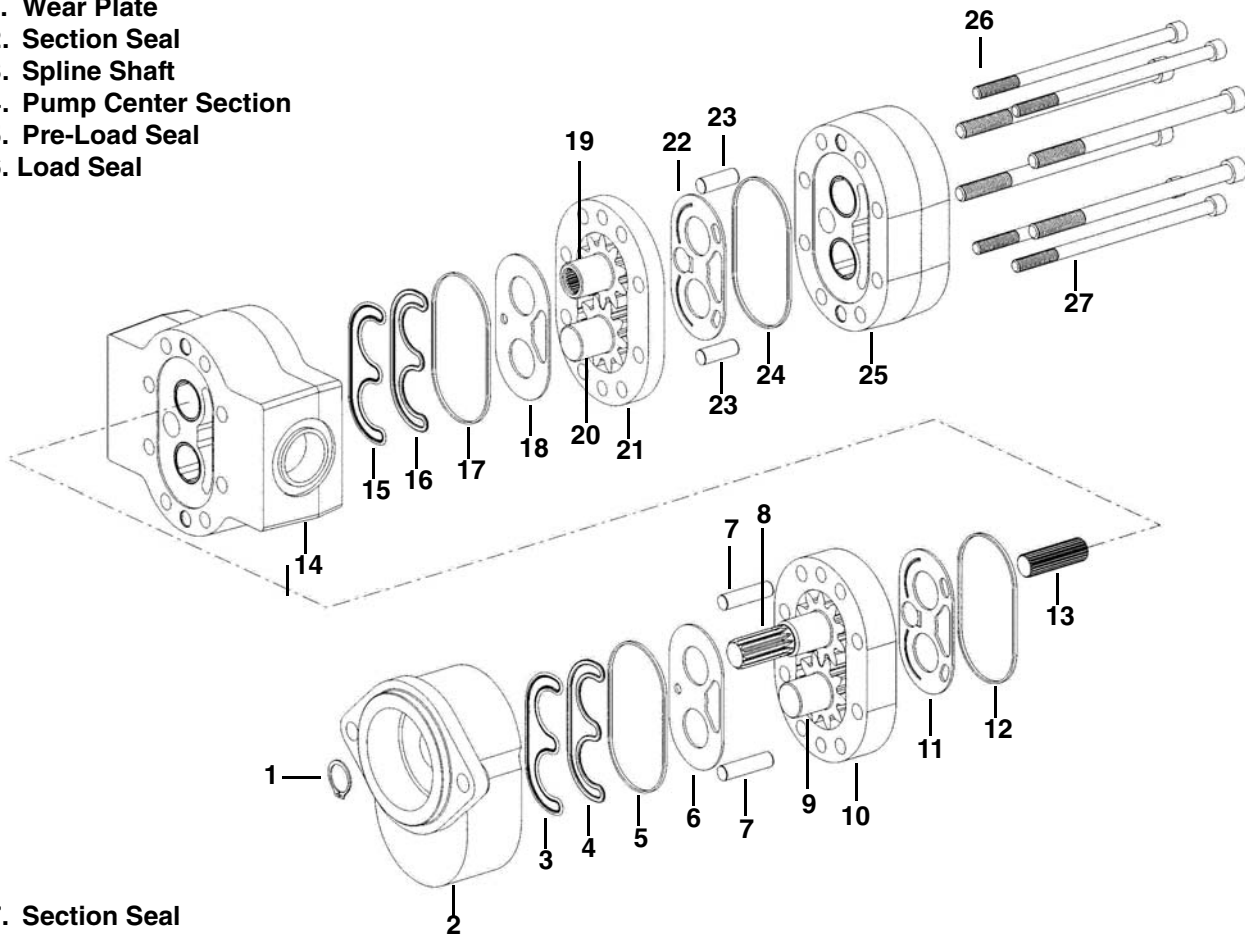


HYDRAULIC PUMP (CAST IRON HI-FLOW) (CONT'D)

Identification (518916428 & Above)

1. Retaining Ring
2. Pump End Section
3. Pre-Load Seal
4. Load Seal
5. Section Seal
6. Wear Plate
7. Pins
8. Drive Gear
9. Idler Gear
10. Pump Section
11. Wear Plate
12. Section Seal
13. Spline Shaft
14. Pump Center Section
15. Pre-Load Seal
16. Load Seal



