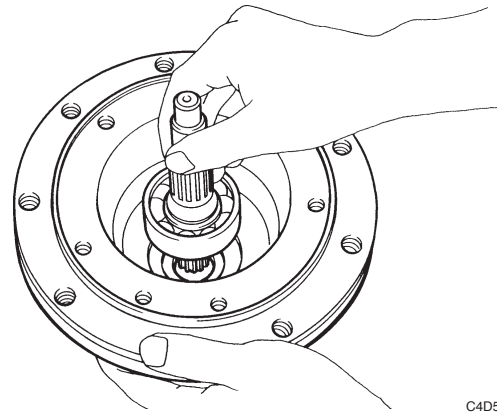
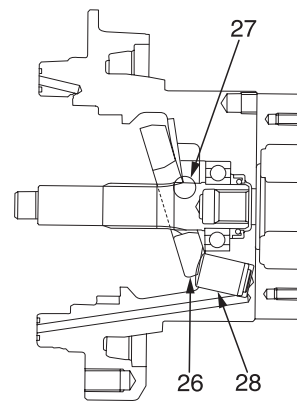


2. Mount the shaft on the flange holder.
 - The bearing has been inserted and cannot be disassembled.
 - Be careful not to damage the oil seal by the shaft.



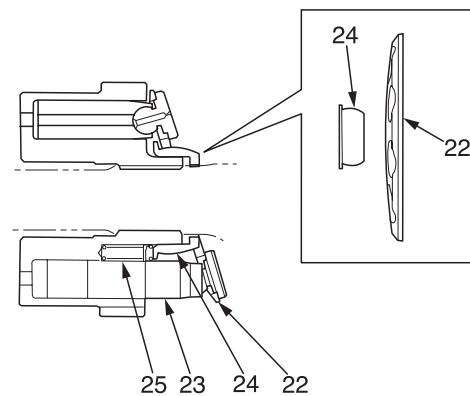
C4D567

3. Install the 2-speed piston (28).
4. Install the balls (27) and swash plate (26).
 - Apply hydraulic oil to the sliding surfaces of the swash plate.



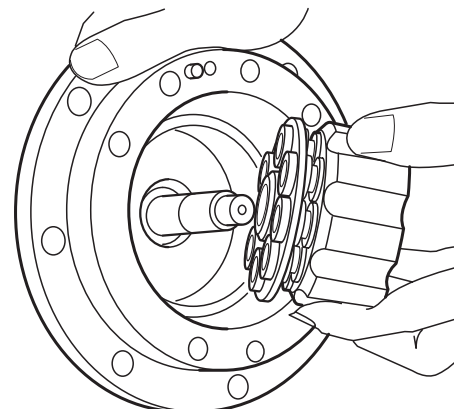
L3D524

5. Mount the springs (25) on the cylinder block assembly.
6. Mount the piston (23) and guide (24) on to the shoe holder (22) to assemble the shoe holder assembly.
7. Mount the shoe holder assembly on the cylinder block to assemble the cylinder block assembly.



L3D523

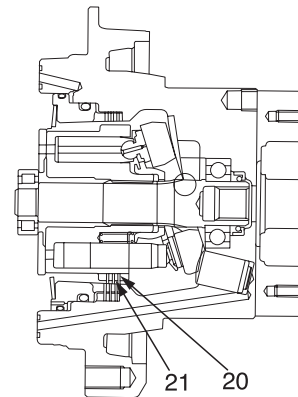
8. Mount the cylinder block assembly on the flange holder.
 - Mount the cylinder block assembly in such a manner that the shoe will touch the swash plate.



C4D575

9. Install the center discs (21) in the groove of the flange holder and then install the friction discs (20) in the groove of the cylinder block, alternately one by one.

