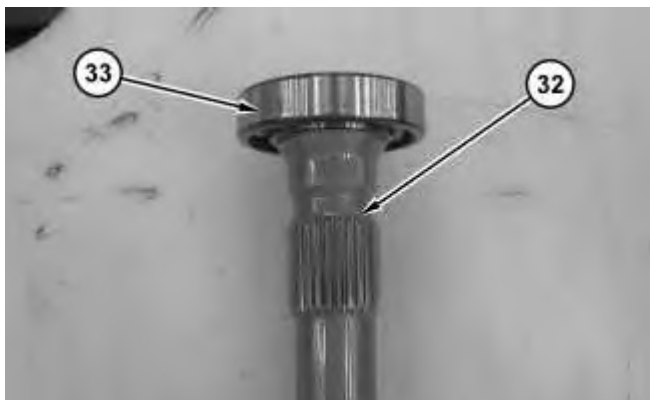


Illustration 1

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1. Raise the temperature of bearing (42).
2. Install bearing (42).
3. Use Tooling (D) to install retaining ring (43).
4. Install shaft assembly (40) and seal (44).
5. Install O-ring seal (45).
6. Install plate (46).
7. Install retaining ring (47).



8. Raise the temperature of bearing (33).
9. Install bearing (33) onto shaft (32).

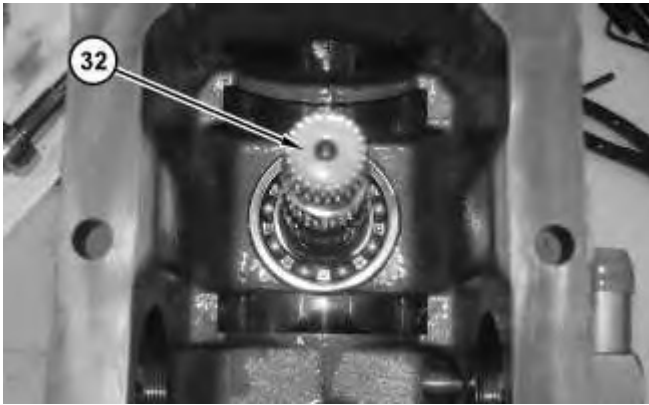


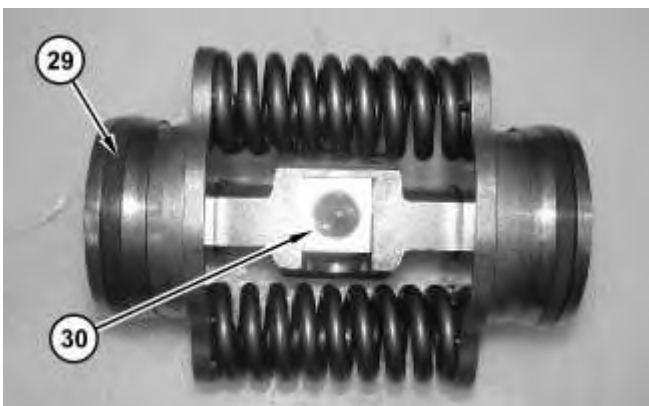
Illustration 3

10. Install shaft (32).



Illustration 4

11. Install bearings (31) onto swashplate (28).



12. Install seals (29) and block (30).

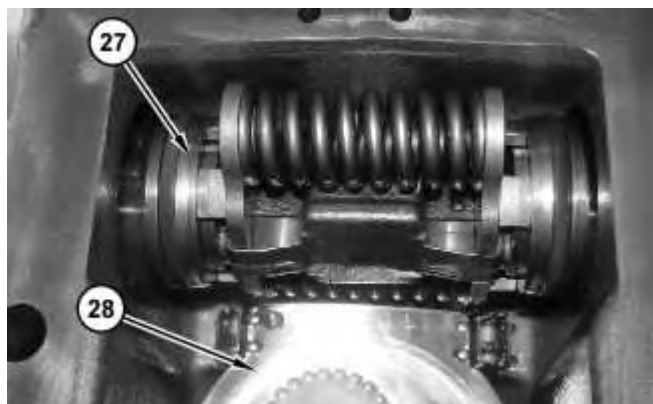


Illustration 6

13. Install piston assembly (27) and swashplate (28).



Illustration 7

14. Install O-ring seal (26).

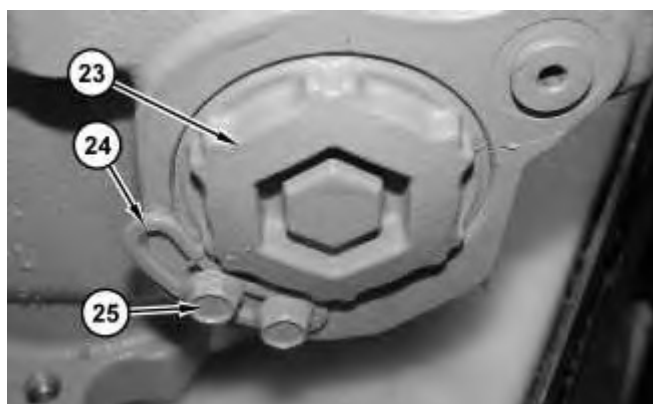


Illustration 8

15. Install set screw (23). Apply slight pressure to the piston assembly.
16. Repeat Step 15 for the opposite side.
