

ASSEMBLY OF THE HYDRAULIC PUMP (VICKERS)

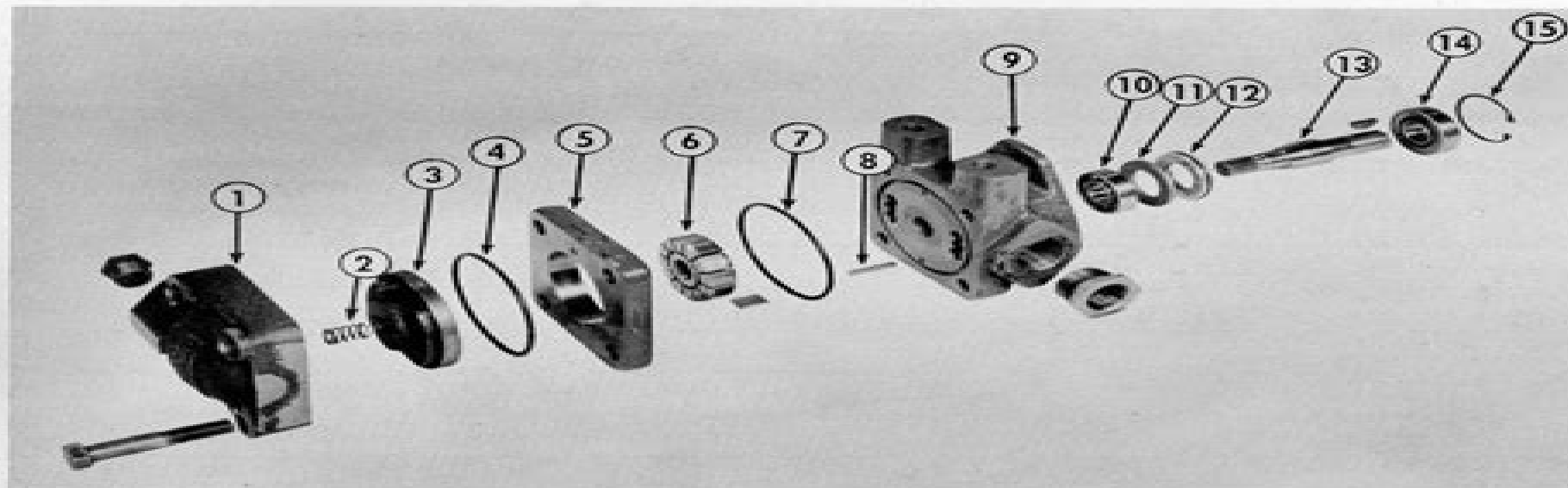


Fig. 37

Step 14—Reassembly of Low Pressure section of pump.

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

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

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

- Install pins (8), in pump body.
- Install rotor assembly (6), on splined end of shaft.
- Install ring (5), in place on locating pins.
Be sure arrows on ring point in direction of crankshaft travel.
- Install "O" ring (4).
- Install pressure plate (3), on pins.
- Install spring (2), and cap (1).
- 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.

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Table of Contents Vickers Repair Manual

1. Understanding the eBook Vickers Repair Manual
 - The Rise of Digital Reading Vickers Repair Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Vickers Repair Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Vickers Repair Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Vickers Repair Manual
 - Personalized Recommendations
 - Vickers Repair Manual User Reviews and Ratings
 - Vickers Repair Manual and Bestseller Lists
5. Accessing Vickers Repair Manual Free and Paid eBooks

- Vickers Repair Manual Public Domain eBooks
- Vickers Repair Manual eBook Subscription Services
- Vickers Repair Manual Budget-Friendly Options
- 6. Navigating Vickers Repair Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Vickers Repair Manual Compatibility with Devices
 - Vickers Repair Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Vickers Repair Manual
 - Highlighting and Note-Taking Vickers Repair Manual
 - Interactive Elements Vickers Repair Manual
- 8. Staying Engaged with Vickers Repair Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Vickers Repair Manual
- 9. Balancing eBooks and Physical Books Vickers Repair Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Vickers Repair Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Vickers Repair Manual
 - Setting Reading Goals Vickers Repair Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Vickers Repair Manual
 - Fact-Checking eBook Content of Vickers Repair Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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