

ASSEMBLY OF THE HYDRAULIC PUMP (VICKERS)

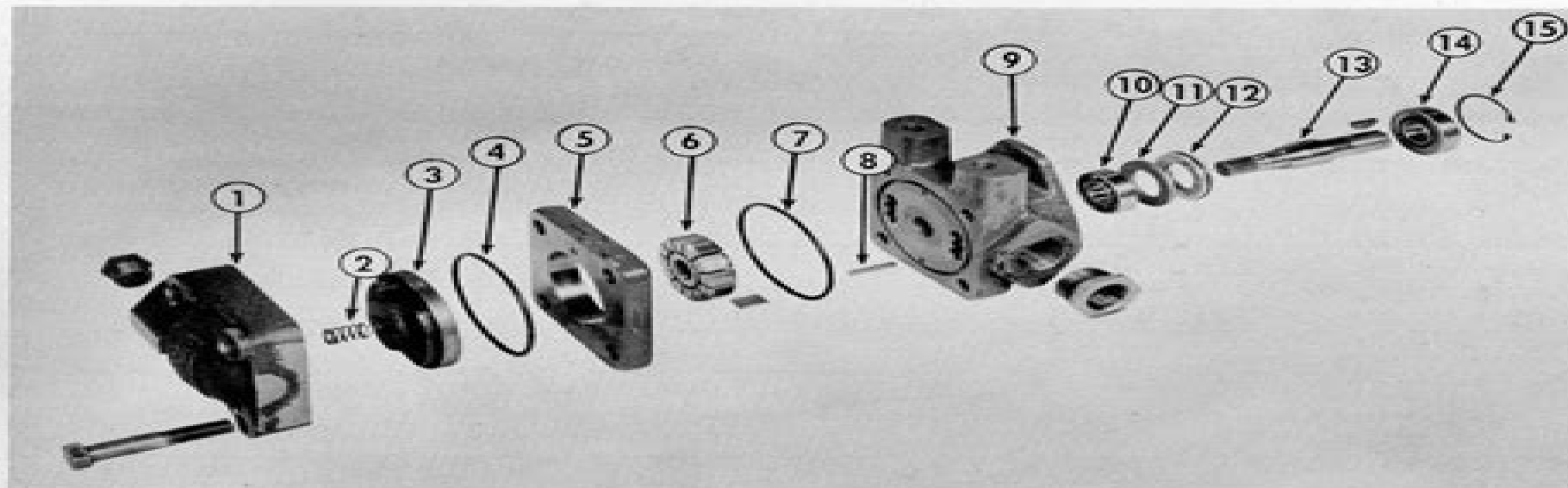


Fig. 37

Step 14—Reassembly of Low Pressure section of pump.

- a. Press bearing (10), into pump body (9).
- b. Install spacer (11), in pump body.
- c. Press oil seal (12), into pump body. Be sure sealing lip faces out.
- d. Using an arbor press, install bearing (14), on splined shaft (13).
- e. Install shaft and bearing assembly in pump body and tap in place with a soft hammer.
- f. Install snap ring (15), in place. See Step 9, Fig. 32.

Step 15—Assembly of high pressure section of the Hydraulic pump.

- a. Install "O" Ring seal (7), in pump body.

- b. Install pins (8), in pump body.
- c. Install rotor assembly (6), on splined end of shaft.
- d. Install ring (5), in place on locating pins.
Be sure arrows on ring point in direction of crankshaft travel.
- e. Install "O" ring (4).
- f. Install pressure plate (3), on pins.
- g. Install spring (2), and cap (1).
- h. Tighten the 4 cap screws securely. Torqued to 110 ft. lbs.

Step 16—Install pump.

Step 17—Refill the system with oil and operate a few times with air vent screw loose to work air out of system.

Vickers Hydraulic Pump Manual

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