JLG®

An Oshkosh Corporation Company

Service and Maintenance Manual

Models
800S
810SJ
860SJ

Prior to SN 0300182743 &
B300001328

P/N - 3121139

August 11, 2017

ANSI

CE

AS/NZS

PARTS FINDER

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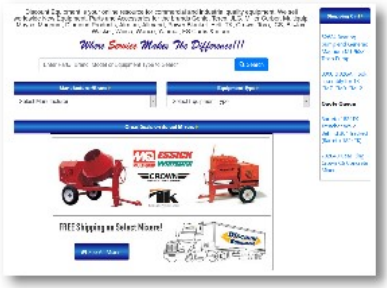

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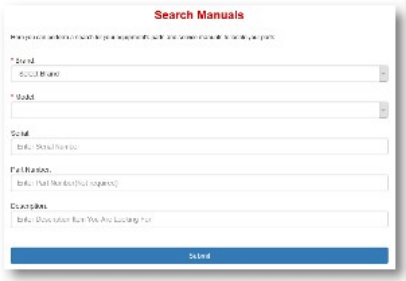

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SECTION A. INTRODUCTION - MAINTENANCE SAFETY PRECAUTIONS

A GENERAL

This section contains the general safety precautions which must be observed during maintenance of the aerial platform. It is of utmost importance that maintenance personnel pay strict attention to these warnings and precautions to avoid possible injury to themselves or others, or damage to the equipment. A maintenance program must be followed to ensure that the machine is safe to operate.

⚠ WARNING

MODIFICATION OR ALTERATION OF AN AERIAL WORK PLATFORM SHALL BE MADE ONLY WITH WRITTEN PERMISSION FROM THE MANUFACTURER.

The specific precautions to be observed during maintenance are inserted at the appropriate point in the manual. These precautions are, for the most part, those that apply when servicing hydraulic and larger machine component parts.

Your safety, and that of others, is the first consideration when engaging in the maintenance of equipment. Always be conscious of weight. Never attempt to move heavy parts without the aid of a mechanical device. Do not allow heavy objects to rest in an unstable position. When raising a portion of the equipment, ensure that adequate support is provided.

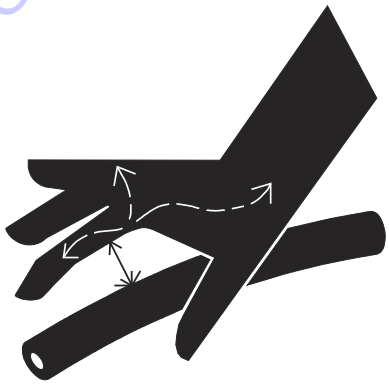
⚠ WARNING

SINCE THE MACHINE MANUFACTURER HAS NO DIRECT CONTROL OVER THE FIELD INSPECTION AND MAINTENANCE, SAFETY IN THIS AREA IS THE RESPONSIBILITY OF THE OWNER/OPERATOR.

B HYDRAULIC SYSTEM SAFETY

It should be noted that the machines hydraulic systems operate at extremely high potentially dangerous pressures. Every effort should be made to relieve any system pressure prior to disconnecting or removing any portion of the system.

Do not use your hand to check for leaks. Use a piece of cardboard or paper to search for leaks. Wear gloves to help protect hands from spraying fluid.



C MAINTENANCE

⚠ WARNING

FAILURE TO COMPLY WITH SAFETY PRECAUTIONS LISTED IN THIS SECTION COULD RESULT IN MACHINE DAMAGE, PERSONNEL INJURY OR DEATH AND IS A SAFETY VIOLATION.

- ENSURE REPLACEMENT PARTS OR COMPONENTS ARE IDENTICAL OR EQUIVALENT TO ORIGINAL PARTS OR COMPONENTS.
- NO SMOKING IS MANDATORY. NEVER REFUEL DURING ELECTRICAL STORMS. ENSURE THAT FUEL CAP IS CLOSED AND SECURE AT ALL OTHER TIMES.
- REMOVE ALL RINGS, WATCHES AND JEWELRY WHEN PERFORMING ANY MAINTENANCE.
- DO NOT WEAR LONG HAIR UNRESTRAINED, OR LOOSE-FITTING CLOTHING AND NECKTIES WHICH ARE APT TO BECOME CAUGHT ON OR ENTANGLED IN EQUIPMENT.
- OBSERVE AND OBEY ALL WARNINGS AND CAUTIONS ON MACHINE AND IN SERVICE MANUAL.
- KEEP OIL, GREASE, WATER, ETC. WIPED FROM STANDING SURFACES AND HAND HOLDS.
- USE CAUTION WHEN CHECKING A HOT, PRESSURIZED COOLANT SYSTEM.
- NEVER WORK UNDER AN ELEVATED BOOM UNTIL BOOM HAS BEEN SAFELY RESTRAINED FROM ANY MOVEMENT BY BLOCKING OR OVERHEAD SLING, OR BOOM SAFETY PROP HAS BEEN ENGAGED.
- BEFORE MAKING ADJUSTMENTS, LUBRICATING OR PERFORMING ANY OTHER MAINTENANCE, SHUT OFF ALL POWER CONTROLS.
- BATTERY SHOULD ALWAYS BE DISCONNECTED DURING REPLACEMENT OF ELECTRICAL COMPONENTS.
- KEEP ALL SUPPORT EQUIPMENT AND ATTACHMENTS STOWED IN THEIR PROPER PLACE.
- USE ONLY APPROVED, NONFLAMMABLE CLEANING SOLVENTS.

REVISON LOG

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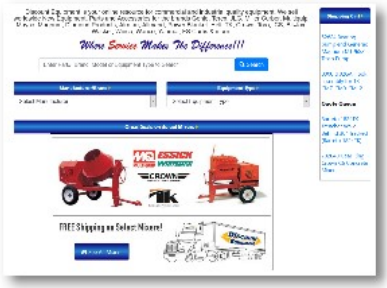

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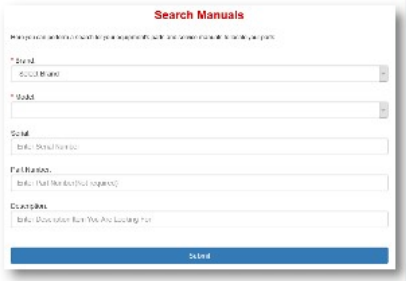

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SECTION 1. SPECIFICATIONS

1.1 OPERATING SPECIFICATIONS

Table 1-1. Operating Specifications - Prior to S/N 0300143294

Maximum Work Load (Capacity)	
Unrestricted:	500 lbs. (230 kg)
Restricted	Refer to Capacity Decals on machine for restricted platform capacities
Maximum Capacity - Dual Rating	
800S	1000 lbs. (450 kg)
860SJ	750 lbs. (340 kg)
Maximum Travel Grade (Gradeability)*	
2WD	30%
4WD	45%
Maximum Travel Grade (Side Slope)*	5°
Maximum Vertical Platform Height:	
800S	80 ft. (24.3 m)
860SJ	86 ft. (26.2 m)
Maximum Horizontal Platform Reach	
800S	71 ft. (21.6 m)
860SJ	75 ft. (22.9 m)
Turning Radius (outside)	22 ft. 6 in. (6.8 m)
Turning Radius (inside)	12 ft. (3.6 m)
Maximum Drive Speed:	3.5 mph (1.5 m/s)
Max. Hydraulic System Pressure	4500 psi (310 Bar)
Maximum Wind Speed	28 mph (12.5 m/s)
Maximum Manual Force	400 N
Electrical System Voltage	12 Volts
Gross Machine Weight (Platform Empty)	
800S	34,700 lbs. (15,740 kg)
860SJ	37,900 lbs. (17,191 kg)

* With boom in stowed position

Table 1-2. Operating Specifications - S/N 0300143294 & B300000153 to S/N 0300182742

Maximum Work Load (Capacity)	
ANSI	
Unrestricted:	500 lbs. (227 kg)
Restricted	Refer to Capacity Decals on machine for restricted platform capacities
Maximum Work Load (Capacity)	
CE & Australia	
Unrestricted:	500 lbs. (230 kg)
Restricted	Refer to Capacity Decals on machine for restricted platform capacities
Maximum Capacity - Dual Rating	
ANSI	
800S	1000 lbs. (454 kg)
860SJ	750 lbs. (340 kg)
Maximum Capacity - Dual Rating	
CE & Australia	
800S	1000 lbs. (450 kg)
860SJ	750 lbs. (340 kg)
Maximum Travel Grade (Gradeability)*	
2WD	30%
4WD	45%
Maximum Travel Grade (Side Slope)*	5°
Maximum Vertical Platform Height:	
800S	80 ft. (24.3 m)
860SJ	86 ft. (26.2 m)
Maximum Horizontal Platform Reach	
800S	71 ft. (21.6 m)
860SJ	75 ft. (22.9 m)
Turning Radius (outside)	22 ft. 6 in. (6.8 m)
Turning Radius (inside)	12 ft. (3.6 m)
Maximum Drive Speed:	3.5 mph (1.5 m/s)
Max. Hydraulic System Pressure	4500 psi (310 Bar)
Maximum Wind Speed	28 mph (12.5 m/s)
Maximum Manual Force	400 N
Electrical System Voltage	12 Volts
Gross Machine Weight (Platform Empty)	
800S	34,700 lbs. (15,740 kg)
860SJ	37,900 lbs. (17,191 kg)

* With boom in stowed position

1.2 SPECIFICATIONS AND PERFORMANCE DATA

Table 1-3. Specifications and Performance Data

Swing	360°
Tail Swing	4'8" (1.42 m)
Platforms	36" x 72" (0.91m x 1.83m) 36" x 96" (0.91m x 2.44m)
Overall Width	8' 2" (2.5 m)
Stowed Height 800S 860SJ	 9' 10.6" (3.01 m) 10' (3.04 m)
Stowed Length 800S 860SJ	 37' 3.25" (11.4 m) 40' (12.2 m)
Wheel base	10' (3.04 m)
Ground Clearance	15.625" (0.4 m)
Drive Speed Stowed 2WD Stowed 4WD Elevated	 3.0 mph (5.5 kph) 3.5 mph (5.6 kph) 0.75 mph (1.2 kph)
Ground Bearing Pressure - 800S 15-625 15-625FF 41/18LLx22.5	 72 psi (5.0 kgm/cm^2) 79 psi (5.5 kgm/cm^2) 68 psi (4.8 kgm/cm^2)
Ground Bearing Pressure - 860SJ 15-625 15-625FF 41/18LLx22.5	 81 psi (5.7 kgm/cm^2) 92 psi (6.5 kgm/cm^2) 79 psi (5.5 kgm/cm^2)
Max. Tire Load - 800S	17,350 lbs. (7870 kg)
Max. Tire Load - 860SJ	20,200 lbs. (9163 kg)

1.3 CAPACITIES

Table 1-4. Capacities

Fuel Tank	Approx. 31 gallons (117 liters)
Hydraulic Tank (Optional)	Approx. 52.8 gallons (200 liters)
Hydraulic Tank	Approx. 47.8 gallons (181 liters)
Engine Oil Capacity Ford Deutz Cooling System Crankcase Total Capacity Caterpillar GM	 4.5 Quarts (4.25 L) w/Filter 5 Quarts (4.5 L) 11 Quarts (10.5 L) w/Filter 16 Quarts (15 L) 10.6 quarts (10 L) 4.5 Quarts (4.25 L) w/Filter

1.4 COMPONENT DATA

Engine Data

Table 1-5. Ford LRG-425 Specifications

Type	Water-cooled
Fuel	Gasoline
Oil Capacity	4.5 Quarts (4.25 L) w/Filter
Idle RPM	1000
Low RPM	1800
High RPM	2800
Alternator	95 Amp, Belt Drive
Fuel Consumption Low RPM High RPM	 3.45 GPH (13.06 lph) 4.60 GPH (17.41 lph)
Horsepower	74 @ 3000 RPM, full load
Cooling System	16 Quarts (15.14 L)
Spark Plug	AWSF-52-C
Spark Plug Gap	0.044 in. (1.117 mm)

Table 1-6. Deutz F4M2011 Specifications

Type	Liquid Cooled (Oil)
Fuel	Diesel
Oil Capacity Cooling System Crankcase Total Capacity	 5 Quarts (4.5 L) 11 Quarts (10.5 L) w/Filter 16 Quarts (15 L)
Idle RPM	1000
Low RPM	1800
High RPM	2800
Alternator	55 Amp, belt drive
Fuel Consumption Low RPM High RPM	 1.90 GPH (7.19 lph) 2.50 GPH (9.46 lph)
Horsepower	66 @ 3000 RPM, full load

Table 1-7. Deutz D2011L04 Specifications

Type	Liquid Cooled (Oil)
Fuel	Diesel
Oil Capacity	
Cooling System	5 Quarts (4.5 L)
Crankcase	11 Quarts (10.5 L) w/Filter
Total Capacity	16 Quarts (15 L)
Idle RPM	1000
Low RPM	1800
High RPM	2600
Alternator	55 Amp, belt drive
Fuel Consumption	
Low RPM	1.90 GPH (7.19 lph)
High RPM	2.50 GPH (9.46 lph)
Battery	1000 Cold Cranking Amps, 210 minutes Reserve Capacity, 12 VDC
Horsepower	64 @ 2600 RPM, full load

Table 1-8. Caterpillar 3044C/ Caterpillar 3.4

Type	Four Stroke Cycle
Cylinders	4 in-line
Bore	3.70 in. (94 mm)
Stroke	4.72 in. (120 mm)
Aspiration	turbocharged
Compression ratio	19:1
Displacement	203 in^3 (3.33 L)
Firing Order	1-3-4-2
Rotation (viewed from flywheel)	Counterclockwise
Oil Capacity (w/filter)	10.6 quarts (10 L)
Cooling System (Engine Only)	5.8 quarts (5.5 L)
Idle RPM	1000
Low RPM	1800
High RPM - 3044C	2600
High RPM - 3.4	2500
Alternator	60 Amp, belt drive

Table 1-9. GM 3.0L

Fuel	Gasoline or Gasoline/LP Gas
No. of Cylinders	4
BHP	
Gasoline	83 hp @ 3000 rpm
LP	75 hp @ 3000 rpm
Bore	4.0 in. (101.6 mm)
Stroke	3.6 in. (91.44 mm)
Displacement	181 cu.in. (3.0 L, 2966 cc)
Oil Capacity w/filter	4.5 qts. (4.25 L)
Minimum Oil Pressure	
At Idle	6 psi (0.4 Bar) @ 1000 rpm
Hot	18 psi (1.2 Bar) @ 2000 rpm
Compression Ratio	9.2:1
Firing Order	1-3-4-2
Max. RPM	2800

Battery

Table 1-10. Battery Specifications

Voltage	12 Volt
Type	31-950
Cold Cranking Amps	950 CCA @ 0° F (-18° C)
Reserve Capacity	205 Minutes @ 80° F (27° C)

1.5 TIRES

Table 1-11. Tire Specifications

Size	Type	Ply Rating	Load Range	Weight (Tire & Wheel)
15 - 625	Pneumatic 95 psi (6.5 Bar)	16	H	269 lbs. (122 kg)
15 - 625	Foam-Filled	16	H	544 lbs. (247 kg)
18 - 625	Pneumatic 85 psi (6.5 Bar)	16	H	288 lbs. (131 kg)
18 - 625	Foam-Filled	16	H	601 lbs. (273 kg)
41/18LL x 22.5	Foam-Filled	16	H	724 lbs. (329 kg)

1.6 TORQUE REQUIREMENTS

Table 1-12. Torque Requirements

Description	Torque Value (Dry)	Interval Hours
Wheel Lugs	300 ft. lbs. (407 Nm)	150
Swing Bearing Bolts	190 ft. lbs. (258 Nm)	50/600*
Starter Solenoid Contacts Coil	 95 in. lbs. (9.5 Nm) 40 in. lbs. (4 Nm)	 As required
*Check swing bearing bolts for security after first 50 hours of operation and every 600 hours thereafter. (See Swing Bearing in Section 3.)		
NOTE: *When maintenance becomes necessary or a fastener has loosened, refer to the Torque Chart to determine proper torque value.*		

1.7 MAJOR COMPONENT WEIGHTS

Table 1-13. Component Weights

Component	Pounds	Kilograms
Turntable (bare)	3700	1678
Counterweight (800S)	7000	3175
Counterweight (860SJ)	8750	3969
Upright	1050	476
Tower	685	311
Fly Boom (SJ)	472	214
Fly Boom (S)	490	222
Mid Boom (SJ)	750	340
Mid Boom (S)	740	336
Base Boom (SJ)	1400	635
Base Boom (S)	1410	640
Boom Assembly	3337	1514
Telescope Cylinder (800S)	590	268
Telescope Cylinder (860SJ)	570	259
Slave Cylinder	73	33
Drive Hub (2WD)	218	99
Tire & Wheel (pneu)	269	122
Tire & Wheel (FF)	544	247

1.8 LUBRICATION

Hydraulic Oil

Table 1-14. Hydraulic Oil

Hydraulic System Operating Temperature Range	S.A.E. Viscosity Grade
+0° to + 180° F (-18° to +83° C)	10W
+0° to + 210° F (-18° to +99° C)	10W-20, 10W30
+50° to + 210° F (+10° to +99° C)	20W-20

NOTE: *Hydraulic oils must have anti-wear qualities at least to API Service Classification GL-3, and sufficient chemical stability for mobile hydraulic system service. JLG Industries recommends Mobilfluid 424 hydraulic oil, which has an SAE viscosity index of 152.*

NOTE: *When temperatures remain consistently below 20 degrees F. (-7 degrees C.), JLG Industries recommends the use of Mobil DTE10.*

NOTE: *Aside from JLG recommendations, it is not advisable to mix oils of different brands or types, as they may not contain the same required additives or be of comparable viscosities. If use of hydraulic oil other than Mobilfluid 424 is desired, contact JLG Industries for proper recommendations.*

Table 1-15. Mobilfluid 424 Specs

SAE Grade	10W30
ISO Grade	55
Gravity, API	29.0
Density, Lb/Gal. 60°F	7.35
Pour Point, Max	-46°F (-43°C)
Flash Point, Min.	442°F (228°C)
Viscosity	
Brookfield, cP at -18°C	2700
at 40° C	55 cSt
at 100° C	9.3 cSt
Viscosity Index	152

Table 1-16. Mobil DTE 10 Excel 32 Specs

ISO Viscosity Grade	#32
Gravity API	
Pour Point, Max	-65.2°F (-54°C)
Flash Point, Min.	482°F (250°C)
Viscosity	
at 40° C	32.7 cSt
at 100° C	6.6 cSt
at 100° F	32.7 cSt
at 212° F	6.6 cSt
cp at -30° F	
Viscosity Index	164
Density@ 15°C	0.85 Kg/l
Density@ 60°F	0.03 lb/in^3

Table 1-17. Mobil EAL 224H Specs

Type	Synthetic Biodegradable
ISO Viscosity Grade	32/46
Specific Gravity	.922
Pour Point, Max	-25°F (-32°C)
Flash Point, Min.	428°F (220°C)
Operating Temp.	0 to 180°F (-17 to 162°C)
Weight	7.64 lb. per gal. (0.9 kg per liter)
Viscosity	
at 40° C	37 cSt
at 100° C	8.4 cSt
Viscosity Index	213
NOTE: *Must be stored above 32°F (14°C)*	

Table 1-18. UCon Hydrolube HP-5046

Type	Synthetic Biodegradable
Specific Gravity	1.082
Pour Point, Max	-58°F (-50°C)
pH	9.1
Viscosity	
at 0° C (32° F)	340 cSt (1600SUS)
at 40° C (104° F)	46 cSt (215SUS)
at 65° C (150° F)	22 cSt (106SUS)
Viscosity Index	170

Table 1-19. Exxon Univis HVI 26 Specs

Specific Gravity	32.1
Pour Point	-76°F (-60°C)
Flash Point	217°F (103°C)
Viscosity	
at 40° C	25.8 cSt
at 100° C	9.3 cSt
Viscosity Index	376
NOTE: *Mobil/Exxon recommends that this oil be checked on a yearly basis for viscosity.*	

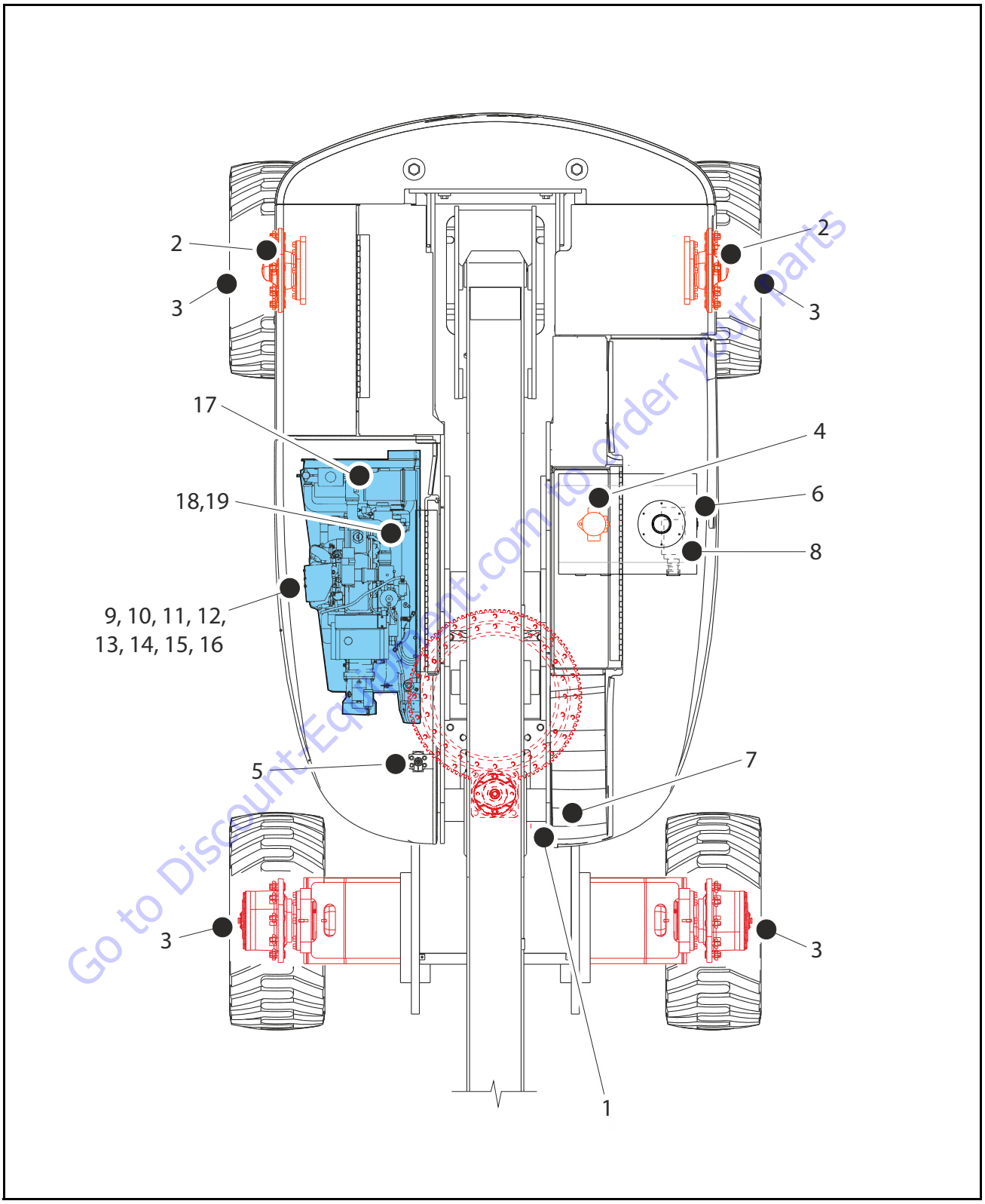


Figure 1-1. Operator Maintenance and Lubrication Diagram

1.9 OPERATOR MAINTENANCE

NOTE: *The following numbers correspond to those in Figure 1-1., Operator Maintenance and Lubrication Diagram.*

Table 1-20. Lubrication Specifications

KEY	SPECIFICATIONS
MPG	Multipurpose Grease having a minimum dripping point of 350° F (177° C). Excellent water resistance and adhesive qualities, and being of extreme pressure type. (Timken OK 40 pounds minimum.)
EPGL	Extreme Pressure Gear Lube (oil) meeting API service classification GL-5 or MIL-Spec MIL-L-2105
HO	Hydraulic Oil. API service classification GL-3, e.g. Mobilfluid 424.
EO	Engine (crankcase) Oil. Gas - API SF, SH, SG class, MIL-L-2104. Diesel - API CC/CD class, MIL-L-2104B/MIL-L-2104C.

NOTICE

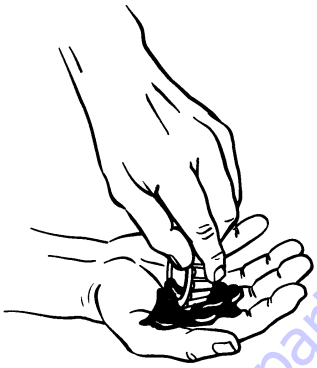
LUBRICATION INTERVALS ARE BASED ON MACHINE OPERATION UNDER NORMAL CONDITIONS. FOR MACHINES USED IN MULTI-SHIFT OPERATIONS AND/OR EXPOSED TO HOSTILE ENVIRONMENTS OR CONDITIONS, LUBRICATION FREQUENCIES MUST BE INCREASED ACCORDINGLY.

NOTE: *It is recommended as a good practice to replace all filters at the same time.*

1. Swing Bearing - Internal Ball Bearing

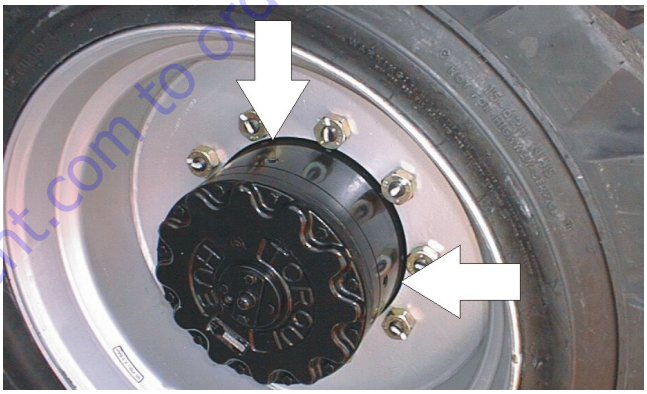
Lube Point(s) - 1 Grease Fittings
Capacity - A/R
Lube - MPG
Interval - Every 3 months or 150 hrs of operation
Comments - Remote Access

2. Wheel Bearings



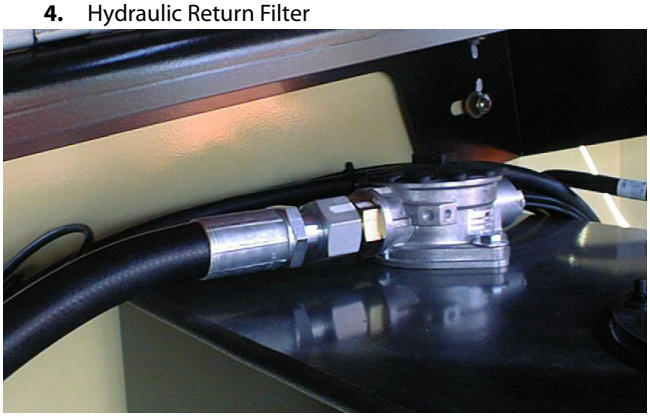
Lube Point(s) - Repack
Capacity - A/R
Lube - MPG
Interval - Every 2 years or 1200 hours of operation

3. Wheel Drive Hub



Lube Point(s) - Level/Fill Plug
Capacity - 17 oz. (0.5 L) - 1/2 Full
Lube - EPGL
Interval - Check level every 3 months or 150 hrs of operation; change every 2 years or 1200 hours of operation
Comments - Place Fill port at 12 o'clock position and Check port at 3 o'clock position. Pour lubricant into fill port until it just starts to flow out of check port.

4. Hydraulic Return Filter

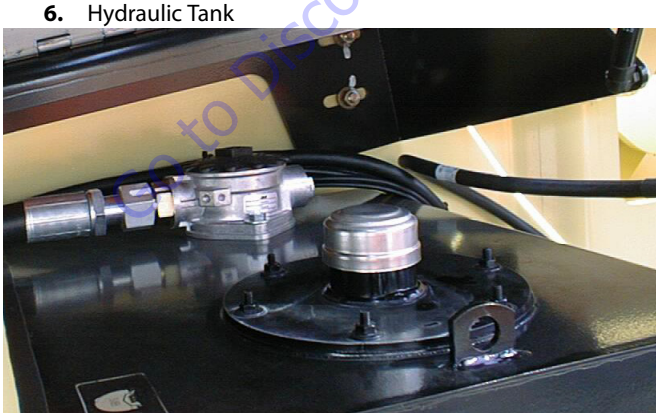


Interval - Change after first 50 hrs. and every 6 months or 300 hrs. thereafter or as indicated by Condition Indicator.

5. Hydraulic Charge Filter

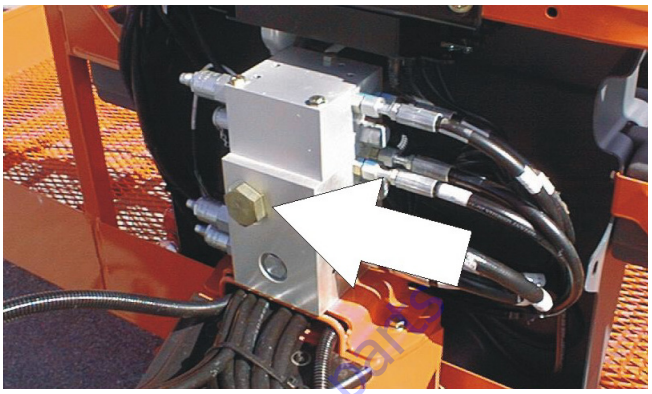
Interval - Change after first 50 hrs. and every 6 months or 300 hrs. thereafter or as indicated by Condition Indicator.

6. Hydraulic Tank



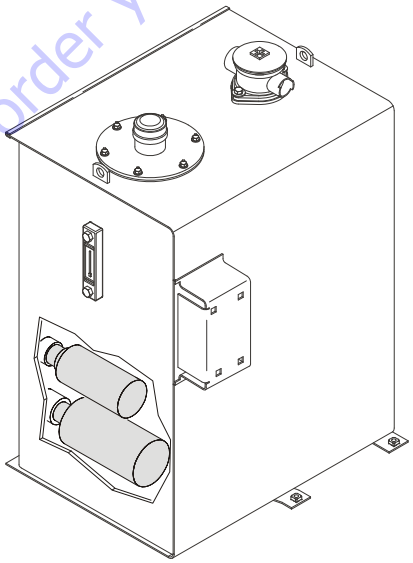
Lube Point(s) - Fill Cap
Capacity - 116 liters Tank 124 liters System
Lube - HO
Interval - Check Level daily; Change every 2 years or 1200 hours of operation.

