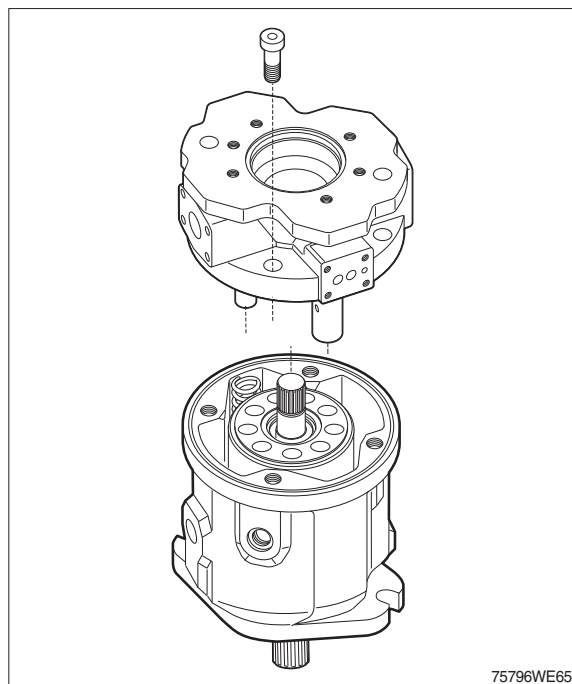
- (1) Remove the control valve.



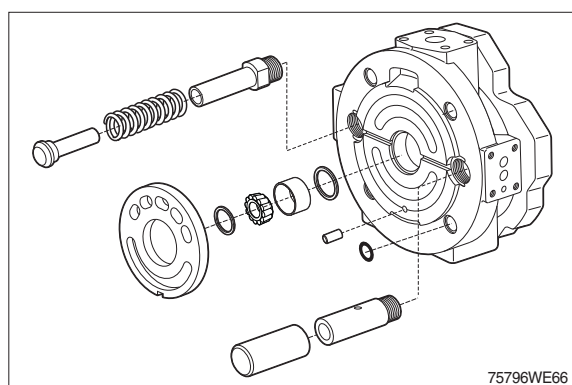
- (2) Mark the location of the connection plate on the housing.



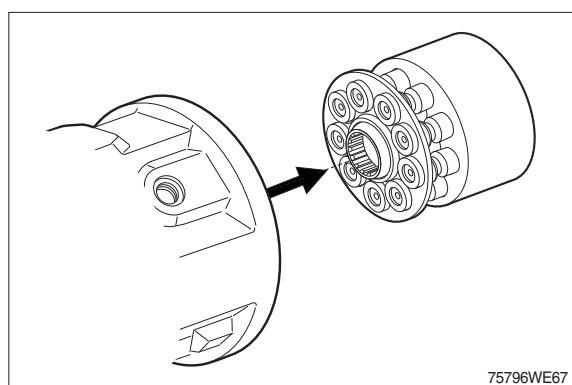
- (3) Remove the connection plate fixing bolts and the connection plate.
※ Distributor plate and adjustment piston can drop down.



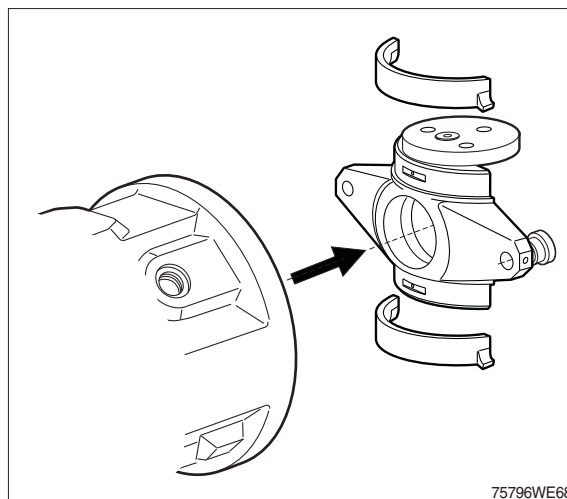
- (4) Remove distributor plate.
Take note of the orientation.
※ Remove bearing with withdrawal tool.
Do not damage the sealing surface.



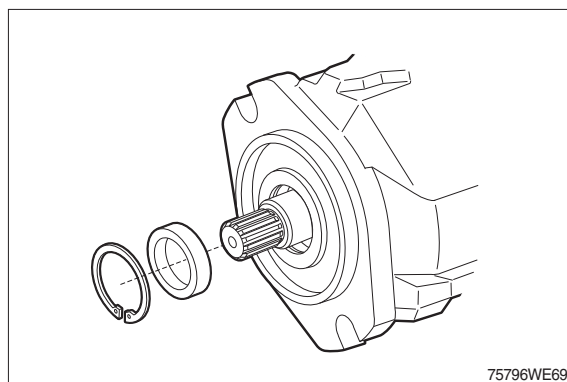
- (5) Remove the rotary group in a horizontal position.



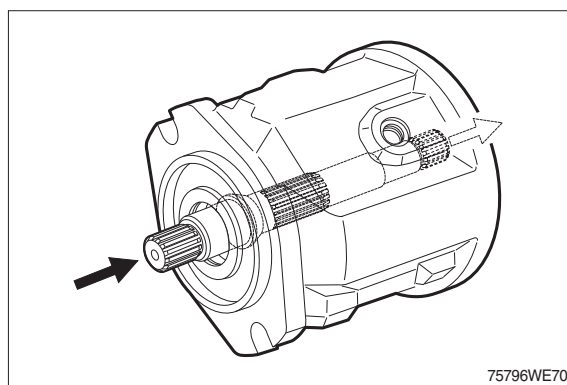
(6) Remove swash plate and bearing shells.



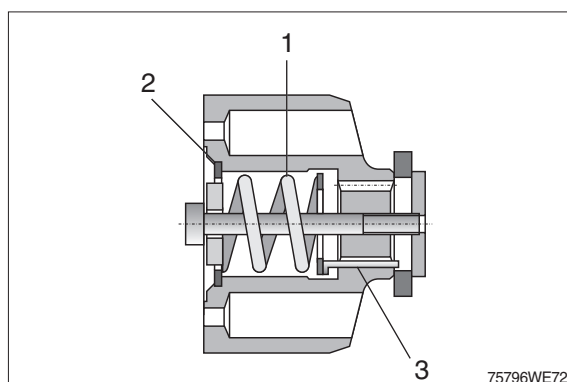
(7) Remove the circlip and the shaft seal.



