

Note: Cleanliness is an important factor. Before assembly, all parts should be thoroughly cleaned in cleaning fluid. Allow the parts to air dry. Wiping cloths or rags should not be used to dry parts. Lint may be deposited on the parts which may cause later trouble. Inspect all parts. If any parts are worn or damaged, use new parts for replacement. All disassembly and all assembly procedures must be performed on a clean work surface and in a clean hydraulic area. Keep cleaned parts covered and protected at all times.

Note: O-rings, gaskets, and seals should always be replaced. A used O-ring seal may not have the same sealing properties as a new O-ring seal. Use Tooling (M) during the assembly procedure.



Illustration 1

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1. Use Tooling (N) to install Duo-Cone seal (29) onto housing (28) .



Illustration 2

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2. Install bearing cone (27) onto housing (28) .
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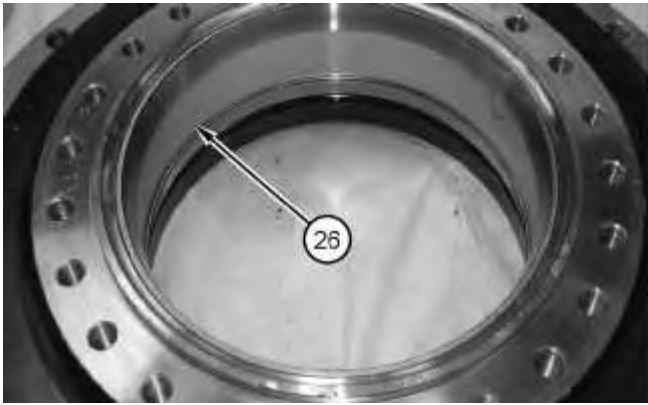


Illustration 3

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3. Lower the temperature of bearing cups (26). Install bearing cups (26) into support ring (23) .



Illustration 4

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4. Use Tooling (N) to install Duo-Cone seal (25) into support ring (23) .

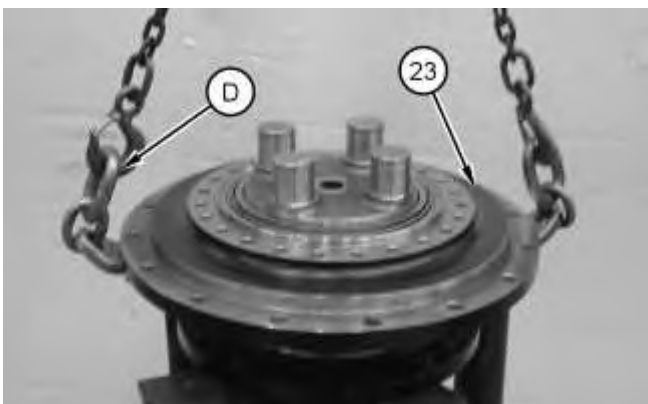


Illustration 5

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5. Use Tooling (D) and a suitable lifting device in order to install support ring (23) onto housing (28) .



Illustration 6

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6. Install bearing cone (24), as shown.



Illustration 7

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7. Install retainer nut (19) .
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