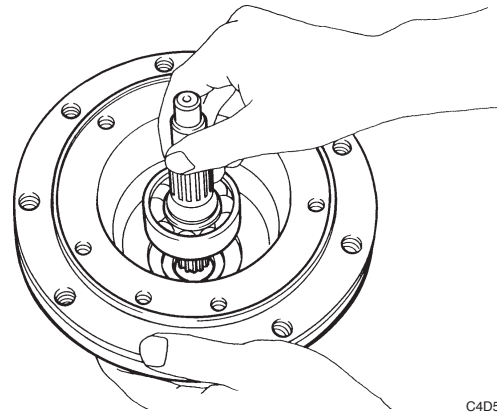
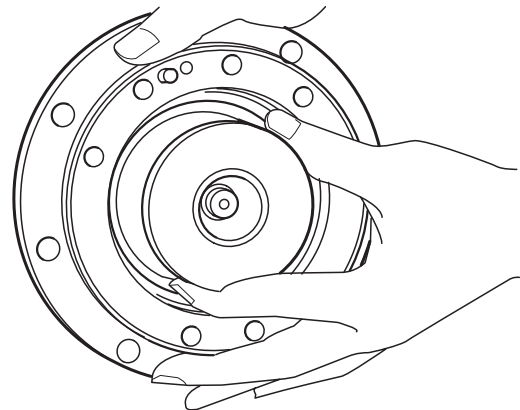


13. Mount the shaft on the flange holder.
- The bearing has been inserted and cannot be disassembled.
  - Be careful not to damage the oil seal by the shaft.



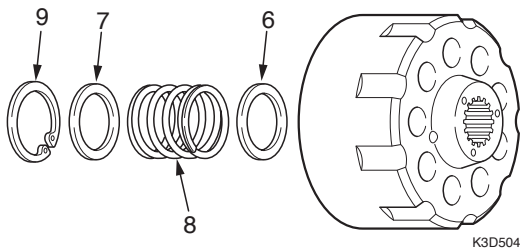
C4D567

14. Mount the balls and swash plate.
- Apply hydraulic oil to the sliding surfaces of the swash plate.

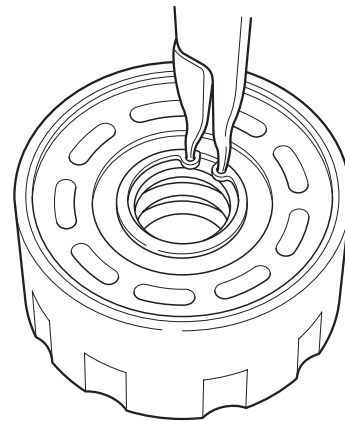


C4D568

15. Mount the retainer (6), spring (8) and retainer (7) on the cylinder block and fix them with the snap ring (9).



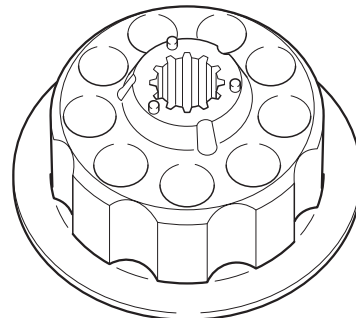
K3D504



K3D505

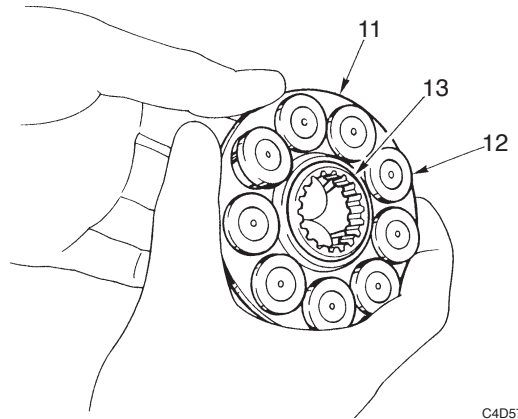
16. Fit the three pins to the cylinder block.