7. Platform Filter



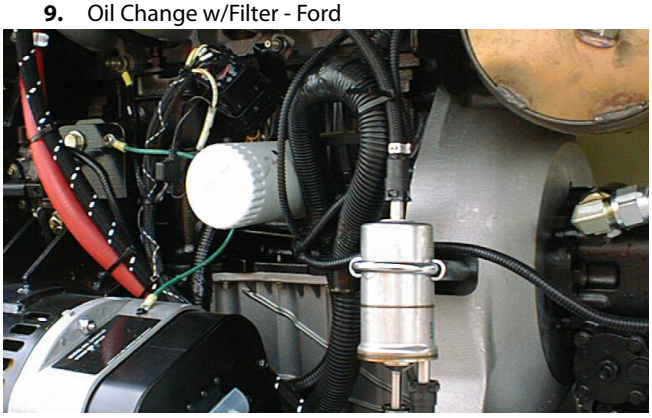
Interval - Change as necessary

8. Suction Strainers



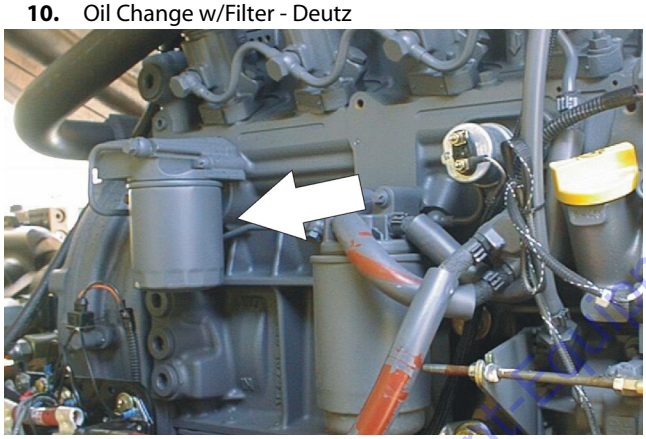
Lube Point(s) - 2
Interval - Every 2 years or 1200 hours of operation, remove and clean at time of hydraulic oil change.

9. Oil Change w/Filter - Ford



Lube Point(s) - Fill Cap/Spin-on Element
Capacity - 4.5 Quarts
Lube - EO
Interval - 3 Months or 150 hours of operation
Comments - Check level daily/Change in accordance with engine manual.

10. Oil Change w/Filter - Deutz



Lube Point(s) - Fill Cap/Spin-on Element
Capacity - 11 Quarts(10.5 L) Crankcase;
Lube - EO
Interval - Every Year or 1200 hours of operation
Comments - Check level daily/Change in accordance with engine manual. Refer to Figure 1-2., Deutz Engine Dipstick.

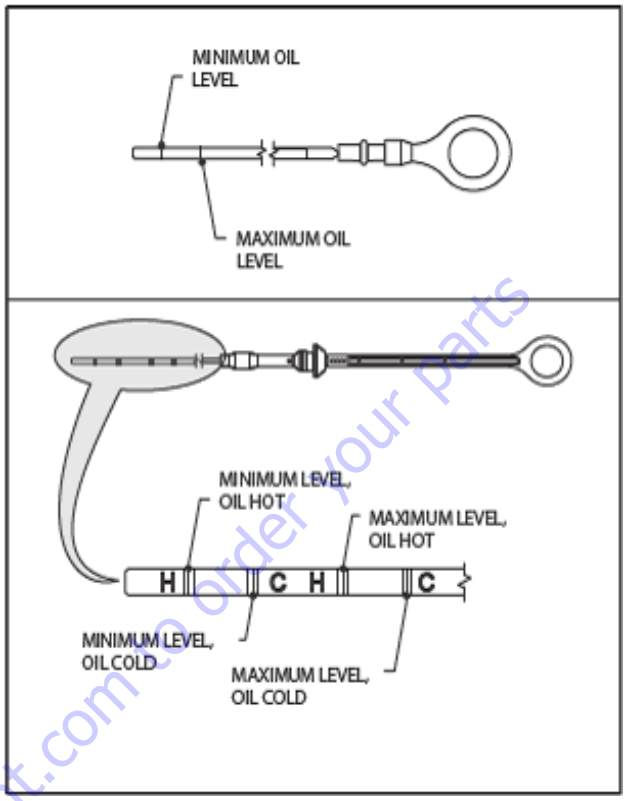
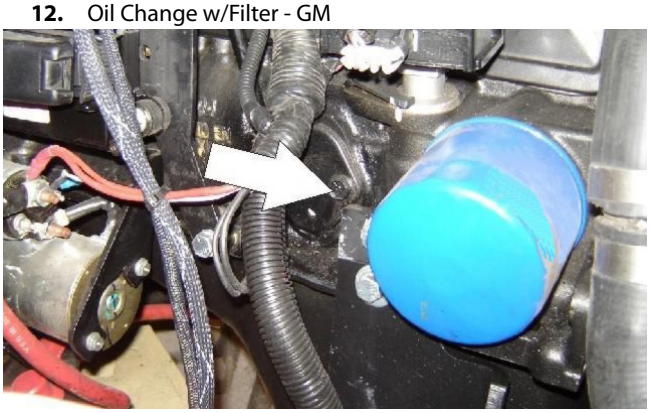


Figure 1-2. Deutz Engine Dipstick

11. Oil Change w/Filter - Caterpillar

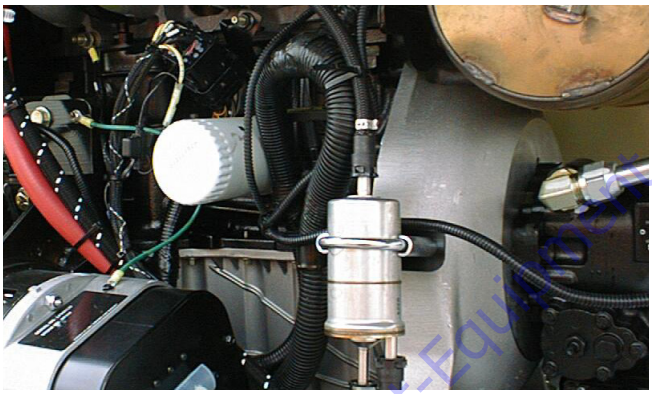
Lube Point(s) - Fill Cap/Spin-on Element
Capacity - 10.6 Quarts
Lube - EO
Interval - 3 Months or 150 hours of operation
Comments - Check level daily/Change in accordance with engine manual.

12. Oil Change w/Filter - GM



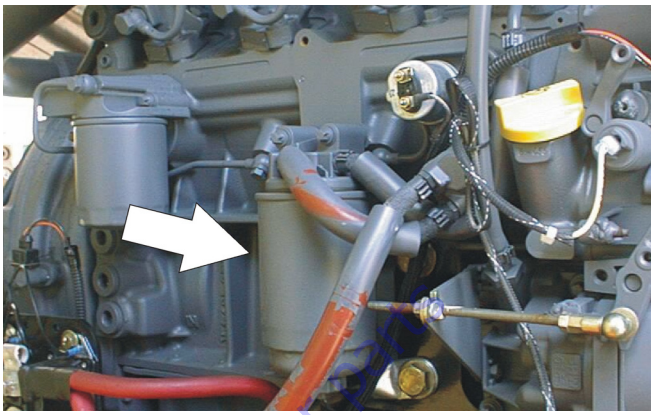
Lube Point(s) - Fill Cap/Spin-on Element
Capacity - 4.5 qt. (4.25 L) w/filter
Lube - EO
Interval - 3 Months or 150 hours of operation
Comments - Check level daily/Change in accordance with engine manual.

13. Fuel Filter - Ford



Lube Point(s) - Replaceable Element
Interval - Every Year or 1200 hours of operation

14. Fuel Filter - Deutz



Lube Point(s) - Replaceable Element
Interval - Every Year or 600 hours of operation

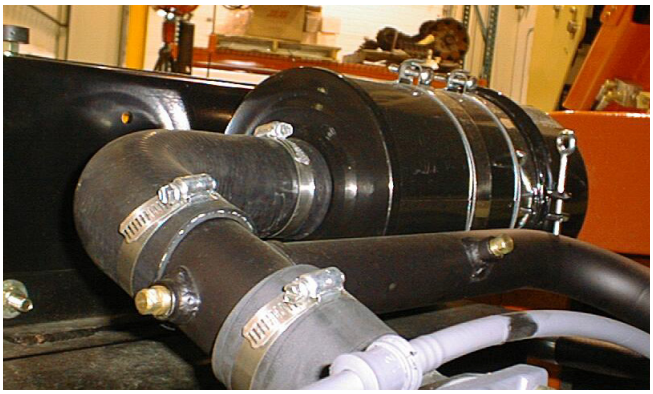
15. Fuel Filter - Caterpillar

Lube Point(s) - Replaceable Element
Interval - Every Year or 600 hours of operation

16. Fuel Filter (Gasoline) - GM

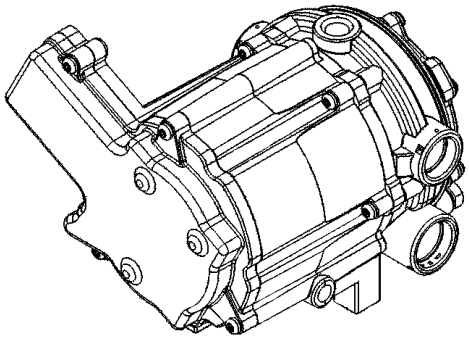
Lube Point(s) - Replaceable Element
Interval - Every 6 months or 300 hours of operation

17. Air Filter



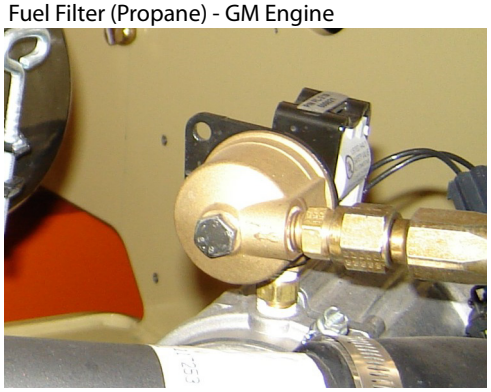
Lube Point(s) - Replaceable Element
Interval - Every 6 months or 300 hours of operation or as indicated by the condition indicator

18. Electronic Pressure Regulator (LP only)



Interval - 3 Months or 150 hours of operation
Comments - Drain oil build up. Refer to Draining Oil Build Up From The Propane Regulator

19. Fuel Filter (Propane) - GM Engine



Interval - 3 Months or 150 hours of operation
Comments - Replace filter. Refer to Propane Fuel Filter Replacement

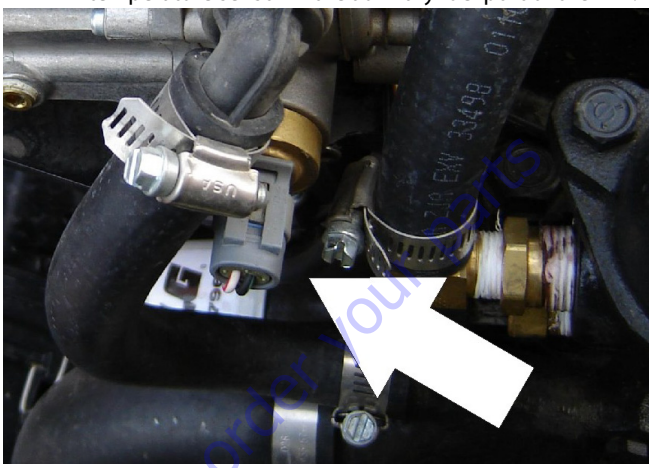
Draining Oil Build Up From The Propane Regulator (Prior to S/N 0300134626)

During the course of normal operation oils may build inside the primary and secondary chambers of the propane pressure regulator. These oils may be a result of poor fuel quality, contamination of the fuel supply chain, or regional variation in the make up of the fuel. If the build up of the oil is significant this can effect the operation of the fuel control system. Refer to Section 1.9, Operator Maintenance for maintenance intervals. More frequent draining may be required if the fuel supply has been contaminated.

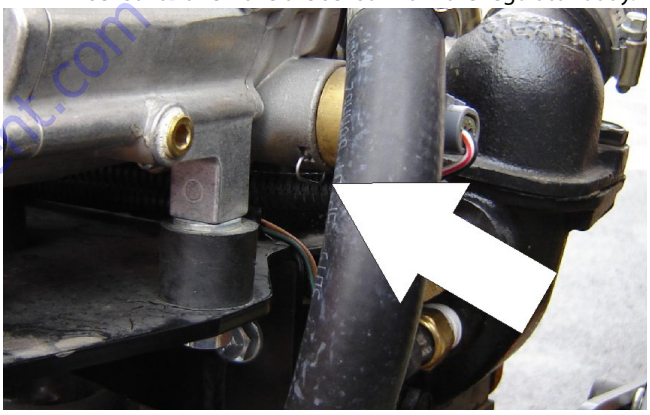
NOTICE

FOR BEST RESULTS WARM THE ENGINE TO OPERATING TEMPERATURE BEFORE DRAINING. THIS WILL ALLOW THE OILS TO BE LIQUID AND FLOW FREELY FROM THE REGULATOR.

1. Move the equipment to a well ventilated area. Ensure there are no external ignition sources.
2. Start the engine and bring to operating temperature.
3. With the engine running, close the manual tank valve and run the engine out of fuel.
4. Push in the Emergency Switch once the engine stops.
5. Disconnect the electrical connection to the LPG fuel temperature sensor in the auxiliary fuel port of the EPR.



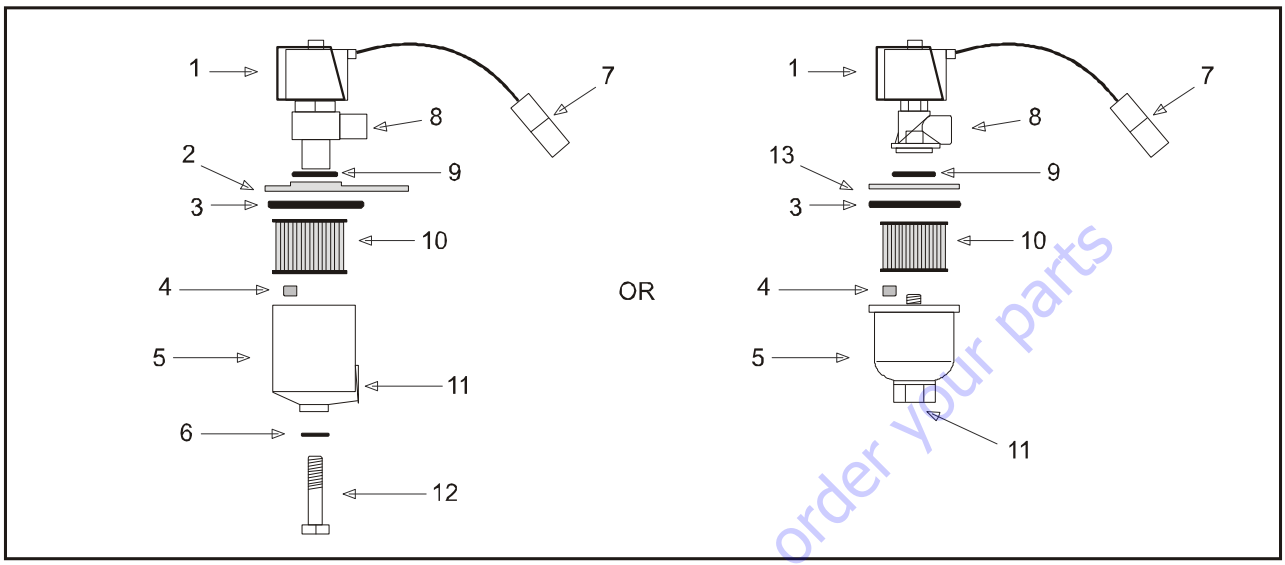
6. Remove the retainer clip for the LPG fuel temperature sensor and remove the sensor from the regulator body.



NOTE: *Have a small container ready to collect oil that will drain freely from the regulator at this point.*

7. Once all of the oil has been drained, reinstall the LPG fuel temperature sensor and reconnect the electrical connector.
8. Open the fuel tank manual valve.
9. Start the engine and verify all connections are secure.
10. Dispose of any drained oil in a safe and proper fashion.

Propane Fuel Filter Replacement



1. Electric Lock Off Solenoid
2. Mounting Plate
3. Housing Seal
4. Filter Magnet
5. Filter Housing
6. Seal
7. Electrical Connector
8. Fuel Outlet
9. O-ring
10. Filter
11. Fuel Inlet
12. Retaining Bolt
13. Ring

Figure 1-3. Filter Lock Assembly

REMOVAL

1. Relieve the propane fuel system pressure. Refer to Propane Fuel System Pressure Relief.
2. Disconnect the negative battery cable.
3. Slowly loosen the Filter housing retaining bolt and remove it.
4. Pull the filter housing from the Electric lock off assembly.
5. Locate Filter magnet and remove it.
6. Remove the filter from the housing.
7. Remove and discard the housing seal.
8. Remove and discard the retaining bolt seal.
9. Remove and discard mounting plate to lock off o-ring seal.

INSTALLATION

NOTICE

BE SURE TO REINSTALL THE FILTER MAGNET INTO THE HOUSING BEFORE INSTALLING NEW SEAL

1. Install the mounting plate to lock off o-ring seal.
2. Install the retaining bolt seal.
3. Install the housing seal.
4. Drop the magnet into the bottom of the filter housing.
5. Install the filter into the housing.
6. Install the retaining bolt into the filter housing.
7. Install the filter up to the bottom of the electric lock off.
8. Tighten the filter retaining bolt to 106 in lbs (12 Nm).
9. Open manual shut-off valve. Start the vehicle and leak check the propane fuel system at each serviced fitting. Refer to Propane Fuel System Leak Test.

Propane Fuel System Pressure Relief

⚠ CAUTION

THE PROPANE FUEL SYSTEM OPERATES AT PRESSURES UP TO 312 PSI (21.5 BAR). TO MINIMIZE THE RISK OF FIRE AND PERSONAL INJURY, RELIEVE THE PROPANE FUEL SYSTEM PRESSURE (WHERE APPLICABLE) BEFORE SERVICING THE PROPANE FUEL SYSTEM COMPONENTS.

To relieve propane fuel system pressure:

1. Close the manual shut-off valve on the propane fuel tank.
2. Start and run the vehicle until the engine stalls.
3. Turn the ignition switch OFF.

⚠ CAUTION

RESIDUAL VAPOR PRESSURE WILL BE PRESENT IN THE FUEL SYSTEM. ENSURE THE WORK AREA IS WELL VENTILATED BEFORE DISCONNECTING ANY FUEL LINE.

1.10 SERIAL NUMBER LOCATION

A serial number plate is affixed to the left rear side of the frame. If the serial number plate is damaged or missing, the machine serial number is stamped on the left side of the frame.

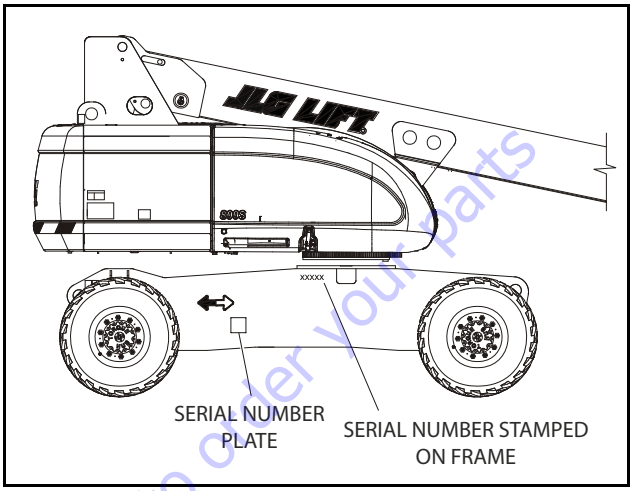


Figure 1-4. Serial Number Locations

Values for Zinc Yellow Chromate Fasteners (Ref 4150707)																		
				SAE GRADE 5 BOLTS & GRADE 2 NUTS									SAE GRADE 8 (HEX HD) BOLTS & GRADE 8 NUTS*						
Size	TPI	Bolt Dia	Tensile Stress Area	Clamp Load	Torque (Dry)		Torque Lubricated		Torque (Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140)		Torque (Loctite® 262™ or Vibra-TITE™ 131)		Clamp Load	Torque (Dry or Loctite® 263) K= 0.20		Torque (Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140) K=.18		Torque (Loctite® 262™ or Vibra-TITE™ 131) K=0.15	
		In	Sq In	LB	IN-LB	[N.m]	IN-LB	[N.m]	IN-LB	[N.m]	IN-LB	[N.m]	LB	IN-LB	[N.m]	IN-LB	[N.m]	IN-LB	[N.m]
4	40	0.1120	0.00604	380	8	0.9	6	0.7											
	48	0.1120	0.00661	420	9	1.0	7	0.8											
6	32	0.1380	0.00909	580	16	1.8	12	1.4											
	40	0.1380	0.01015	610	18	2.0	13	1.5											
8	32	0.1640	0.01400	900	30	3.4	22	2.5											
	36	0.1640	0.01474	940	31	3.5	23	2.6					1320	43	5				
10	24	0.1900	0.01750	1120	43	4.8	32	3.5					1580	60	7				
	32	0.1900	0.02000	1285	49	5.5	36	4					1800	68	8				
1/4	20	0.2500	0.0318	2020	96	10.8	75	9	105	12			2860	143	16	129	15		
	28	0.2500	0.0364	2320	120	13.5	86	10	135	15			3280	164	19	148	17		
		In	Sq In	LB	FT-LB	[N.m]	FT-LB	[N.m]	FT-LB	[N.m]	FT-LB	[N.m]	LB	FT-LB	[N.m]	FT-LB	[N.m]	FT-LB	[N.m]
5/16	18	0.3125	0.0524	3340	17	23	13	18	19	26	16	22	4720	25	35	20	25	20	25
	24	0.3125	0.0580	3700	19	26	14	19	21	29	17	23	5220	25	35	25	35	20	25
3/8	16	0.3750	0.0775	4940	30	41	23	31	35	48	28	38	7000	45	60	40	55	35	50
	24	0.3750	0.0878	5600	35	47	25	34	40	54	32	43	7900	50	70	45	60	35	50
7/16	14	0.4375	0.1063	6800	50	68	35	47	55	75	45	61	9550	70	95	65	90	50	70
	20	0.4375	0.1187	7550	55	75	40	54	60	82	50	68	10700	80	110	70	95	60	80
1/2	13	0.5000	0.1419	9050	75	102	55	75	85	116	68	92	12750	105	145	95	130	80	110
	20	0.5000	0.1599	10700	90	122	65	88	100	136	80	108	14400	120	165	110	150	90	120
9/16	12	0.5625	0.1820	11600	110	149	80	108	120	163	98	133	16400	155	210	140	190	115	155
	18	0.5625	0.2030	12950	120	163	90	122	135	184	109	148	18250	170	230	155	210	130	175
5/8	11	0.6250	0.2260	14400	150	203	110	149	165	224	135	183	20350	210	285	190	260	160	220
	18	0.6250	0.2560	16300	170	230	130	176	190	258	153	207	23000	240	325	215	290	180	245
3/4	10	0.7500	0.3340	21300	260	353	200		285	388	240	325	30100	375	510	340	460	280	380
	16	0.7500	0.3730	23800	300	407	220	298	330	449	268	363	33600	420	570	380	515	315	430
7/8	9	0.8750	0.4620	29400	430	583	320	434	475	646	386	523	41600	605	825	545	740	455	620
	14	0.8750	0.5090	32400	470	637	350	475	520	707	425	576	45800	670	910	600	815	500	680
1	8	1.0000	0.6060	38600	640	868	480	651	675	918	579	785	51500	860	1170	770	1045	645	875
	12	1.0000	0.6630	42200	700	949	530	719	735	1000	633	858	59700	995	1355	895	1215	745	1015
1 1/8	7	1.1250	0.7630	42300	800	1085	600	813	840	1142	714	968	68700	1290	1755	1160	1580	965	1310
	12	1.1250	0.8560	47500	880	1193	660	895	925	1258	802	1087	77000	1445	1965	1300	1770	1085	1475
1 1/4	7	1.2500	0.9690	53800	1120	1518	840	1139	1175	1598	1009	1368	87200	1815	2470	1635	2225	1365	1855
	12	1.2500	1.0730	59600	1240	1681	920	1247	1300	1768	1118	1516	96600	2015	2740	1810	2460	1510	2055
1 3/8	6	1.3750	1.1550	64100	1460	1979	1100	1491	1525	2074	1322	1792	104000	2385	3245	2145	2915	1785	2430
	12	1.3750	1.3150	73000	1680	2278	1260	1708	1750	2380	1506	2042	118100	2705	3680	2435	3310	2030	2760
1 1/2	6	1.5000	1.4050	78000	1940	2630	1460	1979	2025	2754	1755	2379	126500	3165	4305	2845	3870	2370	3225
	12	1.5000	1.5800	87700	2200	2983	1640	2224	2300	3128	1974	2676	142200	3555	4835	3200	4350	2665	3625

NOTES: 1. THESE TORQUE VALUES DO NOT APPLY TO CADMIUM PLATED FASTENERS
2. ALL TORQUE VALUES ARE STATIC TORQUE MEASURED PER STANDARD AUDIT METHODS TOLERANCE = ±10%
3. * ASSEMBLY USES HARDENED WASHER

NO. 5000059 REV. K

Figure 1-5. Torque Chart (SAE Fasteners)- Sheet 1 of 5

REFERENCE JLG THREAD LOCKING COMPOUND			
JLG P/N	Loctite® P/N	ND Industries P/N	Description
0100011	242™	Vibra-TITE™ 121	Medium Strength (Blue)
0100019	271™	Vibra-TITE™ 140	High Strength (Red)
0100071	262™	Vibra-TITE™ 131	Medium - High Strength (Red)

Values for Magni Coating Fasteners (Ref 4150701)																	
SAE GRADE 5 BOLTS & GRADE 2 NUTS											SAE GRADE 8 (HEX HD) BOLTS & GRADE 8 NUTS*						
Size	TPI	Bolt Dia	Tensile Stress Area	Clamp Load	Torque (Dry) K=0.17		Torque (Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140) K=0.16		Torque (Loctite® 262™ or Vibra-TITE™ 131) K=0.15		Clamp Load	Torque (Dry or Loctite® 263) K= 0.17		Torque (Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140) K=.16		Torque (Loctite® 262™ or Vibra-TITE™ 131) K=0.15	
		In	Sq In	LB	IN-LB	[N.m]	IN-LB	[N.m]	IN-LB	[N.m]	LB	IN-LB	[N.m]	IN-LB	[N.m]	IN-LB	[N.m]
4	40	0.1120	0.00604	380	7	0.8											
	48	0.1120	0.00661	420	8	0.9											
6	32	0.1380	0.00909	580	14	1.5											
	40	0.1380	0.01015	610	14	1.6											
8	32	0.1640	0.01400	900	25	2.8											
	36	0.1640	0.01474	940	26	2.9					1320	37	4				
10	24	0.1900	0.01750	1120	36	4.1					1580	51	6				
	32	0.1900	0.02000	1285	42	4.7					1800	58	7				
1/4	20	0.2500	0.0318	2020	86	9.7	80	9			2860	122	14	114	13		
	28	0.2500	0.0364	2320	99	11.1	95	11			3280	139	16	131	15		
		In	Sq In	LB	FT-LB	[N.m]	FT-LB	[N.m]	FT-LB	[N.m]	LB	FT-LB	[N.m]	FT-LB	[N.m]	FT-LB	[N.m]
5/16	18	0.3125	0.0524	3340	15	20	14	19	15	20	4720	20	25	20	25	20	25
	24	0.3125	0.0580	3700	15	20	15	21	15	20	5220	25	35	20	25	20	25
3/8	16	0.3750	0.0775	4940	25	35	25	34	25	34	7000	35	50	35	50	35	50
	24	0.3750	0.0878	5600	30	40	28	38	25	34	7900	40	55	40	55	35	50
7/16	14	0.4375	0.1063	6800	40	55	40	54	35	48	9550	60	80	55	75	50	70
	20	0.4375	0.1187	7550	45	60	44	60	40	54	10700	65	90	60	80	60	80
1/2	13	0.5000	0.1419	9050	65	90	60	82	55	75	12750	90	120	85	115	80	110
	20	0.5000	0.1599	10700	75	100	71	97	65	88	14400	100	135	95	130	90	120
9/16	12	0.5625	0.1820	11600	90	120	87	118	80	109	16400	130	175	125	170	115	155
	18	0.5625	0.2030	12950	105	145	97	132	90	122	18250	145	195	135	185	130	175
5/8	11	0.6250	0.2260	14400	130	175	120	163	115	156	20350	180	245	170	230	160	220
	18	0.6250	0.2560	16300	145	195	136	185	125	170	23000	205	280	190	260	180	245
3/4	10	0.7500	0.3340	21300	225	305	213	290	200	272	30100	320	435	300	410	280	380
	16	0.7500	0.3730	23800	255	345	238	324	225	306	33600	355	485	335	455	315	430
7/8	9	0.8750	0.4620	29400	365	495	343	466	320	435	41600	515	700	485	660	455	620
	14	0.8750	0.5090	32400	400	545	378	514	355	483	45800	570	775	535	730	500	680
1	8	1.0000	0.6060	38600	545	740	515	700	480	653	51500	730	995	685	930	645	875
	12	1.0000	0.6630	42200	600	815	563	765	530	721	59700	845	1150	795	1080	745	1015
1 1/8	7	1.1250	0.7630	42300	675	920	635	863	595	809	68700	1095	1490	1030	1400	965	1310
	12	1.1250	0.8560	47500	755	1025	713	969	670	911	77000	1225	1665	1155	1570	1085	1475
1 1/4	7	1.2500	0.9690	53800	955	1300	897	1219	840	1142	87200	1545	2100	1455	1980	1365	1855
	12	1.2500	1.0730	59600	1055	1435	993	1351	930	1265	96600	1710	2325	1610	2190	1510	2055
1 3/8	6	1.3750	1.1550	64100	1250	1700	1175	1598	1100	1496	104000	2025	2755	1905	2590	1785	2430
	12	1.3750	1.3150	73000	1420	1930	1338	1820	1255	1707	118100	2300	3130	2165	2945	2030	2760
1 1/2	6	1.5000	1.4050	78000	1660	2260	1560	2122	1465	1992	126500	2690	3660	2530	3440	2370	3225
	12	1.5000	1.5800	87700	1865	2535	1754	2385	1645	2237	142200	3020	4105	2845	3870	2665	3625

NOTES: 1. THESE TORQUE VALUES DO NOT APPLY TO CADMIUM PLATED FASTENERS
2. ALL TORQUE VALUES ARE STATIC TORQUE MEASURED PER STANDARD AUDIT METHODS TOLERANCE = ±10%
3. * ASSEMBLY USES HARDENED WASHER

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Figure 1-6. Torque Chart (SAE Fasteners)- Sheet 2 of 5