17. Section Seal
18. Wear Plate
19. Drive Gear
20. Idler Gear
21. Pump Section
22. Wear Plate
23. Pins
24. Section Seal
25. Pump End Section
26. Bolts (4)
27. Bolts (4)

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HYDRAULIC PUMP (CAST IRON HI-FLOW) (CONT'D)

Disassembly And Assembly (518916428 & Above)

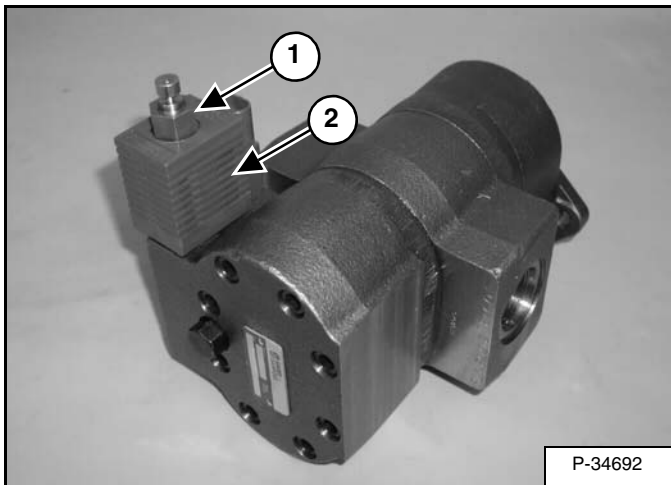
Mark the pump sections for correct assembly.

IMPORTANT

When repairing hydrostatic and hydraulic systems, clean the work area before disassembly and keep all parts clean. Always use caps and plugs on hoses, tubelines and ports to keep dirt out. Dirt can quickly damage the system.

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Figure 20-63-24

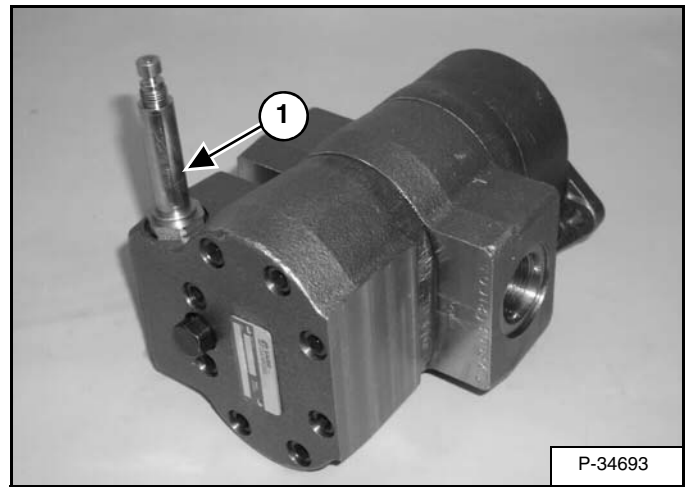


Remove the solenoid nut (Item 1) [Figure 20-63-24].

Remove the solenoid (Item 2) [Figure 20-63-24].

Installation: Tighten the solenoid nut to 48 - 72 in.-lb. (5 - 8 N•m)

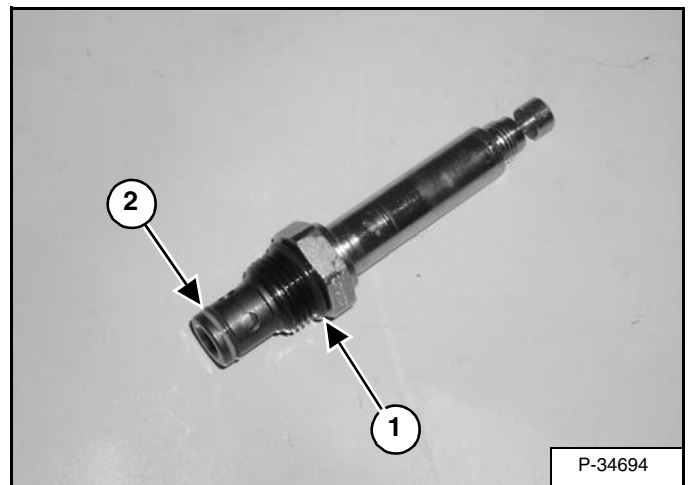
Figure 20-63-25



Remove the valve cartridge (Item 1) [Figure 20-63-25].