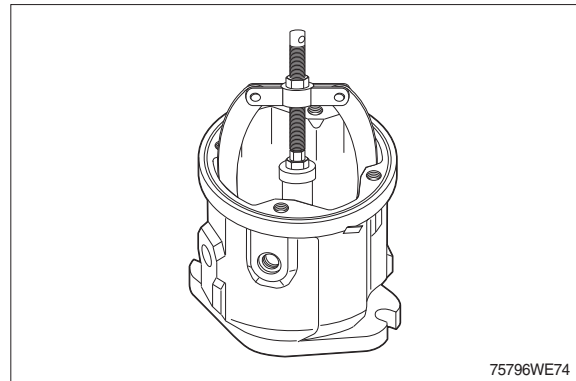
(8) Remove the drive shaft through rear side.



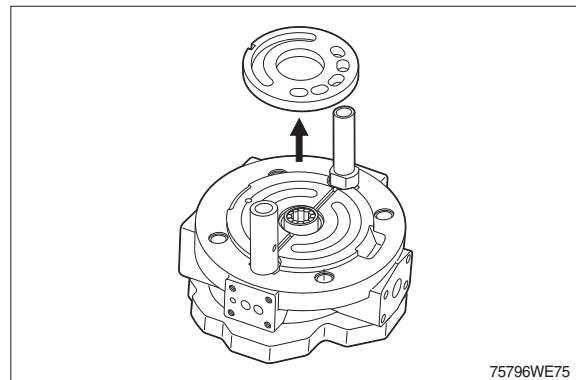
(9) Pre-tension the spring (1) using a suitable device.
Remove circlip (2).
Remove spring (1) and pressure pins (3).



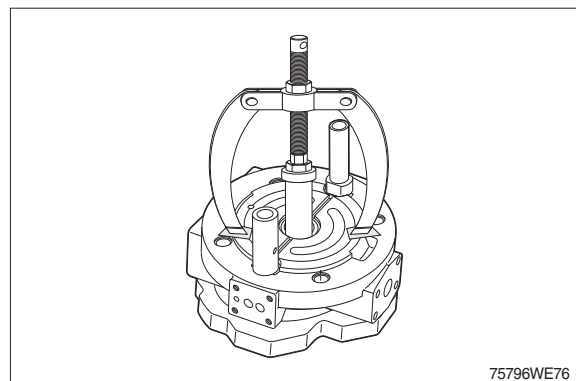
- (10) Use bearing puller to remove outer bearing race of front bearing out of housing press seat.



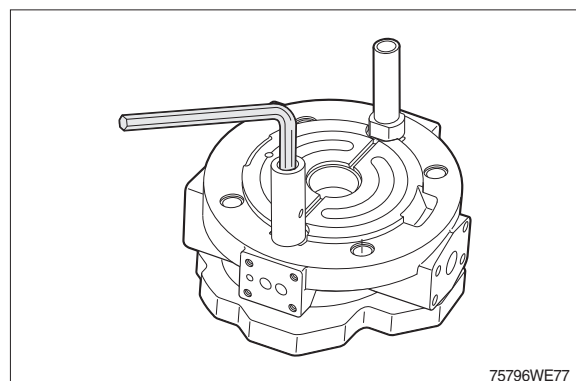
- (11) Remove the control plate.



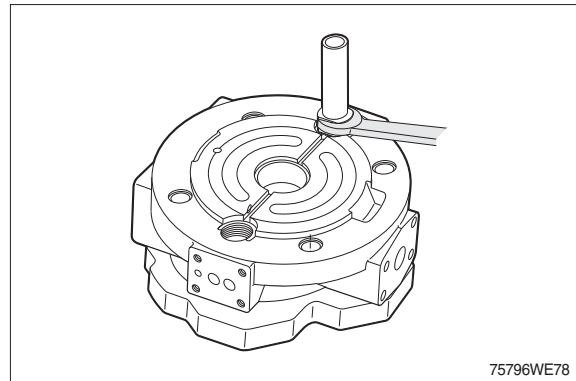
- (12) Use bearing puller to remove outer bearing race of rear bearing - press seat.



- (13) Disassemble the guide of control piston (Mounting position: pilot valve side).

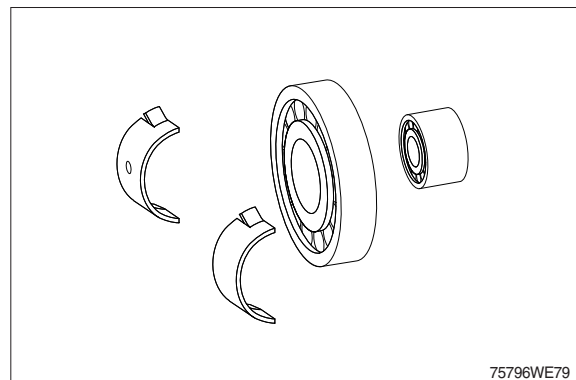


- (14) Disassemble the guide of the opposite piston.



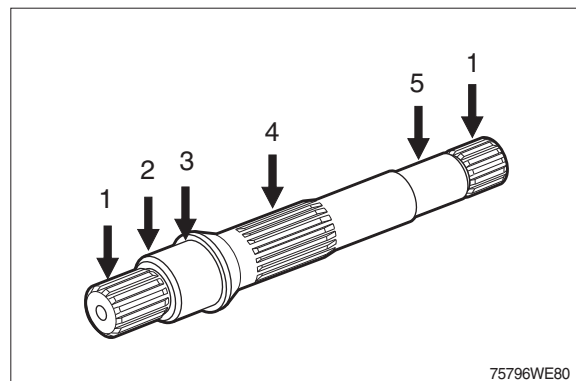
6) INSPECT HINTS

- (1) Renew all bearings.