				SOCKET HEAD CAP SCREWS												
				Magni Coating (Ref 4150701)*							Zinc Yellow Chromate Fasteners (Ref 4150707)*						
Size	TPI	Bolt Dia	Tensile Stress Area	Clamp Load See Note 4	Torque (Dry) K = .17		Torque (Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140 OR Precoat 85®) K=0.16		Torque (Loctite® 262™ or Vibra-TITE™ 131) K=0.15		Clamp Load See Note 4	Torque (Dry) K = .20		Torque (Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140 OR Precoat 85®) K=0.18		Torque (Loctite® 262™ or Vibra-TITE™ 131) K=0.15	
		In	Sq In	LB	IN-LB	[N.m]	IN-LB	[N.m]	IN-LB	[N.m]	LB	IN-LB	[N.m]	IN-LB	[N.m]	IN-LB	[N.m]
4	40	0.1120	0.00604														
	48	0.1120	0.00661														
6	32	0.1380	0.00909														
	40	0.1380	0.01015														
8	32	0.1640	0.01400														
	36	0.1640	0.01474														
10	24	0.1900	0.01750														
	32	0.1900	0.02000														
1/4	20	0.2500	0.0318	2860	122	14	114	13			2860	143	16	129	15		
	28	0.2500	0.0364	3280	139	16	131	15			3280	164	19	148	17		
		In	Sq In	LB	FT-LB	[N.m]	FT-LB	[N.m]	FT-LB	[N.m]	LB	FT-LB	[N.m]	FT-LB	[N.m]	FT-LB	[N.m]
5/16	18	0.3125	0.0524	4720	20	25	20	25	20	25	4720	25	35	20	25	20	25
	24	0.3125	0.0580	5220	25	35	20	25	20	25	5220	25	35	25	35	20	25
3/8	16	0.3750	0.0775	7000	35	50	35	50	35	50	7000	45	60	40	55	35	50
	24	0.3750	0.0878	7900	40	55	40	55	35	50	7900	50	70	45	60	35	50
7/16	14	0.4375	0.1063	9550	60	80	55	75	50	70	9550	70	95	65	90	50	70
	20	0.4375	0.1187	10700	65	90	60	80	60	80	10700	80	110	70	95	60	80
1/2	13	0.5000	0.1419	12750	90	120	85	115	80	110	12750	105	145	95	130	80	110
	20	0.5000	0.1599	14400	100	135	95	130	90	120	14400	120	165	110	150	90	120
9/16	12	0.5625	0.1820	16400	130	175	125	170	115	155	16400	155	210	140	190	115	155
	18	0.5625	0.2030	18250	145	195	135	185	130	175	18250	170	230	155	210	130	175
5/8	11	0.6250	0.2260	20350	180	245	170	230	160	220	20350	210	285	190	260	160	220
	18	0.6250	0.2560	23000	205	280	190	260	180	245	23000	240	325	215	290	180	245
3/4	10	0.7500	0.3340	30100	320	435	300		280	380	30100	375	510	340	460	280	380
	16	0.7500	0.3730	33600	355	485	335	455	315	430	33600	420	570	380	515	315	430
7/8	9	0.8750	0.4620	41600	515	700	485	660	455	620	41600	605	825	545	740	455	620
	14	0.8750	0.5090	45800	570	775	535	730	500	680	45800	670	910	600	815	500	680
1	8	1.0000	0.6060	51500	730	995	685	930	645	875	51500	860	1170	775	1055	645	875
	12	1.0000	0.6630	59700	845	1150	795	1080	745	1015	59700	995	1355	895	1215	745	1015
1 1/8	7	1.1250	0.7630	68700	1095	1490	1030	1400	965	1310	68700	1290	1755	1160	1580	965	1310
	12	1.1250	0.8560	77000	1225	1665	1155	1570	1085	1475	77000	1445	1965	1300	1770	1085	1475
1 1/4	7	1.2500	0.9690	87200	1545	2100	1455	1980	1365	1855	87200	1815	2470	1635	2225	1365	1855
	12	1.2500	1.0730	96600	1710	2325	1610	2190	1510	2055	96600	2015	2740	1810	2460	1510	2055
1 3/8	6	1.3750	1.1550	104000	2025	2755	1905	2590	1785	2430	104000	2385	3245	2145	2915	1785	2430
	12	1.3750	1.3150	118100	2300	3130	2165	2945	2030	2760	118100	2705	3680	2435	3310	2030	2760
1 1/2	6	1.5000	1.4050	126500	2690	3660	2530	3440	2370	3225	126500	3165	4305	2845	3870	2370	3225
	12	1.5000	1.5800	142200	3020	4105	2845	3870	2665	3625	142200	3555	4835	3200	4350	2665	3625

NOTES: 1. THESE TORQUE VALUES DO NOT APPLY TO CADMIUM PLATED FASTENERS

2. ALL TORQUE VALUES ARE STATIC TORQUE MEASURED PER STANDARD AUDIT METHODS TOLERANCE = ±10%

*3. ASSEMBLY USES HARDENED WASHER OR FASTENER IS PLACED AGAINST PLATED STEEL OR RAW ALUMINUM

4. CLAMP LOAD LISTED FOR SHCS IS SAME AS GRADE 8 OR CLASS 10.9 AND DOES NOT REPRESENT FULL STRENGTH CAPABILITY OF SHCS. IF HIGHER LOAD IS REQUIRED, ADDITIONAL TESTING IS REQUIRED.

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Figure 1-7. Torque Chart (SAE Fasteners)- Sheet 3 of 5

Values for Zinc Yellow Chromate Fasteners (Ref 4150707)

Size	PITCH	Tensile Stress Area	CLASS 8.8 METRIC (HEX/SOCKET HEAD) BOLTS CLASS 8 METRIC NUTS					CLASS 10.9 METRIC (HEX HEAD) BOLTS CLASS 10 METRIC NUTS CLASS 12.9 SOCKET HEAD CAP SCREWS M3 - M5*			
			Clamp Load	Torque (Dry or Loctite® 263™)	Torque (Lub)	Torque (Loctite® 262™ OR Vibra-TITE™ 131)	Torque (Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140)	Clamp Load	Torque (Dry or Loctite® 263™) K = 0.20	Torque (Lub OR Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140) K= 0.18	Torque (Loctite® 262™ OR Vibra-TITE™ 131) K=0.15
		Sq mm	KN	[N.m]	[N.m]	[N.m]	[N.m]	KN	[N.m]	[N.m]	[N.m]
3	0.5	5.03	2.19	1.3	1.0	1.2	1.4	3.13			
3.5	0.6	6.78	2.95	2.1	1.6	1.9	2.3	4.22			
4	0.7	8.78	3.82	3.1	2.3	2.8	3.4	5.47			
5	0.8	14.20	6.18	6.2	4.6	5.6	6.8	8.85			
6	1	20.10	8.74	11	7.9	9.4	12	12.5			
7	1	28.90	12.6	18	13	16	19	18.0	25	23	19
8	1.25	36.60	15.9	26	19	23	28	22.8	37	33	27
10	1.5	58.00	25.2	50	38	45	55	36.1	70	65	55
12	1.75	84.30	36.7	88	66	79	97	52.5	125	115	95
14	2	115	50.0	140	105	126	154	71.6	200	180	150
16	2	157	68.3	219	164	197	241	97.8	315	280	235
18	2.5	192	83.5	301	226	271	331	119.5	430	385	325
20	2.5	245	106.5	426	320	383	469	152.5	610	550	460
22	2.5	303	132.0	581	436	523	639	189.0	830	750	625
24	3	353	153.5	737	553	663	811	222.0	1065	960	800
27	3	459	199.5	1080	810	970	1130	286.0	1545	1390	1160
30	3.5	561	244.0	1460	1100	1320	1530	349.5	2095	1885	1575
33	3.5	694	302.0	1990	1490	1790	2090	432.5	2855	2570	2140
36	4	817	355.5	2560	1920	2300	2690	509.0	3665	3300	2750
42	4.5	1120	487.0	4090	3070	3680	4290	698.0	5865	5275	4395

NOTES: 1. THESE TORQUE VALUES DO NOT APPLY TO CADMIUM PLATED FASTENERS
2. ALL TORQUE VALUES ARE STATIC TORQUE MEASURED PER STANDARD AUDIT METHODS TOLERANCE = ±10%
*3. ASSEMBLY USES HARDENED WASHER OR FASTENER IS PLACED AGAINST PLATED STEEL OR RAW ALUMINUM
4. CLAMP LOAD LISTED FOR SHCS IS SAME AS GRADE 8 OR CLASS 10.9 AND DOES NOT REPRESENT FULL STRENGTH CAPABILITY OF SHCS. IF HIGHER LOAD IS REQUIRED, ADDITIONAL TESTING IS REQUIRED.

NO. 5000059 REV. K

Figure 1-8. Torque Chart (METRIC Fasteners) - Sheet 4 of 5

Values for Magni Coated Fasteners (Ref 4150701)

Size	PITCH	Tensile Stress Area	CLASS 8.8 METRIC (HEX/SOCKET HEAD) BOLTS CLASS 8 METRIC NUTS				CLASS 10.9 METRIC (HEX HEAD) BOLTS CLASS 10 METRIC NUTS CLASS 12.9 SOCKET HEAD CAP SCREWS M6 AND ABOVE*			
			Clamp Load	Torque (Dry or Loctite® 263™) K=0.17	Torque (Loctite® 262™ OR Vibra-TITE™ 131) K=0.16	Torque (Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140) K=0.15	Clamp Load	Torque (Dry or Loctite® 263™) K = 0.17	Torque (Lub OR Loctite® 242™ or 271™ OR Vibra-TITE™ 111 or 140) K= 0.16	Torque (Loctite® 262™ OR Vibra-TITE™ 131) K=0.15
		Sq mm	KN	[N.m]	[N.m]	[N.m]	KN	[N.m]	[N.m]	[N.m]
3	0.5	5.03	2.19	1.1	1.1	1.0	3.13			
3.5	0.6	6.78	2.95	1.8	1.7	1.5	4.22			
4	0.7	8.78	3.82	2.6	2.4	2.3	5.47			
5	0.8	14.20	6.18	5.3	4.9	4.6	8.85			
6	1	20.10	8.74	9	8.4	7.9	12.5	13	12	11
7	1	28.90	12.6	15	14	13	18.0	21	20	19
8	1.25	36.60	15.9	22	20	19	22.8	31	29	27
10	1.5	58.00	25.2	43	40	38	36.1	61	58	55
12	1.75	84.30	36.7	75	70	66	52.5	105	100	95
14	2	115	50.0	119	110	105	71.6	170	160	150
16	2	157	68.3	186	175	165	97.8	265	250	235
18	2.5	192	83.5	256	240	225	119.5	365	345	325
20	2.5	245	106.5	362	340	320	152.5	520	490	460
22	2.5	303	132.0	494	465	435	189.0	705	665	625
24	3	353	153.5	627	590	555	222.0	905	850	800
27	3	459	199.5	916	860	810	286.0	1315	1235	1160
30	3.5	561	244.0	1245	1170	1100	349.5	1780	1680	1575
33	3.5	694	302.0	1694	1595	1495	432.5	2425	2285	2140
36	4	817	355.5	2176	2050	1920	509.0	3115	2930	2750
42	4.5	1120	487.0	3477	3275	3070	698.0	4985	4690	4395

NO. 5000059 REV. K

'ES: 1. THESE TORQUE VALUES DO NOT APPLY TO CADMIUM PLATED FASTENERS
2. ALL TORQUE VALUES ARE STATIC TORQUE MEASURED PER STANDARD AUDIT METHODS TOLERANCE = ±10%
*3. ASSEMBLY USES HARDENED WASHER OR FASTENER IS PLACED AGAINST PLATED STEEL OR RAW ALUMINUM
4. CLAMP LOAD LISTED FOR SHCS IS SAME AS GRADE 8 OR CLASS 10.9 AND DOES NOT REPRESENT FULL STRENGTH CAPABILITY OF SHCS. IF HIGHER LOAD IS REQUIRED, ADDITIONAL TESTING IS REQUIF

Figure 1-9. Torque Chart (METRIC Fasteners) - Sheet 5 of 5

PARTS FINDER

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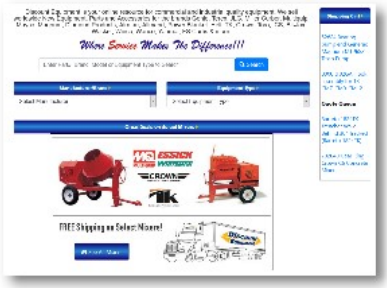

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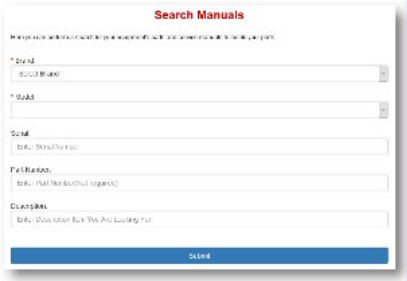

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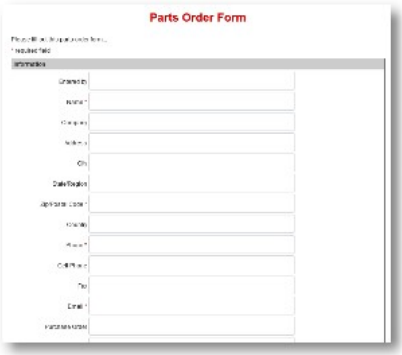

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We sell worldwide for the brands: Genie, Terex, JLG, MultiQuip, Mikasa, Essick, Whiteman, Mayco, Toro Stone, Diamond Products, Generac Magnum, Airman, Haulotte, Barreto, Power Blanket, Nifty Lift, Atlas Copco, Chicago Pneumatic, Allmand, Miller Curber, Skyjack, Lull, Skytrak, Tsurumi, Husquvarna Target, , Stow, Wacker, Sakai, Mi-T- M, Sullair, Basic, Dynapac, MBW, Weber, Bartell, Bennar Newman, Haulotte, Ditch Runner, Menegotti, Morrison, Contec, Buddy, Crown, Edco, Wyco, Bomag, Laymor, Barreto, EZ Trench, Bil-Jax, F.S. Curtis, Gehl Pavers, Heli, Honda, ICS/PowerGrit, IHI, Partner, Imer, Clipper, MMD, Koshin, Rice, CH&E, General Equipment, ,AMida, Coleman, NAC, Gradall, Square Shooter, Kent, Stanley, Tamco, Toku, Hatz, Kohler, Robin, Wisconsin, Northrock, Oztec, Toker TK, Rol-Air, Small Line, Wanco, Yanmar

SECTION 2. GENERAL

2.1 MACHINE PREPARATION, INSPECTION, AND MAINTENANCE

General

This section provides the necessary information needed by those personnel that are responsible to place the machine in operation readiness and maintain its safe operating condition. For maximum service life and safe operation, ensure that all the necessary inspections and maintenance have been completed before placing the machine into service.

Preparation, Inspection, and Maintenance

It is important to establish and conform to a comprehensive inspection and preventive maintenance program. The following table outlines the periodic machine inspections and maintenance recommended by JLG Industries, Inc. Consult your national, regional, or local regulations for further requirements for aerial work platforms. The frequency of inspections and maintenance must be increased as environment, severity and frequency of usage requires.

Pre-Start Inspection

It is the User's or Operator's primary responsibility to perform a Pre-Start Inspection of the machine prior to use daily or at each change of operator. Reference the Operator's and Safety Manual for completion procedures for the Pre-Start Inspection. The Operator and Safety Manual must be read in its entirety and understood prior to performing the Pre-Start Inspection.

Pre-Delivery Inspection and Frequent Inspection

The Pre-Delivery Inspection and Frequent Inspection shall be performed by a qualified JLG equipment mechanic. JLG Industries, Inc. recognizes a qualified JLG equipment mechanic as a person who, by possession of a recognized degree, certificate, extensive knowledge, training, or experience, has successfully demonstrated the ability and proficiency to service, repair, and maintain the subject JLG product model.

The Pre-Delivery Inspection and Frequent Inspection procedures are performed in the same manner, but at different times. The Pre-Delivery Inspection shall be performed prior to each sale, lease, or rental delivery. The Frequent Inspection shall be accomplished for each machine in service for 3 months or 150 hours (whichever comes first); out of service for a period of more than 3 months; or when purchased used. The frequency of this inspection must be increased as environment, severity and frequency of usage requires.

Reference the JLG Pre-Delivery and Frequent Inspection Form and the Inspection and Preventative Maintenance Schedule for items requiring inspection during the performance of these inspections. Reference the appropriate areas of this manual for servicing and maintenance procedures.

Annual Machine Inspection

The Annual Machine Inspection must be performed on an annual basis, no later than thirteen (13) months from the date of the prior Annual Machine Inspection. JLG Industries recommends this task be performed by a Factory Trained Service Technician. JLG Industries, Inc. recognizes a Factory-Trained Service Technician as a person who has successfully completed the JLG Service Training School for the subject JLG product model. Reference the machine Service and Maintenance Manual and appropriate JLG inspection form for performance of this inspection.

Reference the JLG Annual Machine Inspection Form and the Inspection and Preventative Maintenance Schedule for items requiring inspection during the performance of this inspection. Reference the appropriate areas of this manual for servicing and maintenance procedures.

For the purpose of receiving safety-related bulletins, it is important that JLG Industries, Inc. has updated ownership information for each machine. When performing each Annual Machine Inspection, notify JLG Industries, Inc. of the current machine ownership.

Preventative Maintenance

In conjunction with the specified inspections, maintenance shall be performed by a qualified JLG equipment mechanic. JLG Industries, Inc. recognizes a qualified JLG equipment mechanic as a person who, by possession of a recognized degree, certificate, extensive knowledge, training, or experience, has successfully demonstrated the ability and proficiency to service, repair, and maintain the subject JLG product model.

Reference the Preventative Maintenance Schedule and the appropriate areas of this manual for servicing and maintenance procedures. The frequency of service and maintenance must be increased as environment, severity and frequency of usage requires.

Table 2-1. Inspection and Maintenance

Type	Frequency	Primary Responsibility	Service Qualification	Reference
Pre-Start Inspection	Prior to use each day; or At each Operator change.	User or Operator	User or Operator	Operation and Safety Manual
Pre-Delivery Inspection	Prior to each sale, lease, or rental delivery.	Owner, Dealer, or User	Qualified JLG Mechanic	Service and Maintenance Manual and applicable JLG inspection form.
Frequent Inspection	In service for 3 months or 150 hours, whichever comes first; or Out of service for a period of more than 3 months; or purchased used.	Owner, Dealer, or User	Qualified JLG Mechanic	Service and Maintenance Manual and applicable JLG inspection form.
Annual Machine Inspection	Annually, no later than 13 months from the date of the prior inspection.	Owner, Dealer, or User	Factory Trained Service Technician (Recommended)	Service and Maintenance Manual and applicable JLG inspection form.
Preventative Maintenance	At intervals as specified in the Service and Maintenance Manual.	Owner, Dealer, or User	Qualified JLG Mechanic	Service and Maintenance Manual

2.2 SERVICE AND GUIDELINES

General

The following information is provided to assist you in the use and application of servicing and maintenance procedures contained in this book.

Safety and Workmanship

Your safety, and that of others, is the first consideration when engaging in the maintenance of equipment. Always be conscious of weight. Never attempt to move heavy parts without the aid of a mechanical device. Do not allow heavy objects to rest in an unstable position. When raising a portion of the equipment, ensure that adequate support is provided.

Cleanliness

1. The most important single item in preserving the long service life of a machine is to keep dirt and foreign materials out of the vital components. Precautions have been taken to safeguard against this. Shields, covers, seals, and filters are provided to keep air, fuel, and oil supplies clean; however, these items must be maintained on a scheduled basis in order to function properly.
2. At any time when air, fuel, or oil lines are disconnected, clear adjacent areas as well as the openings and fittings themselves. As soon as a line or component is disconnected, cap or cover all openings to prevent entry of foreign matter.
3. Clean and inspect all parts during servicing or maintenance, and assure that all passages and openings are unobstructed. Cover all parts to keep them clean. Be sure all parts are clean before they are installed. New parts should remain in their containers until they are ready to be used.

Components Removal and Installation

1. Use adjustable lifting devices, whenever possible, if mechanical assistance is required. All slings (chains, cables, etc.) should be parallel to each other and as near perpendicular as possible to top of part being lifted.
2. Should it be necessary to remove a component on an angle, keep in mind that the capacity of an eyebolt or similar bracket lessens, as the angle between the supporting structure and the component becomes less than 90 degrees.
3. If a part resists removal, check to see whether all nuts, bolts, cables, brackets, wiring, etc., have been removed and that no adjacent parts are interfering.

Component Disassembly and Reassembly

When disassembling or reassembling a component, complete the procedural steps in sequence. Do not partially disassemble or assemble one part, then start on another. Always recheck your work to assure that nothing has been overlooked. Do not make any adjustments, other than those recommended, without obtaining proper approval.

Pressure-Fit Parts

When assembling pressure-fit parts, use a molybdenum disulfide base compound or equivalent to lubricate the mating surface.

Bearings

1. When a bearing is removed, cover it to keep out dirt and abrasives. Clean bearings in nonflammable cleaning solvent and allow to drip dry. Compressed air can be used but do not spin the bearing.
2. Discard bearings if the races and balls (or rollers) are pitted, scored, or burned.
3. If bearing is found to be serviceable, apply a light coat of oil and wrap it in clean (waxed) paper. Do not unwrap reusable or new bearings until they are ready to install.
4. Lubricate new or used serviceable bearings before installation. When pressing a bearing into a retainer or bore, apply pressure to the outer race. If the bearing is to be installed on a shaft, apply pressure to the inner race.

Gaskets

Check that holes in gaskets align with openings in the mating parts. If it becomes necessary to hand-fabricate a gasket, use gasket material or stock of equivalent material and thickness. Be sure to cut holes in the right location, as blank gaskets can cause serious system damage.

Bolt Usage and Torque Application

NOTICE

SELF LOCKING FASTENERS, SUCH AS NYLON INSERT AND THREAD DEFORMING LOCKNUTS, ARE NOT INTENDED TO BE REINSTALLED AFTER REMOVAL.

1. Always use new replacement hardware when installing locking fasteners. Use bolts of proper length. A bolt which is too long will bottom before the head is tight against its related part. If a bolt is too short, there will not be enough thread area to engage and hold the part properly. When replacing bolts, use only those having the same specifications of the original, or one which is equivalent.
2. Unless specific torque requirements are given within the text, standard torque values should be used on heat-treated bolts, studs, and steel nuts, in accordance with recommended shop practices. (See Torque Chart Section 1.)

Hydraulic Lines and Electrical Wiring

Clearly mark or tag hydraulic lines and electrical wiring, as well as their receptacles, when disconnecting or removing them from the unit. This will assure that they are correctly reinstalled.

Hydraulic System

1. Keep the system clean. If evidence of metal or rubber particles are found in the hydraulic system, drain and flush the entire system.
2. Disassemble and reassemble parts on clean work surface. Clean all metal parts with non-flammable cleaning solvent. Lubricate components, as required, to aid assembly.

Lubrication

Service applicable components with the amount, type, and grade of lubricant recommended in this manual, at the specified intervals. When recommended lubricants are not available, consult your local supplier for an equivalent that meets or exceeds the specifications listed.

Battery

Clean battery using a non-metallic brush and a solution of baking soda and water. Rinse with clean water. After cleaning, thoroughly dry battery and coat terminals with an anti corrosion compound.

Lubrication and Servicing

Components and assemblies requiring lubrication and servicing are shown in the Lubrication Chart in Section 1.

2.3 LUBRICATION AND INFORMATION

Hydraulic System

1. The primary enemy of a hydraulic system is contamination. Contaminants enter the system by various means, e.g., using inadequate hydraulic oil, allowing moisture, grease, filings, sealing components, sand, etc., to enter when performing maintenance, or by permitting the pump to cavitate due to insufficient system warm-up or leaks in the pump supply (suction) lines.

2. The design and manufacturing tolerances of the component working parts are very close, therefore, even the smallest amount of dirt or foreign matter entering a system can cause wear or damage to the components and generally results in faulty operation. Every precaution must be taken to keep hydraulic oil clean, including reserve oil in storage. Hydraulic system filters should be checked, cleaned, and/or replaced as necessary, at the specified intervals required in the Lubrication Chart in Section 1. Always examine filters for evidence of metal particles.

3. Cloudy oils indicate a high moisture content which permits organic growth, resulting in oxidation or corrosion. If this condition occurs, the system must be drained, flushed, and refilled with clean oil.

4. It is not advisable to mix oils of different brands or types, as they may not contain the same required additives or be of comparable viscosities. Good grade mineral oils, with viscosities suited to the ambient temperatures in which the machine is operating, are recommended for use.

NOTE: *Metal particles may appear in the oil or filters of new machines due to the wear-in of meshing components.*

Hydraulic Oil

Refer to Section 1 for recommendations for viscosity ranges.

Changing Hydraulic Oil

1. Filter elements must be changed after the first 50 hours of operation and every 300 hours (unless specified otherwise) thereafter. If it is necessary to change the oil, use only those oils meeting or exceeding the specifications appearing in this manual. If unable to obtain the same type of oil supplied with the machine, consult local supplier for assistance in selecting the proper equivalent. Avoid mixing petroleum and synthetic base oils.

2. Use every precaution to keep the hydraulic oil clean. If the oil must be poured from the original container into another, be sure to clean all possible contaminants from the service container. Always clean the mesh element of the filter and replace the cartridge any time the system oil is changed.

3. While the unit is shut down, a good preventive maintenance measure is to make a thorough inspection of all hydraulic components, lines, fittings, etc., as well as a functional check of each system, before placing the machine back in service.

Lubrication Specifications

Specified lubricants, as recommended by the component manufacturers, are always the best choice, however, multi-purpose greases usually have the qualities which meet a variety of single purpose grease requirements. Should any question arise, regarding the use of greases in maintenance stock, consult your local supplier for evaluation. Refer to Section 1 for an explanation of the lubricant key designations appearing in the Lubrication Chart.

2.4 CYLINDER DRIFT

Theory

When a hydraulic cylinder is supporting a load, cylinder drift may occur as a result of any of the circumstances below:

- Normal leakage of load holding valves or malfunction of load holding valves. See Cylinder Leakage Test and Table 2-2, Cylinder Drift below for evaluation.
- Damaged or worn piston seal.
- Normal thermal expansion and contraction of the hydraulic oil within cylinders (See Cylinder Thermal Drift below).

The first two circumstances may result in cylinder movement due to oil leakage out of the cylinder externally or by leaking back to tank or due to oil leaking internally from one cylinder chamber to the other.

Thermal expansion or contraction of oil in hydraulic cylinders is a normal occurrence and does not result in oil leaking out of the cylinder or leaking internally from one cylinder chamber to the other. Thermal expansion or contraction is the tendency for materials to change size in response to a change in temperature.

Cylinder Leakage Test

Cylinder oil must be at stabilized ambient temperature before beginning this test.

Measure drift at cylinder rod with a calibrated dial indicator.

In an area free of obstructions, cylinder must have load applied and appropriately positioned to detect drift.

Cylinder leakage is acceptable if it passes this test.

Table 2-2. Cylinder Drift

Cylinder Bore Diameter		Max. Acceptable Drift in 10 Minutes	
inches	mm	inches	mm
3	76.2	0.026	0.66
3.5	89	0.019	0.48
4	101.6	0.015	0.38
5	127	0.009	0.22
6	152.4	0.006	0.15
7	177.8	0.005	0.13
8	203.2	0.004	0.10
9	228.6	0.003	0.08

NOTE: *This information is based on 6 drops per minute cylinder* leakage.

Cylinder Thermal Drift

The oil in all hydraulic cylinders will expand or contract due to thermal effects over time and may result in changes to the boom and/or platform position while the machine is stationary. These effects occur as the cylinder oil changes temperature, usually from a higher oil temperature as it cools and approaches the ambient air temperature. Results of these effects are related to several factors including cylinder length and change in temperature over the time the cylinder remains stationary.

2.5 PINS AND COMPOSITE BEARING REPAIR GUIDELINES

Filament wound bearings.

1. Pinned joints should be disassembled and inspected if the following occurs:
   a. Excessive sloppiness in joints.
   b. Noise originating from the joint during operation.
2. Filament wound bearings should be replaced if any of the following is observed:
   a. Frayed or separated fibers on the liner surface.
   b. Cracked or damaged liner backing.
   c. Bearings that have moved or spun in their housing.
   d. Debris embedded in liner surface.
3. Pins should be replaced if any of the following is observed (pin should be properly cleaned prior to inspection):
   a. Detectable wear in the bearing area.
   b. Flaking, pealing, scoring, or scratches on the pin surface.
   c. Rusting of the pin in the bearing area.
4. Re-assembly of pinned joints using filament wound bearings.
   a. Housing should be blown out to remove all dirt and debris. Bearings and bearing housings must be free of all contamination.
   b. Bearing / pins should be cleaned with a solvent to remove all grease and oil. Filament wound bearing are a dry joint and should not be lubricated.
   c. Pins should be inspected to ensure it is free of burrs, nicks, and scratches which would damage the bearing during installation and operation.

2.6 WELDING ON JLG EQUIPMENT

NOTE: *This instruction applies to repairs, or modifications to the machine and to welding performed from the machine on an external structure, or component,*

Do the Following When Welding on JLG Equipment

- Disconnect the battery.
- Disconnect the moment pin connection (where fitted).
- Ground only to structure being welded.

Do NOT Do the Following When Welding on JLG Equipment

- Ground on frame and weld on any other area than the chassis.
- Ground on turntable and weld on any other area than the turntable.
- Ground on the platform/support and weld on any other area than the platform/support.
- Ground on a specific boom section and weld on any other area than that specific boom section.
- Allow pins, wear pads, wire ropes, bearings, gearing, seals, valves, electrical wiring, or hoses to be between the grounding position and the welded area.

NOTICE

FAILURE TO COMPLY WITH THE ABOVE REQUIREMENTS MAY RESULT IN COMPONENT DAMAGE (I.E. ELECTRONIC MODULES, SWING BEARING, COLLECTOR RING, BOOM WIRE ROPES ETC.)