Installation: Tighten the solenoid valve to 35 - 40 ft.-lb. (47 - 54 N•m).

Figure 20-63-26



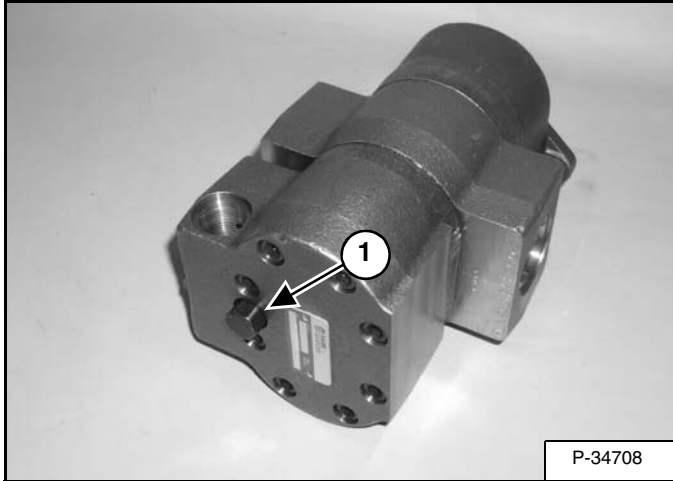
Inspect the o-ring (Item 1) [Figure 20-63-26] and replace as needed.

Inspect the o-ring and back-up ring (Item 2) [Figure 20-63-26] and replace as needed.

HYDRAULIC PUMP (CAST IRON HI-FLOW) (CONT'D)

Disassembly And Assembly (518916428 & Above) (Cont'd)

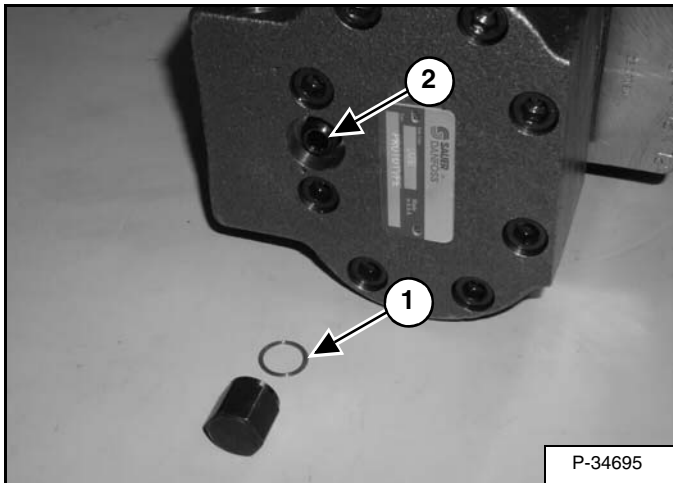
Figure 20-63-27



Remove the cap (Item 1) [Figure 20-63-27].

Installation: Tighten the cap to 13 - 16 ft.-lb. (18 - 22 N•m) after the relief valve has been set.

Figure 20-63-28

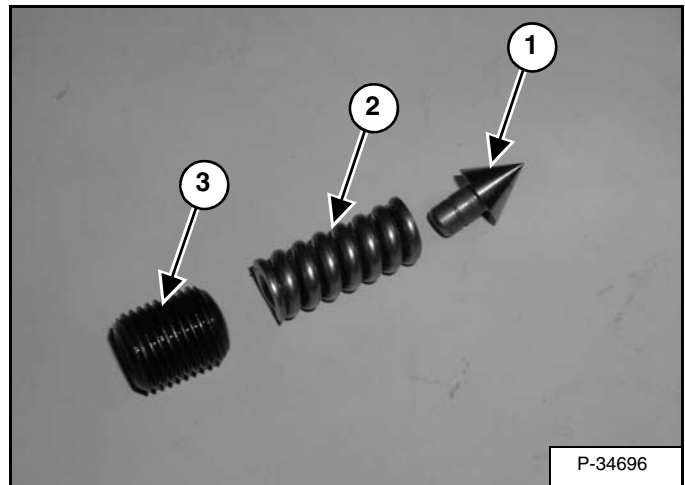


Remove the washer (Item 1) [Figure 20-63-28].

Remove the set screw, spring and relief valve (Item 2) [Figure 20-63-28].

