

Product: TRACK-TYPE TRACTOR

Model: D8R TRACK-TYPE TRACTOR 9EM

Configuration: D8R TRACK-TYPE TRACTOR 9EM00001-UP (MACHINE) POWERED BY 3406C Engine

## Disassembly and Assembly D8R Track-Type Tractor Hydraulic System

Media Number -SEN8331-07

Publication Date -01/09/2018

Date Updated -04/09/2018

i01022332

### Steering Pump - Assemble

SMCS - 4306-016

**Note:** The internal components of the piston pump are machined to fine tolerances. Take care to protect the surfaces of these components during the maintenance procedure.

**Note:** Clean all components and apply clean oil to the surfaces of the parts before assembly.

1. Inspect all O-rings for wear and for damage. Replace any damaged O-rings.

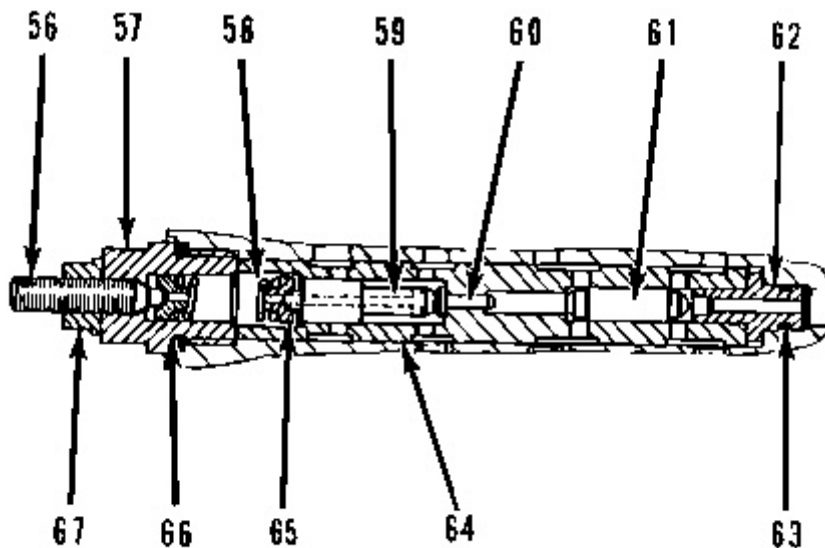
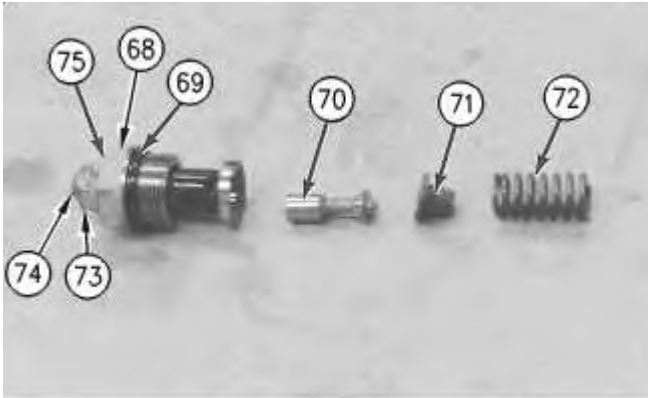


Illustration 1

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2. The following procedure is used to assemble pressure compensator valve (51).
  - a. Install O-ring seal (66) on plug (57). Use the marks from disassembly for reference to align the following parts: adjustment screw (56), plug (57) and locknut (67).
  - b. Install O-ring seal (63) on seat (62).

- c. Install seat (62).
- d. Install valve spool (61).
- e. Install pistons (64), (60), and (59).
- f. Install two retainers (65) and install spring (58).