Table 2-3. Inspection and Preventive Maintenance Schedule

AREA	INTERVAL		
	Pre-Delivery[1] or Frequent[2] Inspection	Annual[3] (Yearly) Inspection	Every 2 Years
Boom Assembly			
Boom Weldments	1,2,4	1,2,4	
Hose/Cable Carrier Installations	1,2,9,12	1,2,9,12	
Pivot Pins and Pin Retainers	1,2	1,2	
Sheaves, Sheave Pins	1,2	1,2	
Bearings	1,2	1,2	
Wear Pads	1,2	1,2	
Covers or Shields	1,2	1,2	
Extend/Retract Chain or Cable Systems	1,2,3	1,2,3	
Boom Assembly	1,2,3,4,5	1,2,3,4,5,7,9,14	
Platform Assembly			
Platform		1,2	
Railing	1	1,2	
Gate	1,5	1,5	
Floor	1	1,2	
Rotator	5,9,15	5,9,15	
Lanyard Anchorage Point	1,2,10	1,2,10	
Turntable Assembly			
Swing Bearing	1,2,14	1,2,3,13,14	
Oil Coupling	9	9	
Swing Drive System	11	11	
Turntable Lock	1,2,5	1,2,5	
Hood, Hood Props, Hood Latches	5	1,2,5	
Chassis Assembly			
Tires	16,17,18	16,17,18	
Wheel Nuts/Bolts	15	15	
Wheel Bearings			14,24
Oscillating Axle/Lockout Cylinder Systems	5,8	5,8	
Extendable Axle Systems	5,8	5,8	
Steer Components	1,2	1,2	
Spindle Thrust Bearing/Washers	1,2	1,2	
Drive Hubs	11	11	

Table 2-3. Inspection and Preventive Maintenance Schedule

AREA	INTERVAL		
	Pre-Delivery[1] or Frequent[2] Inspection	Annual[3] (Yearly) Inspection	Every 2 Years
Functions/Controls			
Platform Controls	5,6	6	
Ground Controls	5,6	6	
Function Control Locks, Guards, or Detents	1,5	5	
Footswitch	5	5	
Emergency Stop Switches (Ground & Platform)	5	5	
Function Limit or Cutout Switch Systems	5	5	
Drive Brakes	5	5	
Swing Brakes	5	5	
Auxiliary Power	5	5	
Power System			
Engine Idle, Throttle, and RPM	3	3	
Engine Fluids (Oil, Coolant, Fuel)	9,11	11	
Air/Fuel Filter	1,7	7	
Exhaust System	1,9	9	
Batteries	1,9	19	
Battery Fluid	11	11	
Battery Charger	5	5	
Fuel Reservoir, Cap, and Breather	1,2,5	1,5	
Hydraulic/Electric System			
Hydraulic Pumps	1,2,9	1,2,9	
Hydraulic Cylinders	1,2,7,9	1,2,9	
Cylinder Attachment Pins and Pin Retainers	1,2,9	1,2	
Hydraulic Hoses, Lines, and Fittings	1,2,9,12	1,2,9,12	
Hydraulic Reservoir, Cap, and Breather	1,2,5,9	1,5	24
Hydraulic Filter	1,7,9	7	
Hydraulic Fluid	7,11	7,11	
Electrical Connections	1,20	20	
Instruments, Gauges, Switches, Lights, Horn	1	5,23	
General			
Operation and Safety Manuals in Storage Box	21	21	
ANSI and AEM Manuals/Handbooks Installed (ANSI Markets Only)		21	
Capacity Decals Installed, Secure, Legible	21	21	
All Decals/Placards Installed, Secure, Legible	21	21	

Table 2-3. Inspection and Preventive Maintenance Schedule

AREA	INTERVAL		
	Pre-Delivery[1] or Frequent[2] Inspection	Annual[3] (Yearly) Inspection	Every 2 Years
Annual Machine Inspection Due		21	
No Unauthorized Modifications or Additions	21	21	
All Relevant Safety Publications Incorporated	21	21	
General Structural Condition and Welds	2,4	2,4	
All Fasteners, Pins, Shields, and Covers	1,2	1,2	
Grease and Lubricate to Specifications	22	22	
Function Test of All Systems	21	21, 22	
Paint and Appearance	7	7	
Stamp Inspection Date on Frame		22	
Notify JLG of Machine Ownership		22	

Footnotes:

[1] Prior to each sale, lease, or delivery

[2] In service for 3 months or 150 Hours; or Out of service for 3 months or more; or Purchased used

[3] Annually, no later than 13 months from the date of the prior inspection

Performance Codes:

1 - Check for proper and secure installation
2 - Visual inspection for damage, cracks, distortion or excessive wear
3 - Check for proper adjustment
4 - Check for cracked or broken welds
5 - Operates Properly
6 - Returns to neutral or "off" position when released
7 - Clean and free of debris
8 - Interlocks function properly
9 - Check for signs of leakage
10 - Decals installed and legible
11 - Check for proper fluid level
12 - Check for chafing and proper routing
13 - Check for proper tolerances
14 - Properly lubricated
15 - Torqued to proper specification
16 - No gouges, excessive wear, or cords showing
17 - Properly inflated and seated around rim
18 - Proper and authorized components
19 - Fully charged
20 - No loose connections, corrosion, or abrasions
21 - Verify
22 - Perform
23 - Sealed Properly
24 - Drain, Clean, Refill

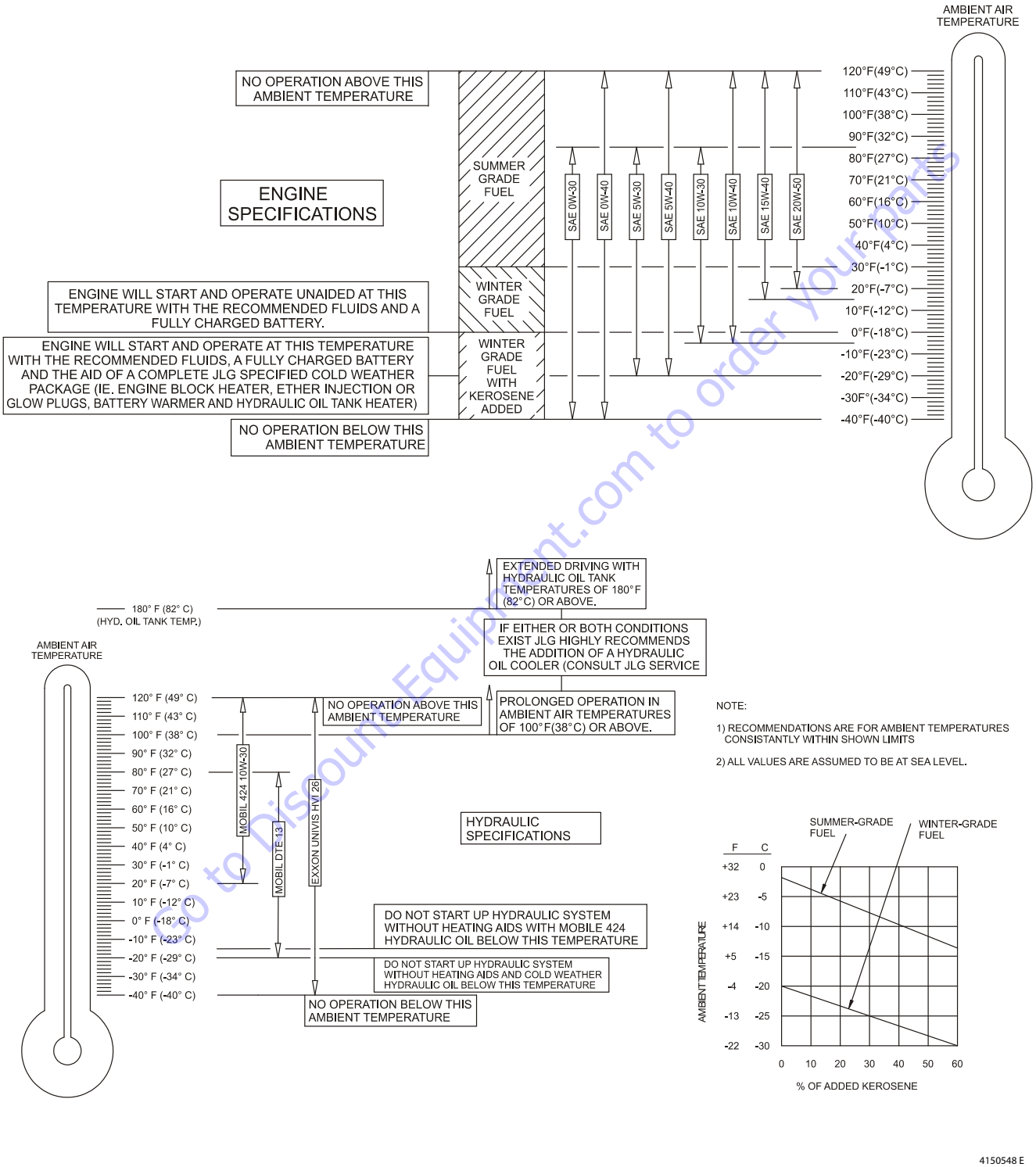


Figure 2-1. Engine Operating Temperature Specifications - Deutz

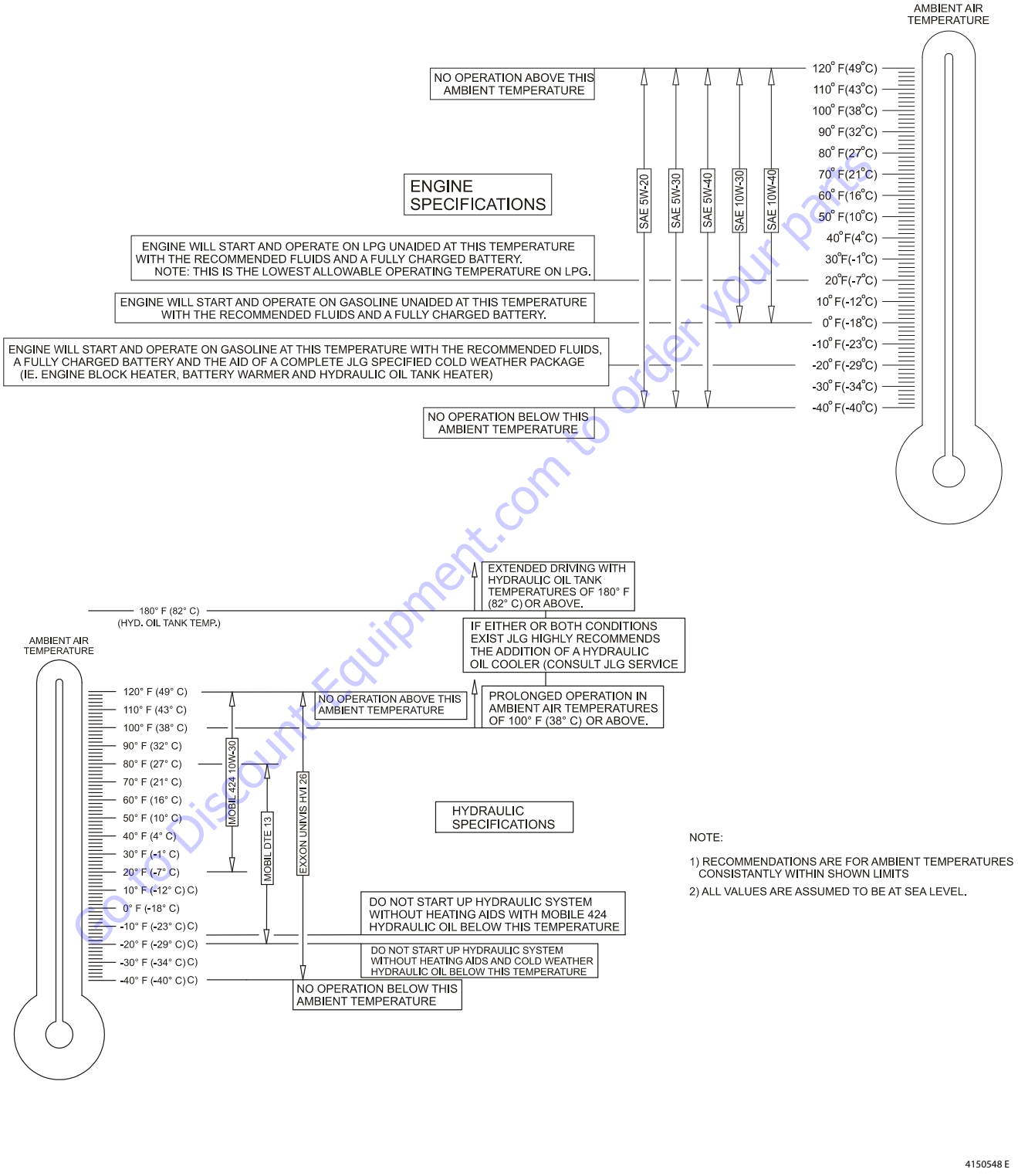


Figure 2-2. Engine Operating Temperature Specifications - Ford

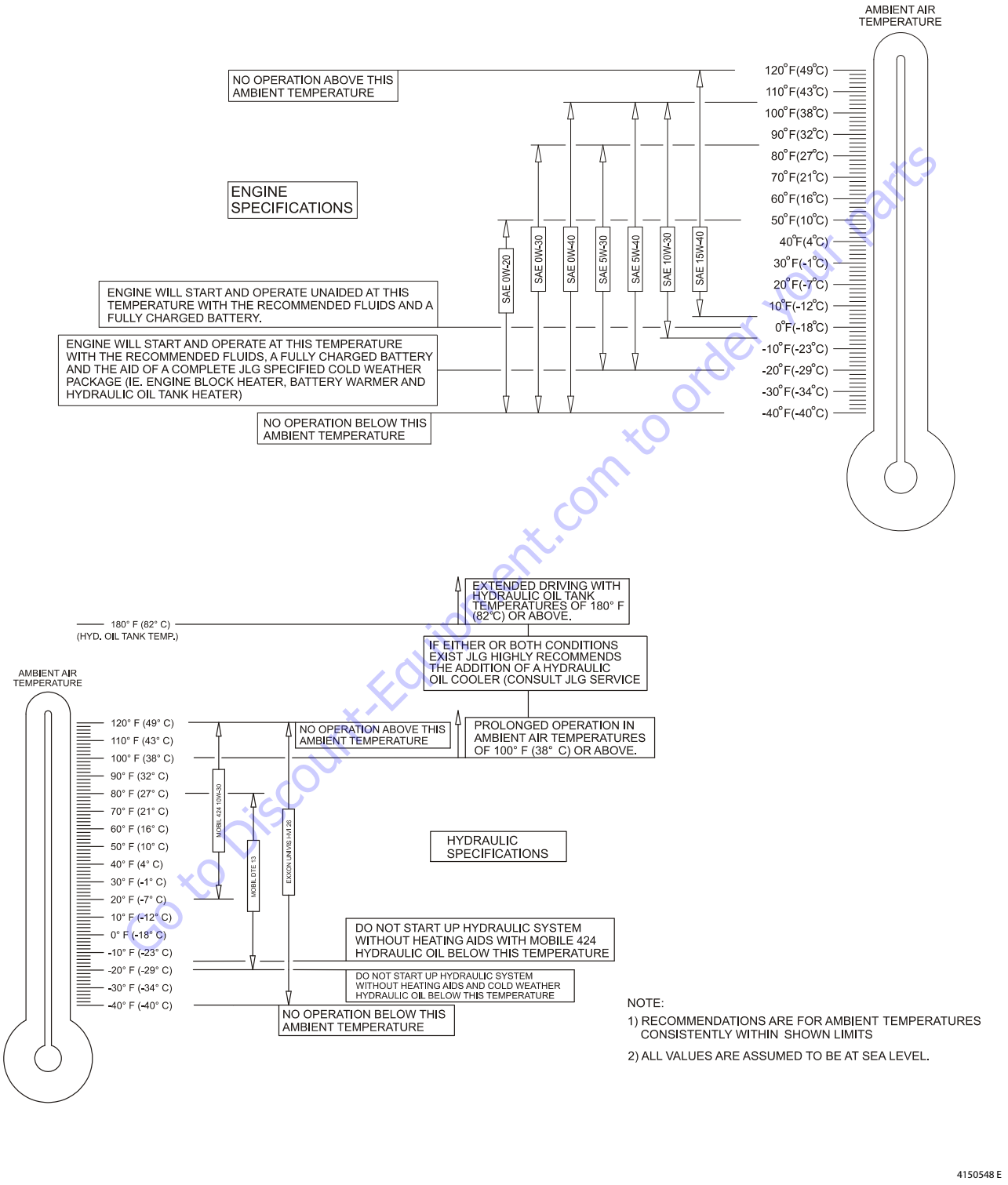


Figure 2-3. Engine Operating Temperature Specifications - Caterpillar

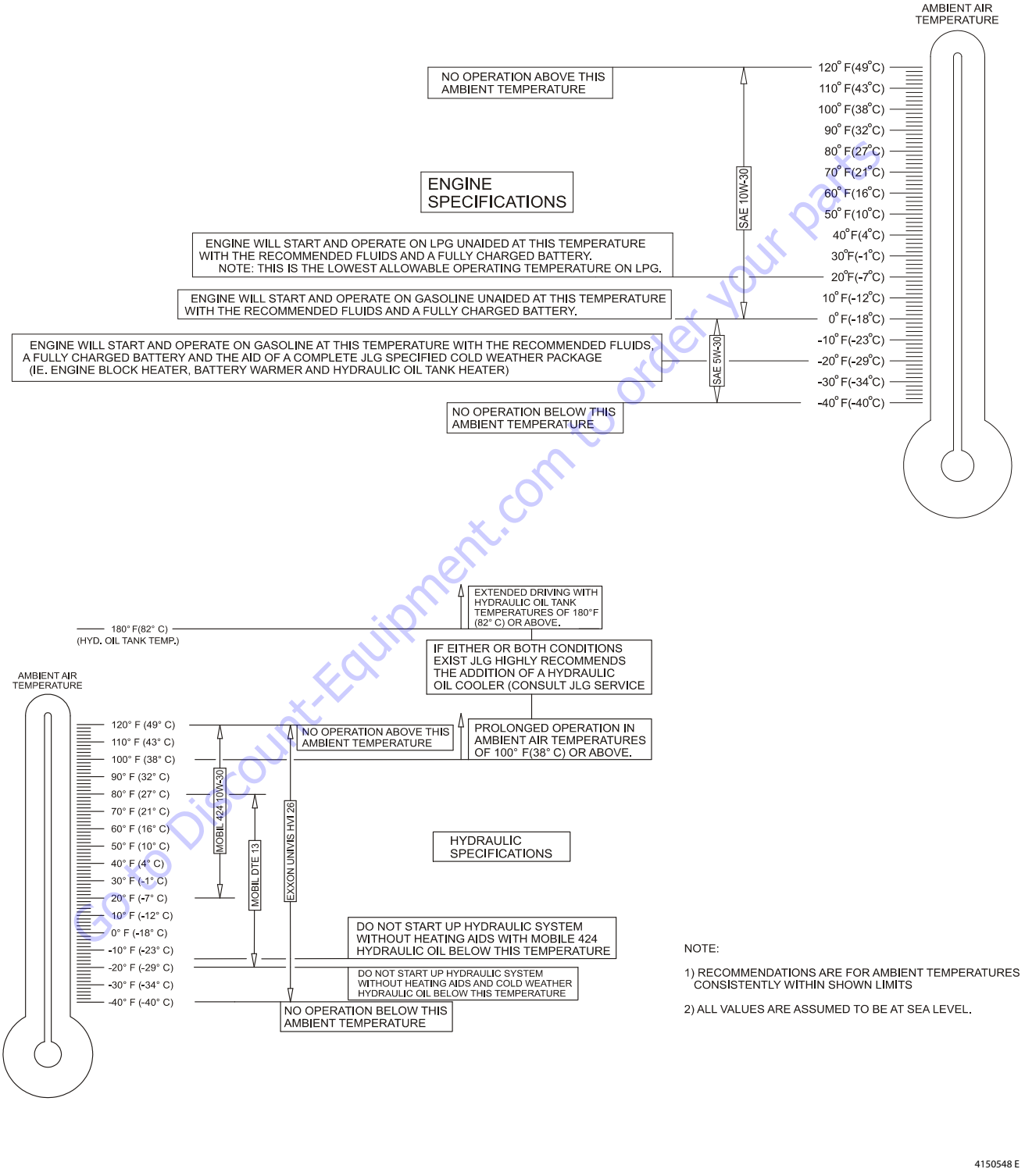
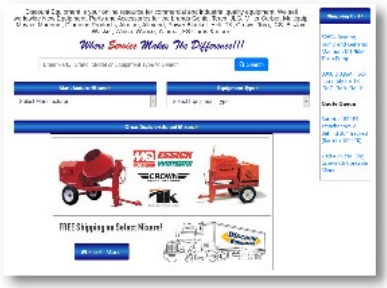


Figure 2-4. Engine Operating Temperature Specifications - GM

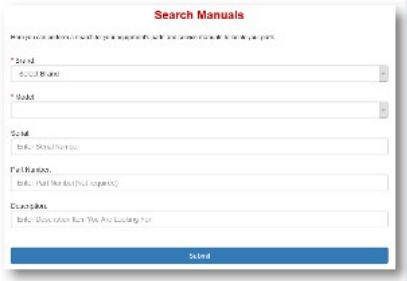
PARTS FINDER

Search Website by Part Number

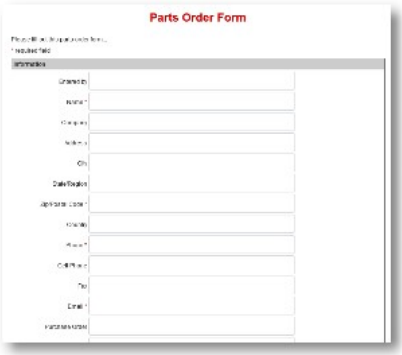
Discount Equipment



Search Manual Library For Parts Manual & Lookup Part Numbers – Purchase or Request Quote



Can't Find Part or Manual? Request Help by Manufacturer, Model & Description



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We sell worldwide for the brands: Genie, Terex, JLG, MultiQuip, Mikasa, Essick, Whiteman, Mayco, Toro Stone, Diamond Products, Generac Magnum, Airman, Haulotte, Barreto, Power Blanket, Nifty Lift, Atlas Copco, Chicago Pneumatic, Allmand, Miller Curber, Skyjack, Lull, Skytrak, Tsurumi, Husquvarna Target, , Stow, Wacker, Sakai, Mi-T- M, Sullair, Basic, Dynapac, MBW, Weber, Bartell, Bennar Newman, Haulotte, Ditch Runner, Menegotti, Morrison, Contec, Buddy, Crown, Edco, Wyco, Bomag, Laymor, Barreto, EZ Trench, Bil-Jax, F.S. Curtis, Gehl Pavers, Heli, Honda, ICS/PowerGrit, IHI, Partner, Imer, Clipper, MMD, Koshin, Rice, CH&E, General Equipment, ,AMida, Coleman, NAC, Gradall, Square Shooter, Kent, Stanley, Tamco, Toku, Hatz, Kohler, Robin, Wisconsin, Northrock, Oztec, Toker TK, Rol-Air, Small Line, Wanco, Yanmar

SECTION 3. CHASSIS & TURNTABLE

3.1 TIRES & WHEELS

Tire Inflation

The air pressure for pneumatic tires must be equal to the air pressure that is stenciled on the side of the JLG product or rim decal for safe and proper operational characteristics.

Tire Damage

For pneumatic tires, JLG Industries, Inc. recommends that when any cut, rip, or tear is discovered that exposes sidewall or tread area cords in the tire, measures must be taken to remove the JLG product from service immediately. Arrangements must be made for replacement of the tire or tire assembly.

For polyurethane foam filled tires, JLG Industries, Inc. recommends that when any of the following are discovered, measures must be taken to remove the JLG product from service immediately and arrangements must be made for replacement of the tire or tire assembly.

- A smooth, even cut through the cord plies which exceeds 3 in. (7.5 cm) in total length.
- Any tears or rips (ragged edges) in the cord plies which exceeds 1 in. (2.5 cm) in any direction.
- Any punctures which exceed 1 in. in diameter.
- Any damage to the bead area cords of the tire.

If a tire is damaged but is within the above noted criteria, the tire must be inspected on a daily basis to ensure the damage has not propagated beyond the allowable criteria.

Tire Replacement

JLG recommends a replacement tire be the same size, ply and brand as originally installed on the machine. Please refer to the JLG Parts Manual for the part number of the approved tires for a particular machine model. If not using a JLG approved replacement tire, we recommend that replacement tires have the following characteristics:

- Equal or greater ply/load rating and size of original.
- Tire tread contact width equal or greater than original.
- Wheel diameter, width, and offset dimensions equal to the original.
- Approved for the application by the tire manufacturer (including inflation pressure and maximum tire load).

Unless specifically approved by JLG Industries Inc. do not replace a foam filled or ballast filled tire assembly with a pneumatic tire. When selecting and installing a replacement tire, ensure that all tires are inflated to the pressure recommended by JLG. Due to size variations between tire brands, both tires on the same axle should be the same.

Wheel Replacement

The rims installed on each product model have been designed for stability requirements which consist of track width, tire pressure, and load capacity. Size changes such as rim width, center piece location, larger or smaller diameter, etc., without written factory recommendations, may result in an unsafe condition regarding stability.

Wheel Installation

It is extremely important to apply and maintain proper wheel mounting torque.

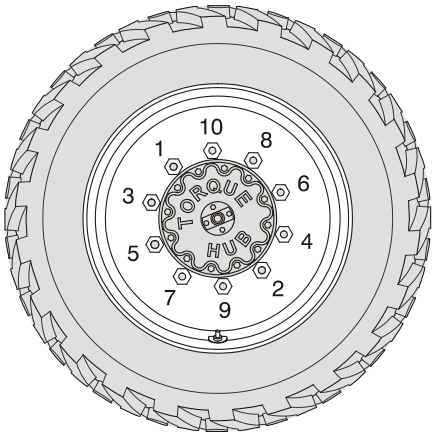
⚠ WARNING

WHEEL NUTS MUST BE INSTALLED AND MAINTAINED AT THE PROPER TORQUE TO PREVENT LOOSE WHEELS, BROKEN STUDS, AND POSSIBLE DANGEROUS SEPARATION OF WHEEL FROM THE AXLE. BE SURE TO USE ONLY THE NUTS MATCHED TO THE CONE ANGLE OF THE WHEEL.

Tighten the lug nuts to the proper torque to prevent wheels from coming loose. Use a torque wrench to tighten the fasteners. If you do not have a torque wrench, tighten the fasteners with a lug wrench, then immediately have a service garage or dealer tighten the lug nuts to the proper torque. Over-tightening will result in breaking the studs or permanently deforming the mounting stud holes in the wheels. The proper procedure for attaching wheels is as follows:

1. Tighten all nuts by hand to prevent cross threading. DO NOT use a lubricant on threads or nuts.

2. Tighten nuts in the following sequence:



3. The tightening of the nuts should be done in stages. Following the recommended sequence, tighten nuts per wheel torque chart.

Table 3-1. Wheel Torque Chart

TORQUE SEQUENCE		
1st Stage	2nd Stage	3rd Stage
70 ft. lbs. (95 Nm)	170 ft. lbs. (225 Nm)	300 ft. lbs. (405 Nm)

4. Wheel nuts should be torqued after first 50 hours of operation and after each wheel removal. Check torque every 3 months or 150 hours of operation.

3.2 LOCKOUT CYLINDER BLEEDING

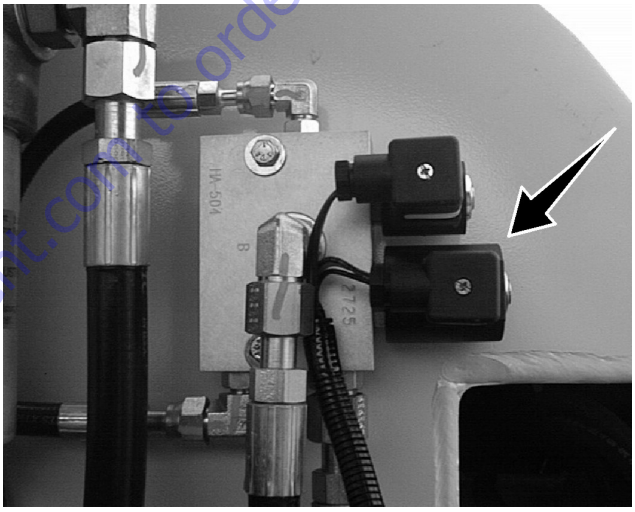
NOTICE

ENSURE PLATFORM IS FULLY LOWERED AND BOOM IS CENTERED OVER REAR AXLE PRIOR TO BEGINNING BLEEDING PROCEDURE.

NOTICE

ENSURE MACHINE IS ON A LEVEL SURFACE AND REAR WHEELS ARE BLOCKED, BRAKE WIRE IS DISCONNECTED.

1. Make sure machine is on a level surface.
2. Center boom over rear axle to make sure the cam valve in the rotary coupling is depressed.
3. Place chocks under the tires to ensure the machine does not move. Disable the machine brakes by disconnecting the brake solenoid on the dual select valve.



4. Use suitable containers to catch any excess hydraulic fluid. Place the containers under each lockout cylinder.
5. Open one bleeder screws at a time.
6. Start the engine, position drive control lever on the main hydraulic pump forward or reverse.
7. Close bleeder screws when all air is dissipated (bled).
8. Reconnect the brake solenoid and remove the wheel chocks.
9. Perform oscillating axle lockout test.
10. If necessary, repeat steps 1 through 7.