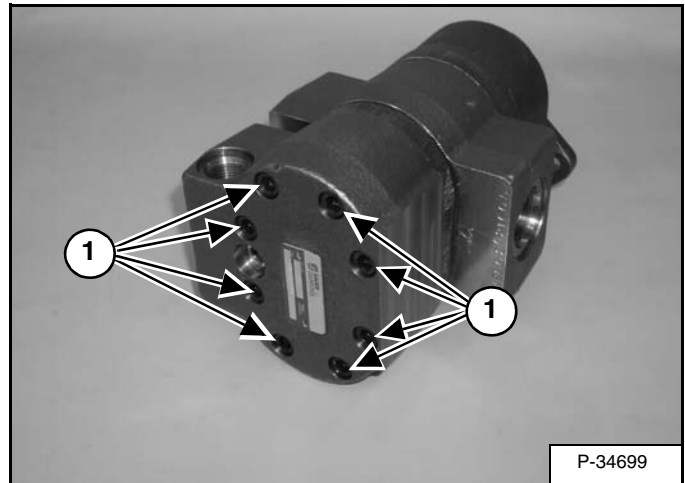
Installation: See High Flow Relief Adjustment Procedure (518916428 & Above) on Page 20-63-6.

Figure 20-63-29



Inspect the check valve (Item 1), spring (Item 2), and plug (Item 3) [Figure 20-63-29] for damage and replace as needed.

Figure 20-63-30



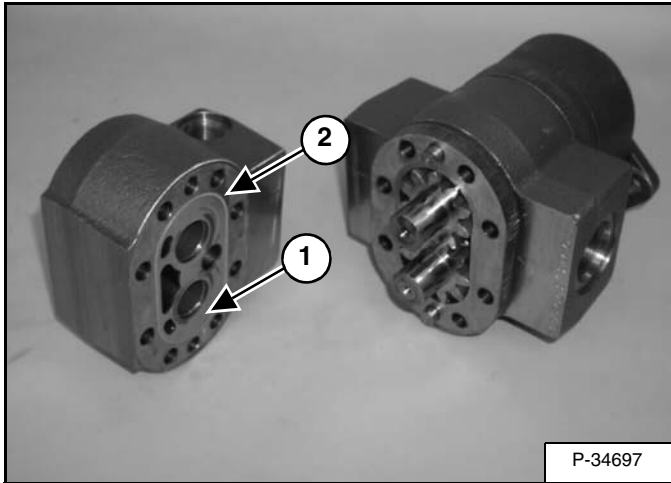
Remove the eight bolts (Item 1) [Figure 20-63-30].

Installation: Tighten the assembly bolts to 45 - 50 ft.-lb. (60 - 67 N•m).

HYDRAULIC PUMP (CAST IRON HI-FLOW) (CONT'D)

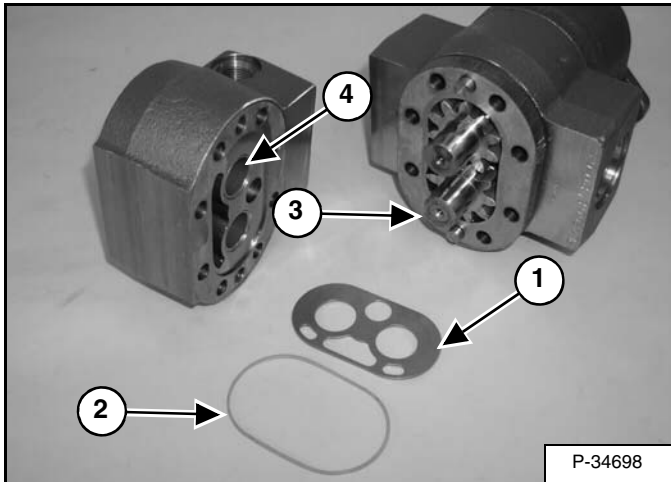
Disassembly And Assembly (518916428 & Above) (Cont'd)

Figure 20-63-31



Remove the wear plate (Item 1) and section seal (Item 2) [Figure 20-63-31] from the pump end section.