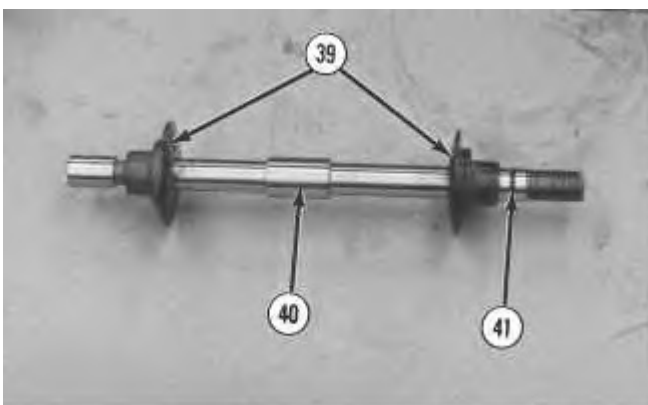


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Illustration 2

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- 3. The following procedure is used to assemble relief valve (54):
  - a. Install O-ring seal (69) on plug (68).
  - b. Install the following items in the relief valve: adjustment screw (74), valve spool (70), retainer (71) and spring (72).
  - c. Install O-ring seal (75) and nut (73).



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Illustration 3

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- 4. Install two retainers (39) on rod (40). Install O-ring seal (41).
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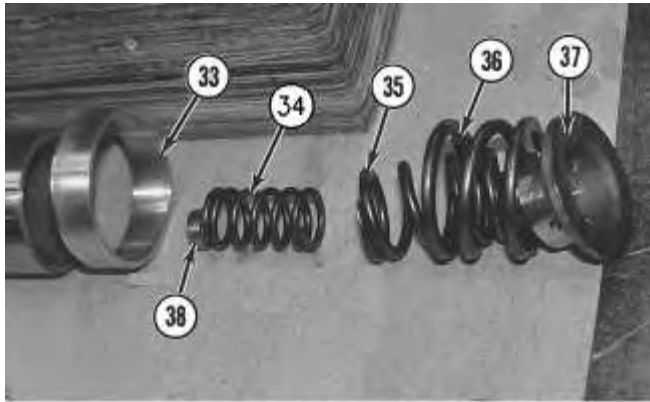


Illustration 4

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5. Install the O-ring seals in bushings (33). Install the following components on each end of the rod: bushing (33), springs (34), (35), and (36), retainer (37) and spacer (38).

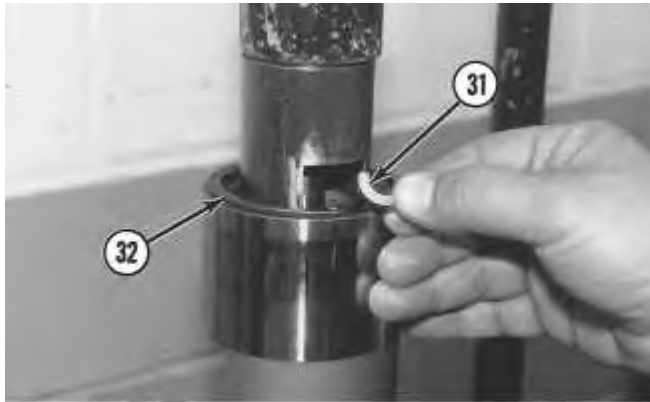


Illustration 5

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6. Install the actuator in a hydraulic press. Apply pressure to the actuator with the press.
7. Install retaining ring (32) and install retainer (31).

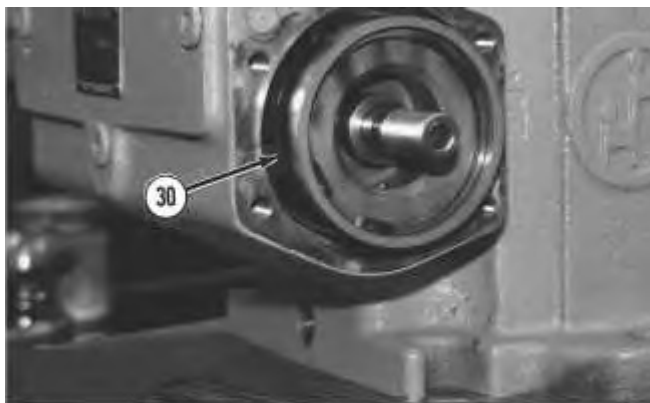


Illustration 6

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8. Install actuator (30) in the piston pump.

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