INTEGRAL ORBIT ROLL

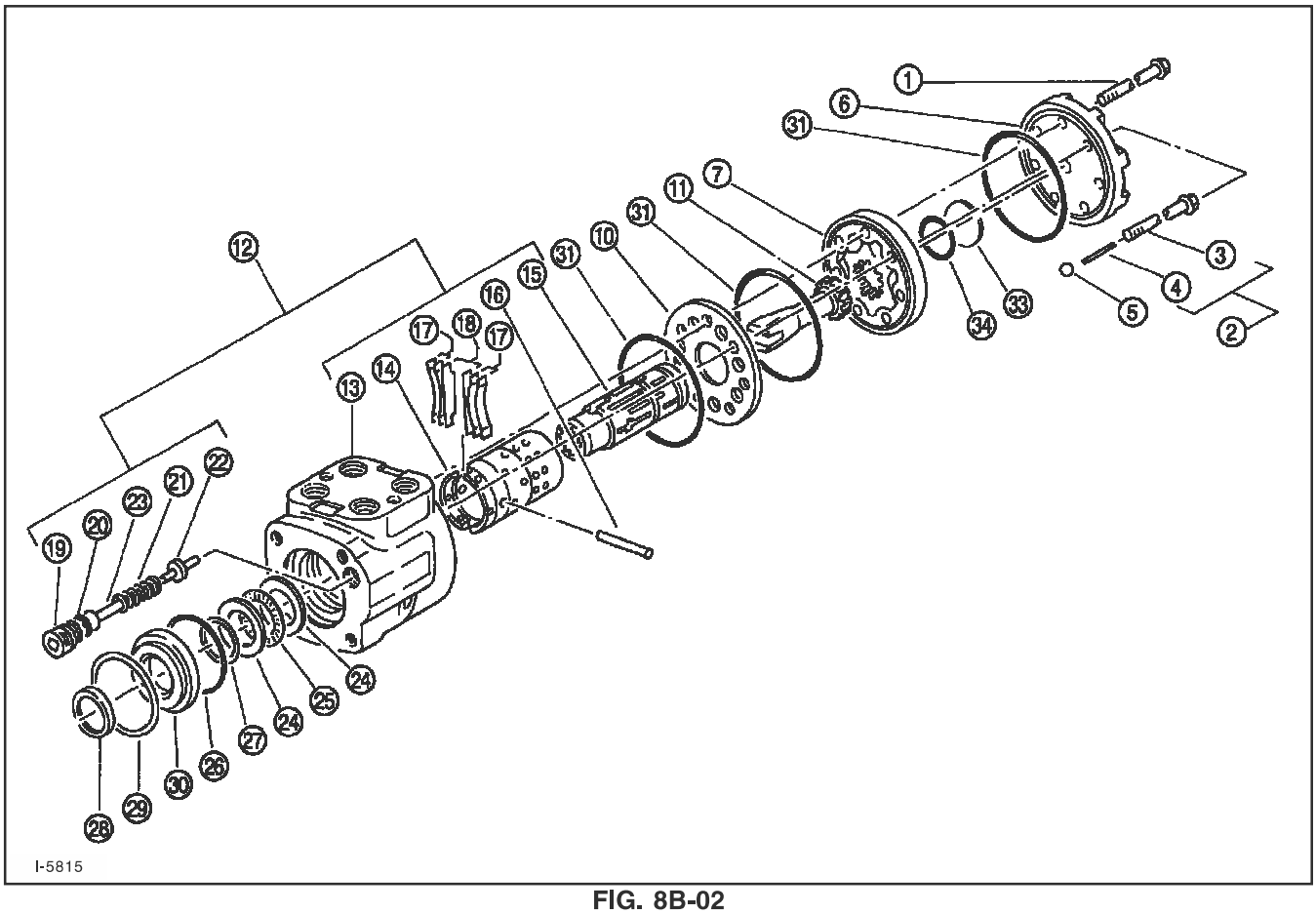

FIG. 8B-02

Components

FIG. 8B-02: Integral orbit roll components

1	Bolts	6
2	Retainer bolt assembly	1
3	Retainer bolt	(1)
4	Spring pin	(1)
5	Ball	1
6	End cap	1
7	Gerotor	1
10	Spacer plate	1
11	Drive	1
12	Control valve assembly	1
13	Housing	(1)
14	Sleeve	(1)
15	Spool	(1)
16	Pin	(1)
17	Centring springs	(4)
18	Flat springs	(2)

19	Adjusting plug	(1)
20	0-ring	(1)
21	Spring	(1)
22	Poppet	(1)
23	Collar (1)	
24	Bearing races	2
25	Thrust needle bearing	1
26	Seal	1
27	Oil seal	1
28	Dust seal	1
29	Retaining ring	1
30	Seal bushing	1
31	0-rings	3
33	Seal	1
34	0-ring	1

DISASSEMBLY

- When repairing the steering unit, a clean work-place is essential.
- Before disconnecting piping, clean around the ports of the unit.
- Remove dust accumulating around the joint of the unit with a wire brush.