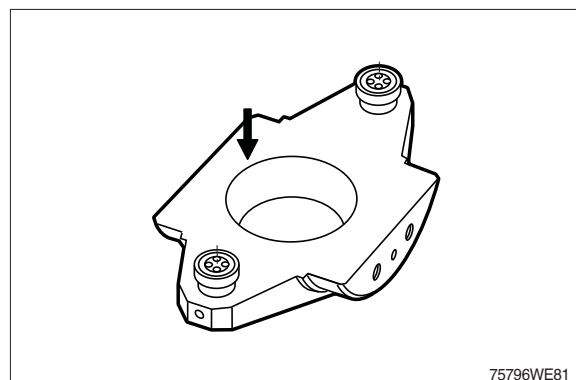
- (2) Check :

- 1 Wear on splines, rust
- 2 Drive shaft seal wear grooves
- 3 Bearing seat
- 4 Splines for cylinder drive
- 5 Bearing seat

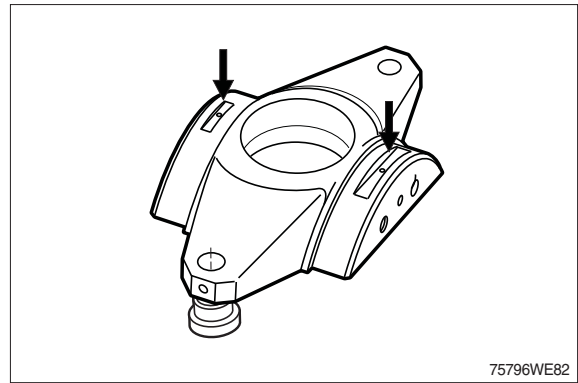


- (3) Check :

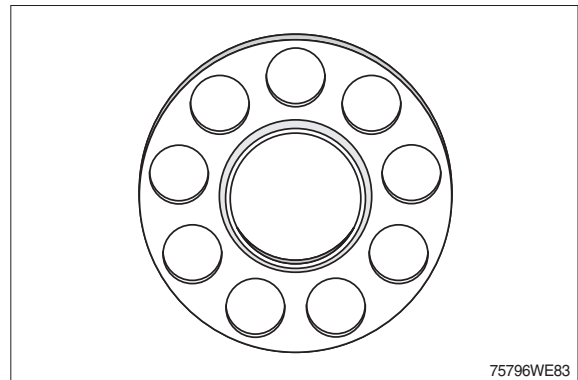
Sliding surface free of grooves.



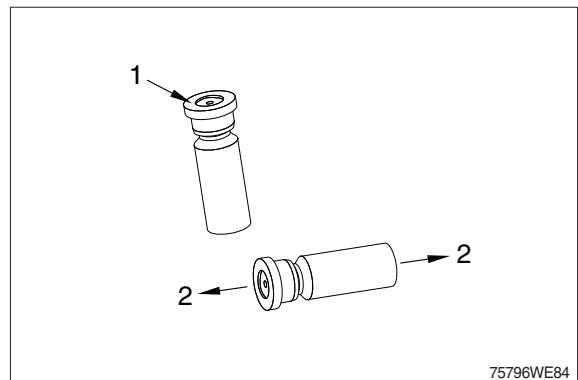
- (4) Check :
Bearing surfaces.



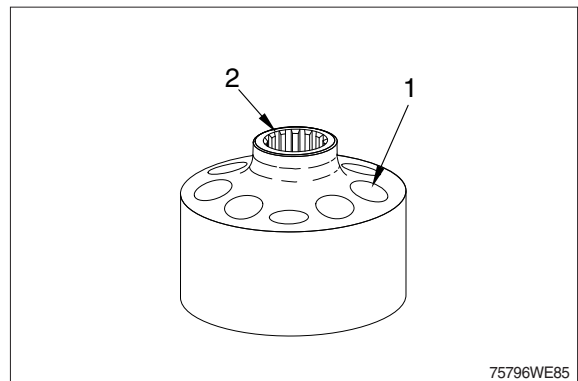
- (5) Check :
That the retaining plate is free of grooves
and that there is no wear in the slipper
pad area.



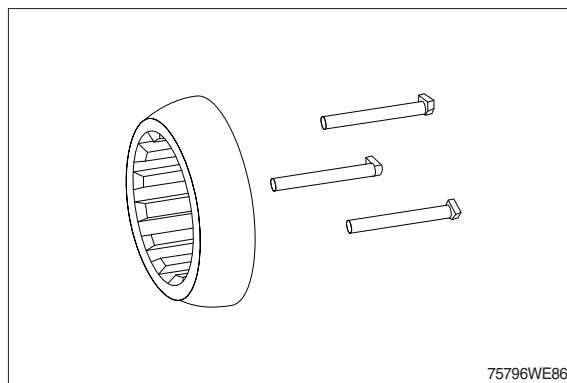
- (6) Check :
Check to see that there are no scratches
or metal deposits on the sliding surface
(1) and that there is no axial play (2)
(Pistons must only be replaced as a set).



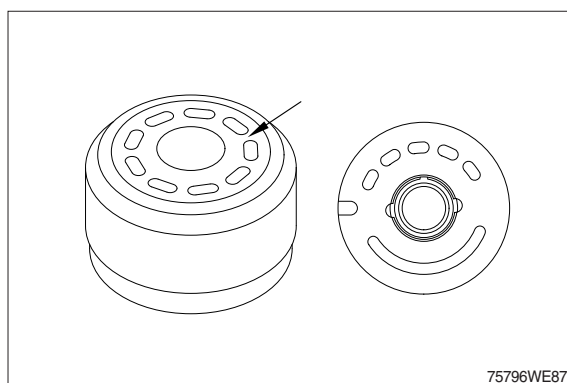
- (7) Check :
1 Cylinder bores
2 Splines



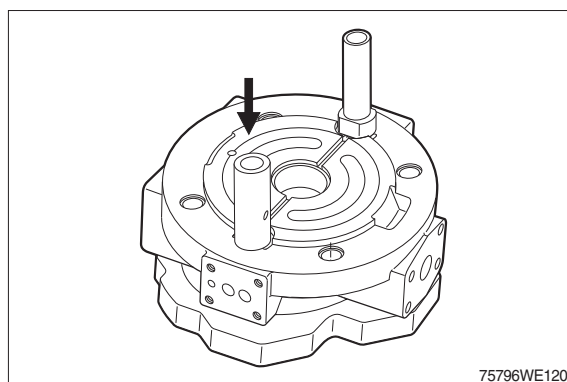
(8) Free of grooves, no signs of wear.



