

1. Fit the swivel pin into correct position and orientation.
Take the hardening time and tightening torque into account.

* M6 = 8.5 N•m

M8 = 14 N•m

M10 = 35 N•m

M12 = 69 N•m

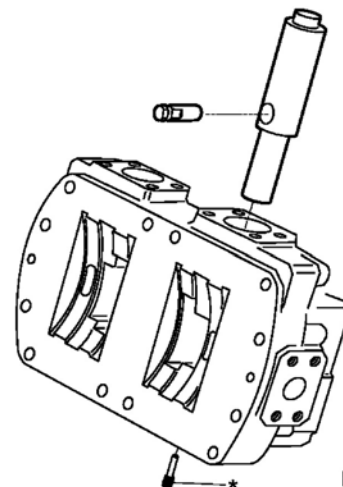


Figure 94

FG003151

2. Push on the piston ring by hand.
Fix adjustment piston.
Take the tightening torques into account.

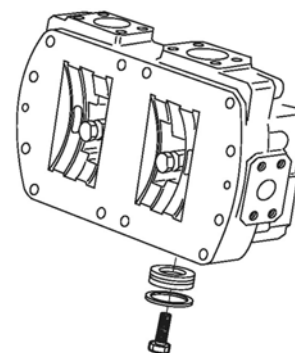


Figure 95

FG003152

3. Fit control housing.

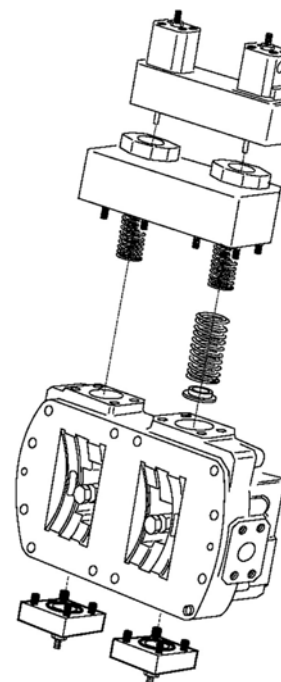


Figure 96

FG003154

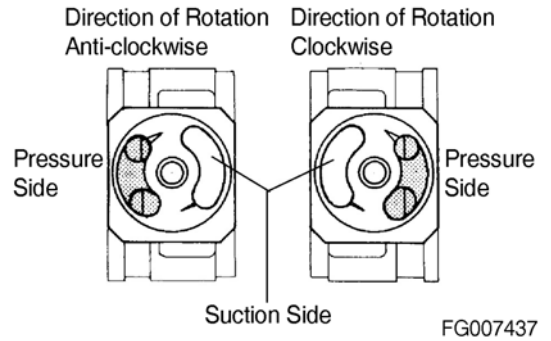


Figure 97

4. Fit the control lens in its correct position using grease to hold it in place.

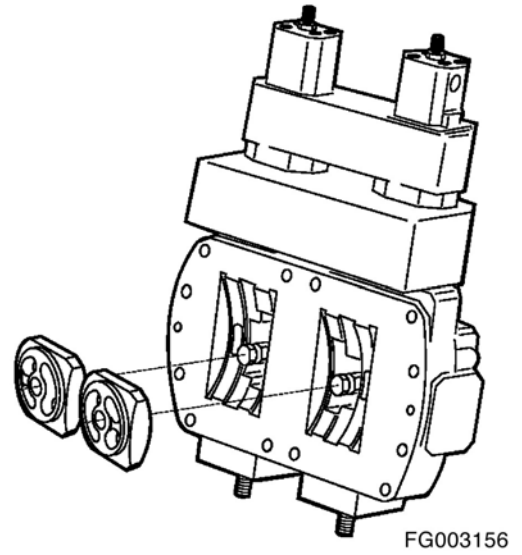


Figure 98

5. Fit seal* and controller.

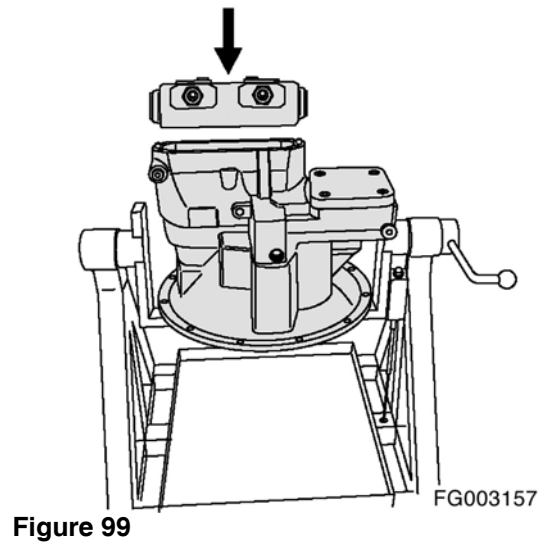


Figure 99

Intermediate Wheel

1. Press in bearing into housing.
2. Install and align the intermediate wheel through side drive opening.

 **CAUTION!**

Cool down the bolt with nitrogen and place it.

