

Illustration 1

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2. Lower the temperature of bearing cup (17). Use Tooling (B) to install bearing cup (17) in head (8). Install bearing cup (17) until the bearing cup is seated.

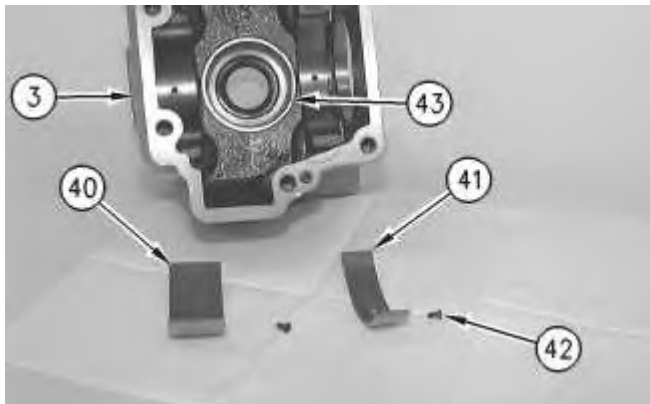


Illustration 2

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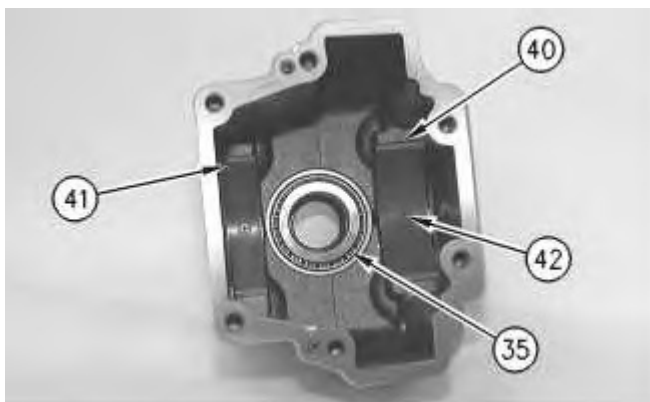
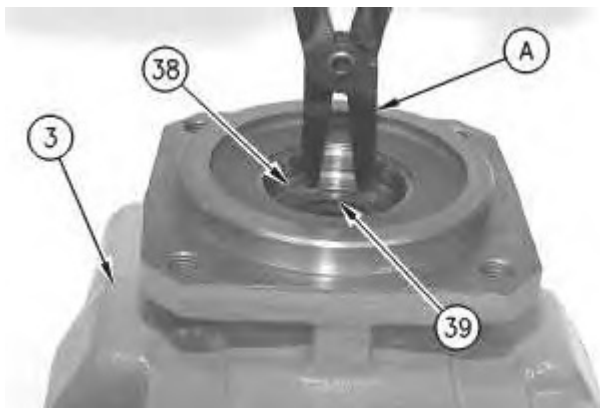


Illustration 3

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3. Lower the temperature of bearing cup (43). Use Tooling (B) to install bearing cup (43) in housing (3). Install bearing cup (43) until the bearing cup is seated.
4. Install bearing (35) in housing (3).

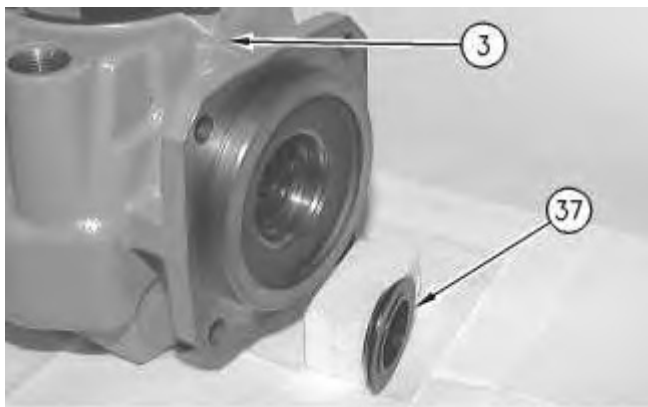
5. Install bearing (40) and bearing (41) into housing (3). Install set screws (42).