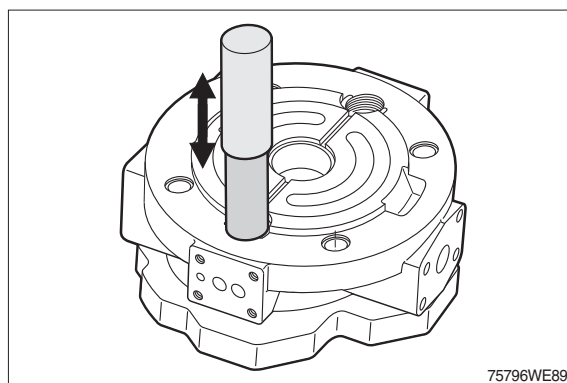
(9) Check :
Cylinder sliding surface free of grooves,
no wear, no embedded foreign particles.
That there are no scratches on the control
plate. (Only replace them as a set).



(10) Check :
Mounting surface - control plate
undamaged.

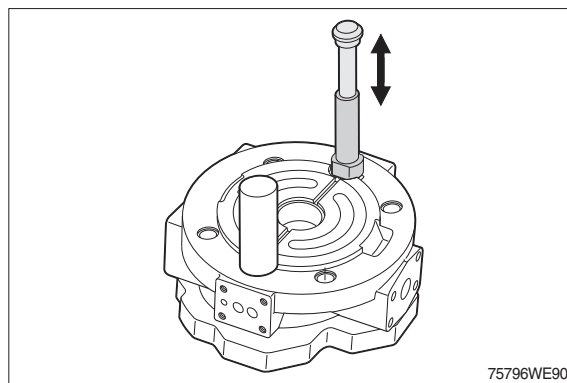


(11) Check :
Check running conditions of the control
piston.



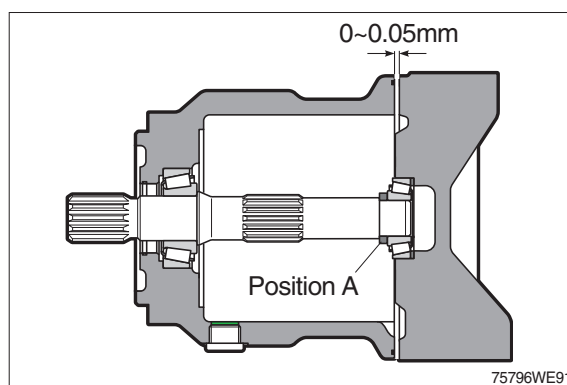
(12) Check :

Check running conditions of the opposite piston.



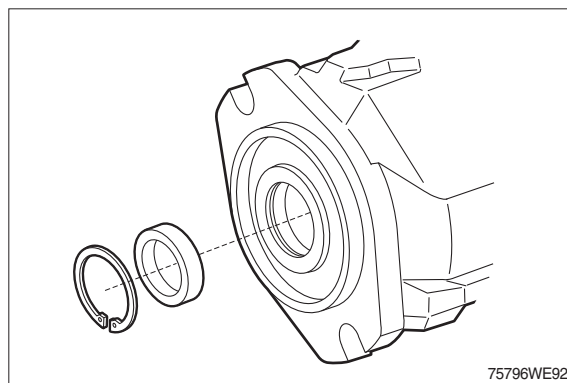
7) ADJUSTMENT OF TAPER ROLLER BEARING SET

- (1) Cast iron housing must have initial tension of the bearings: 0~0,05 mm, grind position A if necessary.

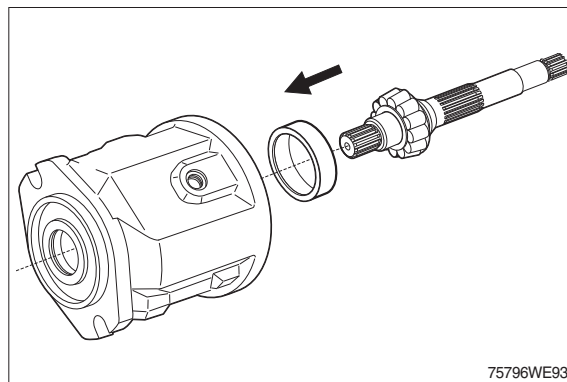


8) PUMP ASSEMBLY

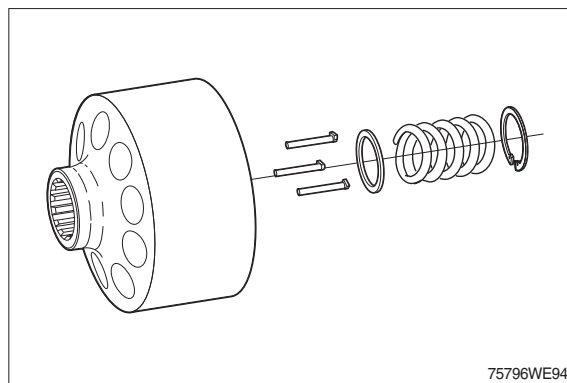
- (1) Fit the seal into the housing.
Fit the circlip.



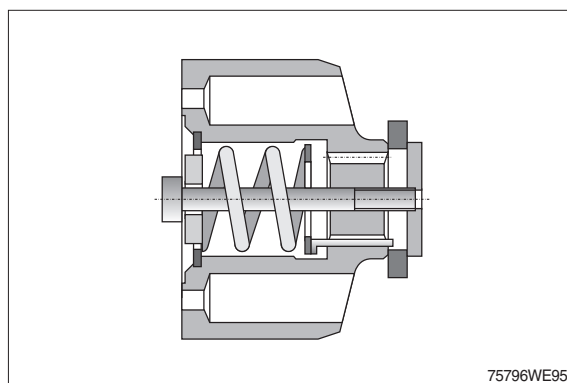
- (2) Fit the drive with bearing from rear end.
※ Do not touch seal lip with edge of keyway or spline.