17. Use a suitable measuring device to center the swashplate. Measure the distance that is from the machined face of the housing to both sides of the swashplate. Adjust setscrews (23) to achieve the same distance to the swashplate.
18. Install retainer (24), and bolts (25).

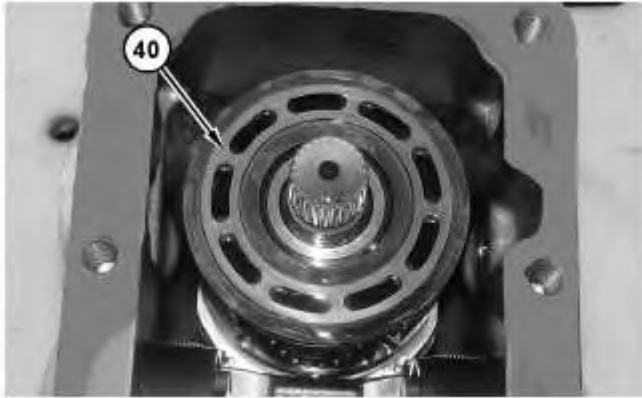


Illustration 9

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19. Install barrel assembly (40).

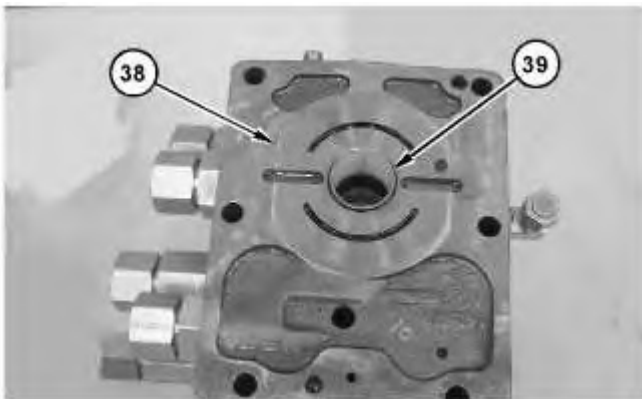


Illustration 10

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20. Install bearings (39).
21. Install port plate (36) and gasket (35).
22. Install head (38).
23. Install coupling (37).

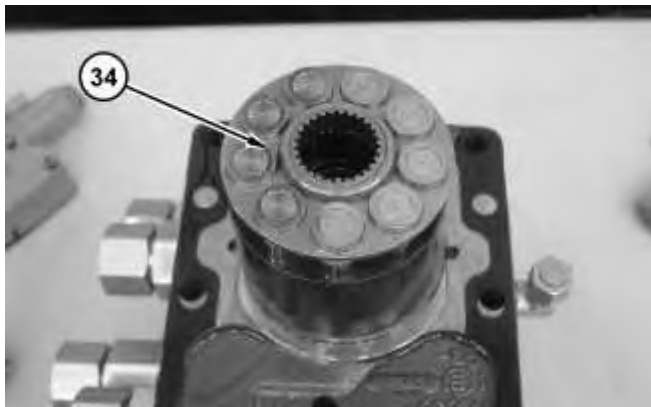


Illustration 12

24. Repeat Steps 16 through Steps 23 for barrel assembly (34).
25. Install barrel assembly (34).

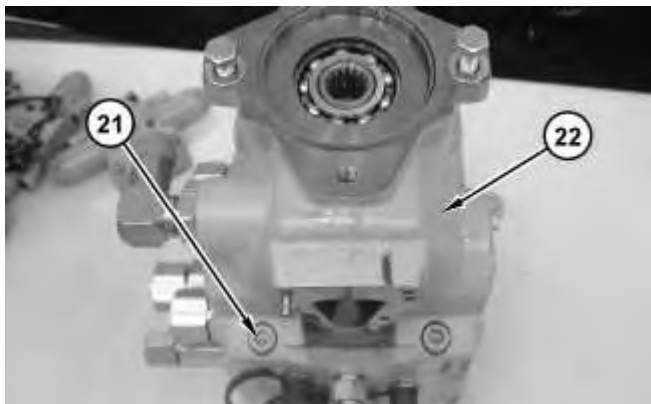


Illustration 13

26. Install housing (22) and bolts (21). Tighten bolts (21) to a torque of 110 ± 10 N·m (81 ± 7 lb ft).
-

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