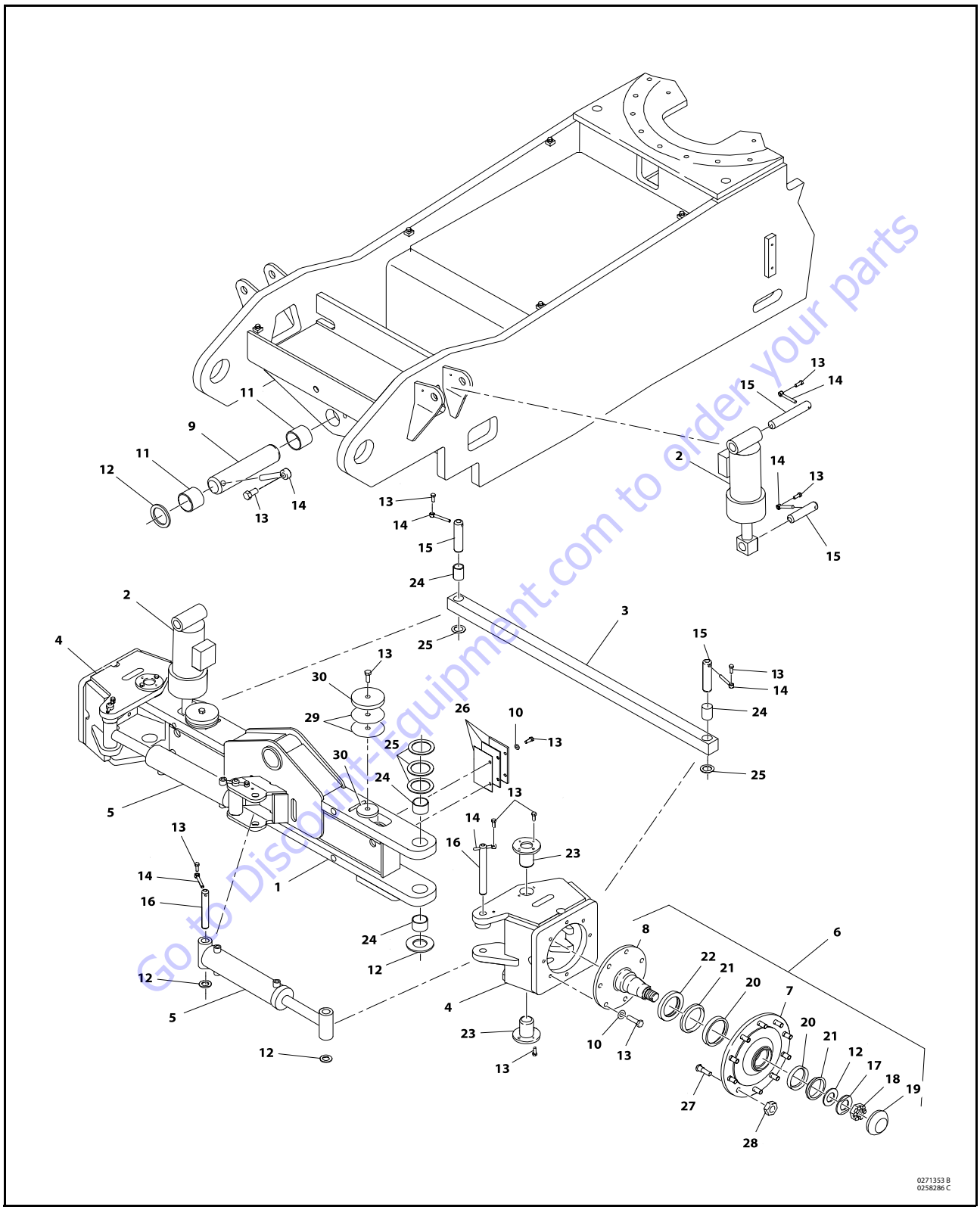


Figure 3-1. Axle and Steering Installation without Tow Package - Sheet 1 of 2

1. Axle Weldment
2. Lockout Cylinder Assembly
3. Tie Rod
4. Spindle Weldment
5. Steer Cylinder Assembly
6. Hub Assembly
7. Housing
8. Spindle
9. Pivot Pin
10. Washer
11. Bushing
12. Washer
13. Bolt
14. Keeper Pin
15. Tie Rod Pin
16. Attach Pin
17. Tanged Washer
18. Bearing Nut
19. Dust Cap
20. Cup Bearing
21. Cone Bearing
22. Lip Seal
23. King Pin
24. Bearing
25. Washer
26. Wear Shim
27. Stud
28. Lugnut
29. Shim
30. Stop Plate

Figure 3-2. Axle and Steering Installation without Tow Package - Sheet 2 of 2

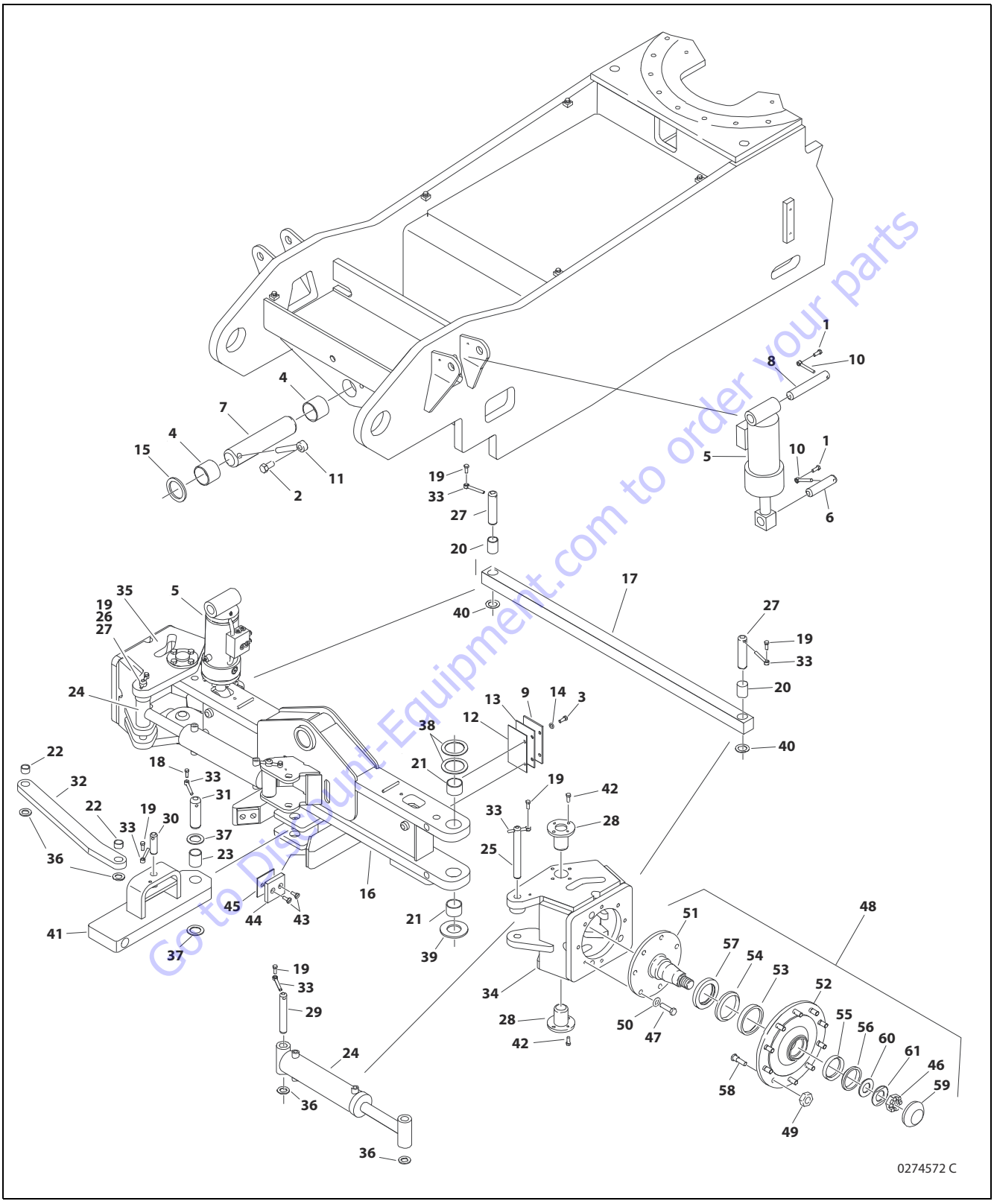


Figure 3-3. Axle and Steering Installation with Tow Package- Sheet 1 of 2

1. Bolt
2. Bolt
3. Bolt
4. Garmax Bushing
5. Lockout Cylinder Assembly
6. Pin
7. Main Pivot Pin
8. Pin
9. Axle Wear Shim
10. Keeper Shaft
11. Keeper Shaft
12. Axle Wear Shim
13. Axle Wear Shim
14. Flatwasher
15. Special Washer
16. Axle Weldment
17. Tie Rod
18. Bolt
19. Bolt
20. Garmax Bearing
21. Bearing
22. Garmax Bearing
23. Garmax Bearing
24. Steer Cylinder Assembly
25. Steer Spindle Attach Pin (RH)
26. Steer Spindle Attach Pin (LH)
27. Tie Rod Pin
28. Kingpin
29. Attach Pin
30. Pin
31. Hitch Pin
32. Connecting link
33. Keeper Shaft
34. Spindle Weldment (LH)
35. Spindle Weldment (RH)
36. Special Washer
37. Thrustwasher
38. Thrustwasher
39. Thrustwasher
40. Special Washer
41. Pivot Bar
42. Bolt
43. Screw
44. Stop pad
45. Shim
46. Bearing Nut
47. Bolt
48. Hub Assembly
49. Lugnut
50. Flatwasher
51. Spindle
52. Housing
53. Inner Bearing Cup
54. Inner Bearing Cone
55. Outer Bearing Cup
56. Outer Bearing Cone
57. Lip Seal
58. Stud
59. Dust Cap
60. Special Washer
61. Tanged Washer

Figure 3-4. Axle and Steering Installation with Tow Package - Sheet 2 of 2

3.3 OSCILLATING AXLE LOCKOUT TEST

NOTICE

LOCKOUT SYSTEM TEST MUST BE PERFORMED QUARTERLY, ANY TIME A SYSTEM COMPONENT IS REPLACED, OR WHEN IMPROPER SYSTEM OPERATION IS SUSPECTED.

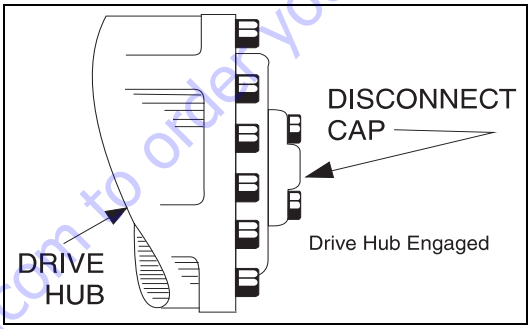
NOTE: *Ensure boom is fully retracted, lowered, and centered between drive wheels prior to beginning lockout cylinder test.*

1. Place a 6 in. (15.2 cm) high block with ascension ramp in front of left front wheel.
2. From platform control station, activate machine hydraulic system.
3. Place FUNCTION SPEED CONTROL and DRIVE SPEED/ TORQUE SELECT control switches to their respective LOW positions.
4. Place DRIVE control lever to FORWARD position and carefully drive machine up ascension ramp until left front wheel is on top of block.
5. Carefully activate SWING control lever and position boom over right side of machine.
6. With boom over right side of machine, place DRIVE control lever to REVERSE and drive machine off of block and ramp.
7. Have an assistant check to see that left front wheel remains locked in position off of ground.
8. Carefully activate SWING control lever and return boom to stowed position (centered between drive wheels). When boom reaches center, stowed position, lockout cylinders should release and allow wheel to rest on ground, it may be necessary activate DRIVE to release cylinders.
9. Place the 6 in. (15.2 cm) high block with ascension ramp in front of right front wheel.
10. Place DRIVE control lever to FORWARD and carefully drive machine up ascension ramp until right front wheel is on top of block.
11. Carefully activate SWING control lever and position boom over left side of machine.
12. With boom over left side of machine, place DRIVE control lever to REVERSE and drive machine off of block and ramp.
13. Have an assistant check to see that right front wheel remains locked in position off of ground.
14. Carefully activate SWING control lever and return boom to stowed position (centered between drive wheels). When boom reaches center, stowed position, lockout cylinders should release and allow wheel to rest on ground, it may be necessary activate DRIVE to release cylinders.
15. If lockout cylinders do not function properly, have qualified personnel correct the malfunction prior to any further operation.

3.4 FREE WHEELING OPTION

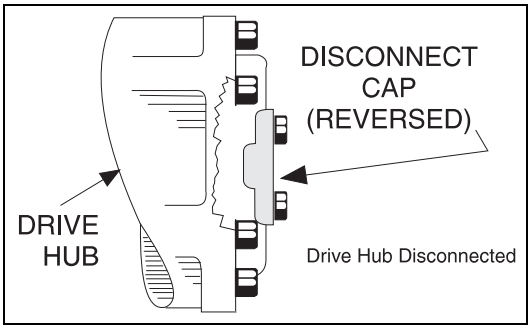
To Disengage Drive Motors and Brakes (Free Wheel) for Emergency Towing

1. Chock wheels securely if not on flat level surface.
2. Disconnect both drive hubs by reversing the disconnect caps in the center of the hubs.
3. If equipped, move steer/tow selector valve to float (tow) position by pulling control knob out.



To Engage Drive Motors and Brakes (Normal Operation)

1. If equipped, move steer/tow valve to steer position by pushing valve knob in.
2. Connect both drive hubs by inverting disconnect cap in center of hub.
3. Remove chocks from wheels as required.



3.5 WHEEL DRIVE ASSEMBLY, 2WD (PRIOR TO SN 0300083331)

Removal

NOTE: *The drive motor and/or drive brake can be removed through the axle flange as part of the wheel drive assembly or they can be removed separately through the bottom of the frame while leaving the drive hub bolted to the axle.*

1. Use a jack to lift the frame enough so the tire and wheel assembly is off of the ground. Place blocking strong enough to support the weight of the machine under the frame and remove the jack.

NOTE: *The pneumatic tire & wheel assembly weighs approximately 269 lbs. (122 kg). The foam-filled tire & wheel assembly weighs approximately 544 lbs. (247.25 kg).*

2. Remove the tire and wheel assembly.
3. Through the access holes in the axle, tag and disconnect the hydraulic lines running to the drive motor and drive brake. Cap or plug all openings to ensure no dirt enters the hydraulic system.

NOTE: *The drive hub, drive brake, and drive motor assembly weighs approximately 275 lbs. (125 kg).*

4. Use a supporting device capable of handling the weight of the drive hub, drive brake, and drive motor and unbolt the drive hub from the frame. Remove the entire assembly from the machine.
5. Remove the nuts and washers that secure the drive motor to the drive hub and drive brake and remove the drive motor. Remove and discard the o-ring between the drive motor and drive brake.
6. Remove the drive brake from the drive hub. Remove and discard the o-ring between the drive brake and drive hub.
7. If necessary, remove the studs from the drive hub.

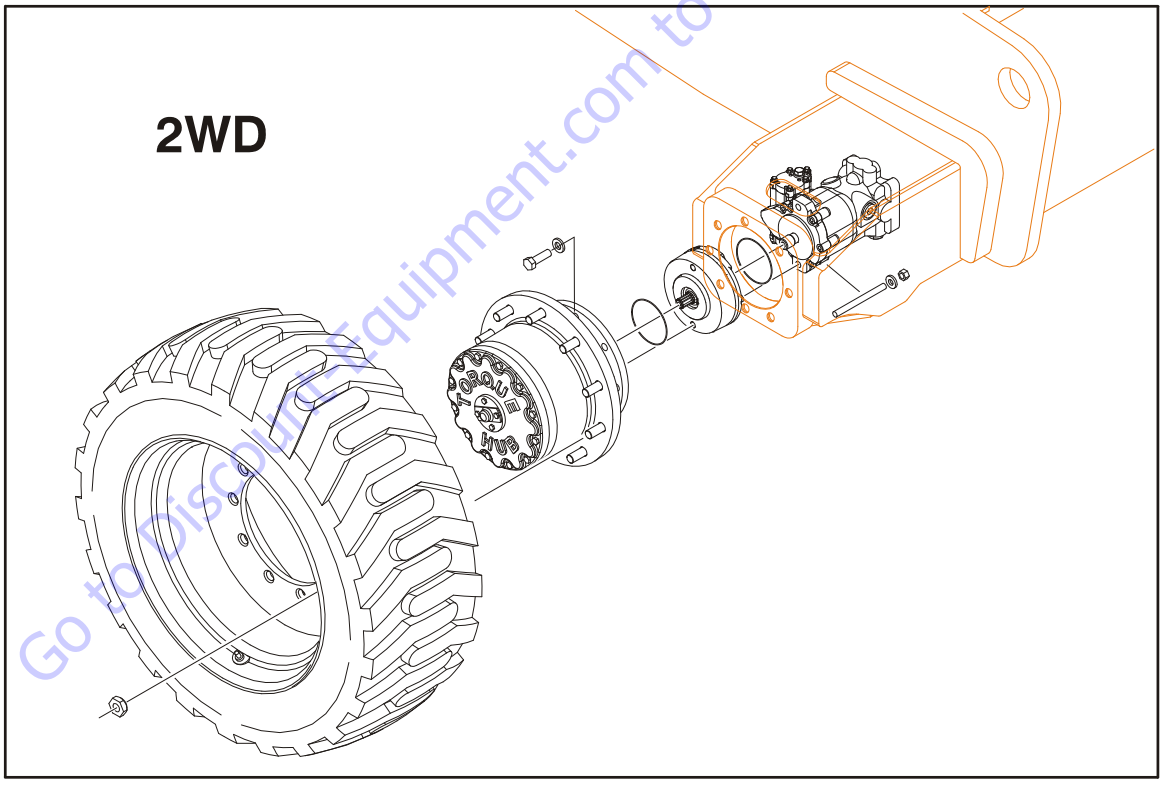
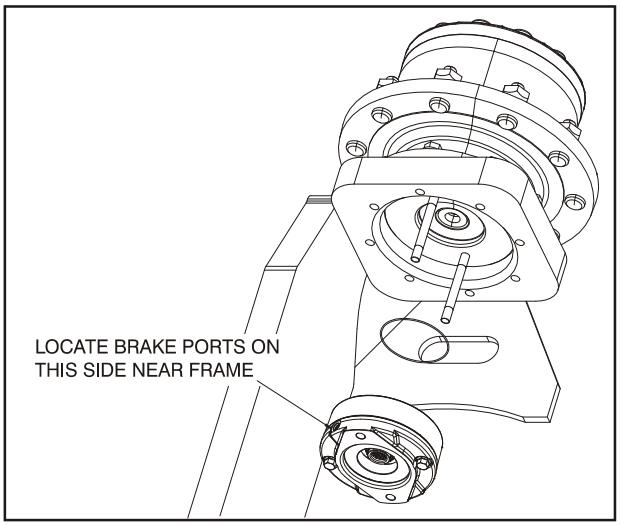


Figure 3-5. Drive Hub Installation - 2WD (Prior to SN 0300083331)

Installation

1. If re-installing the existing studs or installing new ones, coat the threads of the studs with JLG Threadlocker P/N 0100011 before screwing them into the drive hub.
2. Install a new o-ring between the drive brake and drive hub and slide the drive brake over the studs with the brake port positioned as shown.



3. Install a new o-ring between the drive brake and drive motor and slide the drive motor over the studs. Install the washers and nuts to secure the assembly together and torque the nuts to 75 ft. lbs. (102 Nm).
4. Place the drive hub flange against the mounting flange on the axle and fasten it in place with the bolts and washers. Torque the bolts to 220 ft. lbs. (298 Nm).
5. Install the tire and wheel assembly.

3.6 WHEEL DRIVE ASSEMBLY, 2WD & 4WD (SN 0300083331 THROUGH 0300182743, B300000100 THROUGH B300001091)

Removal

NOTE: *The drive motor can be removed through the axle flange as part of the wheel drive assembly or they can be removed separately through the bottom of the frame while leaving the drive hub bolted to the axle.*

1. Use a jack to lift the frame enough so the tire and wheel assembly is off of the ground. Place blocking strong enough to support the weight of the machine under the frame and remove the jack.

NOTE: *The pneumatic tire & wheel assembly weighs approximately 269 lbs. (122 kg). The foam-filled tire & wheel assembly weighs approximately 544 lbs. (247.25 kg).*

2. Remove the tire and wheel assembly.
3. Through the access holes in the axle, tag and disconnect the hydraulic lines running to the drive motor. Cap or plug all openings to ensure no dirt enters the hydraulic system.

NOTE: *The drive hub and drive motor assembly weighs approximately 270 lbs. (122 kg).*

4. Use a supporting device capable of handling the weight of the drive hub and drive motor and unbolt the drive hub from the frame. Remove the entire assembly from the machine.
5. Remove the bolts and washers that secure the drive motor to the drive hub and remove the drive motor. Remove and discard the o-ring between the drive motor and drive hub.

Installation

1. Install a new o-ring between the drive motor and drive hub. Install the bolts and washers to secure them together and torque to 110 ft. lbs. (149 Nm).
2. Place the drive hub flange against the mounting flange on the axle and fasten it in place with the bolts and washers. Torque the bolts to 220 ft. lbs. (298 Nm).
3. Install the tire and wheel assembly.

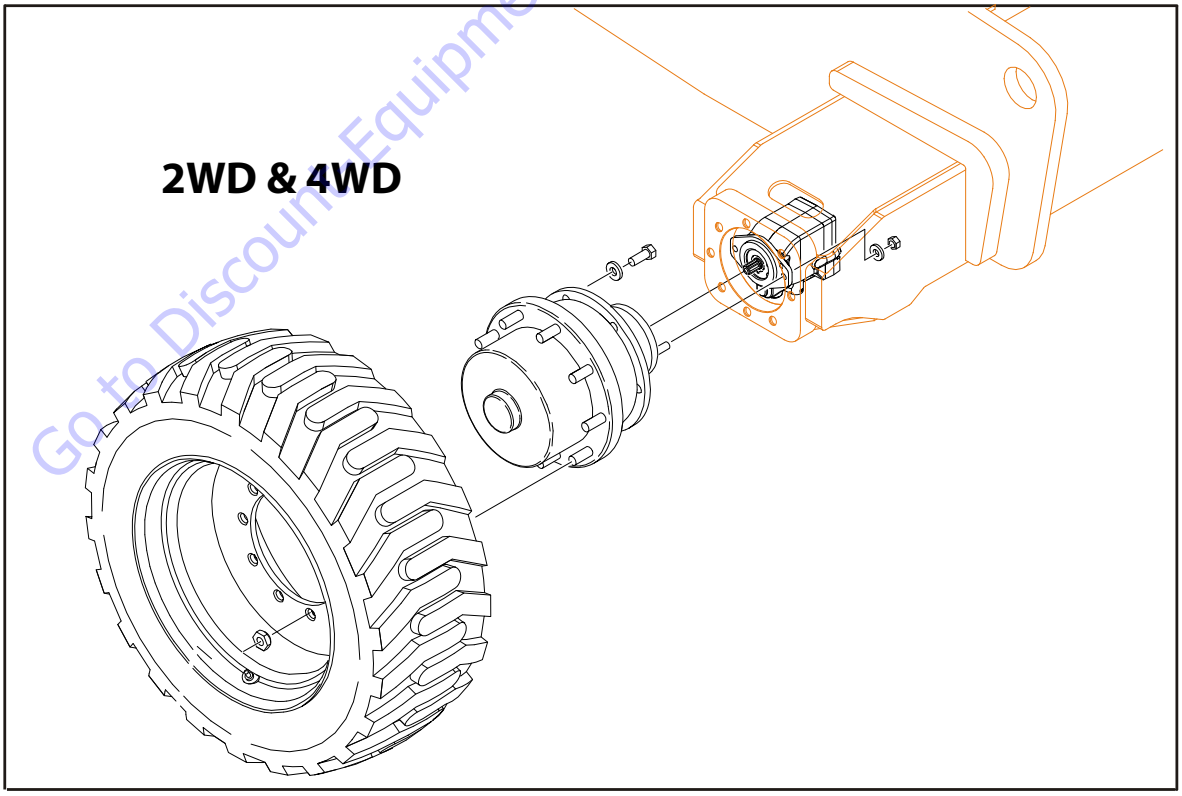


Figure 3-6. Drive Hub Installation - 2WD & 4WD (SN 0300083331 through 0300182743, B300000100 through B300001091)

3.7 WHEEL DRIVE ASSEMBLY, 4WD (PRIOR TO SN 0300083331)

Removal

NOTE: *The drive motor can be removed through the axle flange as part of the wheel drive assembly or they can be removed separately through the bottom of the frame while leaving the drive hub bolted to the axle.*

1. Use a jack to lift the frame enough so the tire and wheel assembly is off of the ground. Place blocking strong enough to support the weight of the machine under the frame and remove the jack.

NOTE: *The pneumatic tire & wheel assembly weighs approximately 269 lbs. (122 kg). The foam-filled tire & wheel assembly weighs approximately 544 lbs. (247.25 kg).*

2. Remove the tire and wheel assembly.
3. Through the access holes in the axle, tag and disconnect the hydraulic lines running to the drive motor. Cap or plug all openings to ensure no dirt enters the hydraulic system.

NOTE: *The drive hub and drive motor assembly weighs approximately 270 lbs. (122 kg).*

4. Use a supporting device capable of handling the weight of the drive hub and drive motor and unbolt the drive hub from the frame. Remove the entire assembly from the machine.
5. Remove the bolts and washers that secure the drive motor to the drive hub and remove the drive motor. Remove and discard the o-ring between the drive motor and drive hub.

Installation

1. Install a new o-ring between the drive motor and drive hub. Install the bolts and washers to secure them together and torque to 110 ft. lbs. (149 Nm).
2. Place the drive hub flange against the mounting flange on the axle and fasten it in place with the bolts and washers. Torque the bolts to 220 ft. lbs. (298 Nm).
3. Install the tire and wheel assembly.

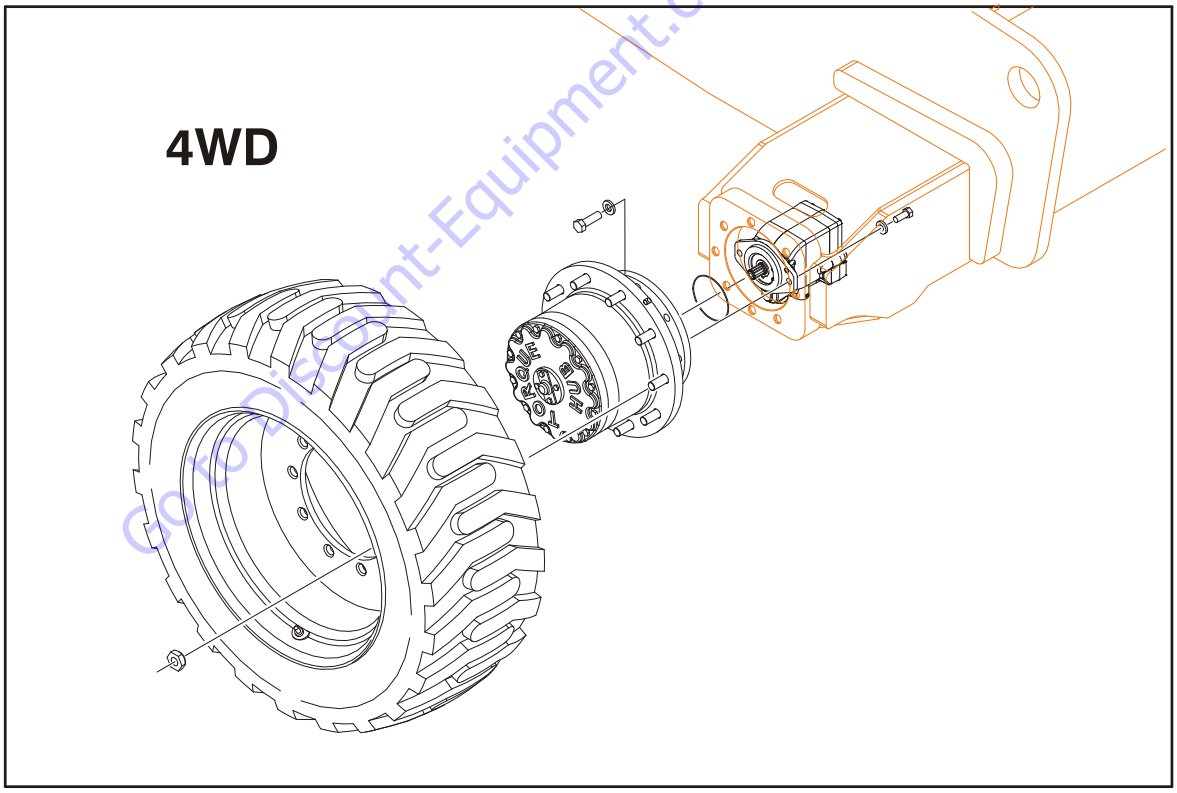


Figure 3-7. Drive Hub Installation - 4WD (Prior to SN 0300083331)

3.8 DRIVE HUB - 2WD (ALL MACHINES), 4WD (SN 0300083331 TO SN 0300182743, B300000100 THROUGH B300001091)

Disassembly

1. Position hub over suitable container and remove drain plugs (10) from unit. Allow oil to completely drain, then replace drain plugs.
2. Remove eight bolts (41) and four shoulder bolts (42) securing cover assembly to hub (7). Remove cover assembly (23) and discard o-ring seal (22).
3. Lift carrier assembly and top thrust washer and thrust bearing(39, 40) from hub. Thrust washer may stick inside cover.
4. Pry ring gear (21) loose from hub and remove it. Remove o-ring seal (22) from hub counterbore and discard it.
5. Remove input gear (37) and thrust spacer (36) from input shaft assembly and remove input shaft assembly from hub.
6. Lift internal gear (12) and thrust washer and thrust bearing (39, 40) from hub. Thrust washer may stick to bottom of carrier.
7. Remove retaining ring (9) from spindle (1) and discard; lift hub from spindle.

⚠ CAUTION

EYE PROTECTION SHOULD BE WORN DURING RETAINING RING REMOVAL.

8. Remove inside bearing cone (6) and bearing shim (8).
9. If necessary, pry seal (2) out of hub using screwdriver or pry bar. With seal removed, outside bearing cone (4) can be removed.
10. If necessary, remove inner and outer bearing cones (3, 5) using a suitable slide hammer puller.

NOTICE

WHEN REBUILDING DRIVE HUB, REMOVE AND REPLACE ALL O-RINGS AND RETAINING RINGS.

Cleaning and Inspection

1. Thoroughly clean all parts in an approved cleaning solvent.
2. Inspect bearing cups and cones for damage, pitting, corrosion, or excessive wear. If necessary, replace bearings as a complete set ensuring that they remain covered until use.
3. Inspect bearing mounting surfaces on spindle, hub, input shaft and carrier. Replace components as necessary.
4. Inspect all geared components for chipped or broken teeth and for excessive or uneven wear patterns.
5. Inspect carrier for damage, especially in anti-roll pin and planet shaft hole areas.
6. Inspect all planet shafts for scoring or other damage.
7. Inspect all threaded components for damage including stretching, thread deformation, or twisting.
8. Inspect seal mounting area in hub for burrs or sharp edges. Dress applicable surfaces or replace components as necessary.
9. Inspect cover for cracks or other damage, and o-ring sealing area for burrs or sharp edges. Dress applicable surfaces or replace cover as necessary.

Repair

1. Cover Assembly:
   - **a.** Remove two bolts (25) securing disconnect cap (26) to cover (23) and remove cap.
   - **b.** Remove two bolts (25) securing cover cap (24) to cover and remove cap.
   - **c.** Remove disconnect rod (27) from cap and remove o-rings (28, 29) from cover cap. Discard o-rings.
   - **d.** If necessary, remove pipe plug (30) from cover.
   - **e.** Clean and inspect parts in accordance with Cleaning and Inspection procedures. Replace parts as necessary.
   - **f.** If removed, screw pipe plug into cover.
   - **g.** Slip o-ring (29) over cover cap and against face.
   - **h.** Place o-ring (28) into cover cap internal groove. Disconnect rod may be used to push o-ring into groove.
   - **i.** Place cover cap into cover with large hole located over pipe plug. Secure cover cap to cover with two bolts. Torque bolts to 70-80 in. lbs. (7.9-9.0 Nm).
   - **j.** Place disconnect cap over cover cap with nipple facing out and secure with two bolts. Torque bolts to 70-80 in. lbs. (7.9-9.0 Nm).

k. Turn cover over and push disconnect rod into cover cap. Rod will be held in place by friction from o-ring.

2. Carrier Assembly:

a. Drive anti-roll pin (19) into planet shaft (17) using a suitable punch.

b. Using a suitable press, press planet shaft from carrier (13). After planet shaft is removed, drive anti-roll pin from shaft.

c. Remove cluster gear (18) and thrust washers (14) from carriers.