17. Install the friction disc.



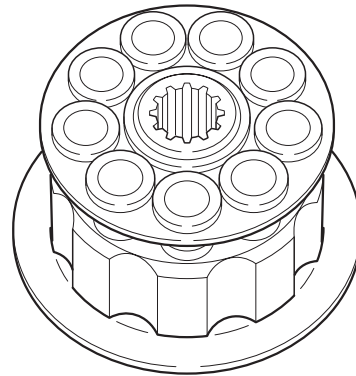
K3D506

18. Mount the piston (12) and guide (13) on to the shoe holder (11) to assemble the shoe holder assembly.



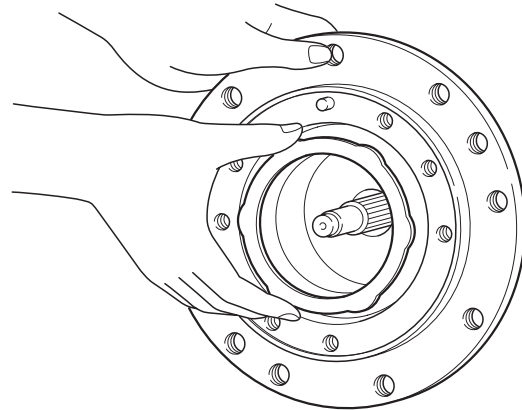
C4D572

19. Mount the shoe holder assembly on the cylinder block to assemble the cylinder block assembly.



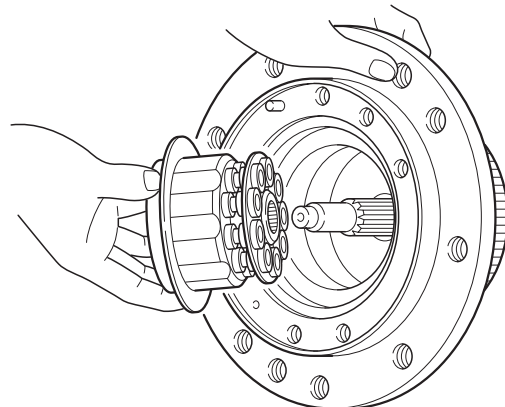
K3D507

20. Install the center disc in the groove of the flange holder.



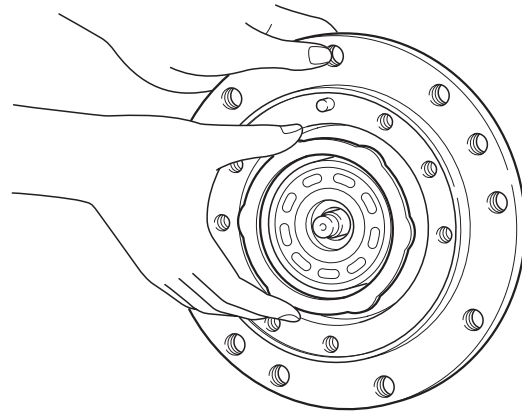
K3D508

21. Install the cylinder block assembly.
  - a. Install the shaft splinge in the guide.



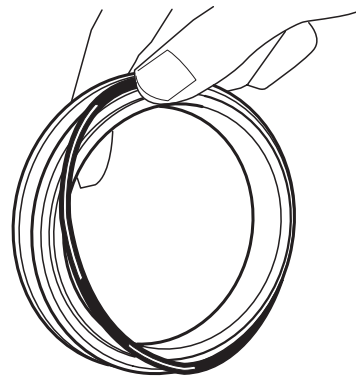
K3D509

22. Install the center disc in the groove of the flange holder.



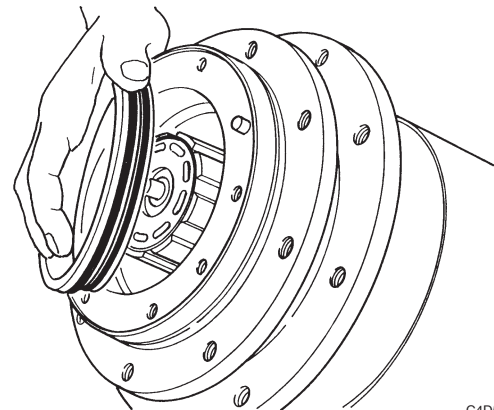
K3D510

23. Mount two O-rings and two backup rings on the brake piston.
- Be sure to position the backup rings on the outer side.



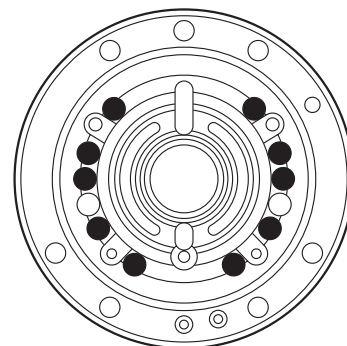
C4D577

24. Mount the brake piston assembly on the flange holder.
- Apply grease to the O-ring and be careful not to let it bite the seal.