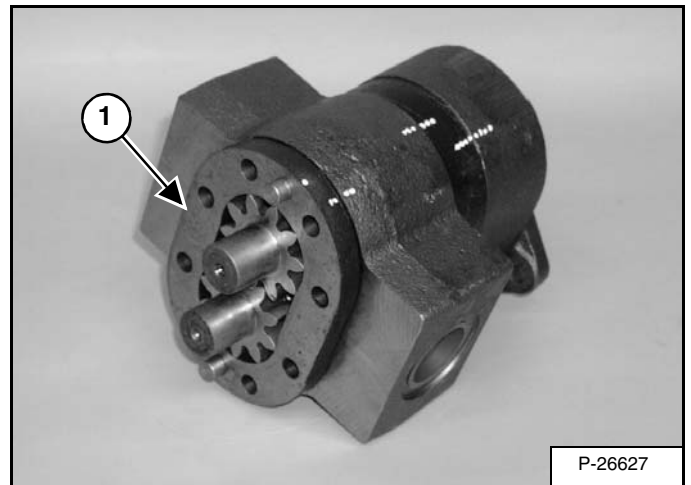
Figure 20-63-32



NOTE: Position wear plate (Item 1) [Figure 20-63-32] inlets and traps as shown with bronze side toward gears.

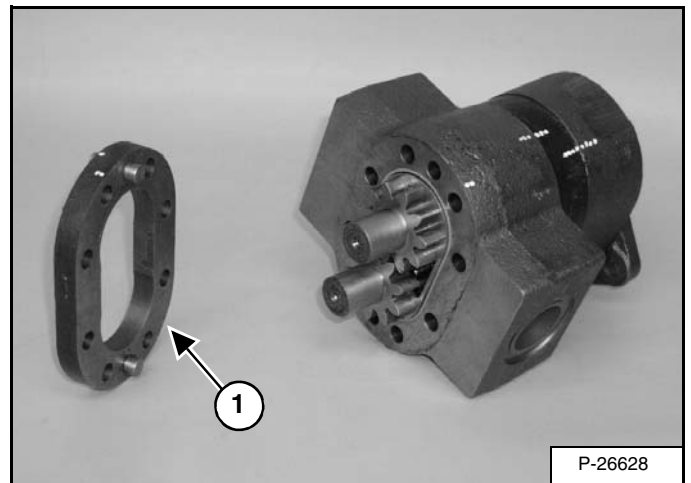
NOTE: Inspect the pump end section (Item 3) and bushings (Item 4) [Figure 20-63-32]. If excessive wear or damage is visible, the pump must be replaced.

Figure 20-63-33



Remove the pump center section (Item 1) [Figure 20-63-33] & [Figure 20-63-34] from the pump center section.

Figure 20-63-34



NOTE: Inspect the pump center section (Item 1) [Figure 20-63-34]. If excessive wear or damage is visible, the pump must be replaced.

HYDRAULIC PUMP (CAST IRON HI-FLOW) (CONT'D)

Disassembly And Assembly (518916428 & Above) (Cont'd)

Figure 20-63-35

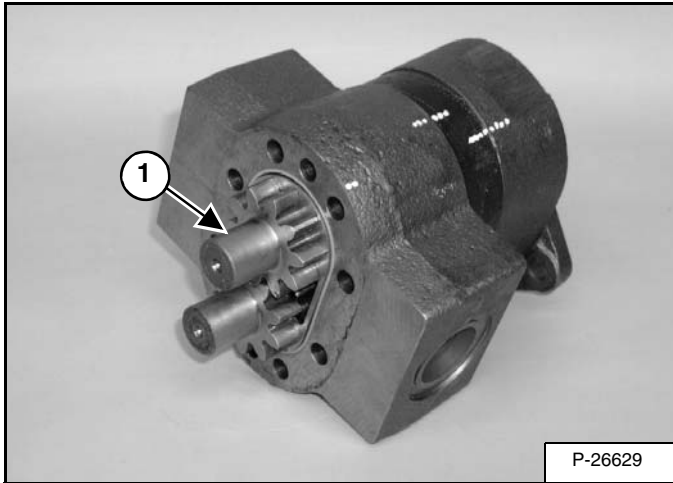
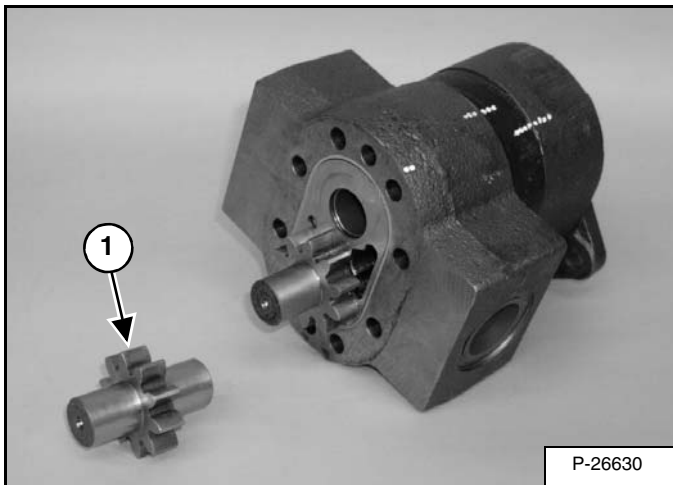


