

must be performed on a clean work surface and in a clean hydraulic area. Keep cleaned parts covered and protected at all times.



Illustration 1

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1. Install O-ring seal (35) onto the housing of the travel motor.



Illustration 2

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2. Install seal (34) and piston actuator (33) .
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Illustration 3

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3. Install backup ring (32) and seal (31) .

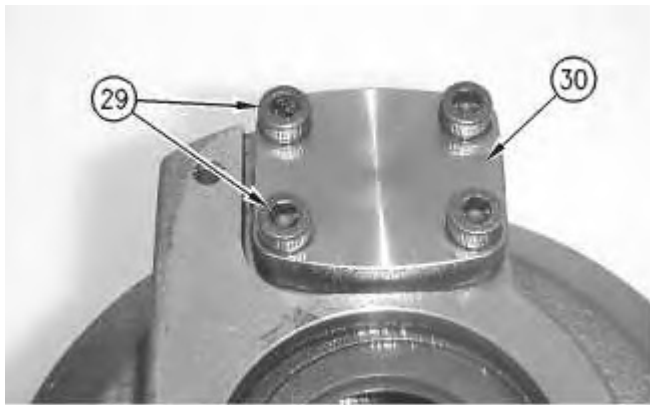


Illustration 4

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4. Install cover (30) and bolts (29) . Tighten bolts (29) to a torque of $28 \pm 7 \text{ N}\cdot\text{m}$ ($21 \pm 5 \text{ lb ft}$).



Illustration 5

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5. Apply Tooling (G) to the mating surface of seal (28) . Use Tooling (E) in order to install seal (28) .
6. Use Tooling (F) in order to install retaining ring (27) .

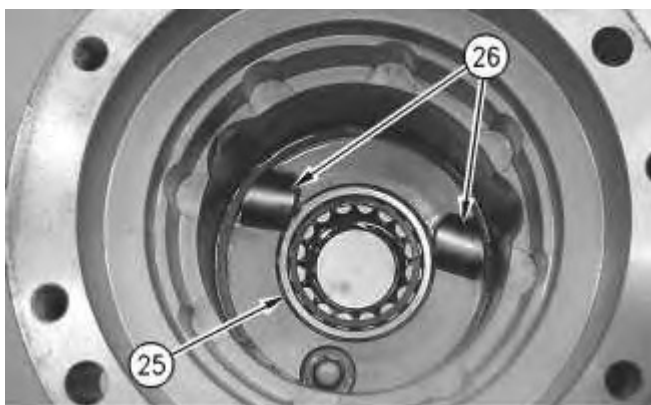


Illustration 6

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7. Rotate the housing.
8. Install keys (26) and locating pins (not shown) into the body of the travel motor.
9. Install bearing (25) .



Illustration 7

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 **WARNING**

Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.

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for your reading.**

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