(3) Fit pressure pins using an assembly aid.

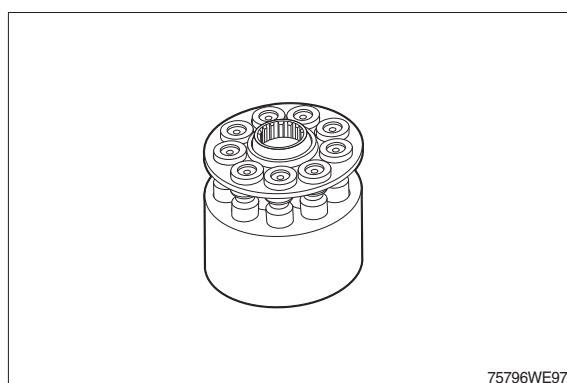


(4) Pre-tension the spring using a suitable device.



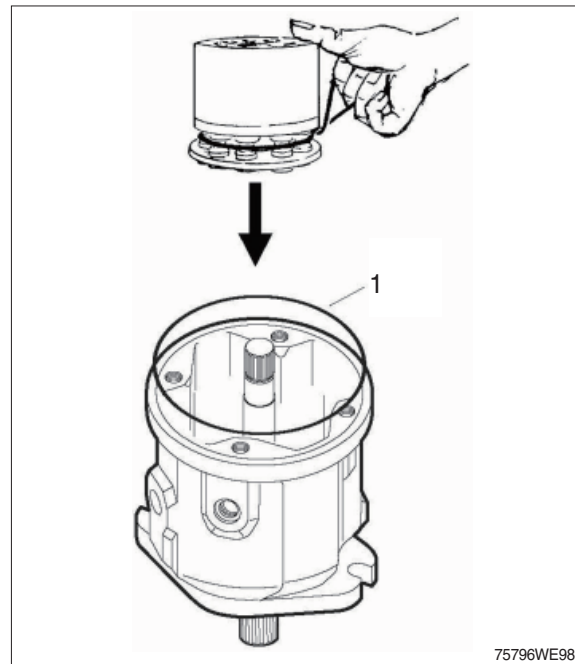
(5) Assemble piston with retaining plate.

※ Oil piston and slipper pad.



(6) Fit rotary group.

- ※ Hold the piston by using an O-ring.
Fit O-ring (1).



(7) Fit bearing (1) in connection plate.

Fit cylindrical pin (2).

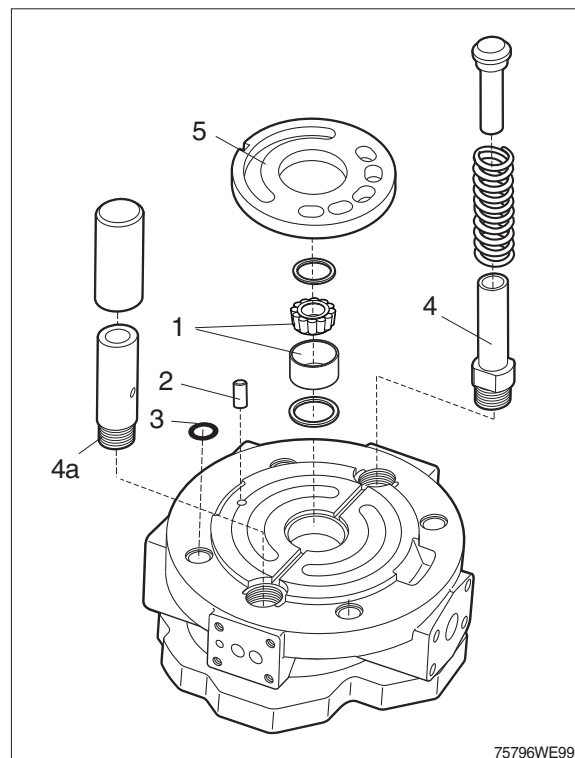
Fit O-rings (3) 4 pieces.

Fit adjustment spool (4) and guide piston (4a).

Fit distributor plate (5) (direction of rotation dependent)

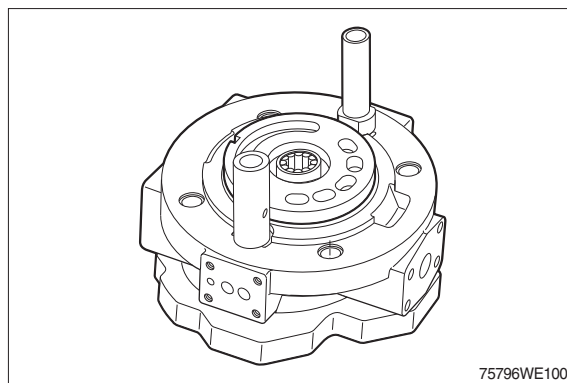
※ Assembly.

Hold the components in place with grease.



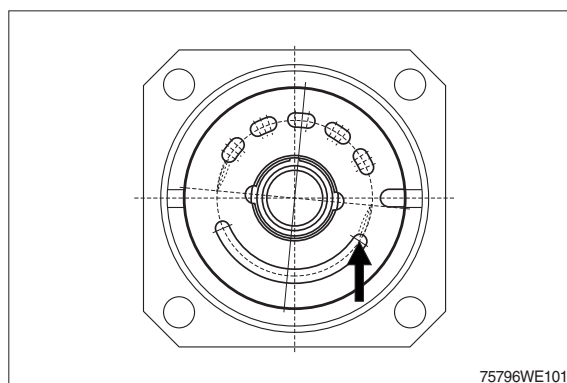
(8) Fit distributor plate.