Figure 20-63-36



Remove the idler gear (Item 1) [Figure 20-63-35] & [Figure 20-63-36].

NOTE: Inspect the idler gear (Item 1) [Figure 20-63-36]. If excessive wear or damage is visible, the pump must be replaced.

Figure 20-63-37

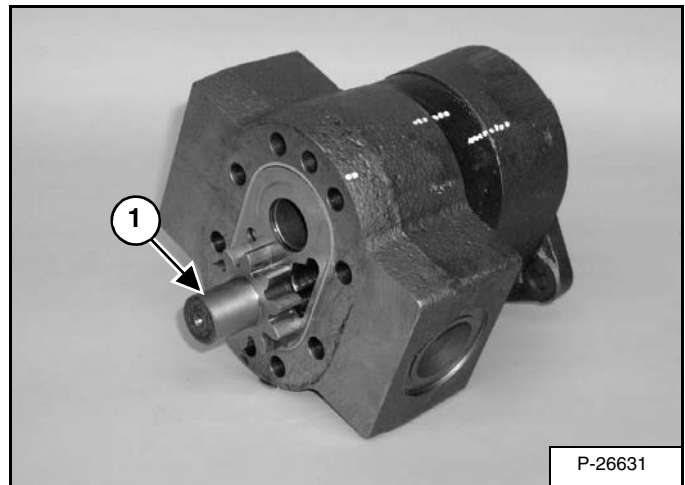
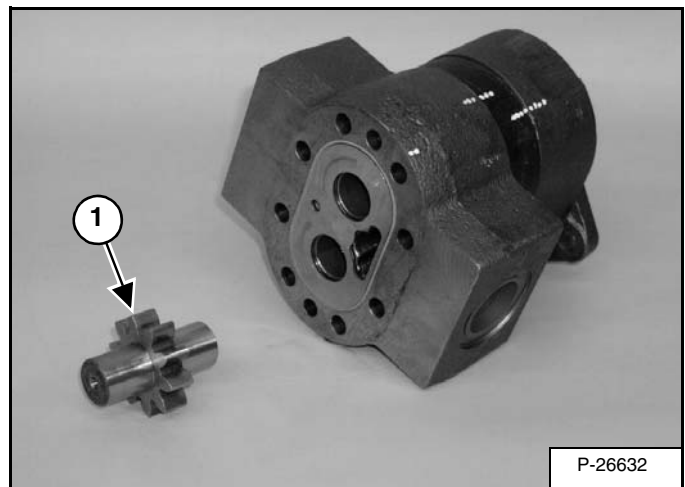


Figure 20-63-38



Remove the drive gear (Item 1) [Figure 20-63-37] & [Figure 20-63-38].

NOTE: Inspect the drive gear (Item 1) [Figure 20-63-38]. If excessive wear or damage is visible, the pump must be replaced.

HYDRAULIC PUMP (CAST IRON HI-FLOW) (CONT'D)

Disassembly And Assembly (518916428 & Above) (Cont'd)

