

Loader Pump - Standard Machines

Dismantling and Assembly

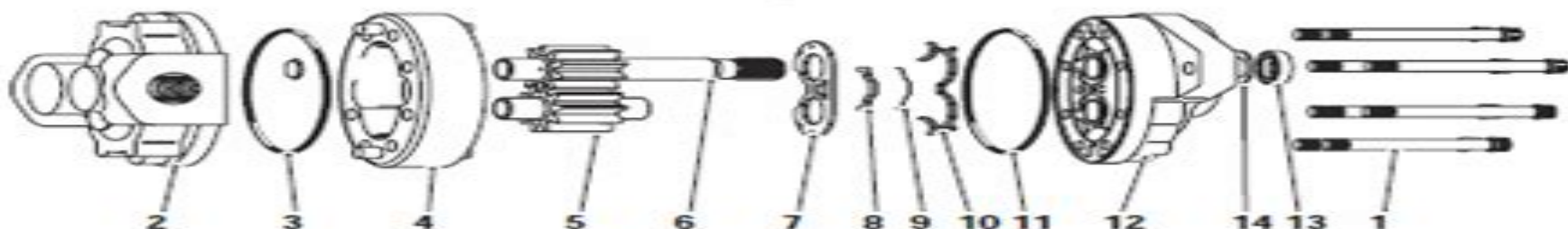


Fig 67.

The numerical sequence shown on the illustration is intended as a guide to dismantling **Fig 87, (1, E-76)**.

For assembly the sequence should be reversed.

Dismantling

Clamp pump in a vice with shaft end upwards.

Mark all parts to ensure correct alignment when assembling. Discard all seals and sealing rings.

Clean all parts in light kerosene, examine for damage and wear.

Inspection

As the only parts available are those contained in the seal kit, a new pump must be fitted if any of the following parts are excessively worn.

Gears and Shafts

Check shafts at seal and bush areas for roughness or excessive wear.

Check gear faces for scoring and excessive wear. If edges of gear teeth are sharp, dress with emery cloth.

Renew the pump if the shaft diameter in the bush area is less than 22.17 mm (0.873 in) or if the gear width is less than 19.63 mm (0.773 in).

Check that snap rings are in grooves on either side of drive and idler gears.

Check for twisted or broken shaft splines.

Housing and Covers

Check gear pockets in housing 4 for excessive scoring or wear. Renew the pump if the internal diameter of gear pockets is more than 53.54 mm (2.108 in).

Renew the pump if the bore diameter of the bushes in covers 2 or 12 is more than 22.33 mm (0.879 in).

Check for scoring on the cover faces. Renew the pump if the face wear is more than 0.038 mm (0.0015 in).

Check that bushes in cover 12 are flush with the cover face. Oil grooves in bushes of covers 2 and 12 should be in line with dowel pin holes and 180 degrees apart, so as to position the oil grooves close to the respective dowel pin holes.

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Zhe Xu



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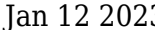
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