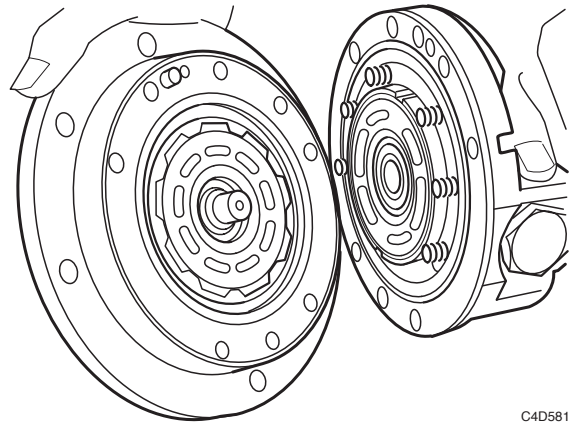
C4D578

25. Mount the valve plate on the flange holder and insert the springs into the spring holes.
- The dot in the figure shows the spring installation positions.
  - Assemble the valve plate in such a manner that the copper surface is on the cylinder block side.
  - Apply grease to the valve plate and springs, and be careful not to drop them.



K3D511

26. Supply 200 mL of hydraulic oil into the flange holder and mount the valve body on the flange holder.

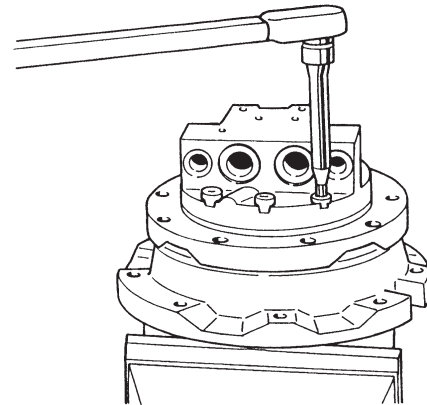


C4D581

27. Fix the flange holder with a vise and tighten it with the screws.

☞ Screw: 51~65 N·m

- Insert a protector such as an aluminum plate between the flange holder and the vise to prevent the outer surface of the body from being damaged.

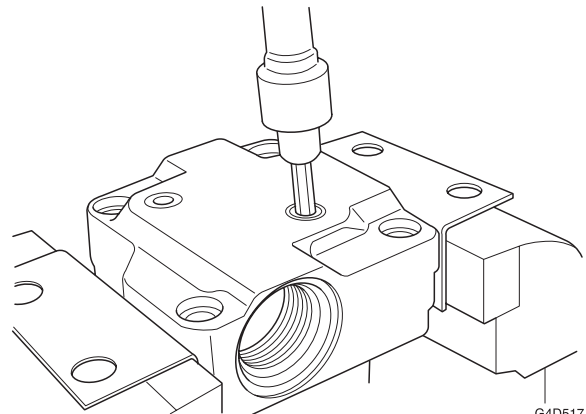


C4D582

28. Install the plug.

- Seal tape should be wound around the threads of the plug.

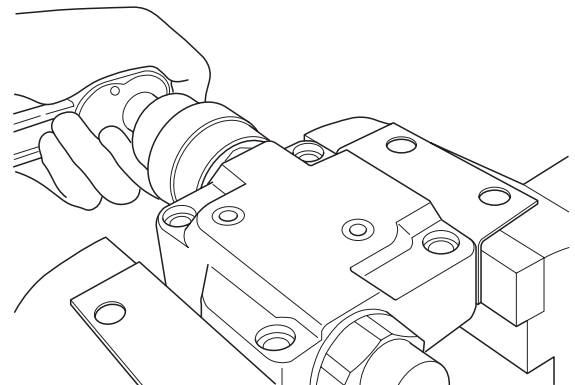
☞ Plug: 26~31 N·m



G4D517

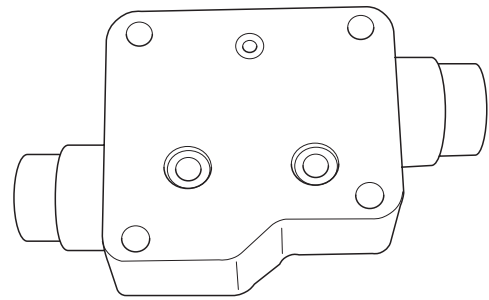
29. Mount the relief valve on the valve body.

☞ Relief valve: 196~245 N·m



G4D518

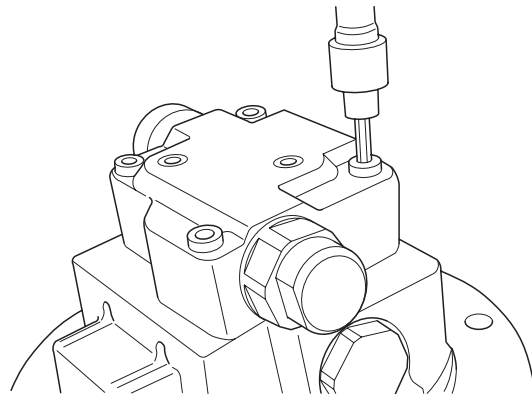
30. Mount the large and small O-ring on the body.