Figure 20-63-39

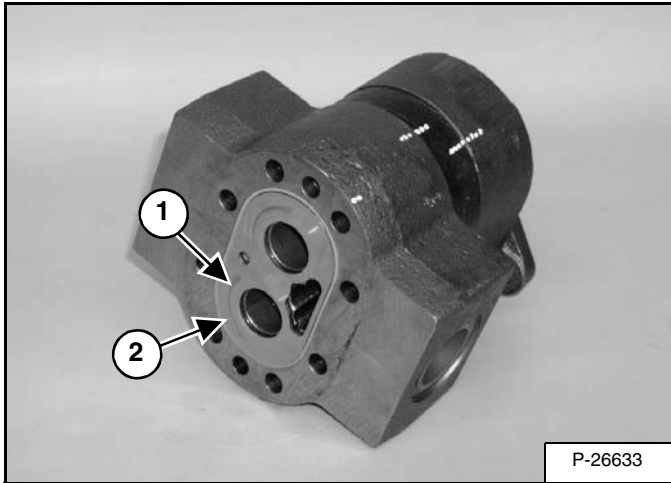
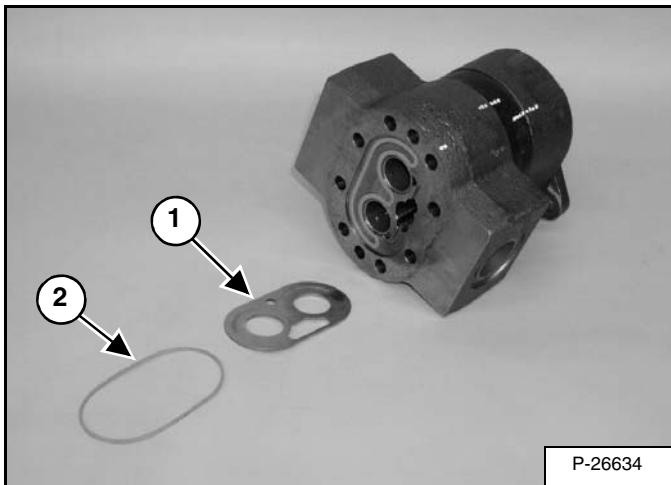


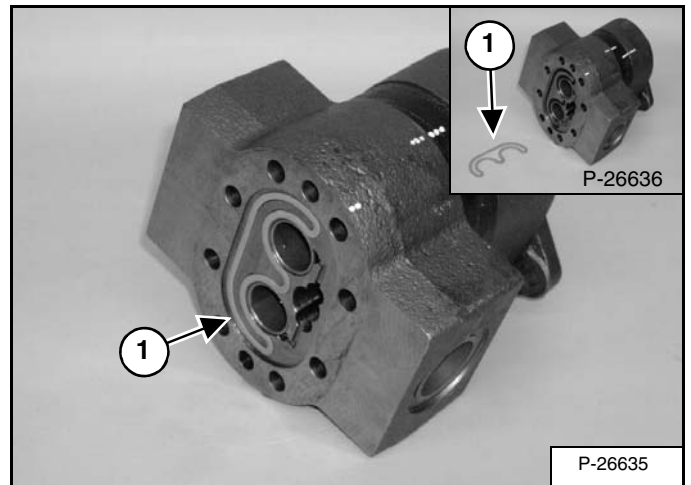
Figure 20-63-40



Remove the wear plate (Item 1) [Figure 20-63-39] & [Figure 20-63-40] and section seal (Item 2) [Figure 20-63-39] & [Figure 20-63-40] from the pump center section.

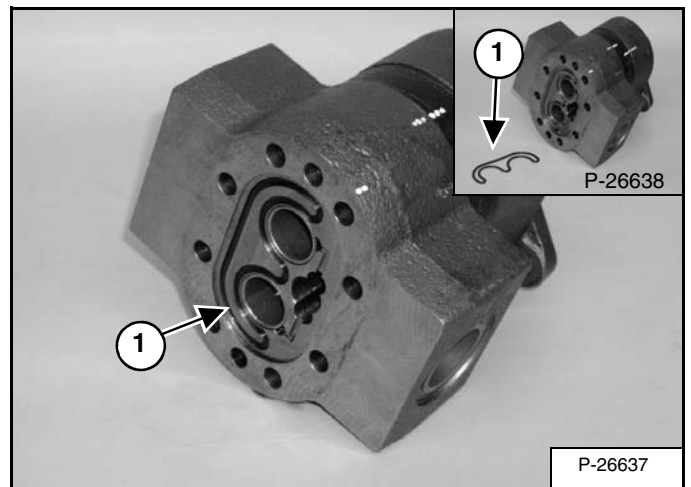
NOTE: Position wear plate (Item 1) [Figure 20-63-40] inlets and traps as shown with bronze side toward gears.

Figure 20-63-41



Remove the load seal (Item 1) [Figure 20-63-41].

Figure 20-63-42



Remove the pre-load seal (Item 1) [Figure 20-63-42].