

4. Assemble anti-inversion valve set. Assemble anti-inversion valve set (34) and plug assembly (35) into rear cover (23) and tighten them with L wrench.

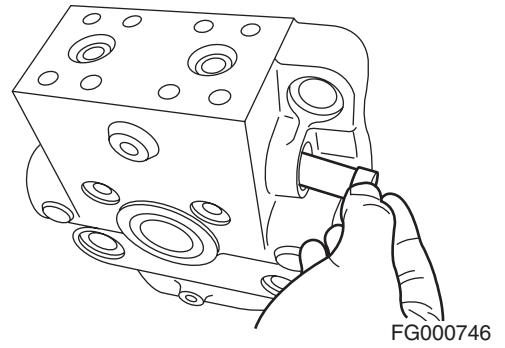


Figure 68

5. Assemble two relief valve assemblies (30) into rear cover (23) with torque wrench. (Left and right symmetrically.)

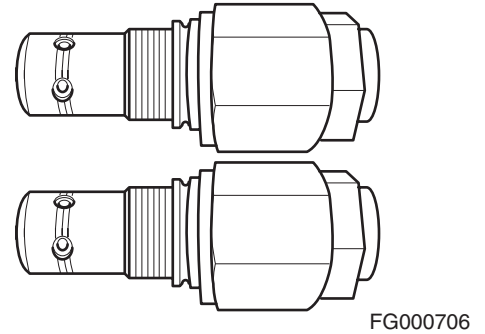


Figure 69



Figure 70

6. Coat valve plate (20) with grease and attach it to rear cover (23).

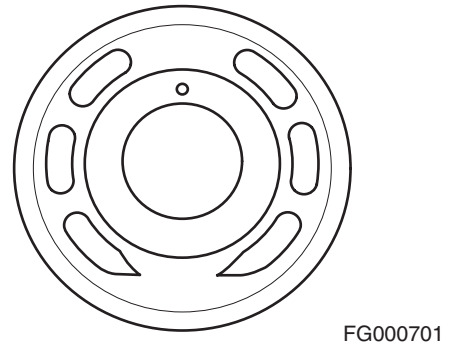


Figure 71



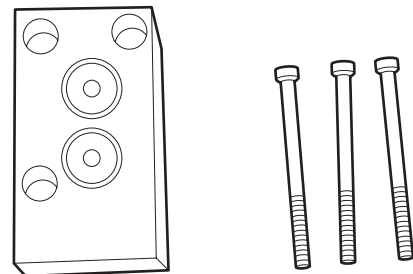
Figure 72

- Put the rear cover ass'y on the body (1) and tighten its wrench bolts (24, 25) with impact and then torch wrench.



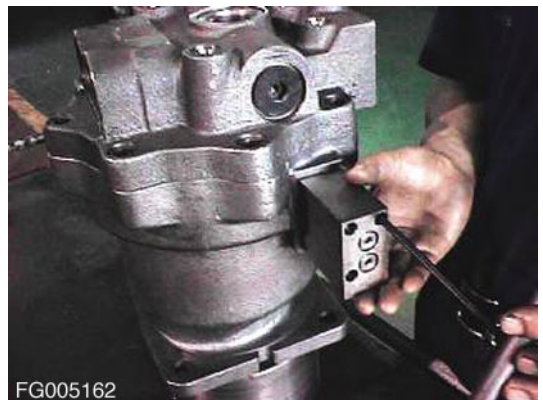
Figure 73

- Install time delay valve assembly onto rear cover (23) with wrench bolts (32).



FG000682

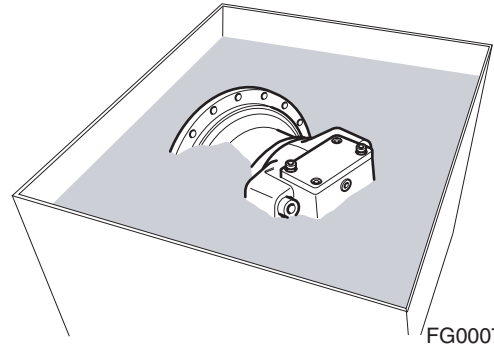
Figure 74



FG005162
Figure 75

Air Pressure Test

Apply air pressure into assembled motor, dip it in treated oil for one minute and check any leakage from it.

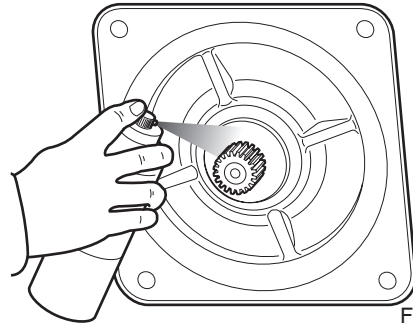


FG000754

Figure 76

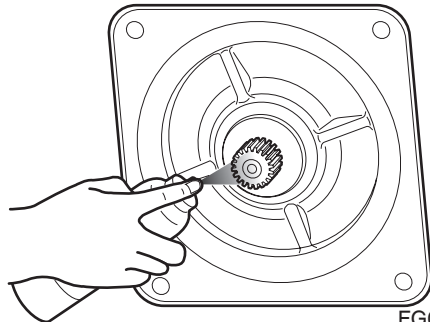
Oil Leakage Check

Wash motor with Color Check No.1, spray No.3, and check for any oil leakage.



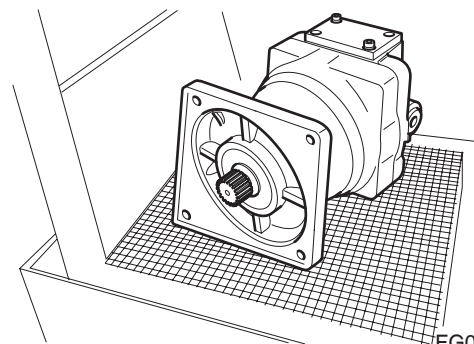
FG005165

Figure 77



FG005166

Figure 78



FG005169

Figure 79

Installation of test bench

Install the motor test bench to test each function.



Figure 80

Travel Motor

Edition 1