※ Assembly aid : Grease

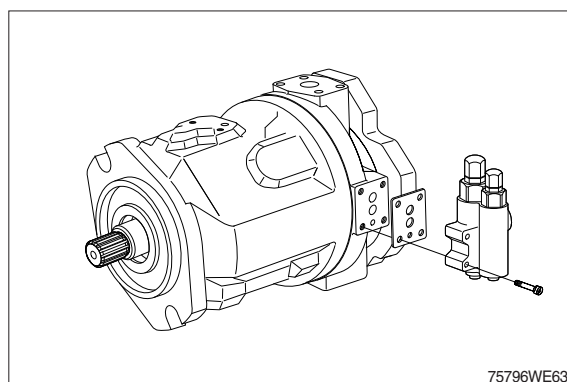


(9) For clockwise rotation pumps the distributor plate is off-set by 4° to the right from the centre position.

(Clockwise and anti-clockwise rotation distributor plates are not identical).

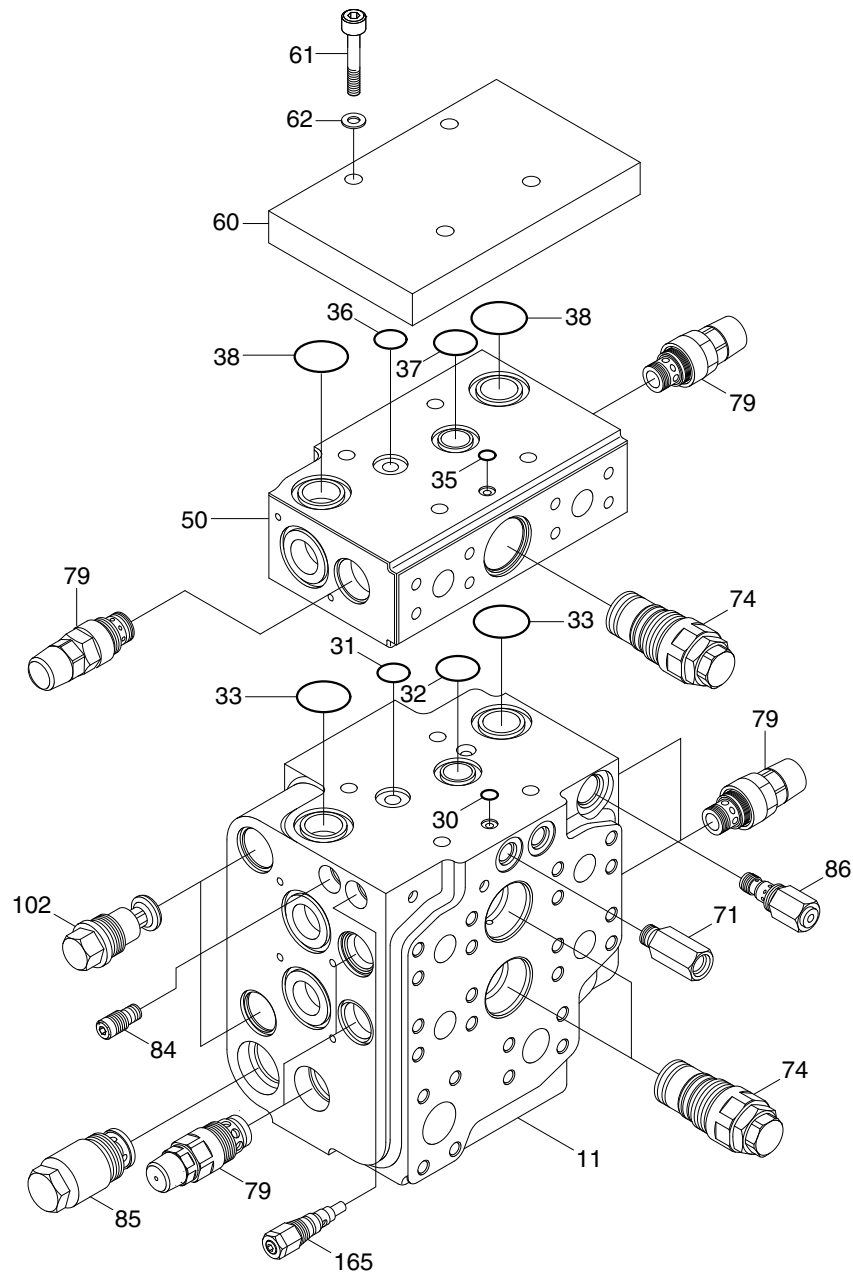


(10) Fit connection plate and control valve.