NOTE: The unit should be held in a vice during operation, although almost of all the illustrations below for easy viewing do not show a vice.

Disassembly Of Rotor Side

FIG. 8B-03: Hold the unit with the rotor side turned upward in the vice, inserting copper plates or the like between the unit and vice, and lightly tighten the unit. Over tightening may damage the unit.

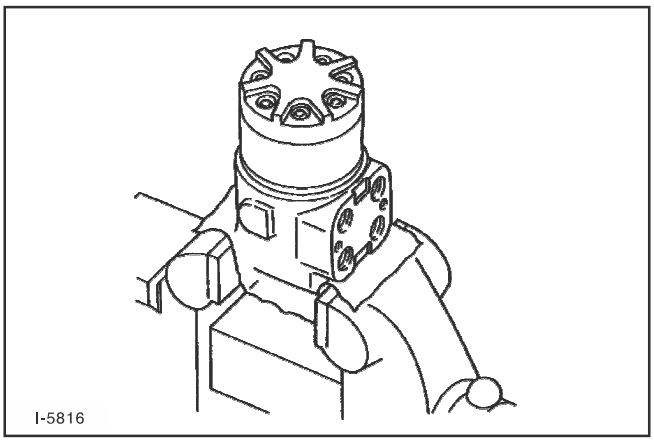

FIG. 8B-03

FIG. 8B-04: Remove the six bolts, 1, and the retainer bolt assembly, 2. Using a 5/16" socket wrench.

Remove the end cap.

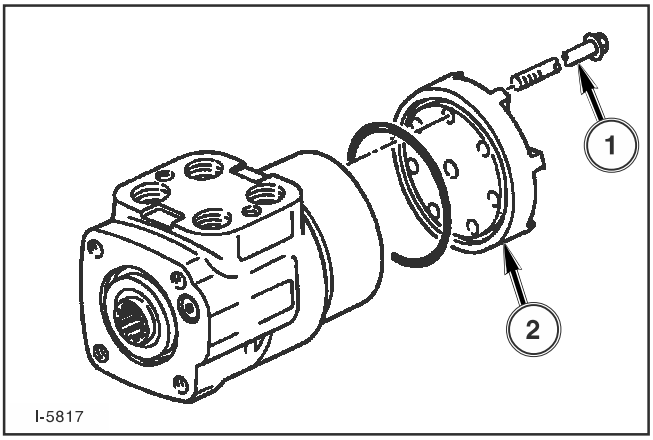

FIG. 8B-04

FIG. 8B-05: Remove 0-ring, 1, from end cap.

Remove seal, 33, and 0-ring, 34, from gerotor, 7.

Remove gerotor, 7, talking care. not to let the star rotor fall out.

Remove 0-ring, 31, from the gerotor.

NOTE: Reference Fig. 8B-02 for component number identification.

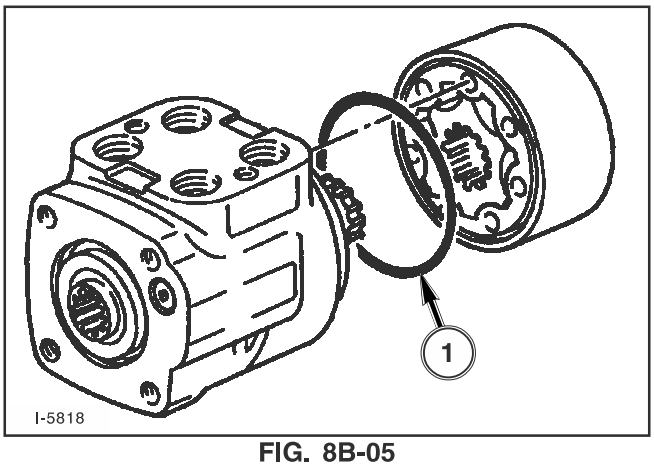

FIG. 8B-05