3. Press in bearing.

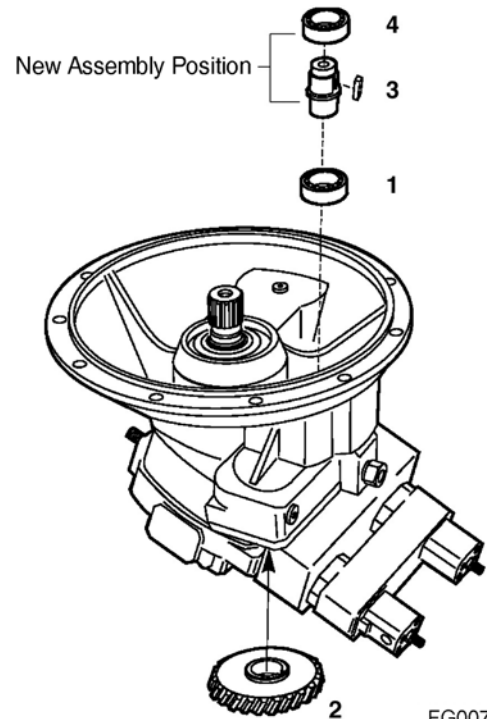


Figure 100

FG007438

4. Press in the bearing into the housing.

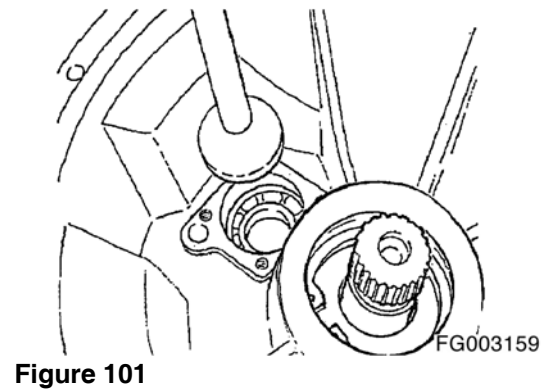
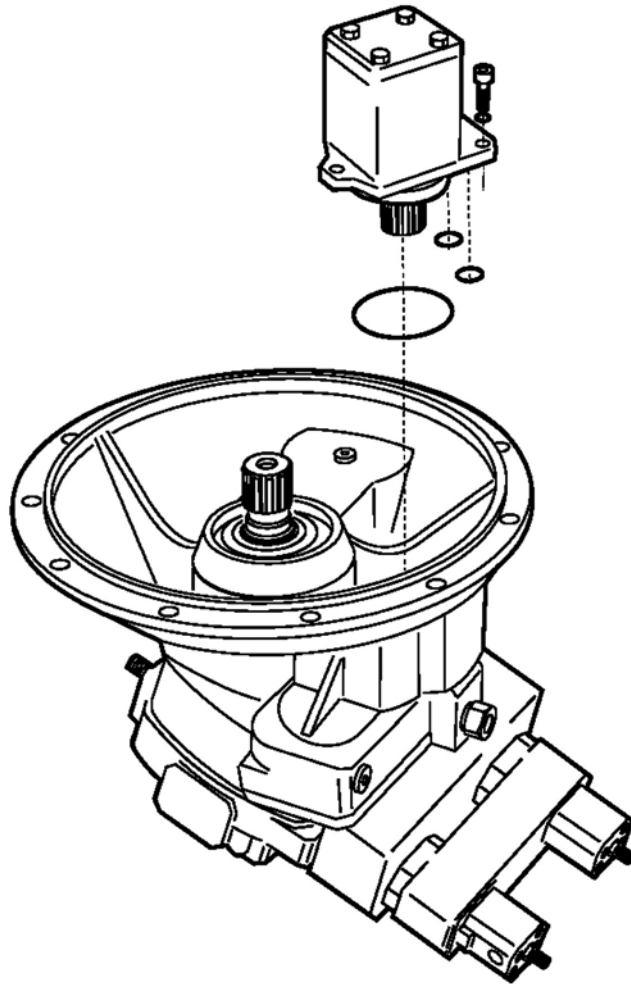


Figure 101

FG003159

Gear Pump

1. Assemble shaft seal, disc and safety ring.
Press-in with assemble sleeve.

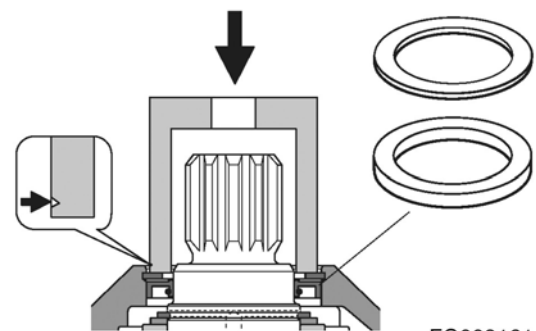


FG003160

Figure 102

 **CAUTION!**

Take care of press-in depth!