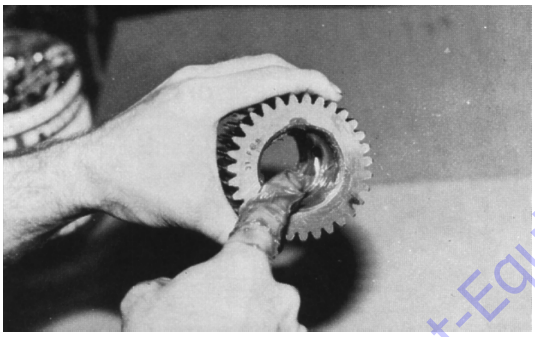
d. Remove sixteen needle rollers (15) from cluster gear bore.

e. Remove spacer (16) from cluster gear bore and remove second set of sixteen needle rollers (15).

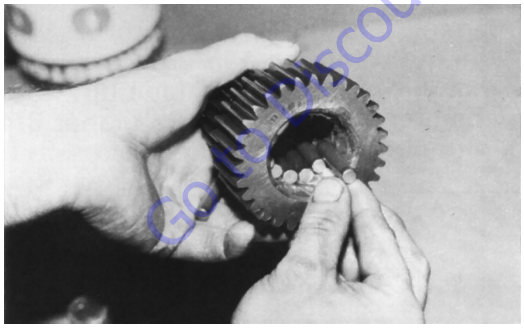
f. Repeat steps (a) through (e) for remaining two cluster gears.

g. Clean and inspect all parts in accordance with Cleaning and Inspection procedures. Replace parts as necessary.

h. Apply a coat of grease or petroleum jelly to cluster gear bore.



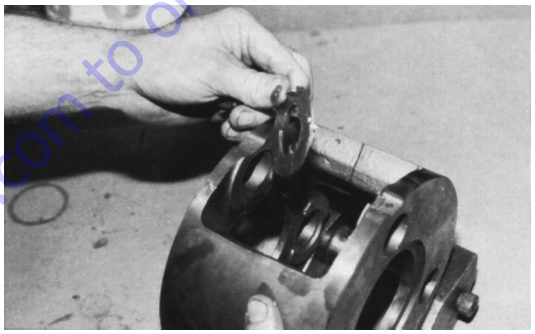
i. Place sixteen needle rollers into cluster gear bore.



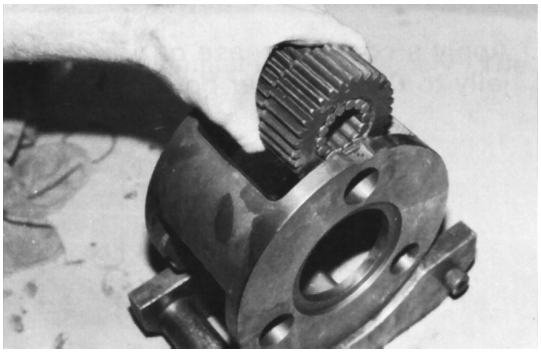
j. Place spacer into opposite side of cluster gear and against needle rollers.

k. Place second set of sixteen needle rollers into cluster gear.

l. Apply grease or petroleum jelly to tang side of two thrust washers. Place thrust washers against bosses in carrier with washer tang fitting into slot in carrier outside diameter.

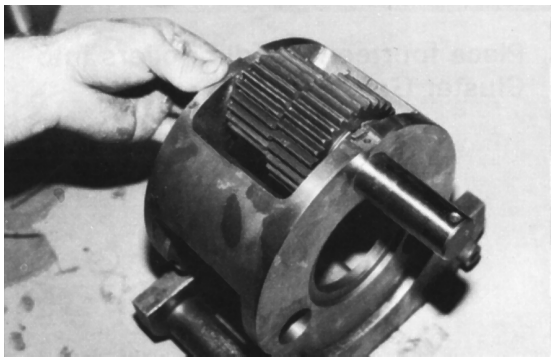


m. While keeping thrust washers in place, slide cluster gear into carrier with larger gear on side with small pin hole.



n. Line up cluster gear and thrust washers with hole in carrier and slide planet shaft through. Ensure cham-

fered side of hole in planet shaft is lined up with pin hole in carrier.



o. Drive anti-roll pin flush into carrier hole, locking planet shaft into place.

3. Input Shaft Assembly:

⚠ CAUTION

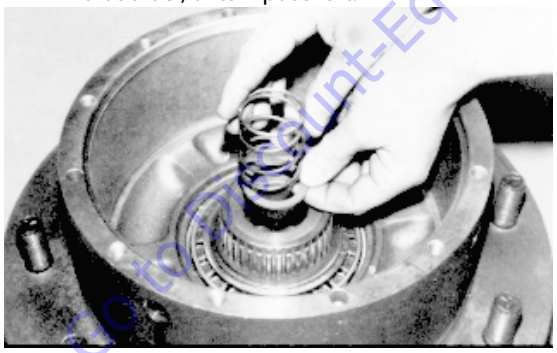
EYE PROTECTION SHOULD BE WORN DURING RETAINING RING REMOVAL AND INSTALLATION.

a. Carefully remove retaining ring (33) from counterbore in the spindle (1) and discard retaining ring.

b. Remove two spacers (31) and spring (32) from input shaft.

c. Clean and inspect all parts in accordance with Cleaning and Inspection procedures. Replace parts as necessary.

d. Place washer (31), spring (32), and washer (31), in that order, onto input shaft.

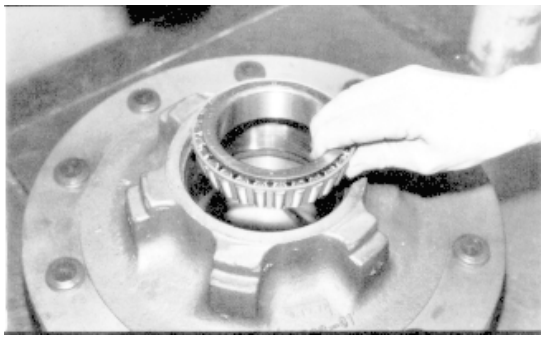


e. Install retaining ring into input shaft groove to secure spacers and spring to shaft.

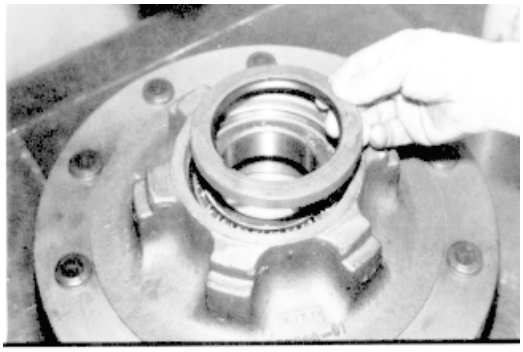
Assembly

1. Using a suitable press, press new bearing cups (3, 5), with large inside diameters facing out, into hub (7) counterbore.

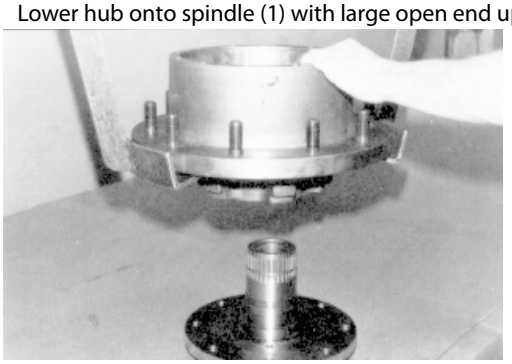
2. Place bearing cone (4) into bearing cup (3) in small end of hub.



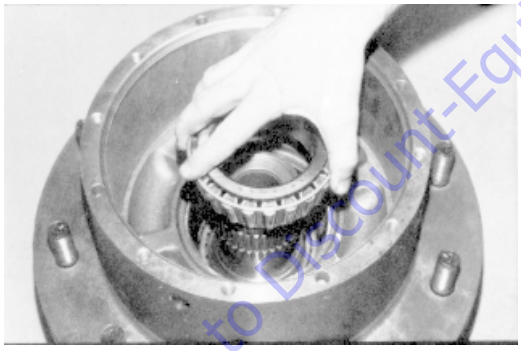
3. Press new seal (2) into hub counterbore with flat metal side facing in. Use a flat object to ensure that seal is pressed evenly and is flush with hub face.



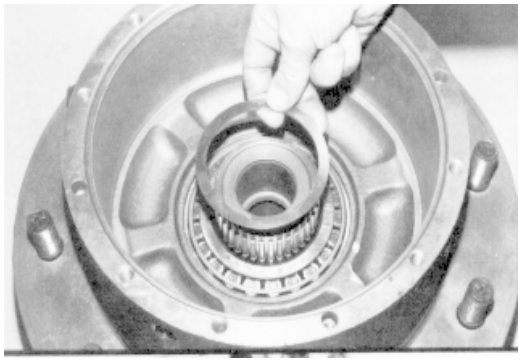
4. Lower hub onto spindle (1) with large open end up.



5. Place bearing cone (6) over end of spindle and into bearing cup.



6. Place bearing shim (8) over end of spindle and against bearing cone.

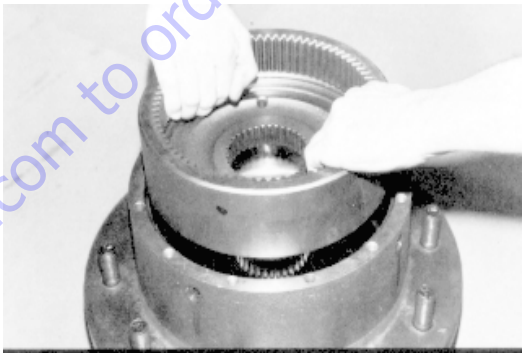


⚠ CAUTION

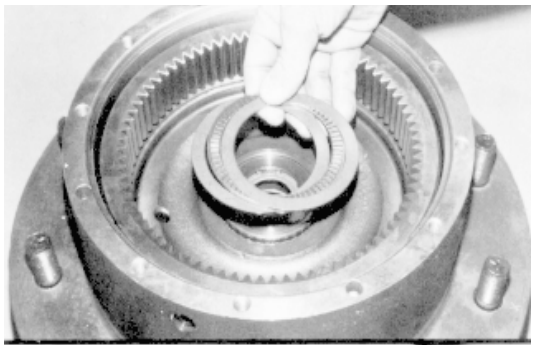
EYE PROTECTION SHOULD BE WORN DURING RETAINING RING INSTALLATION.

7. Install new retaining ring (9) completely into spindle groove and against bearing shim. Ensure retaining ring is entirely in groove.

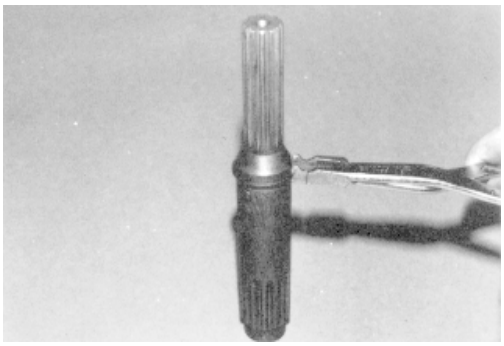
8. Place internal gear (12) onto end of spindle.



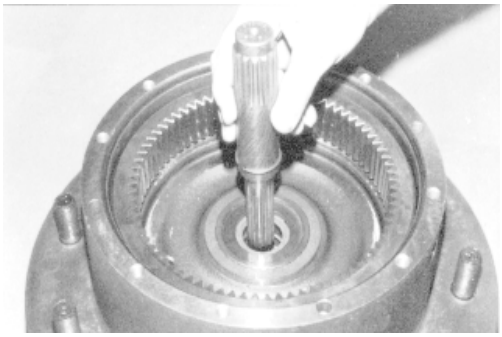
9. Install thrust washers and thrust bearing (39, 40) on the portion of the spindle which extends into the internal gear.



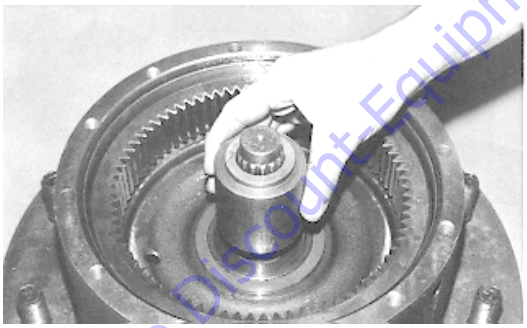
10. Install retaining ring (34) into input shaft retaining ring groove.



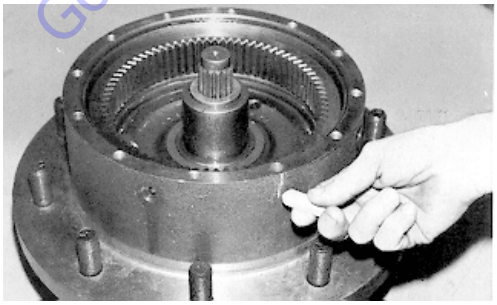
11. Place input shaft assembly (35) into spindle bore with unsplined end facing out.



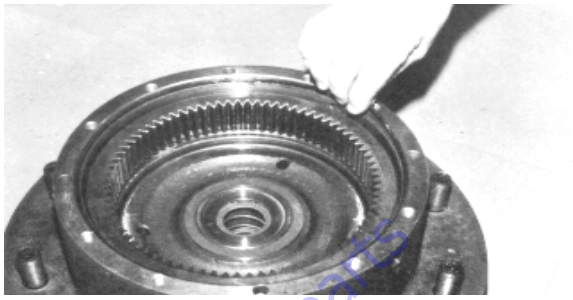
12. Place thrust spacer (36) over input shaft (35) with counterbore side facing spindle.



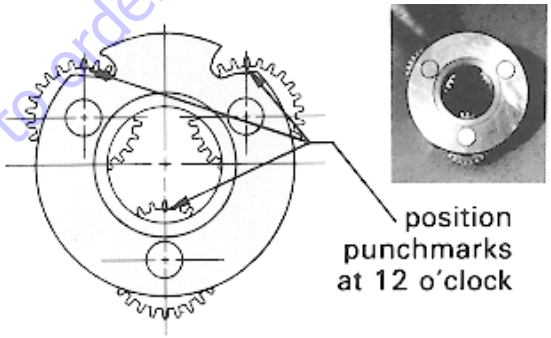
13. Locate the four counter reamed holes in the face of the hub, mark them for later identification.



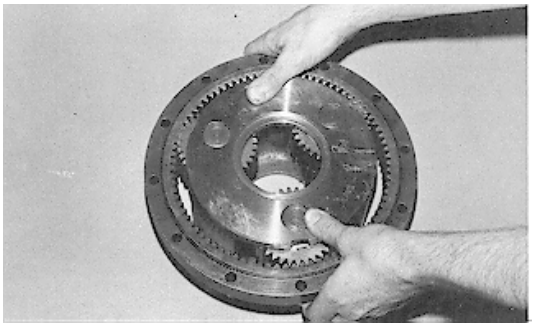
14. Place o-ring (22) into hub counterbore. Use petroleum or grease to hold o-ring in place. Slight stretching of o-ring may be necessary to insure proper seating.



15. Place carrier assembly on a flat surface with large gears up and positioned as shown. Find punch marked tooth on each large gear and locate at 12 o'clock (straight up) from each planet pin. Marked tooth will be located just under carrier on upper two gears.

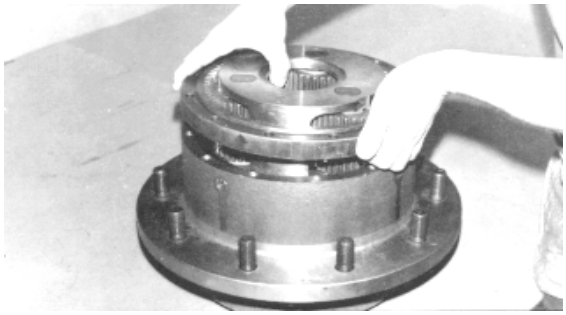


16. With shoulder side of ring gear (21) facing down, place ring gear over (into mesh with) large gears. Ensure punch marks remain in correct location during ring gear installation.



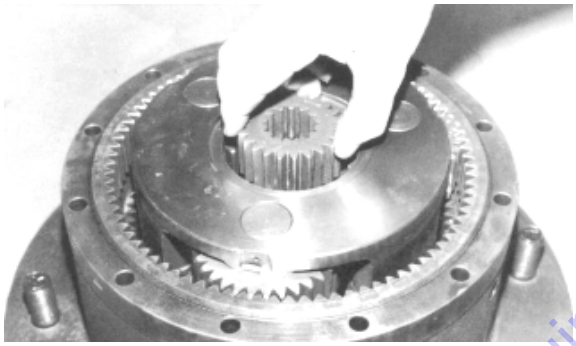
17. While holding ring gear, input gear, and cluster gears in mesh, place small side of cluster gears into mesh with

internal gear. On ring gear, locate hole marked 'X' over one of counterbore holes in hub.

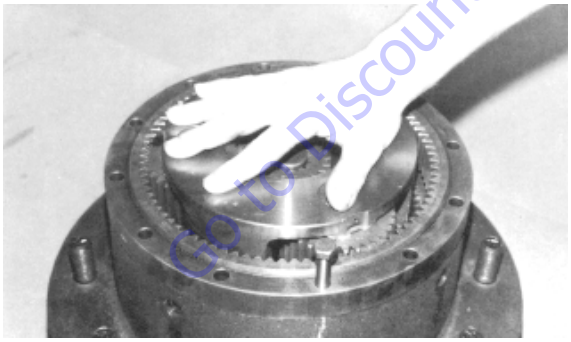


NOTE: *If gears do not mesh easily or carrier assembly does not rotate freely, then remove carrier and ring gear and check cluster gear timing.*

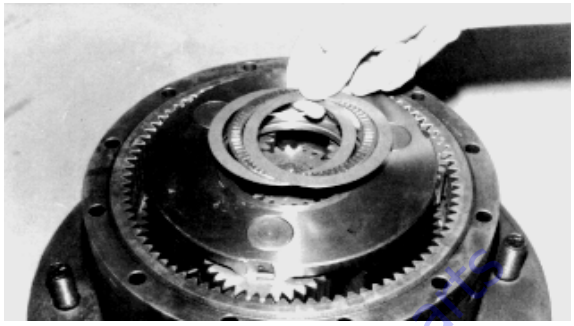
18. Install input gear (37) into carrier, meshing with large diameter cluster gears (18). Counterbore in bore of input gear must be to outside of carrier assembly.



19. After inserting at least one shoulder bolt in the proper location, rotate the carrier. Check freedom of rotation and timing.



20. Install thrust washers and thrust bearing (39, 40) into carrier counterbore.

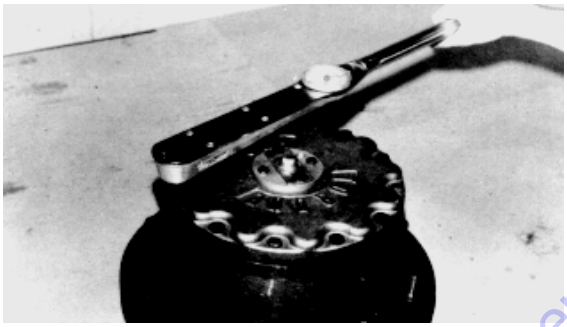


21. Place o-ring (22) into cover assembly counterbore. Use petroleum jelly or grease to hold o-ring in place.

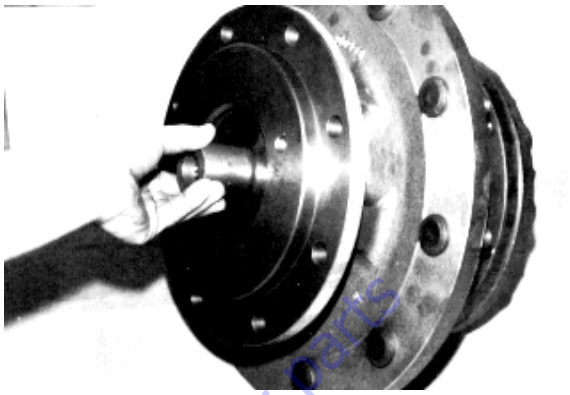
22. Place cover assembly over ring gear with oil level check plug in cover located approximately 90 degrees from oil fill plug in hub.

23. Locate four shoulder bolts (42), 90 degrees apart into counterbore holes in hub marked in step (13). Torque shoulder bolts to 47 ft. lbs. (64 Nm).

24. Install bolts (41) in remaining holes. Torque bolts to 47 ft. lbs. (64 Nm).



25. Place coupling (1) into spindle and onto input shaft.



26. Fill hub one-half full of EPGL 90 lubricant before operation.

1. Spindle
2. Seal
3. Bearing Cup
4. Bearing Cone
5. Bearing Cup
6. Bearing Cone
7. Hub
8. Spacer
9. Retaining Ring
10. Plug
11. Wheel Bolt
12. Internal Gear
13. Carrier
14. Thrust Washer
15. Needle Roller
16. Spacer
17. Piston Shaft
18. Cluster Gear
19. Roll Pin
20. Not Used
21. Cluster Gear
22. O-ring
23. Cover
24. Cover Cap
25. Bolt
26. Disconnect Cap
27. Disconnect Rod
28. O-ring
29. O-ring
30. Pipe Plug
31. Washer
32. Spring
33. Retaining Ring
34. Retaining Ring
35. Input Shaft
36. Thrust Spacer
37. Input Gear
38. Not Used
39. Thrust Washer
40. Thrust Bearing
41. Bolt
42. Shoulder Bolt
43. Coupling

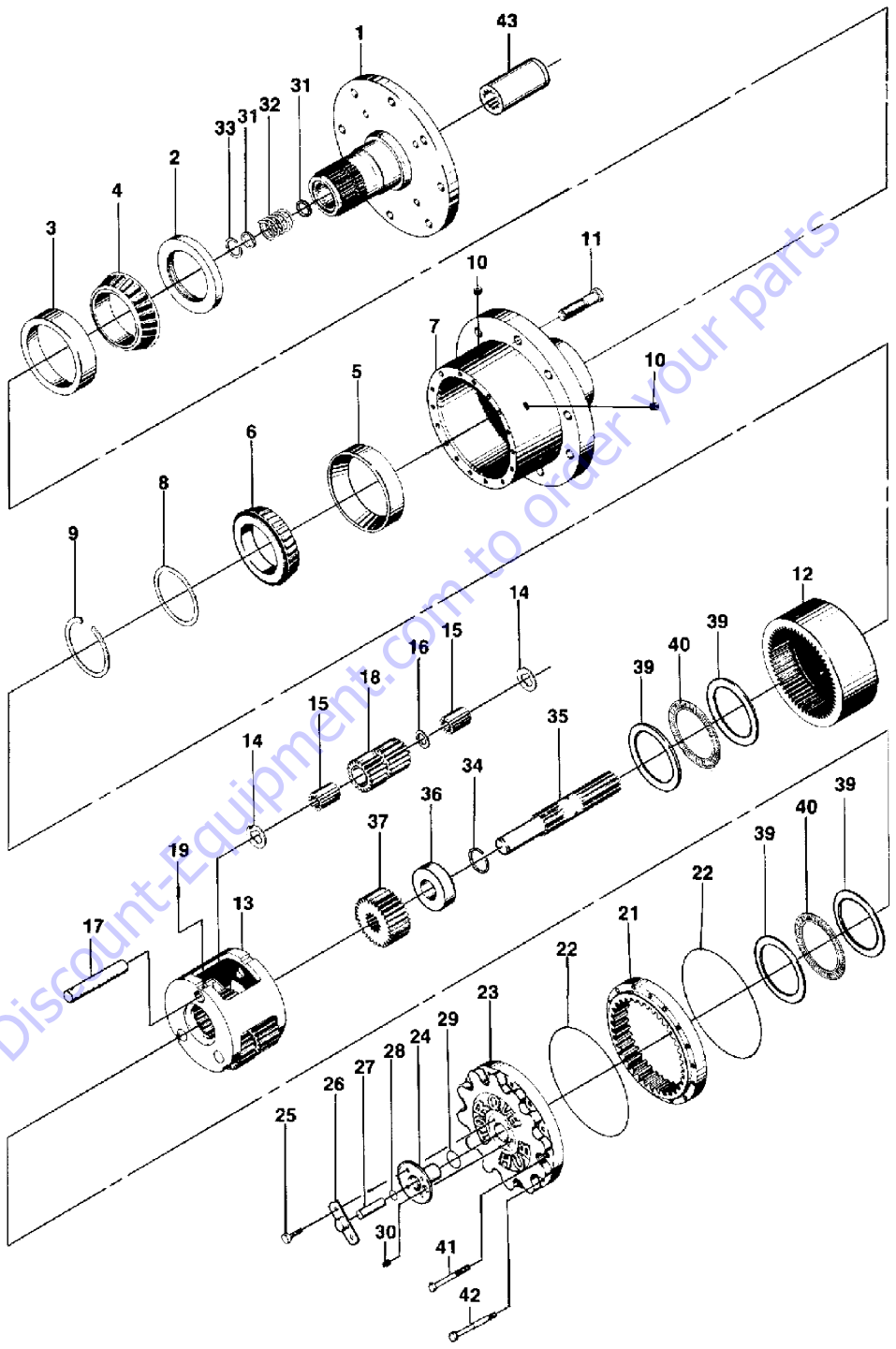


Figure 3-8. Drive Hub - 2WD (All Machines), 4WD (SN 0300083331 through SN 0300182743, B300000100 through B300001091)

3.9 DRIVE BRAKE, 2WD - MICO (PRIOR TO SN 0300083331)

Disassembly

1. Remove pressure plate (3) from cover plate (16) by removing capscrews (1) and washers (2).

⚠ CAUTION

PRESSURE PLATE IS UNDER SPRING TENSION OF APPROXIMATELY 2000 LBS (907 KGF). THE TWO CAPSCREWS MUST BE LOOSENED EVENLY TO RELIEVE THIS FORCE. IF A HYDRAULIC PRESS IS AVAILABLE, 3000 LBS (1361 KGF) MINIMUM, THE PRESSURE PLATE CAN BE HELD IN POSITION WHILE REMOVING THE CAPSCREWS. COVER PLATE (16) MUST BE SUPPORTED AS SHOWN IN FIGURE 3-9.

2. Remove case seal (4) from cover plate (16).
3. Remove piston (7) from pressure plate (3).
4. Remove o-ring (5), backup ring (6), o-ring (8) and backup ring (9) from piston (7).
5. Remove stator disc (11), rotor disc (12) and return plate (13) from cover (16).
6. Remove dowel pins (15) and springs (14) from cover plate (16). Record this information for assembly purposes.

NOTE: *Not all models use the same number of springs or spring pattern. Record this information for assembly purposes.*

7. Remove retaining ring (19) from cover plate (16).
8. Remove shaft (10) by pressing or using a soft mallet on male end of shaft (10).

NOTE: *Cover plate (16) must be supported as shown in Figure 3-9.*

9. Remove retaining ring (20) from cover plate (16) and press out oil seal (17) and bearing (18) if required.

NOTE: *Cover plate (16) must be supported as indicated in Figure 3-9.*

Assembly

NOTICE

LUBRICATE ALL RUBBER COMPONENTS FROM REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM.

1. Use an alkaline wash to clean parts before assembly.
2. Press oil seal (17) into cover plate (16) until it is flush with bearing shoulder. Note direction of seal.
3. Press bearing (18) into position until it bottoms out on borestep.

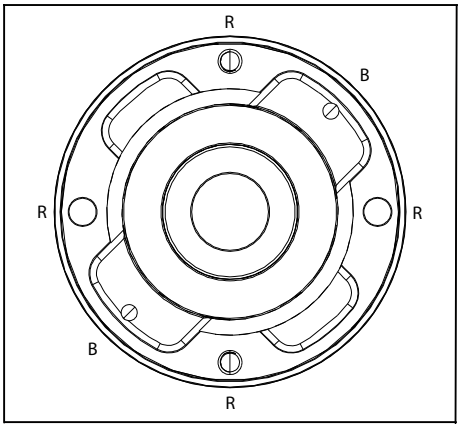
NOTE: *Cover plate (16) must be supported as indicated in Figure 3-9.*

4. Install retaining ring (20) in cover plate (16).
5. Press shaft (10) into bearing (18) until it bottoms on shoulder.

NOTE: *Bearing (18) inner race and cover plate (16) must be supported as indicated in Figure 3-9. during this operation.*

6. Install retaining ring (19) on shaft (10).
7. Insert dowel pins (15) and springs (14) in cover plate (16).

NOTE: *Be sure to use the same number of springs and spring pattern as recorded during disassembly.*



NOTE: *Start with the red springs and space them as evenly as possible throughout the spring retainer, then take the first blue spring and put it in any one of the remaining empty holes, second blue spring should be placed as directly across from the first blue spring as possible.*

8. Position return plate (13) on springs (14).

NOTE: *Discs (11 & 12) and return plate (13) must remain dry during installation. No oil residue must be allowed to contaminate disc surfaces.*

9. Install rotor disc (12) and stator disc (13).

10. Install o-ring (5), backup ring (6), o-ring (8) and backup ring (9) on piston (7). Note order of o-rings and backup rings. Insert piston (7) into pressure plate (3).

NOTE: *Be careful not to shear o-rings or backup rings. Be careful not to scratch or mar piston.*

11. Install new case seal (4) in cover plate (16).

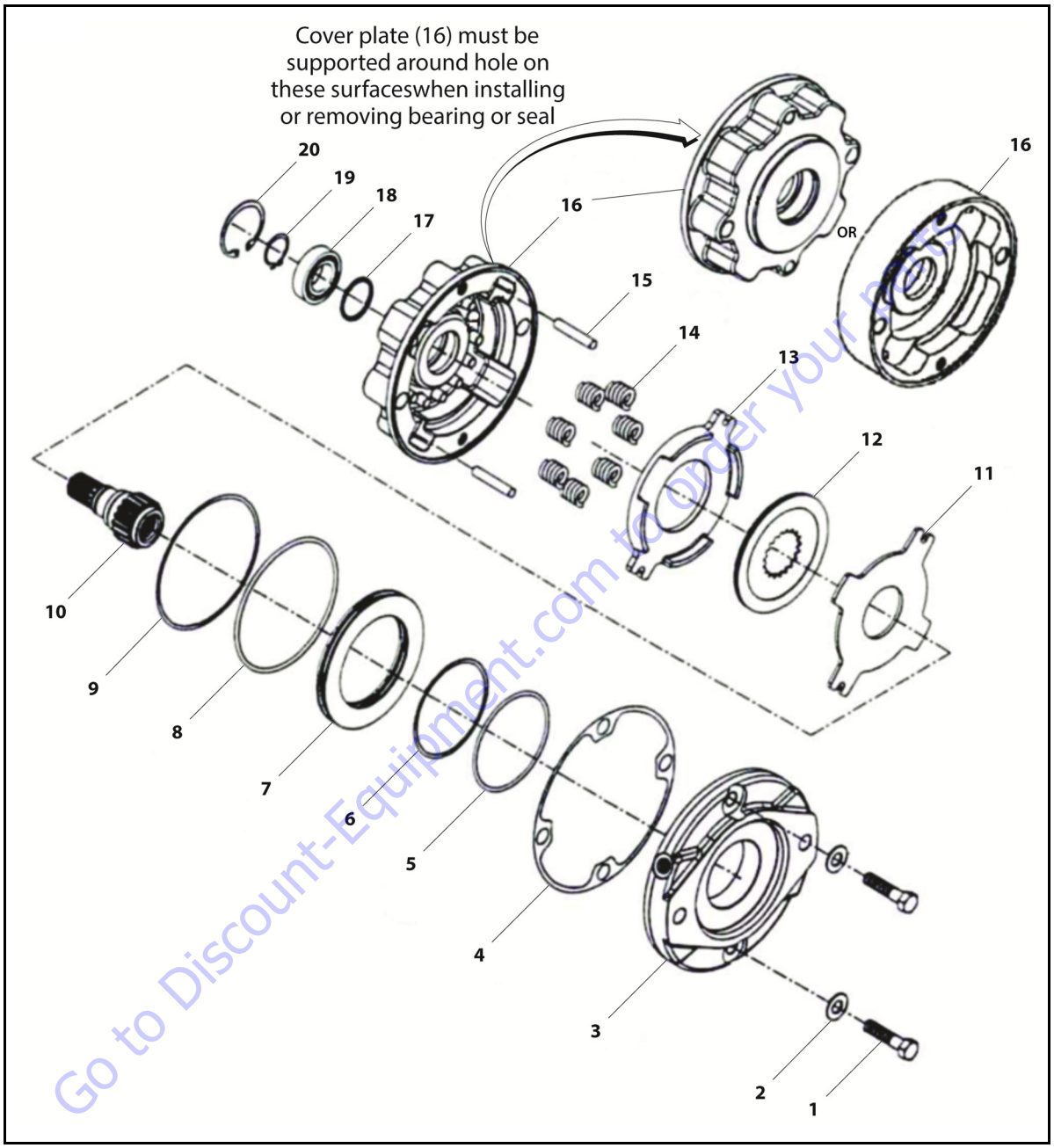
12. Position pressure plate (3) on cover plate (16) aligning dowel pins (15) with holes in pressure plate.