### Illustration 4

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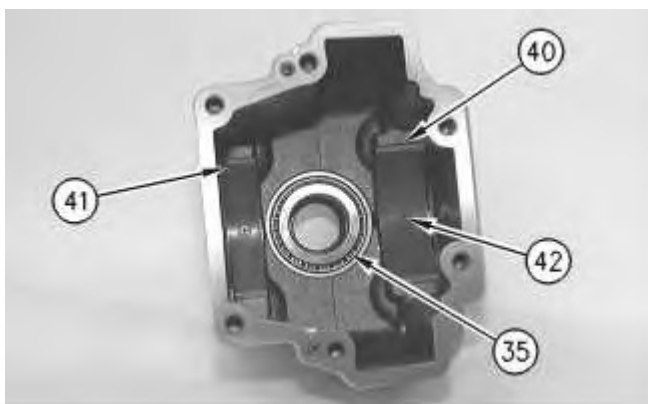
6. Use Tooling (B) to install lip seal (39) in housing (3) until the lip seal is seated. The sealing lip must face inward. Lubricate the sealing lip lightly with hydraulic oil before installation. Use Tool (A) to install retaining ring (38) into housing (3).



### Illustration 5

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7. Install shield (37) into housing (3).



### Illustration 6

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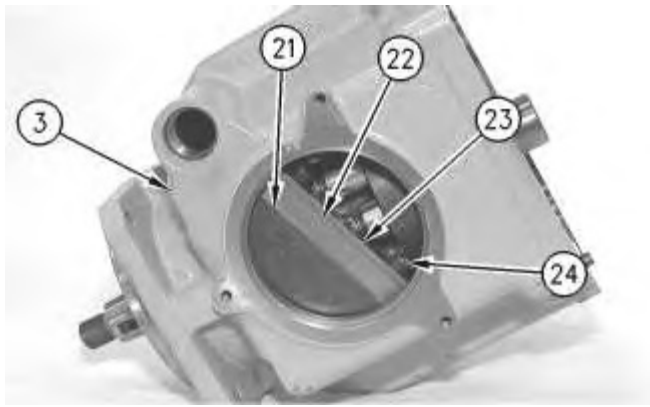


Illustration 7

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8. Place a light coat of hydraulic oil on bearing (41) and bearing (42). The hydraulic oil will hold swashplate (21) in position during the following steps. Install swashplate (21) into housing (3). Swashplate (21) should fit into bearing (41) and bearing (42).

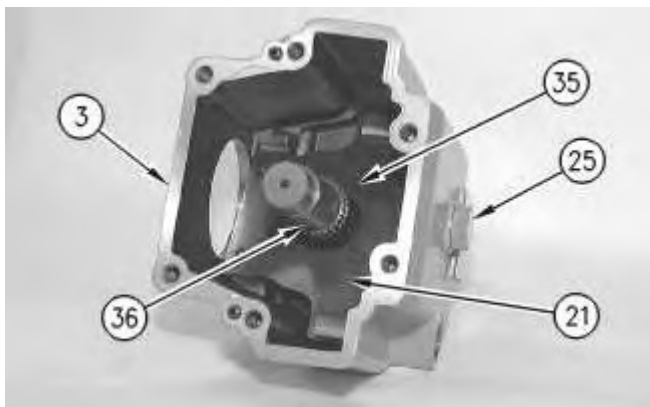
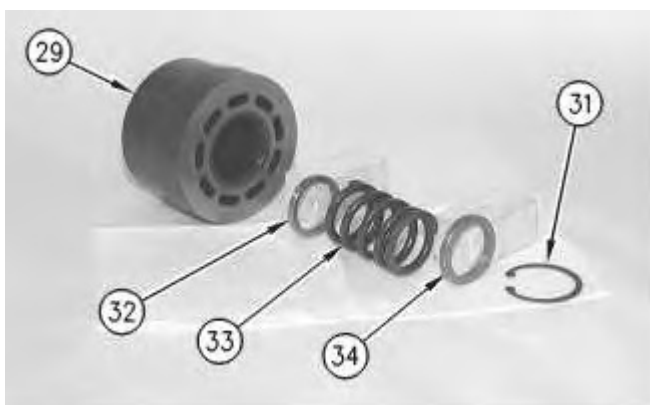


Illustration 8

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9. Place housing (3) onto support blocks to allow space for installation of shaft (36). Shaft (36) extends beyond the end of housing (3). Install shaft (36) through swashplate (21), through bearing (35) (not shown), and through housing (3).
10. Install plug (25) into housing (3). Install the O-ring seal into housing (3). Tighten plug (25) to a torque of  $102 \pm 4 \text{ N}\cdot\text{m}$  ( $75 \pm 3 \text{ lb ft}$ ).



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