FG003161

Figure 103

Cover / Auxiliary Drive

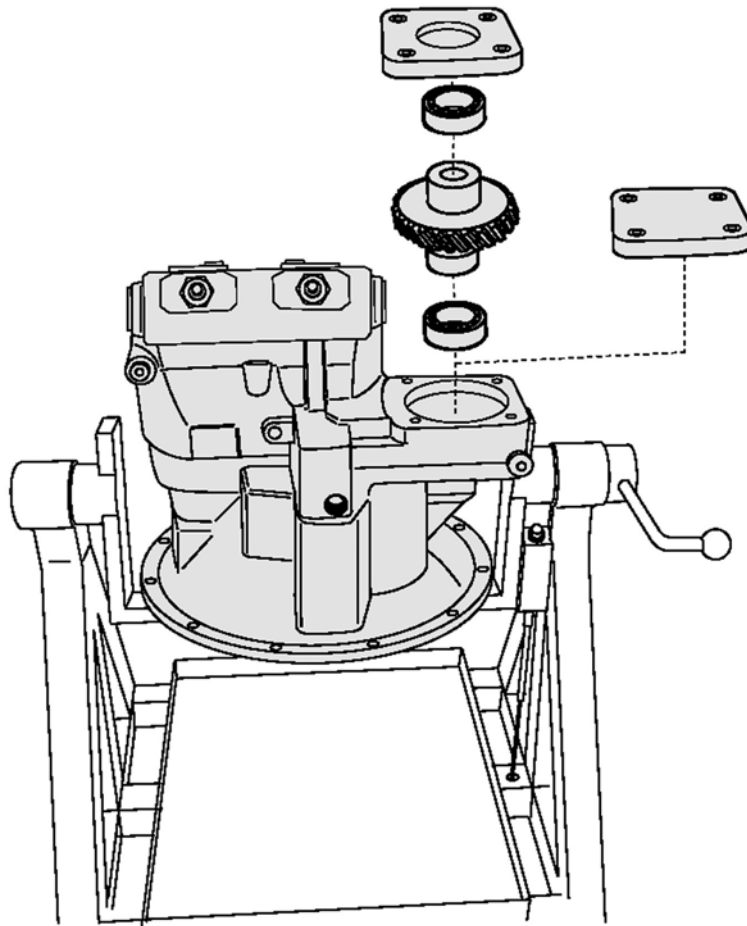


Figure 104

FG003162

ASSEMBLY GUIDELINES FOR TIGHTENING TORQUES

Bolts (to N 08.001)

The values stated are valid for bolts with metric ISO threads to DIN 13 part 13, as well as head areas to DIN 912 socket head cap screws, DIN 931 hexagon bolt or DIN 933 hexagon bolts with threads up to the head.

Thread	Tensile Strength Class		
	8.8	10.9	12.9
	Tightening Torque M_A in N•m		
M8 x 1	5	G 1/8 A	10
M10 x 1	10	G 1/4 A	30
M12 x 1.5	20	G 3/8 A	35
M14 x 1.5	30	G 1/2 A	60
M16 x 1.5	35	G 3/4 A	90
M18 x 1.5	40	G 1 A	140
M20 x 1.5	50	G 1 1/4 A	240
M22 x 1.5	60	G 1 1/2 A	300
M26 x 1.5	70		
M27 x 2	90		
M30 x 1.5	100		
M33 x 2	140		
M42 x 2	240		

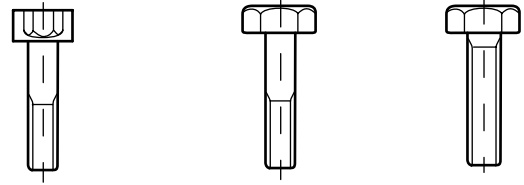


Figure 105

FG003163

Plugs with Internal Hexagon and Profile Seal Ring (to N 02.009)

Thread	Tightening Torque M_A in N•m
M8 x 1	5
M10 x 1	10
M12 x 1.5	20
M14 x 1.5	30
M16 x 1.5	35
M18 x 1.5	40
M20 x 1.5	50
M22 x 1.5	60
M26 x 1.5	70
M27 x 2	90
M30 x 1.5	100
M33 x 2	140
M42 x 2	240
M48 x 2	300
G 1/8 A	10
G 1/4 A	30
G 3/8 A	35
G 1/2 A	60
G 3/4 A	90
G 1 A	140
G 1 1/4 A	240
G 1 1/2 A	300

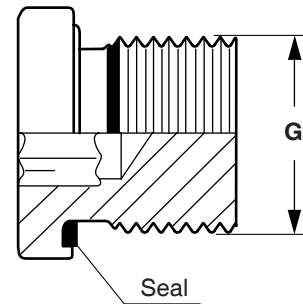


Figure 106

FG007439

Seal-Lock - Sealing Nuts (to N 02.100)

Thread	Tightening Torque M_A in N•m
M6	10
M6 x 0.5	11
M8	22
M8 x 1	24
M10	40
M10 x 1	44
M12	69
M12 x 1.5	72
M14	110
M14 x 2	120
M16	170
M16 x 1.5	180

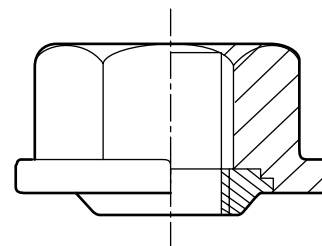


Figure 107

FG003165

Gear Pump

Edition 1

MEMO

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