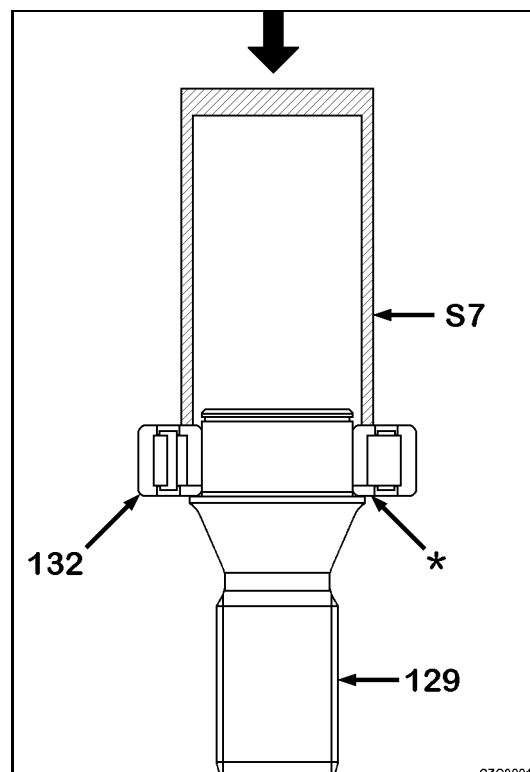



REAR PUMP

Shaft and Cradle

1. Apply [G2-LI] grease to shaft before pressing bearing in place.
 2. Assemble flange ring (*) to shaft (129), using tool **S7** to press bearing (132) in place.
- ★ When pressing the bearing, push the inner face of the bearing race with tool **S7**. Do not apply any force on the outer race of bearing.

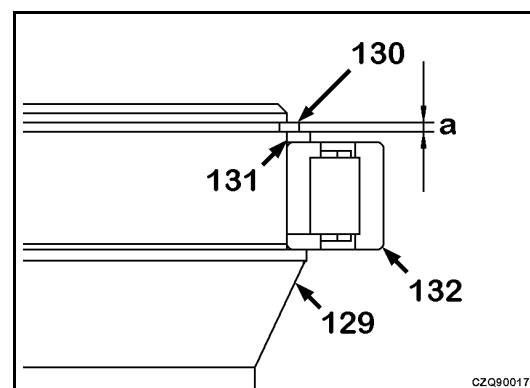


3. Assemble washer (131) as follows and install snap ring (130).
 - A. After pressing bearing (132) on to shaft (129), assemble washer (131) [removed during disassembly].
 - B. Measure clearance dimension "a" between end face of assembled washer (71) and snap ring groove.

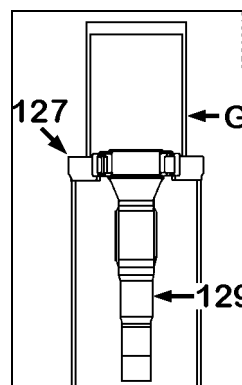
 Dimension of "a" 1.45 to 1.60 mm (0.0571 to 0.0629 in)

 - C. if clearance "a" is not within standard value, select a washer from the table below and assemble.


Part No.	708-17-12750	708-17-12760	708-17-12770
Thick	3.0 mm (0.118 in)	3.1 mm (0.122 in)	3.2 mm (0.125 in)



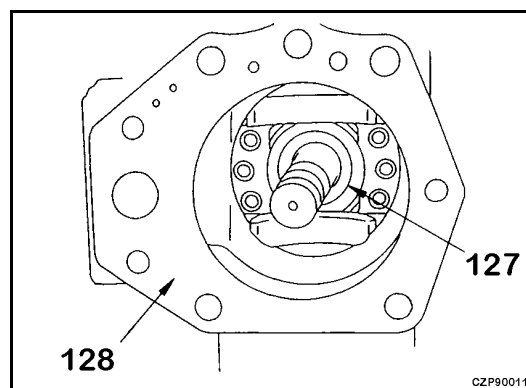
4. Apply [G2-LI] grease to shaft surface. Using tool **G**, press cradle (127) to shaft (129).
- ★ When pressing the bearing, push the end face of the bearing outer race with push tool **G**.
5. Install pump case (128) on tool **S3-4**.



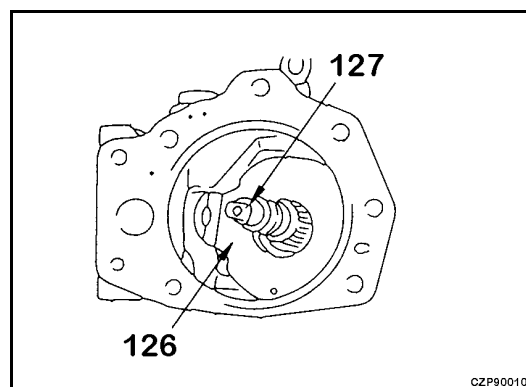
6. Install dowel pins and O-ring to bottom surface of inside pump case (128), then install shaft and cradle.

 Cradle mounting bolts torque: 112 Nm (83 lbf-ft)

- ★ Check to be sure assembly is square and pins do not fall out.
- ★ Be sure the O-ring does not get twisted or pinched in between housings during installation.

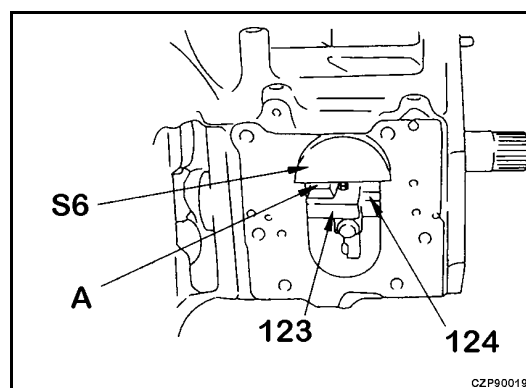


7. Assemble rocker cam (126) to shaft and cradle (127).




Servo Piston

1. Assemble spherical portion of rod (123) to rocker cam.
- ★ When assembling the rod, assemble with the spring seat surface facing in the direction of assembly.
2. Install piston (124), set-up tool S6 on opposite side from spacer A on front end of rod (123) and tighten piston (124).



- ★ Before tightening piston (124), adjust the position of the flats on the rocker cam in reference to the cradle. This is to prevent damage to the rocker cam and cradle when tightening the piston
- ★ Use several drops of Loctite 648 on thread section # of shaft.

 Piston torque: 512 Nm (378 lbf-ft)