G4D519

31. Mount the relief valve on the motor and tighten them with the cap screws.

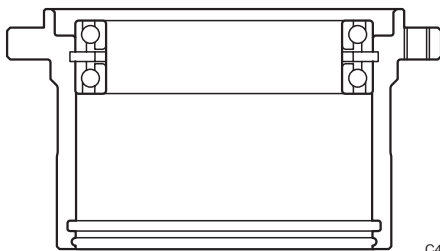
☞ Cap screw: 25~32 N·m



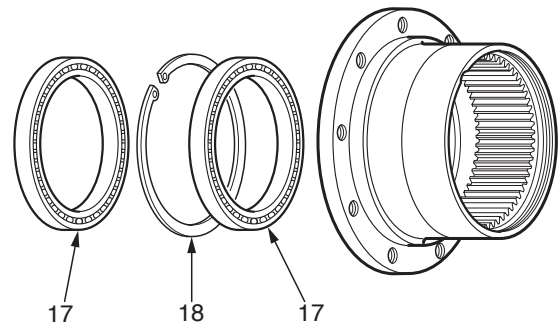
G4D520

Reduction Gears

1. Install the bearing (17), snap ring (18) and bearing (17) in the housing.
  - Be careful of the installation direction of the bearings.



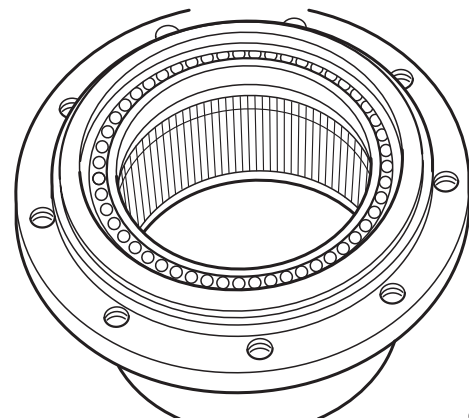
C4D584



C4D583

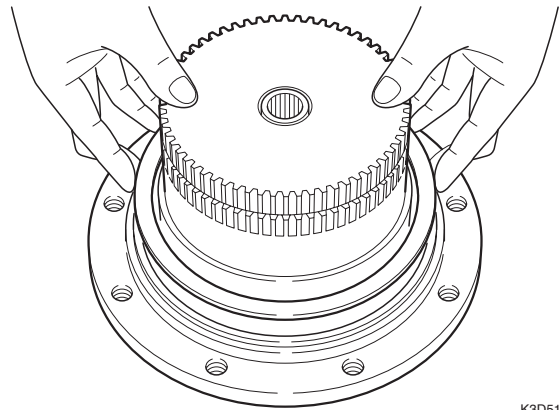
2. Fit the O-ring to the floating seal and install them in the housing.

- Apply grease to the O-ring.



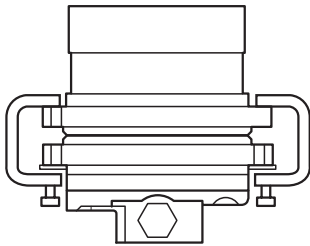
C4D585

3. Fit the O-ring to the floating seal and install them in the flange holder.
  - Apply grease to the O-ring.

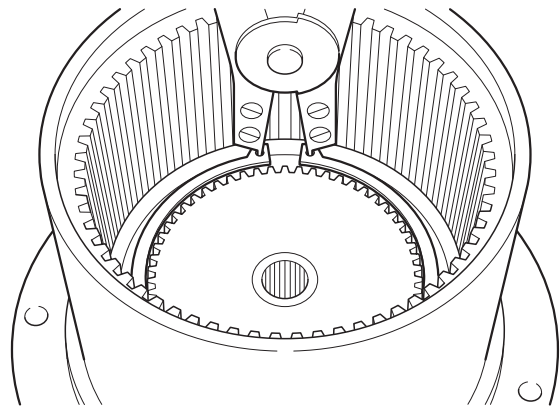


K3D512

4. Mount the housing on the flange holder and fix them with the snap ring.
  - Tighten the housing of the reduction gear and the flange of the hydraulic motor with a C-clamp or hydraulic press, and fix them with the snap ring.