2. MAIN CONTROL VALVE

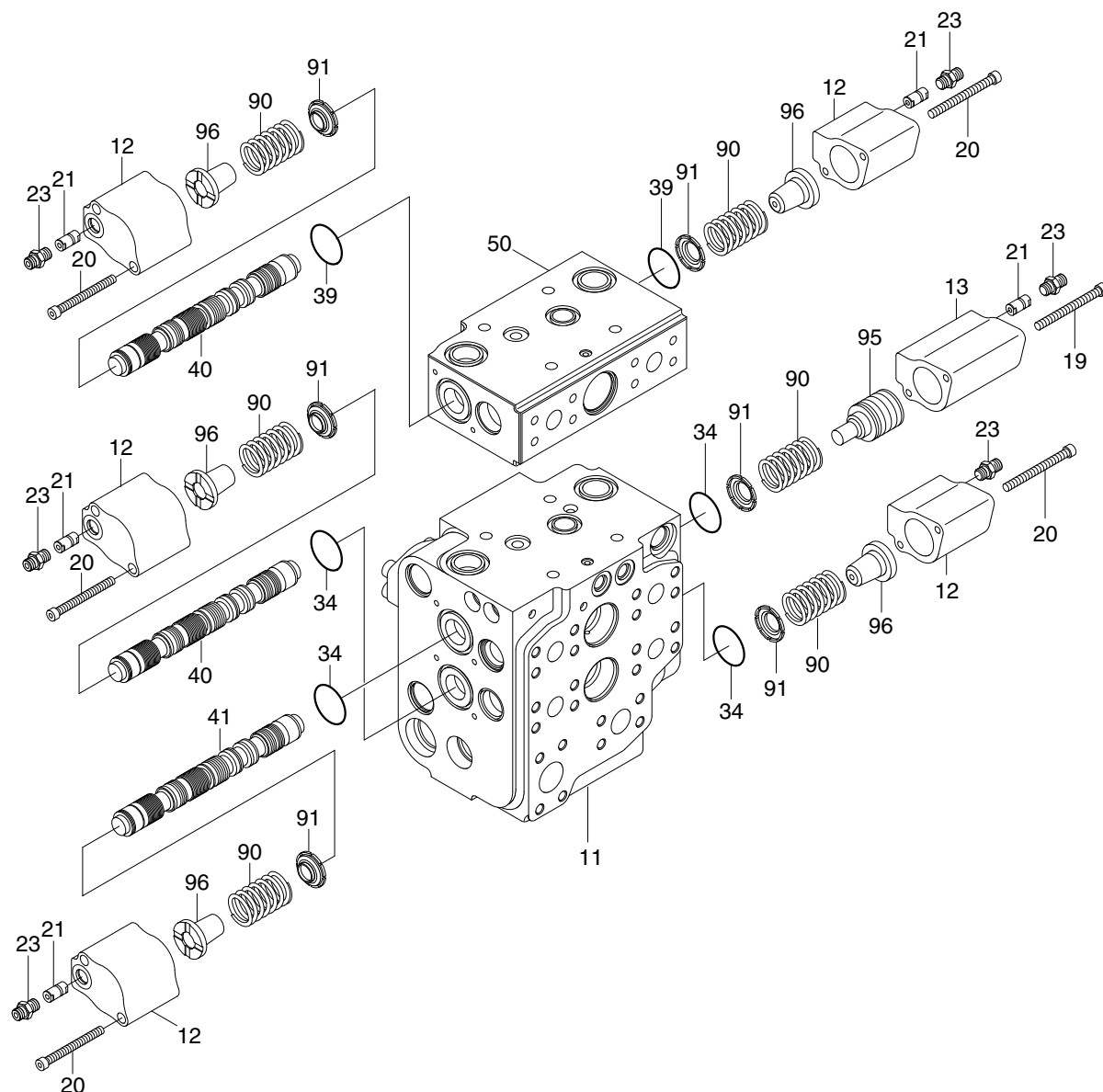
1) STRUCTURE (1/2)



76096WE13

11	Housing	37	O-ring	74	Compensator valve
30	O-ring	38	O-ring	79	Pressure valve
31	O-ring	50	Housing	84	Flow regulator
32	O-ring	60	Plate	85	Precharge valve
33	O-ring	61	Cylinder screw	86	Pilot oil supply
35	O-ring	62	Washer	102	Locking screw
36	O-ring	71	Shuttle valve	165	Pressure relief valve

STRUCTURE (2/2)



76096WE14

11 Housing
12 Cover
13 Cover
14 Cover
19 Bolt
20 Bolt

21 Throttle check valve
23 Threaded steel pipe fitting
34 O-ring
39 O-ring
40 Spool
41 Spool

50 Housing
90 Compression spring
91 Spring retainer
95 Spring retainer
96 Spring retainer

2) GENERAL PRECAUTIONS

- (1) Clean room with no dust is recommended for maintenance. Because hydraulic components are precision, and have minute clearance. Tool and wash-oil must be clean, too. Handle them carefully.
- (2) At removing control valve from the machine, wash around the piping port, and neither dust nor water should go into inside with plugging. It is same at attaching the machine.
- (3) Prepare the required parts by checking structure figure before assembly. There are parts which are supplied with only sub-assembly part, so check the parts list before assembly.

3) PRECAUTIONS FOR DISASSEMBLY

- (1) Handle the components carefully not to drop them or bump them with each other as they are made with precision.
- (2) Do not force the work by hitting or twisting as burred or damaged component may not be assembled or result in oil leakage or low performance.
- (3) When disassembled, tag the components for identification so that they can be reassembled correctly.
- (4) Once disassembled, O-ring and back-up rings are usually not to be used again.(Remove them using a wire with its end made like a shoe-horn. Be careful not to damage the slot)
- (5) If the components are left disassembled or half-disassembled, they may get rust from moisture or dust. If the work has to be interrupted, take care to prevent rust and dust.

4) PRECAUTIONS FOR REASSEMBLY

- (1) Take the same precautions as for disassembly.
- (2) When assembling the components, remove any metal chips or foreign objects and check them for any burrs or dents. Remove burrs and dents with oil-stone, if any.
- (3) O-rings and back-up rings are to be replaced with new ones, as a rule.
- (4) When installing O-rings and back-up rings, be careful not to damage them. (Apply a little amount of grease for smoothness)
- (5) Tighten the bolts and caps with specified torque.

5) DISASSEMBLY AND ASSEMBLY

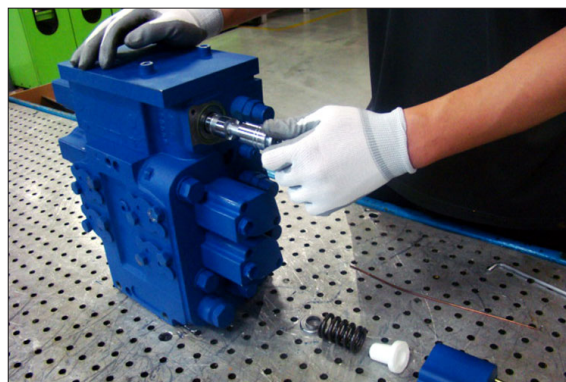
(1) Spool

- ① Loosen the bolt (2EA).
 - Tool : Wrench 5 mm
 - Tightening torque : 0.85 kgf · m
(6.1 lbf · ft)



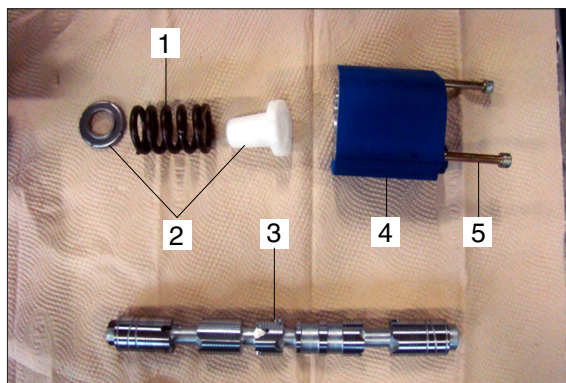
76096WE40

- ② Remove the cover, spring retainer, spring and spool.



