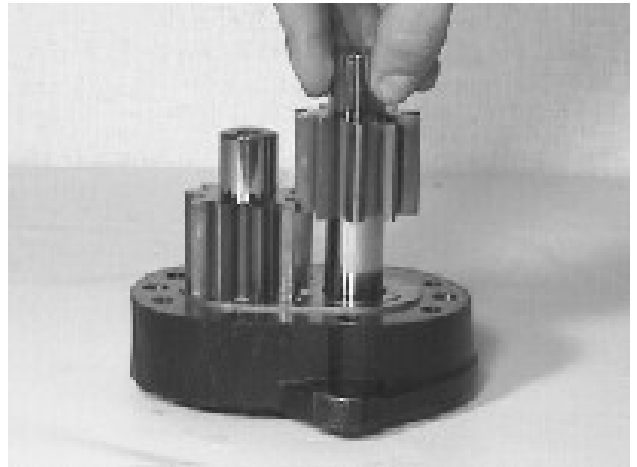


7. Insert the idler shaft through the wear plate, and into the housing.



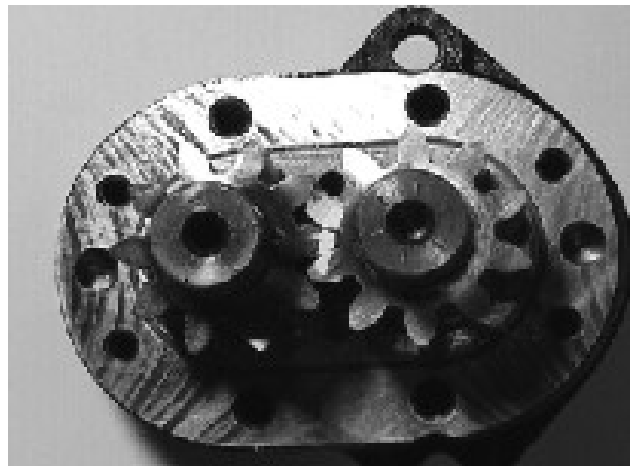
GD98J808 7

8. Insert the drive shaft through the wear plate, and into the housing.



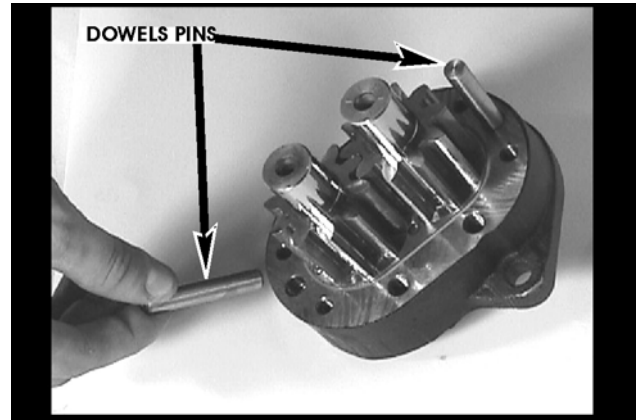
GD98J807 8

9. During the gear pump disassembly, the gear teeth were aligned and then marked. Please refer to **Hydraulic pump - Disassemble (A.10.A.20 - F.10.A.25)**. Ensure that the meshed teeth marks, on the drive shaft and the idler shaft, are properly aligned.



GD98J806 9

10. Insert the guide dowels into the housing.



GD98J805_2 10

11. Align and slide the gear plate down the shafts and guide dowels until it is snug against the body.



GD98J804 11

12. During the gear pump disassembly, alignment marks were placed on the housing for the body and cover. Please refer to **Hydraulic pump - Disassemble (A.10.A.20 - F.10.A.25)**. Align and place the cover on top of the body



GD98J803 12

13. Secure the cover on top of the body with washers and socket bolts. Tighten the socket bolts. Do not overtighten.



GD98J802 13

Hydraulic pump - Install (A.10.A.20 - F.10.A.15)

435, 445, 445CT

Prior operation: Before pump installation, apply Molykote G-4700 (P/N 86983138) to the pump and the coupling splines. Pre-fill the pump with clean hydraulic oil. Inspect O-ring on the pump pilot and replace if necessary. Lubricate the O-ring with clean hydraulic oil.

1. Hold the pump in the mounting location. Rotate the gear pump shaft until it aligns with the coupling splines at the rear of the hydrostatic pump. After the splines are aligned, move the pump inward until the mounting flange is flush with the mounting surface of the hydrostatic pump.
2. Apply Loctite 243 to the pump mounting bolts. Install washers on the bolts and install the bolts into the pump mounting flange. Tighten the mounting bolts.
3. **Reservoir - Apply vacuum (A.10.A.22 - F.35.A.50)**
Start the vacuum pump.
4. Remove the cap from the fitting and the plug from the pressure hose.
5. Connect the hose to the pressure port fitting of the pump and tighten the fitting.
6. Remove the cap from the fitting and the plug from the suction hose.
7. Connect the hose to the suction port fitting of the pump and tighten the hose clamp.



BD04C141x 1

8. Stop the vacuum pump. Disconnect the vacuum pump from the hydraulic reservoir and install the reservoir cap on the reservoir filler neck.

DISTRIBUTION SYSTEMS - PRIMARY HYDRAULIC POWER SYSTEM

- Loosen the clamp on the suction hose fitting at the hydraulic pump until hydraulic oil begins to flow from around the fitting. Retighten the clamp.



BD04C141x 2

- Clean up any hydraulic oil from the equipment and floor.
- Disconnect the fuel shutoff solenoid connector. (Photo is for reference only.)



bd04c019 3

- Turn the engine over for 30 seconds to allow hydraulic oil from the reservoir to flow into the hydraulic pump. Reconnect the fuel shutoff solenoid connector.
- Start and run the engine at low idle for 2 to 5 minutes and check for any leaks.
- Stop the engine.
- Check the hydraulic oil level in the reservoir and add hydraulic oil as required. **Reservoir - Filling (A.10.A.22 - F.60.A.10)**



BD04C142 4

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