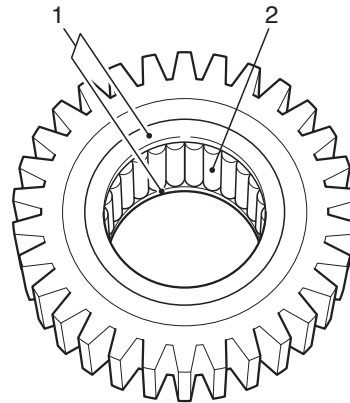


C4D588



K3D513

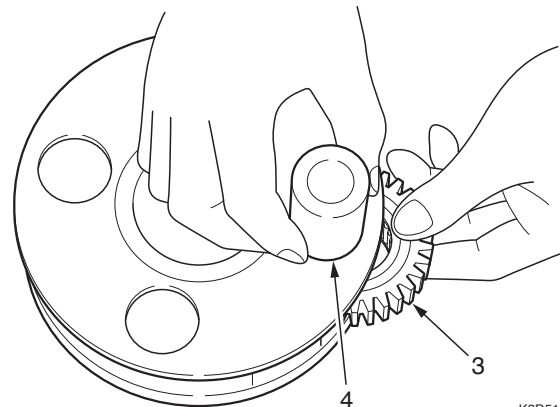
5. Press fit the ring (1) to the gear B.
6. Install the needles (2) in the gear B.
  - Apply grease to the needles to prevent from coming off.



K3D514

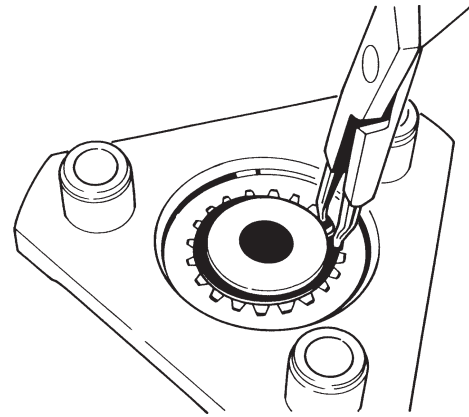
7. Press fit the ring (1) to the other end of the gear B.
8. Install the thrust washer, the gear B assembly (3), the thrust washer and the pin (4).

9. Press fit the spring pins to secure the pins (4).



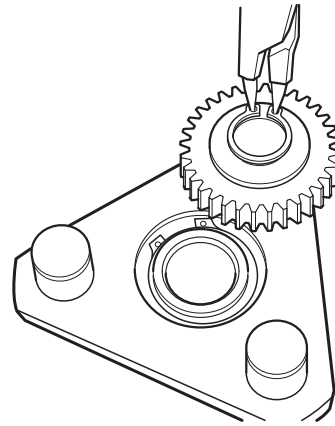
K3D515

- 10. Mount the gear S1 on the carrier and fix them with the snap ring.



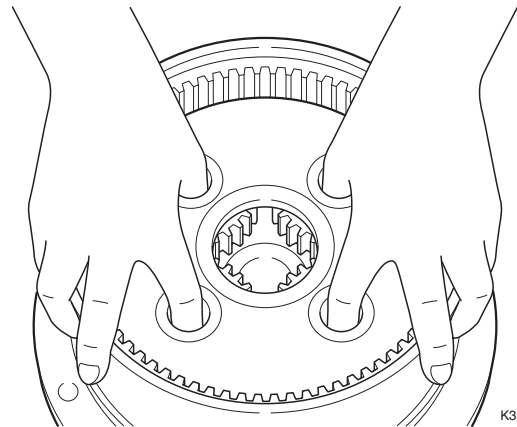
C4D590

- 11. Mount the thrust washer, gear B2, needle and thrust washer on the carrier 2 and fix them with the snap ring.



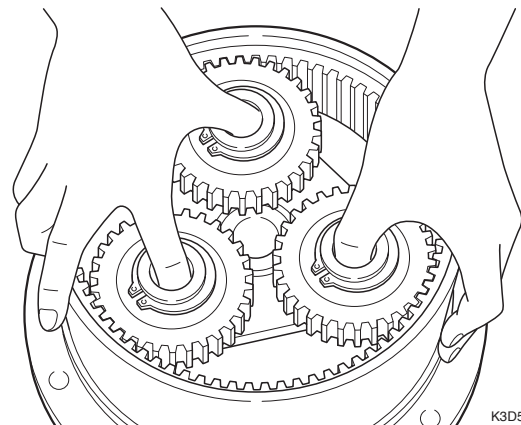
C4D591

- 12. Install the carrier 1 assembly in the housing.



K3D516

- 13. Install the thrust washer and the carrier 2 assembly in the housing.



K3D517