13. Install capscrews (1) and washers (2) and tighten evenly to draw pressure plate (3) to cover plate (16). Torque capscrews 48-50 ft. lbs. (65.1-67.8 Nm).

NOTE: *A hydraulic press will simplify installation of pressure plate on cover. Clamp pressure plate in position while tightening the capscrews. Cover plate (16) must be supported as indicated in Figure 3-9.*

⚠ CAUTION

IF HYDROSTATIC BENCH TESTING IS PERFORMED ON THE BRAKE ASSEMBLY, RELEASE PRESSURE MUST NOT EXCEED 500 PSI (134.5 BAR).



1. Capscrew
2. Washer
3. Pressure Plate
4. Case Seal
5. O-ring
6. Backup Ring
7. Piston
8. O-ring
9. Backup Ring
10. Shaft
11. Stator Disc
12. Rotor Disc
13. Return Plate
14. Springs
15. Dowel Pin
16. Cover Plate
17. Oil Seal
18. Bearing
19. Retaining Ring
20. Retaining Ring

Figure 3-9. Drive Brake, 2WD - Mico (Prior to SN 0300083331)

Bleeding

1. Install brake in system and connect pressure lines.
2. Bleed pressure release section of brake by pressurizing side inlet port and allowing air to escape from top port. Pressure should not exceed 6.9 bar (100 psi) during bleeding.
3. Apply sufficient pressure to release brake and check for proper operation in system.

Table 3-2. Troubleshooting

PROBLEM	CAUSE	EXPLANATION	ACTION
Brake slips	Excessive pressure in hydraulic system	If there is back pressure in the actuation line of the brake, holding torque will be reduced.	Check filters, hose size, restrictions in other hydraulic components.
	Oil in brake if designed for dry use	Wet linings generate 67% of the dry torque rating. If the brake has oil in it, check the type of oil hydraulic or gearbox. 1 . Gearbox oil 2. Hydraulic oil	Replace oil seal in brake. Check motor seal Check piston seals ***NOTE:*** *Internal components will need to be inspected, cleaned and replaced as required.*
	Disc plates worn	The thickness of the disc stack sets the torque level. A thin stack reduces torque.	Check disc thickness.
	Springs broken or have taken a permanent set	Broken or set springs can cause reduced torque - a rare occurrence.	Check release pressure. (See spring replacement).
Brake drags or runs hot	Low actuation pressure	The brake should be pressurized to minimum of 1.38 bar (20 psi) over the full release pressure under normal operating conditions. Lower pressures will cause the brake to drag thus generating heat.	Place pressure gauge in bleed port & check pressure with system on.
	Bearing failure	If the bearing should fail, a large amount of drag can be generated.	Replace bearing.
Brake will not release	Stuck or clogged valve	Brakes are designed to come on when system pressure drops below stated release pressure. If pressure cannot get to brake, the brake will not release.	Place pressure gauge in bleed port - check for adequate pressure. Replace inoperative line or component.
	Bad o-rings	If release piston will not hold pressure, brake will not release.	Replace o-rings.
	Discs frozen	These brakes are designed for only limited dynamic braking. A severe emergency stop or prolonged reduced release pressure operation may result in this type of damage.	Replace disc stack.

3.10 DRIVE BRAKE (SN 0300083331 TO SN 0300182743, B300000100 THROUGH B300001091)

Disassembly

1. Supporting brake:, remove the six socket head capscrews and washers (13 & 14) in equal increments to ensure the spring pressure within the brake is reduced gradually and evenly.

   If a press is available, the cylinder housing (8) can be restrained while removing the six capscrews and washers (13 & 14).

   The brake assembly can now be fully dismantled and the parts examined.
2. Remove cylinder housing (8) and piston (9) subassembly and dismantle if required, removing o-ring seals (15 & 17) and backing rings (16 & 18) as necessary.
3. Remove gasket (7) from housing (2).
4. Remove friction plates (3 & 6) and pressure plate (4).
5. Remove two dowel pins (19).
6. Remove springs (22 & 23).
7. Should it be necessary to replace ball bearing (10) or shaft seal (12), reverse remainder of brake subassembly, supporting on face C of housing (2).
8. Remove internal retaining ring (11).
9. Using arbor press or similar to break Loctite seal, remove brake shaft (1) from housing (2) and lay aside.
10. Reverse housing (2) and press out ball bearing (10). Shaft seal (12) can also be removed if necessary.

Inspection

1. Inspect friction plates (3 & 6) and friction surface on pressure plate (4) for wear or damage.
2. Examine friction plates (3) and brake shaft (1) for wear or damage to the splines.
3. Examine input and output splines of brake shaft (1) for wear or damage.
4. Examine compression springs (22 & 23) for damage or fatigue.
5. Check ball bearing (10) for axial float or wear.
6. Examine o-ring seals (15 & 17) and backing rings (16 & 18) for damage.

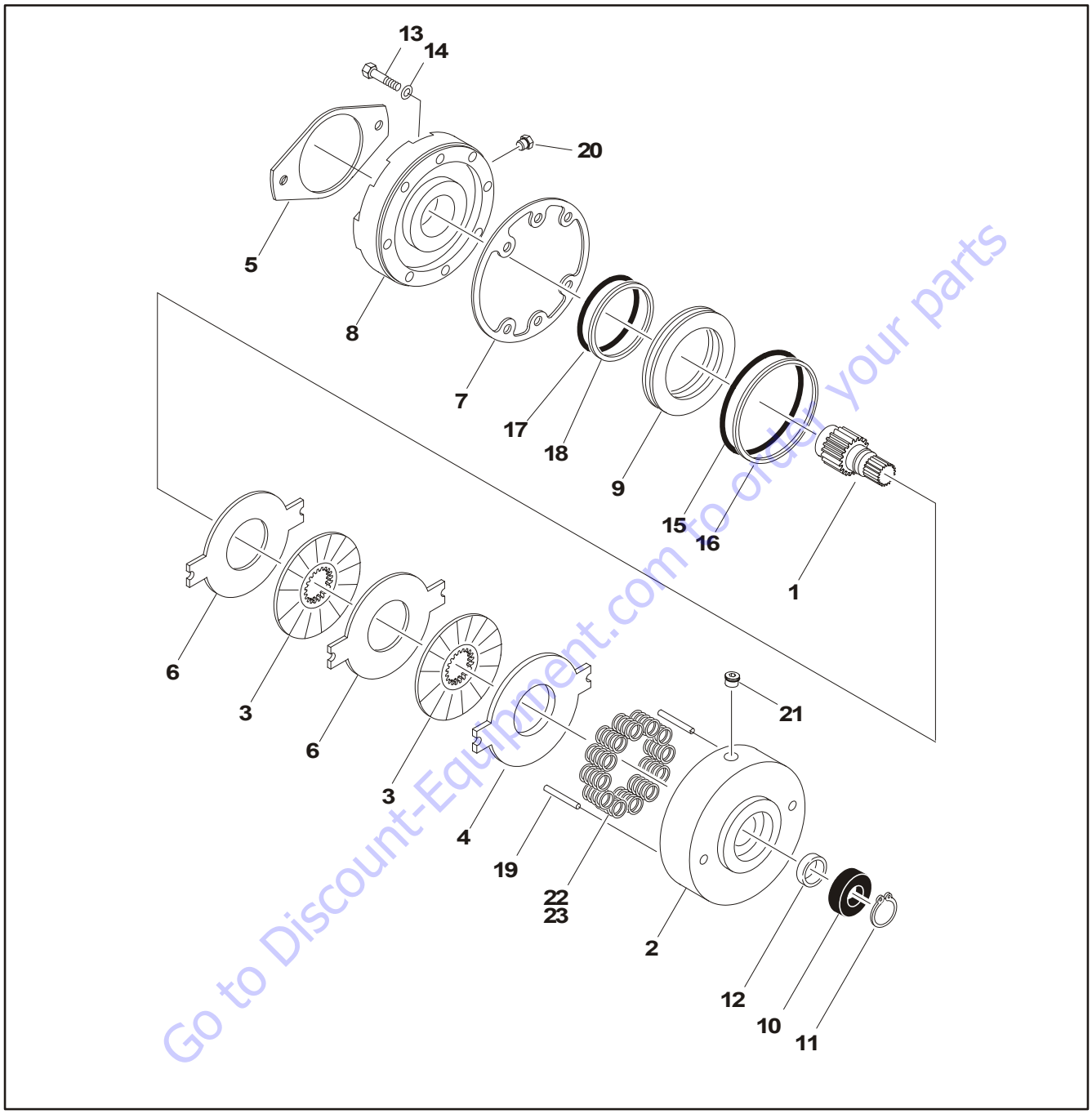
Assembly

1. Lightly lubricate rotary shaft seal (12) and assemble to housing (2) taking care not to damage seal lip.
2. Apply ring of Loctite 641 or equivalent adhesive to full circumference of housing (2) bearing recess adjacent to shoulder.

   Apply complete coverage of Loctite 641 to outside diameter of bearing (10) and assemble fully In housing (2), retaining with internal retaining ring (11). Remove excess adhesive with a clean cloth.

   Press shaft (1) through bearing (10), ensuring bearing inner ring Is adequately supported.
3. Assemble correct quantity of springs (22 & 23) in orientation required.
4. Lubricate o-ring seals (15 & 17) with Molykote 55M (or equivalent) silicon grease and assemble together with backing rings (16 & 18) to piston (9). To ensure correct brake operation. It is important that the backing rings are assembled opposite to the pressurized side of piston.
5. Correctly orientate piston (9) aligning spaces with the two dowel pin holes and, assemble into cylinder housing (8) taking care not to damage seals and carefully lay aside.
6. Locate 2-off pins (19) in housing (2) followed by pressure plate (4) and friction plates i.e. an inner (3) followed by an outer (6) in correct sequence.
7. Position gasket (7) in correct orientation.
8. Align two holes in cylinder with dowel pins (19) and assemble piston & cylinder sub-assembly to remainder of brake securing with 6 capscrews and washers (13 & 14). Torque to 55 ft.lbs. (75 Nm).

NOTE: *The use of a suitable press (hydraulic or arbor) pressing down on cylinder end face B will ease assembly of the capscrews (13).*



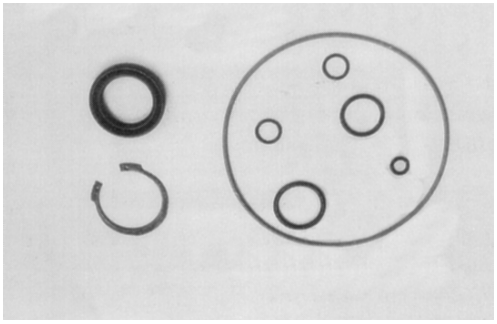
1. Shaft
2. Housing
3. Friction Plate
4. Pressure Plate
5. Gasket
6. Outer Plate
7. Gasket
8. Cylinder
9. Piston
10. Ball Bearing
11. Retaining Ring
12. Shaft Seal
13. Capscrew
14. Lockwasher
15. O-ring
16. Backup Ring
17. O-ring
18. Backup Ring
19. Dowel Pin
20. Plug
21. Plug
22. Spring (Natural)
23. Spring (Blue)

Figure 3-10. Drive Brake (SN 0300083331 to SN 0300182743, B300000100 through B300001091)

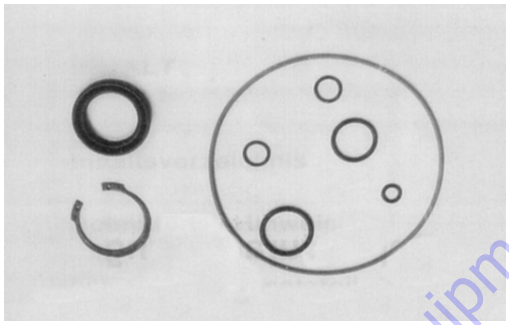
3.11 DRIVE MOTOR - 2WD (PRIOR TO SN 0300083331)

Spare Parts Kits

Sealing kit, existing spare parts: shaft sealing ring, 6 different o-rings and a circlip (sealing mat.: perbunan)

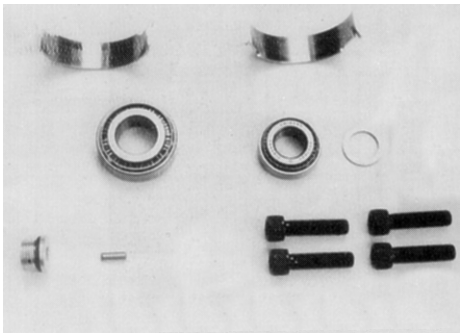


Same sealing kit like shown above only seal material changed to Viton

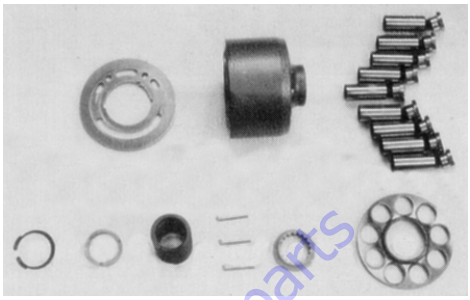


Drive shaft

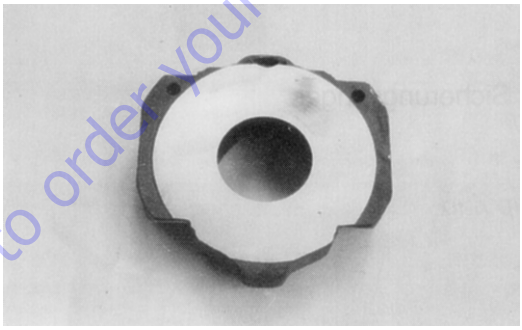
Bearing set/miscellaneous parts



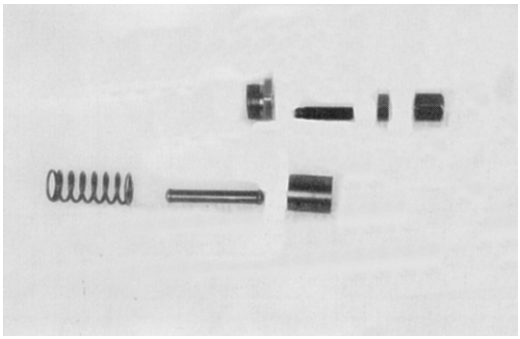
Rotary group complete 9 pistons, cylinder sub-assembly, valve plate (cw or ccw corresponding to the order) retaining plate and retaining ball.



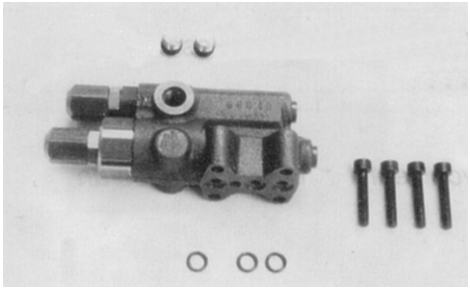
Swashplate



Parts of the control device: control piston, piston rod, plug, spring stopper max flow, hex. nut, and hex. head nut



Spare parts kit DFR pilot valve



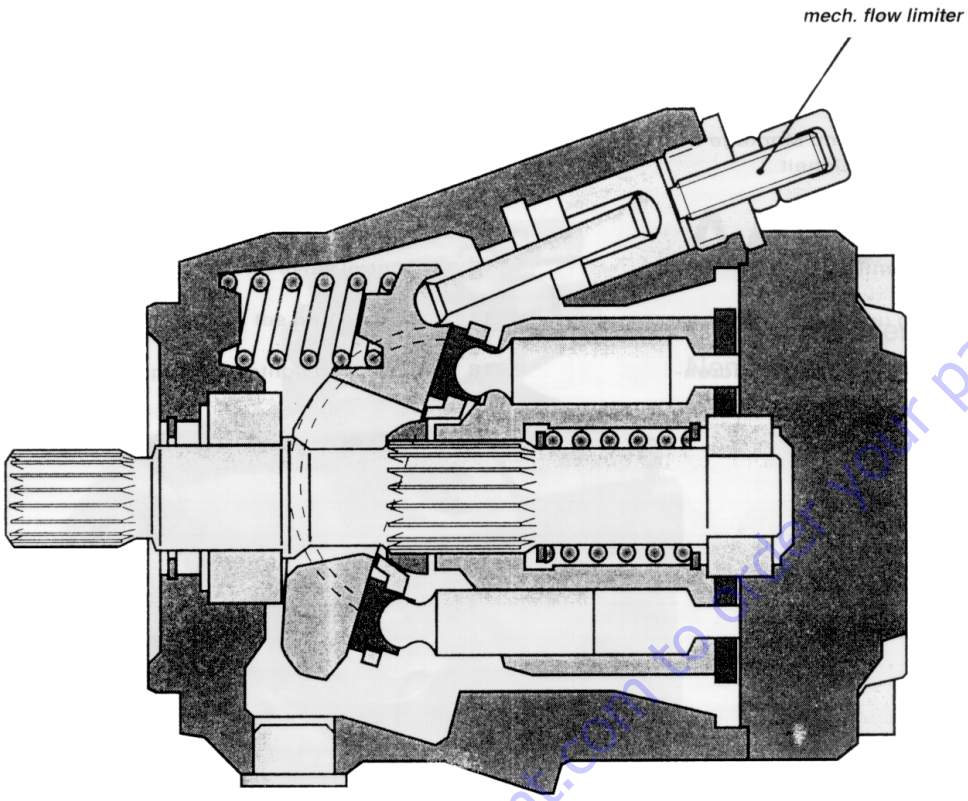
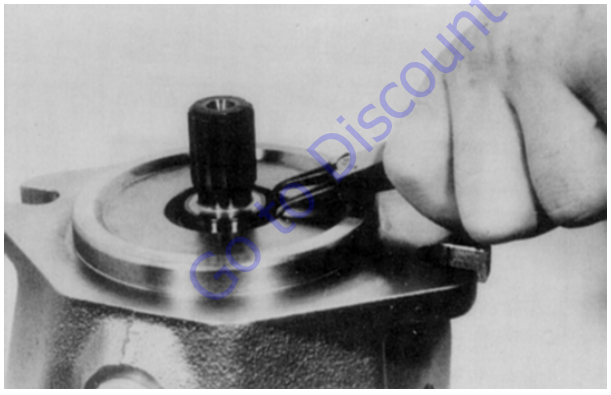


Figure 3-11. Drive Motor Cutaway

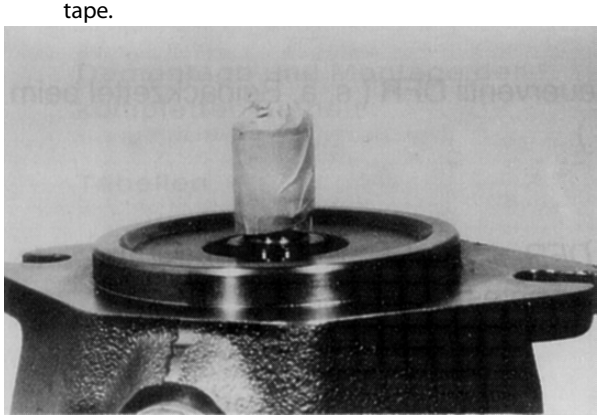
Replacing the Drive Shaft Seal

1. Remove snap ring.

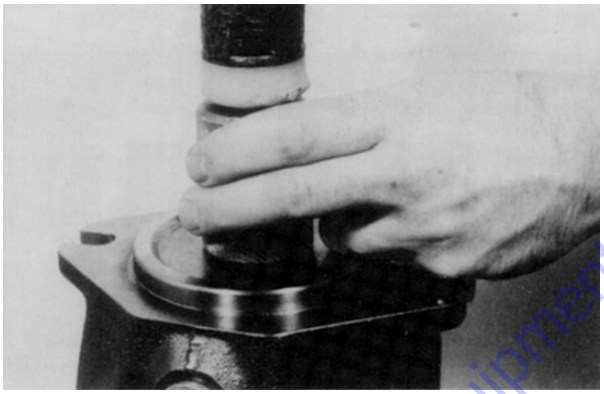


2. Change the shaft seal and check its sliding surface (drive shaft) and housing. Grease the sealing ring.

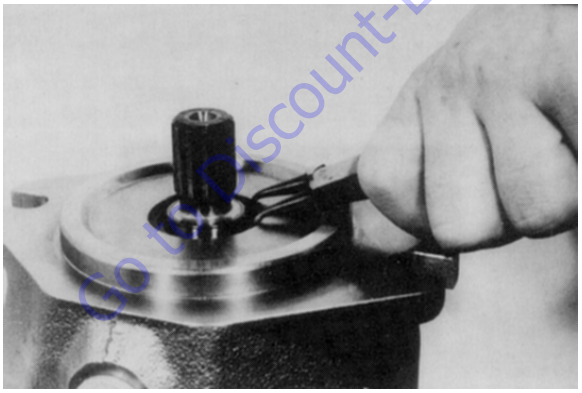
3. Be careful while you seal the drive shaft, use an adhesive tape.



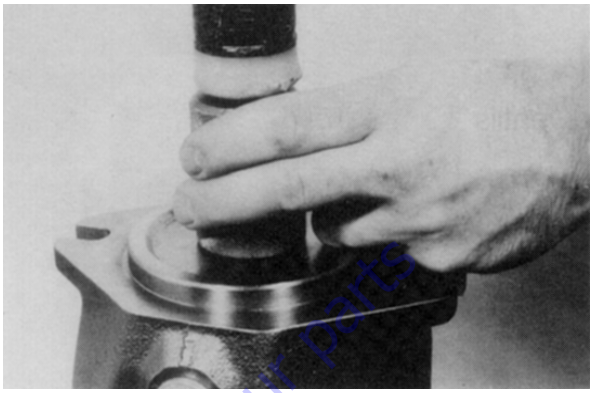
4. Assemble the sealing ring, fitting tool holds the correct position of the sealing ring in the pump housing.



5. Assemble the snap ring.



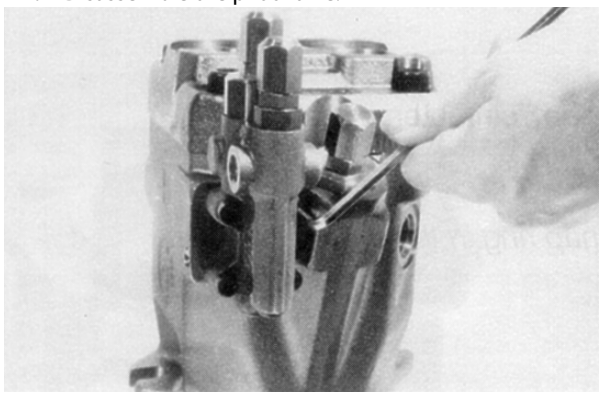
6. Assemble the snap ring in the correct position.



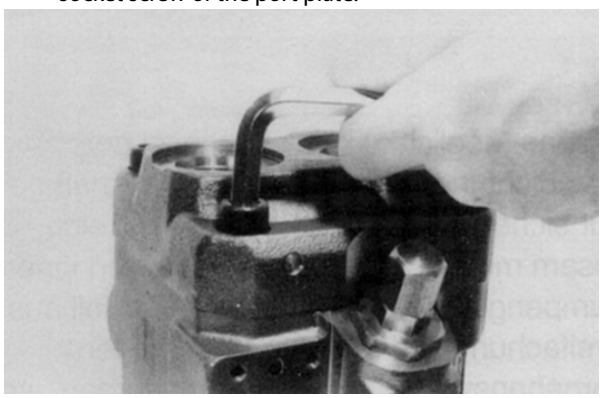
NOTE: *This description shows how to change the drive shaft sealing ring but isn't the way of serial assembly. the sealing ring is assembled together with the taper roller bearing from inside the pump housing normally to get a secure condition. If you decide to repair the pump in the shown way be very careful while handling so that the drive shaft will not be damaged during disassembly of the shaft sealing ring.*

Disassembly

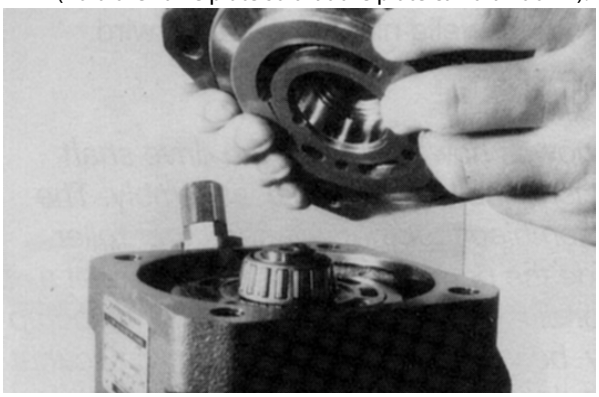
1. Disassemble the pilot valve.



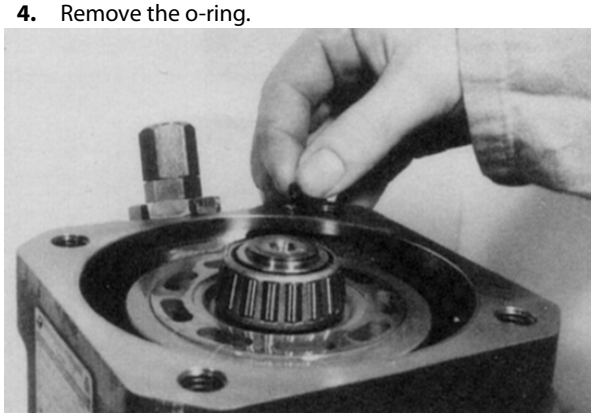
2. Mark the position of the port plate and remove the socket screw of the port plate.



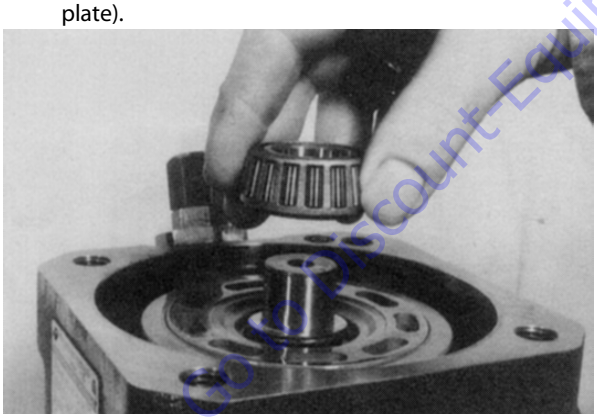
3. Remove the port plate together with the valve plate (hold the valve plate so that the plate can't fall down).



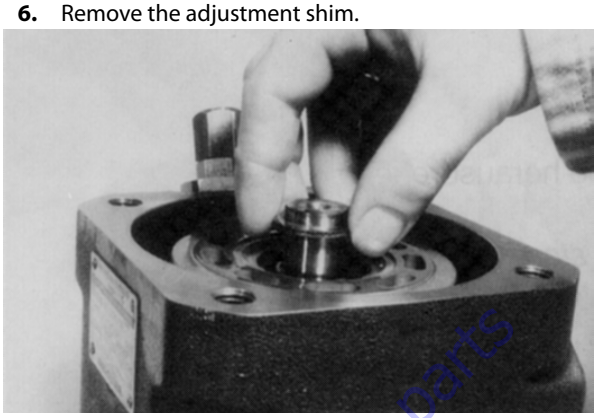
4. Remove the o-ring.



5. Disassemble the taper roller bearing (near by port plate).

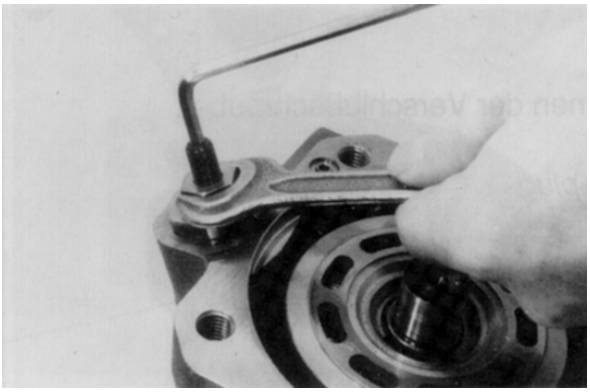


6. Remove the adjustment shim.

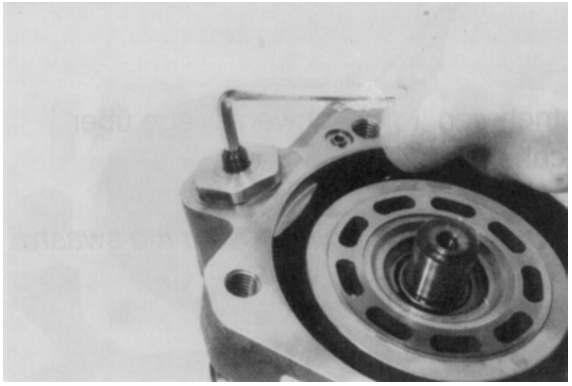


7. Unscrew the cap nut and remove it.

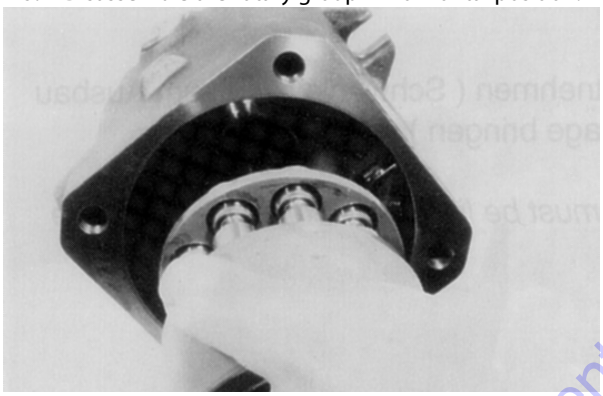
8. Loosen the fixing nut of the stopper max flow and disassemble it.