76096WE41

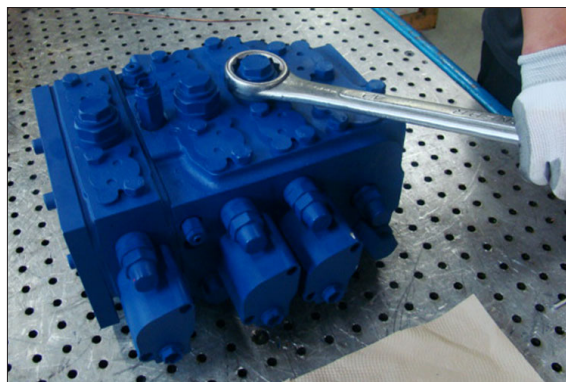
- 1 Spring
- 2 Spring retainer
- 3 Spool
- 4 Cover
- 5 Bolt



76096WE42

(2) Compensator valve

- Tool : Spanner 42 mm



76096WE43

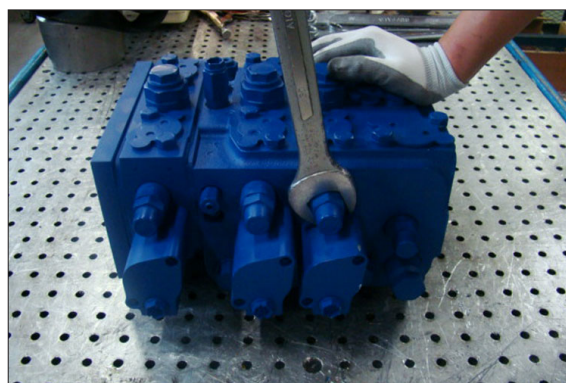
- Tightening torque : 20.4 kgf · m
(148 lbf · ft)



76096WE44

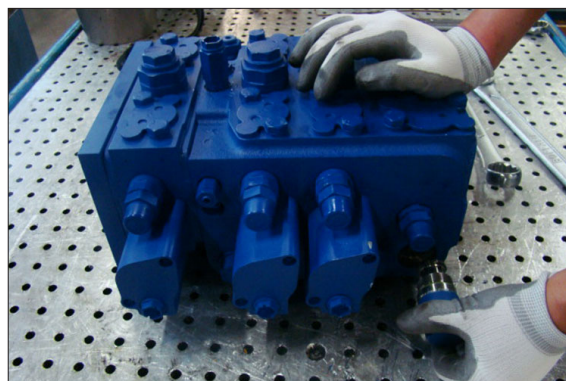
(3) Port relief valve

- Tool : Spanner 30 mm



76096WE45

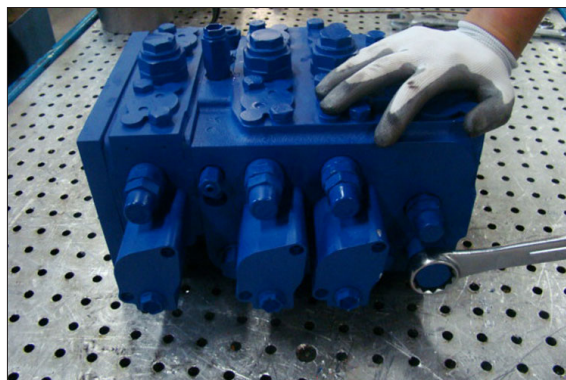
- Tightening torque : 10.2 kgf · m
(73.8 lbf · ft)



76096WE46

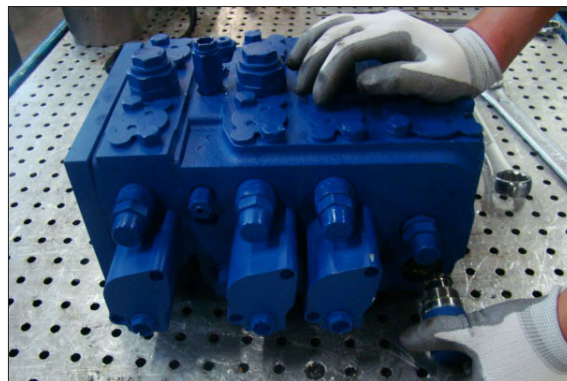
(4) Precharge valve

- Tool : Spanner 32 mm



76096WE47

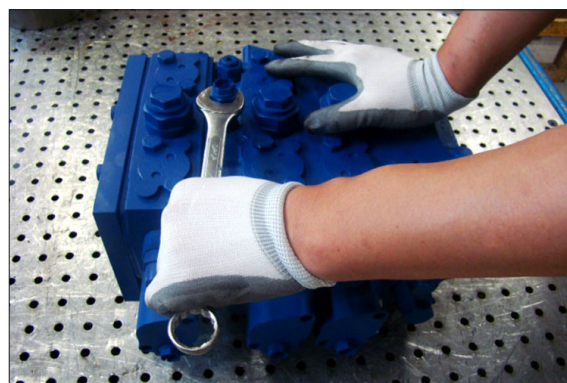
- Tightening torque : 6.1 kgf · m
(44.3 lbf · ft)



76096WE48

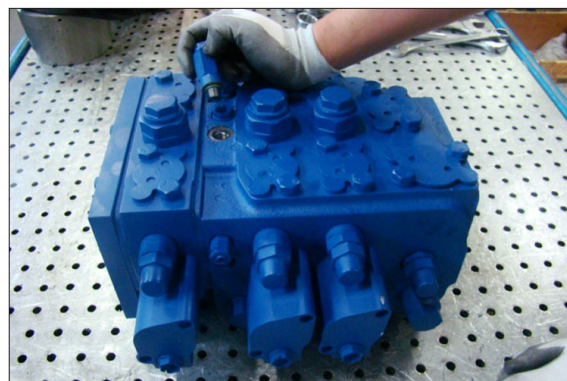
(5) Shuttle valve

- Tool : Spanner 22 mm



76096WE49

- Tightening torque : 3.6 kgf · m
(25.8 lbf · ft)



76096WE50