

---

Illustration 1

g00780677

1. Raise the temperature of inner race (43). Lower the temperature of shaft (42). Use a soft hammer in order to install inner race (43) on shaft (42).



---

Illustration 2

g00780698

2. Raise the temperature of bearing assembly (41). Lower the temperature of shaft (42). Install bearing assembly (41) on shaft (42).



---

Illustration 3

g00780494

3. Install retaining rings (40) on each side of the bearing.
-



Illustration 4

g01018474

4. Use Tooling (F) in order to install seal (39).

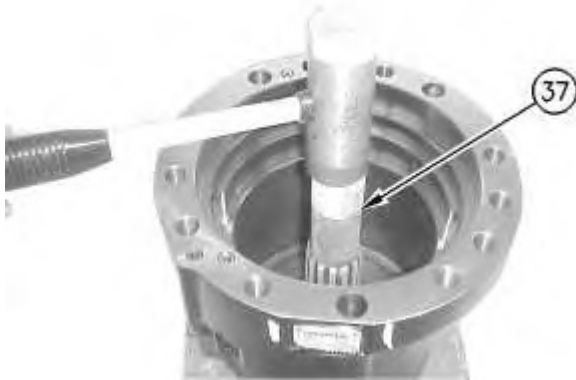


Illustration 5

g00780715

5. Use a soft hammer in order to install shaft assembly (37).



Illustration 6

g00780723

6. Install plugs (38) and the O-ring seals. Tighten plugs (38) to a torque of  $140 \pm 14$  N·m ( $103 \pm 10$  lb ft).

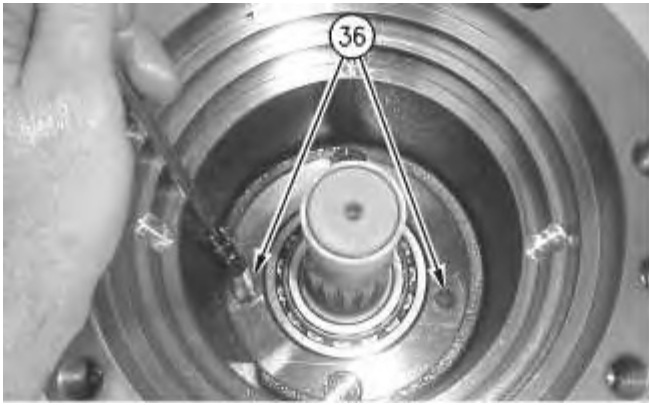


Illustration 7

g00780352

7. Use a magnet in order to install pins (36).

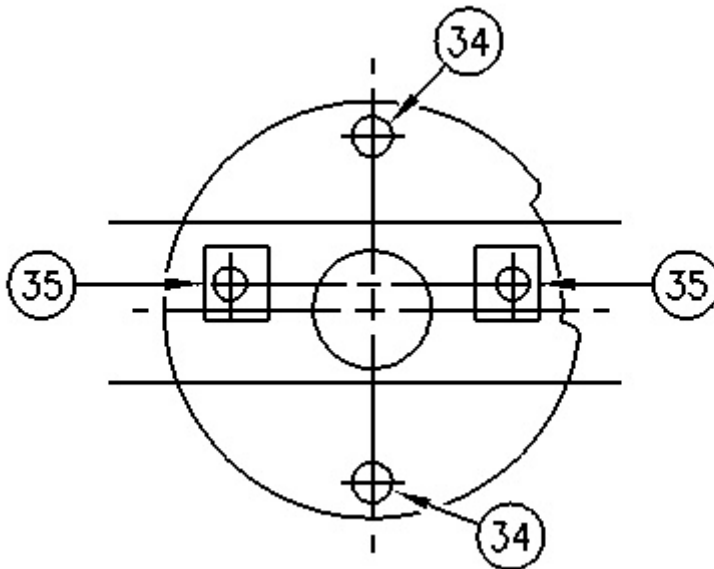


Illustration 8

g00780839

### NOTICE

**The locating pin on each key is not centered. In order to prevent damage to the barrel assembly during assembly of the travel motor, the keys must be installed as shown. Also, the keys must be installed in the key's original location in the body of the travel motor.**

8. Install pistons (34) and keys (35).

Hello.

Thanks a lot for buying from us.

**Please click here and then download.**

If you need to unzip anything here are the two recommended software.

7-Zip (Free): <http://www.7-zip.org/download.html>

Winzip ( Free Trial): <http://www.winzip.com/downwz.htm> or

If you have any difficulty with this manual, please contact us right away.

We will reply as soon as possible. --[manualonline668@gmail.com](mailto:manualonline668@gmail.com)

Hope you have a great day.

Best Regards