

CD300413

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| 1. Mounting Nut | 11. Drive Gear Housing | 21. Seal Plate |
| 2. Flat Washer | 12. Seal Plate | 22. Seal Ring |
| 3. Spacer Sleeve | 13. Seal Ring | 23. Driven Gear |
| 4. Stud Bolt | 14. Dowel Pin | 24. Driven Gear Housing |
| 5. Mounting Flange | 15. Center Section | 25. Plate Seal |
| 6. Plate Seal | 16. Seal Plate | 26. Plate Seal |
| 7. Plate Seal | 17. Seal Ring | 27. Seal Plate |
| 8. Seal Plate | 18. Plate Seal | 28. Seal Ring |
| 9. Seal Ring | 19. Plate Seal | 29. Rear Section |
| 10. Drive Gear | 20. Dowel Pin | |

DISASSEMBLY

- ★ Callouts from the exploded view correspond with the callouts in the following steps. Clean the exterior of the pump before disassembly.
- ★ Position the pump on a work bench so that the drive shaft is up. Index mark the five sections to retain relationship during assembly,
 1. Remove the nuts (1), washers (2) and sleeves (3) from the studs (4).
 2. Remove the mounting flange (5). Remove the plate seals (6 and 7) from flange.
 3. Remove the seal plate (8) and the seal ring (9).
 4. Carefully index mark the teeth of the drive gears (10) to obtain the original mesh so that the same wear pattern will be re-established. Remove the drive gears from the gear housing (11).
 5. Remove the drive gear housing, seal ring (12) and seal plate (13). If necessary, remove dowel pin (14).
 6. Lift off the center section (15). Remove the plate seals (16 and 17) from one side and the plate seal (18 and 19) from the other side of the center section. If necessary, remove dowel pin (20).
 7. Remove the seal plate (21) and seal ring (22).
 8. Carefully index mark the teeth of the driven gears (23) to obtain the original mesh so that the same wear pattern will be re-established. Remove the gears from the driven gear housing (24),
 9. Remove the driven gear housing, seal ring (25) and seal plate (26).
 10. Remove the plate seals (27 and 28) from the rear section (29). Remove the studs from the rear section.

INSPECTION	<p>Discard all seals and seal plates and replace with new ones during assembly.</p> <p>Wash all parts thoroughly in a suitable solvent. Dry thoroughly with compressed air.</p> <p>Inspect the edges of gear teeth and faces for scoring or roughness. If possible, remove roughness or scoring with an oil stone. Also inspect the gear hubs for excessive wear at the bearing surfaces.</p> <p>Remove any roughness from the machined surfaces of flange, housings and section with an oil stone. If roughness is excessive, the components should be replaced.</p> <p>Rewash all parts that were smoothed with an oil stone and dry thoroughly.</p>
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ASSEMBLY

- ★ Callouts from the exploded view correspond with the callouts in the following steps. Clean the exterior of the pump before disassembly.
 1. Install half of the studs (4), course threads first, into the rear section (29). Install the seals (27 and 28) in the groove of the rear section.

2. Place the seal ring (25) around the seal plate (26) and install on the rear section. The seal plate must be installed so that the bronze side with the slots will face toward the driven gears and that the port holes are aligned.
3. Install the gear housing (24) on the rear section so that the index marks line up. Install the driven gears (23) aligning the index marks on the gear teeth.
4. Install the plate seals (18 and 19) in the grooves in the center section (15). Place the seal ring (22) around the seal plate (21) and install on the center section. The seal plate must be installed so that the bronze side with the slots will face toward the driven gears and that the port holes are aligned.
- ★ The seal plate (21) may require grease on its underside to keep it in place during assembly.
5. Install the center section (15) on the driven gear housing (24) so that the index marks line up.
- ★ Check that the dowel pins (20) are installed in the in the center section and are flush with the surface of the section.
6. Insert the remaining studs (4), course threads 1st, through the holes and turn them into section (20).
7. Install the plate seals (16 and 17) in the grooves in the center section (15). Place the seal ring (12) around plate (13) and install on the center section. The seal plate must be installed so that the bronze side with the slots will face toward the drive gears and that the port holes are aligned.
8. Install the drive gear housing (11) on the center section so that the index marks line up. Install the upper drive gear (10) in the housing being sure it splines with the driven gear (23). Insert the lower drive gear aligning the index mark on it with the index mark on the other gear.
9. Install seals (6 and 7) in the groove in the mounting flange (5). Place the seal ring (9) around plate (8) and install on the mounting flange. The seal plate must be installed so that the bronze side with the slots will face toward the drive gears and that the port holes are aligned. The seal plate may require grease on its underside to keep it in place during assembly.
10. Install the mounting flange on the drive gear housing so that the index marks line up. Install the washers (2) and secure with nuts (5).

 **N•m** Stud nuts 30 to 35 N•m

SCAVENGE PUMP AND DRIVE

REMOVAL



WARNING! Be sure that the blade and any rear mounted equipment have been lowered to the ground or onto suitable blocking. This procedure requires extreme caution. Use suitable blocking equipment while under the confines of the machine.

Turn the ignition switch to the OFF position and remove the key. Disconnect the negative \ominus terminal at the battery.

- ★ Disconnected hydraulic lines must be capped with the correct size plastic cap. If these caps are not available, tape or clean rubber corks may be used. Hydraulic openings must never be plugged with rags. This practice could introduce dirt or lint into critical hydraulic components of the machine. Also tag all disconnected lines to facilitate correct and easier installation.

NOT AVAILABLE

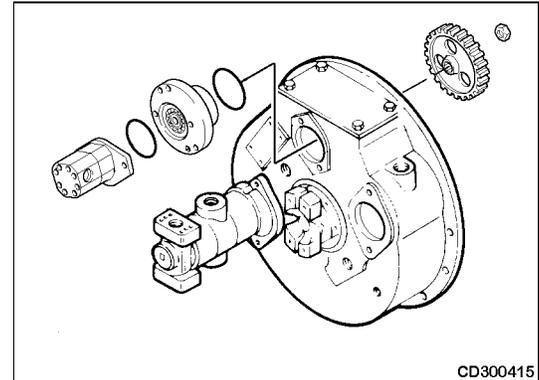
INSTALLATION

NOT AVAILABLE

 **N•m** Pump drive gear nut..... 63 to 77 N•m

 **N•m** Converter top cover bolts..... 110 to 132 N•m

- Refill the drive train system, refer to the **Operation and Maintenance Manual**.



CD300415