- Total number of center discs: 3
- Total number of friction disc: 3

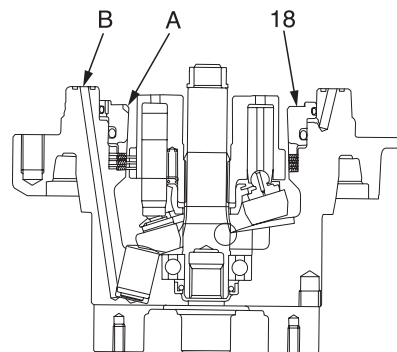


L3D538

10. Fit the O-rings on the brake piston (18).

11. Install the brake piston (18) on the flange holder.

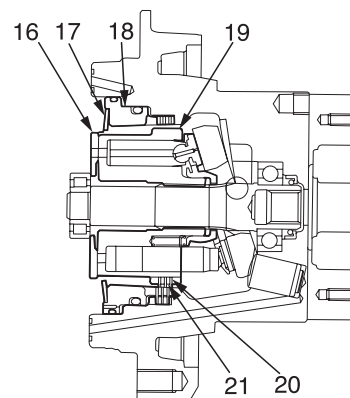
- Align the notch (A) of the brake piston with the pilot passage (B).
- Push the brake piston by hand force evenly on the piston.



L3D539

12. Install the disc spring (17) in the housing.

- Install the disk spring so that its perimeter contacts the brake piston.



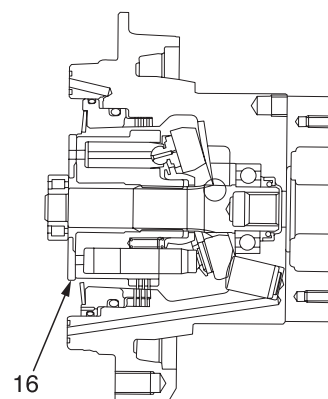
L3D522

13. Mount the O-rings on the flange holder.

14. Supply 0.5 L of hydraulic oil into the flange holder and mount the valve body on the flange holder.

15. Mount the valve plate (16).

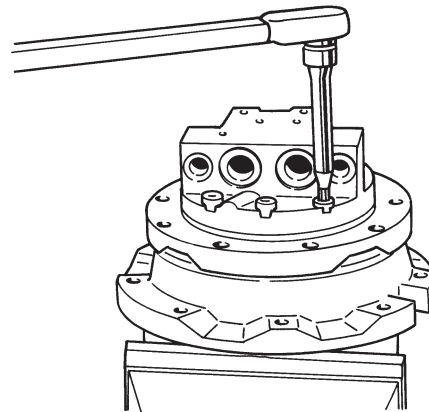
- Face the brass thrust surface of the valve plate toward you and apply grease on its back to prevent the valve plate from dropping off.
- Align the pin of the brake valve with the valve plate and install them.



L3D540

16. Set the valve body, then tighten the cap screw.

☞ Cap screw: 140 N·m



Y6-D523

17. Attach the end of the spool (15) to the spindle (14) and install them on the body.

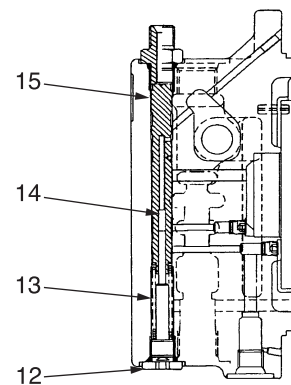
- Insert the spool from the adapter side.

18. Fit the O-ring, spring (13) to the adapter and tighten the adapter to the body.

☞ Adapter: 30 N·m

19. Fit the O-ring to the plug (12) and tighten the plug to the body.

☞ Plug: 35 N·m

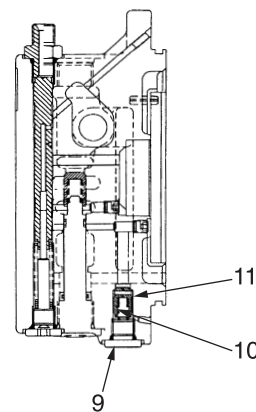


L3D521

20. Install the poppet (11) and spring (10).

21. Fit the O-ring to the plug (9) and tighten the plug to the body.

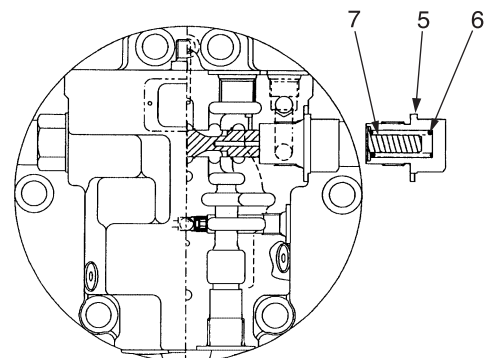
☞ Plug: 270 N·m



L3D520

22. Install the spool assembly in the valve body.

23. Fit the O-ring, spring (6) and stopper (7) on the plug (5).



L3D541