9. Turn in the stopper max flow to get swivel angle zero.

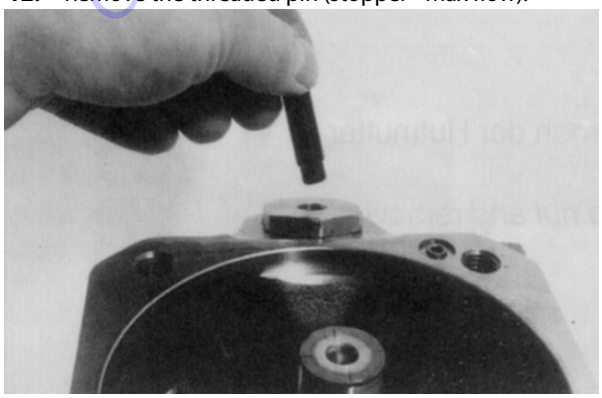


10. Disassemble the rotary group in horizontal position.

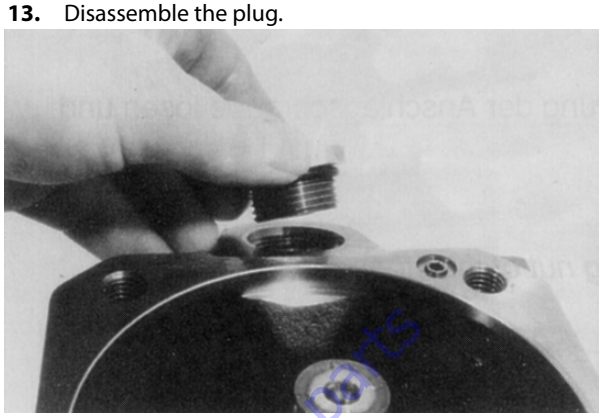


11. Disassemble the stopper - max flow.

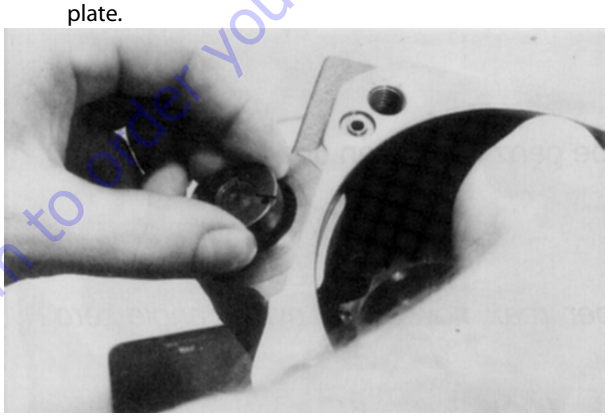
12. Remove the threaded pin (stopper - max flow).



13. Disassemble the plug.

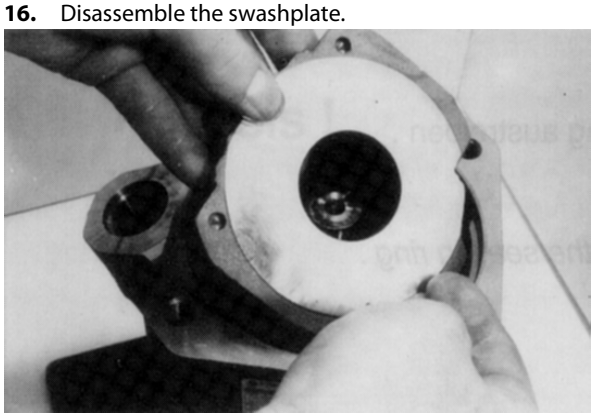


14. Disassemble the control plate while moving the swash-plate.

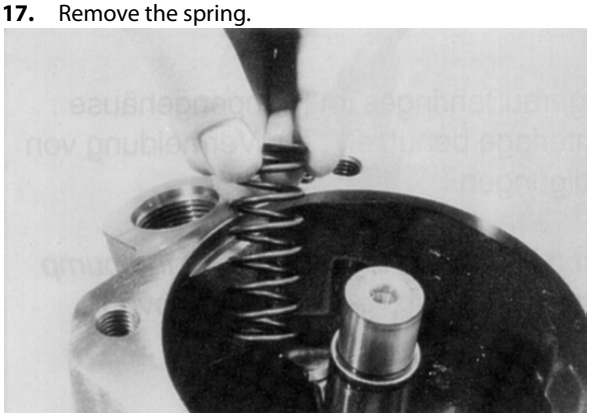


15. The swashplate must be lifted a little bit to disassemble the piston rod.

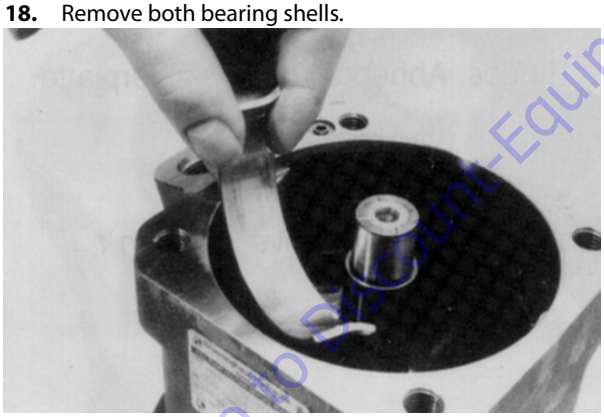
16. Disassemble the swashplate.



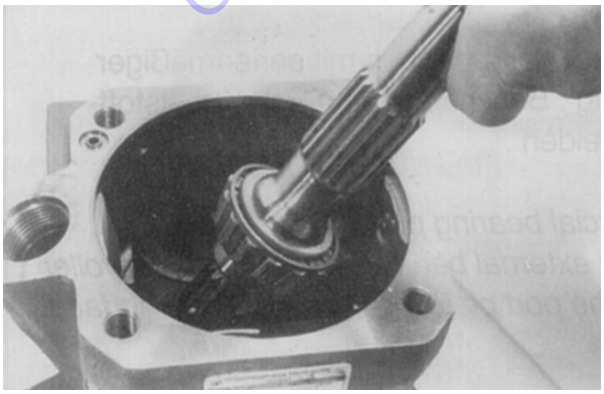
17. Remove the spring.



18. Remove both bearing shells.



19. Remove the drive shaft.

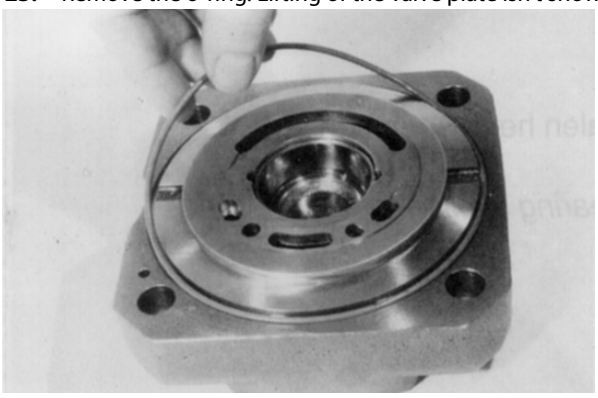


20. Disassemble the snap ring.

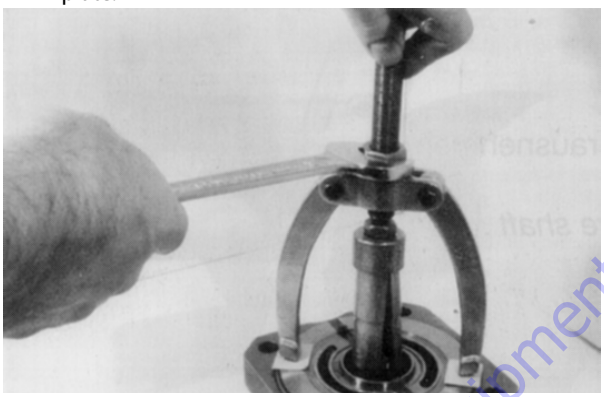
21. Disassemble the sealing ring.

22. The external front bearing ring is pulled out of the pump housing.

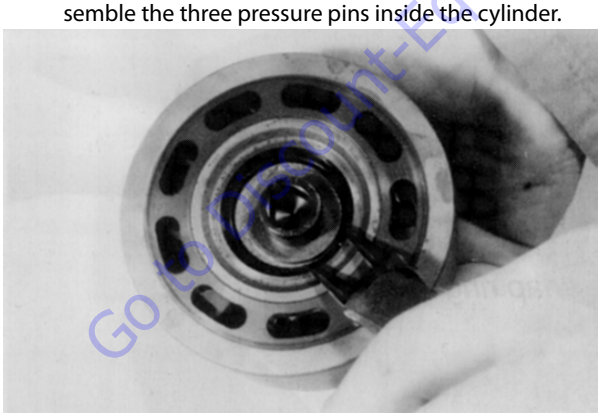
23. Remove the o-ring. Lifting of the valve plate isn't shown.



24. A usual commercial bearing puller is used to disassemble the external bearing ring of the taper roller bearing inside the port plate. Take care of the surface of the port plate.



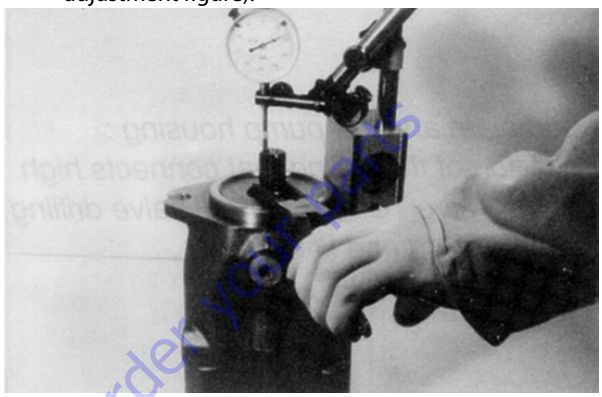
25. The spring has additional pretension while you disassemble the three pressure pins inside the cylinder.



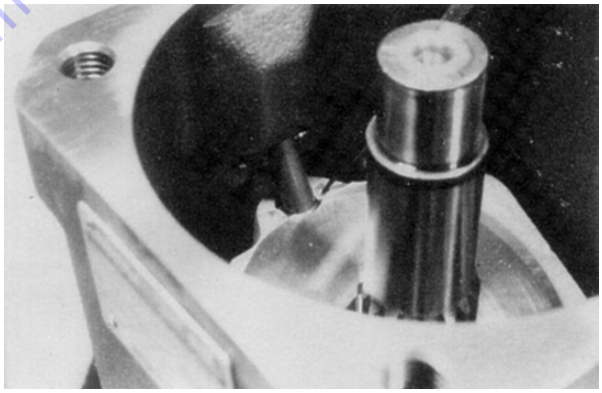
Assembly

1. Assemble the variable displacement pump in reverse order.

2. Measurement of the taper roller bearing pretension (see adjustment figure).

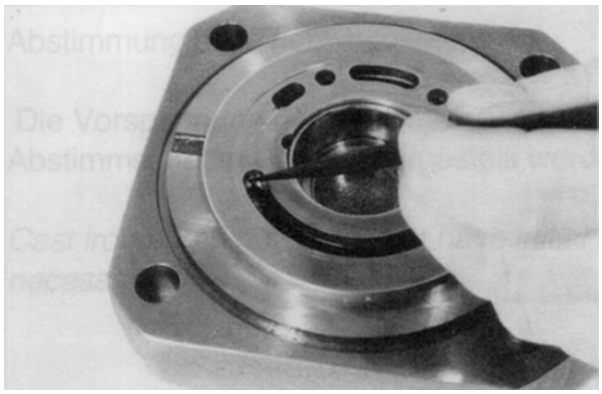


NOTE: *There is a correct connection of the piston rod and swashplate.*

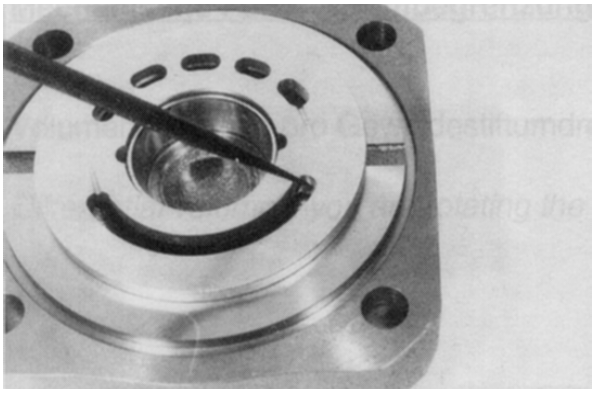


3. Pumps clockwise driven must have a position of the valve plate 4° out of center in the same direction decentered like drive direction.

NOTE: *Spare parts exist as clockwise and counter-clockwise valve plates.*

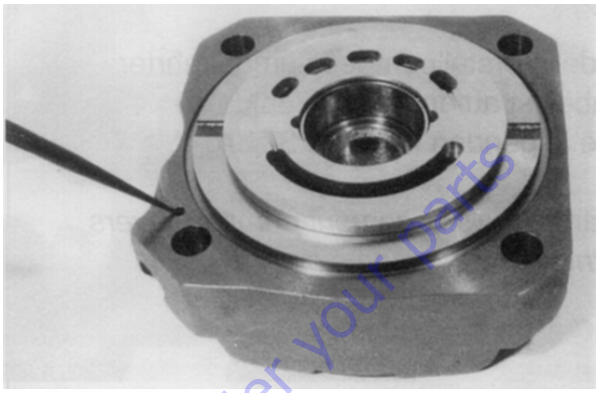


4. Pumps anti-clockwise driven must have a position of the valve plate 4° decentered in counter-clockwise position.

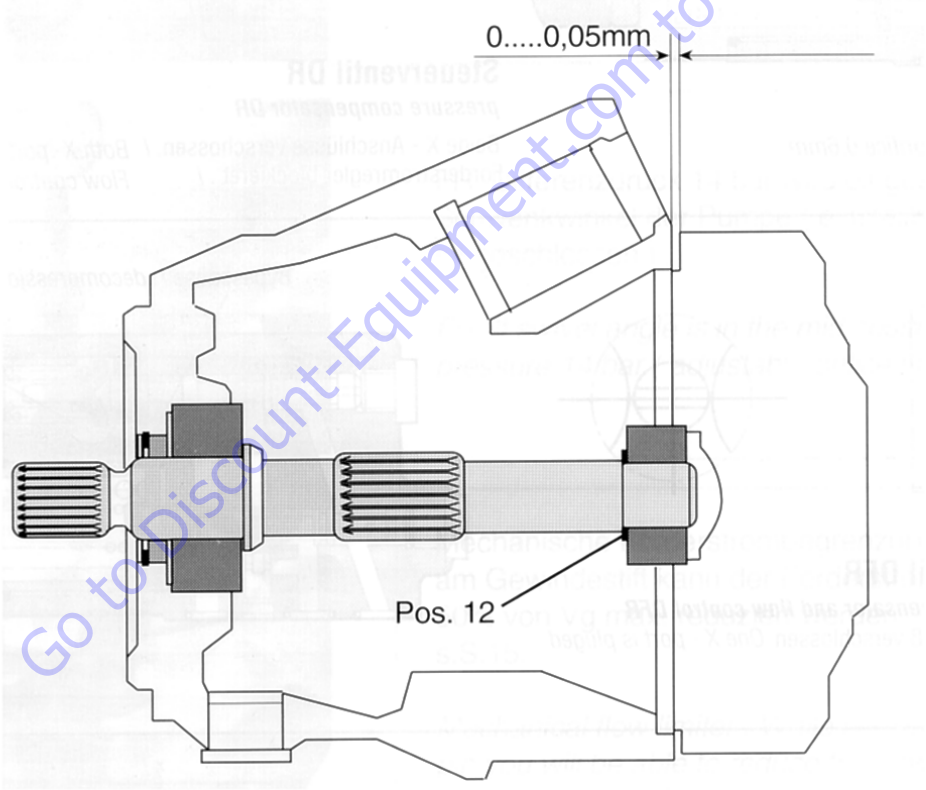


5. Assembly of the port plate and pump housing:

NOTE: *The correct position of the drilling that connects high pressure to the control valve. Check control valve drilling position at the pump housing and fit together.*



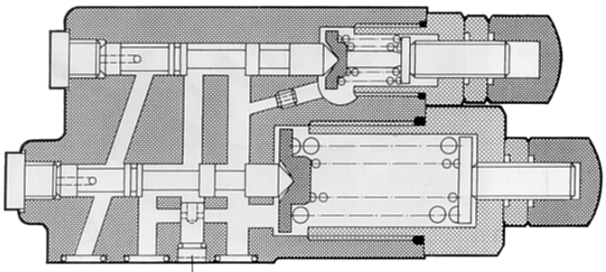
Taper roller bearing initial tension

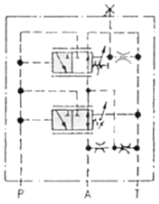


Cast iron pump housing must have initial tension of the bearings : 0.....0,05 mm , grind Pos. 12 if necessary.

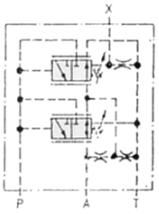
Figure 3-12. Bearing Tension

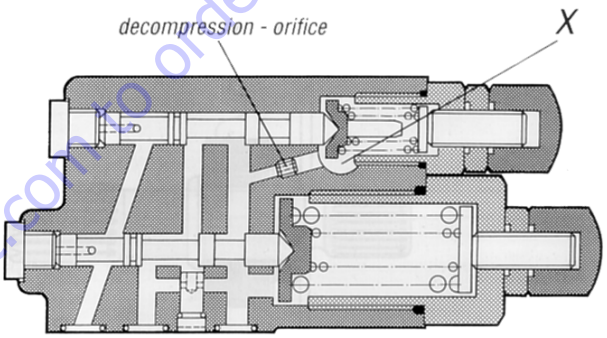
all valves shown here do have open position of the orifice (see picture below "pos. of orifice").



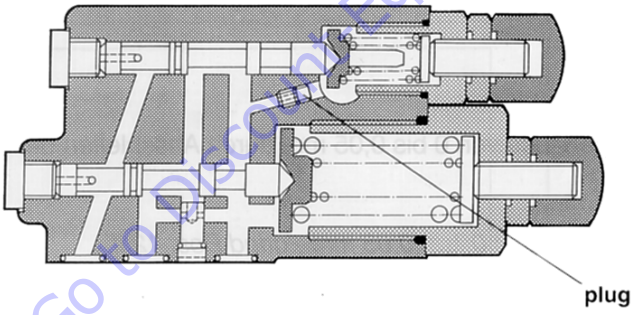


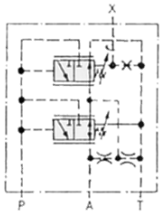
pressure compensator DR
Both X- ports are pluged .
Flow control blocked.



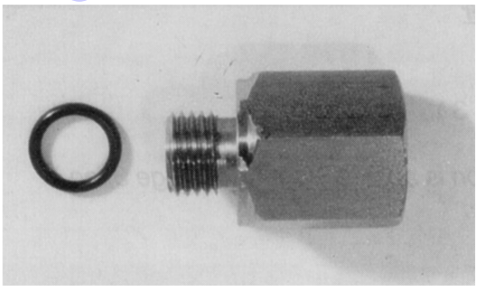


pressure compensator and flow control DFR
One X - port is plugged .





pressure compensator and flow control DFR 1
One X - port is pluged . Decompression orifice X-T is pluged by the plug.



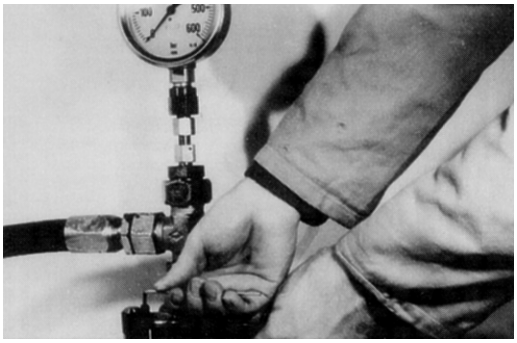
Adapter without orifice of the DFR-pilot valve , if you use a metric pilot pipe connection X .

NOTE: *Differential volume if you are rotating the threaded pin - each rotation is appr. 3,1 cm^3.*

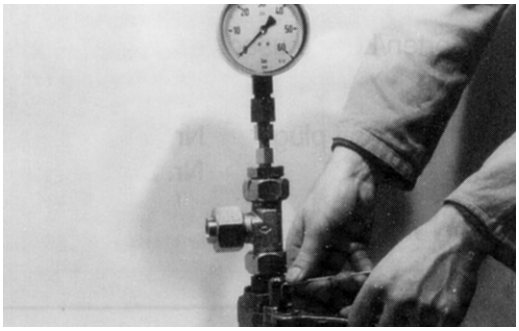
Figure 3-13. Flow Control Pilot Valves

Testing and Setup

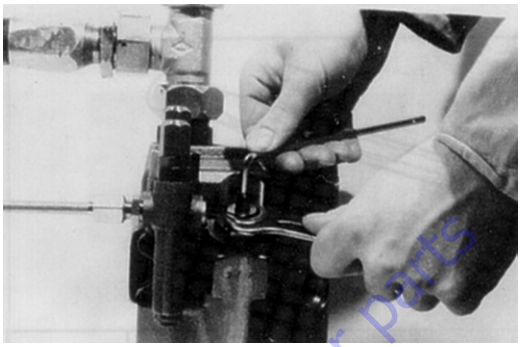
DR: When pressure line is closed adjust the pressure of the controller (if it's DFR design then open the adjustable orifice and increase force of the spring - FR -).



FR: If swivel angle is in the mid position adjust differential pressure 14 bar adjustable orifice is partly closed).



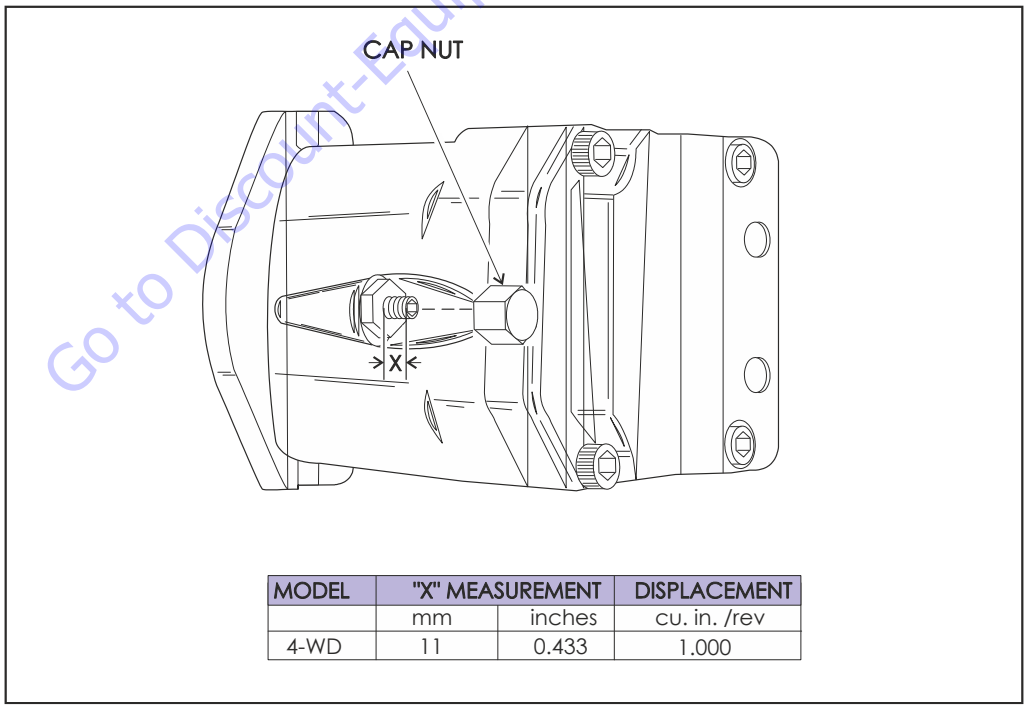
Mechanical flow limiter: While screwing in the threaded pin you will be able to reduce the flow from Vg max to 50% of Vg max.



Drive Motor Adjustment Procedure

1. Remove the cap nut from adjustment screw.
2. Loosen jam nut on the adjustment screw and make adjustment.
3. Measure from top of jam nut to the end of adjustment screw. Refer to Figure 3-14., Drive Motor Adjustment.
4. Tighten jam nut, install cap nut.

NOTE: *The o-ring must be seated in groove in cap nut.*



MODEL	"X" MEASUREMENT		DISPLACEMENT
	mm	inches	cu. in. /rev
4-WD	11	0.433	1.000

Figure 3-14. Drive Motor Adjustment

3.12 DRIVE MOTOR

Description

The drive motors are low to medium power, two-position axial piston motors incorporating an integral servo piston. They are designed for operation in both open and closed circuit applications. The standard control is a direct acting single line hydraulic control. The integral servo piston controls motor displacement.

The motors are spring biased to maximum displacement and hydraulically shifted to minimum displacement. Minimum and maximum displacement can be set with fixed internal stops. The large diameter servo piston allows smooth acceleration and deceleration with relatively large circuit orificing.

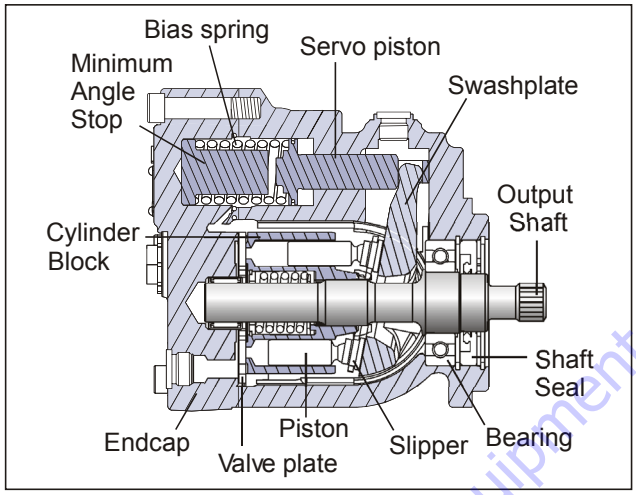
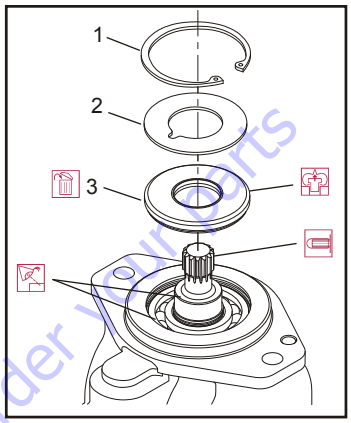


Figure 3-15. Drive Motor Cross Section

Shaft Seal Replacement

REMOVAL

1. Remove the snap ring (1) retaining the shaft seal and support washer.



1. Snap Ring
2. Support Washer
3. Shaft Seal

Figure 3-16. Removing the Shaft Seal

2. Remove the support washer (2).
3. Carefully pry out the shaft seal (3).

NOTE: *To avoid damaging the shaft during removal, install a large sheet metal screw into the chuck of a slide hammer. Drive the screw into the seal surface and use the slide hammer to pull the seal.*

4. Discard the seal.

INSPECT THE COMPONENTS

Inspect the new seal, the motor housing seal bore, and the sealing area on the shaft for rust, wear, and contamination. Polish the shaft and clean the housing if necessary.

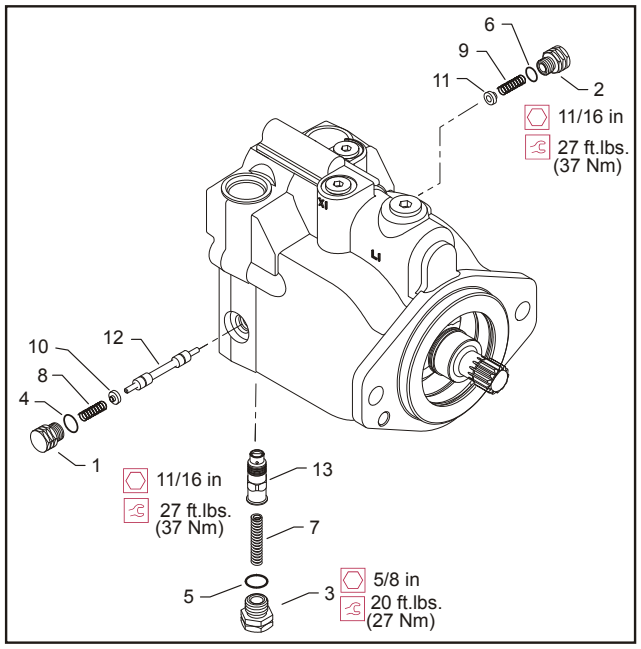
INSTALLATION

1. Cover the shaft splines with an installation sleeve to protect the shaft seal during installation.
2. Install a new shaft seal with the cupped side facing the motor. Press seal into housing until it bottoms out. Press evenly to avoid binding and damaging the seal.
3. Install seal support washer.
4. Install snap ring.
5. Remove the installation sleeve.

Loop Flushing Valve

REMOVAL

1. Using a 11/16 in. internal hex wrench remove plug (1) and (2).



1. Plug
2. Plug
3. Plug
4. O-ring
5. O-ring
6. O-ring
7. Spring
8. Spring
9. Spring
10. Washer
11. Washer
12. Shift Spool
13. Orifice Poppet

Figure 3-17. Loop Flushing Spool

2. Using a 1/4 in. hex wrench remove plug (3).
3. Remove o-rings (4, 5, and 6).
4. Using pliers, remove centering springs (7, 8, and 9).
5. Remove spring retaining washers (10 and 11).
6. Remove shift spool (12).
7. Remove orifice poppet (13).

INSPECT THE COMPONENTS

Inspect new o-rings and the sealing area for rust, wear, or contamination. Also check springs and poppet for wear.

INSTALLATION

1. Install orifice poppet (13).
2. Install shift spool (12).
3. Install spring retaining washers onto springs (10 and 11).
4. Carefully install centering springs (7, 8, and 9).
5. Install new o-rings (6, 4, and 5).
6. Using a 1/4 in. hex wrench torque plug (3) to 20 ft. lbs. (27 Nm).
7. Using a 11/16 in. internal hex, torque plugs (2 and 1) to 27 ft. lbs. (37 Nm).

Troubleshooting

Table 3-3. Excessive Noise and/or Vibration

Item	Description	Action
Check oil level in reservoir and oil supply to the motor.	Insufficient hydraulic fluid could lead to cavitation that would cause system noise.	Fill the reservoir to the proper level and ensure that oil supply to the motor is adequate and the lines are unobstructed.
Check for air in the system.	Air trapped within the system lines, or the motor itself, could result in cavitation that would cause system noise.	Ensure that all of the system lines and components are purged of air.
Inspect the output shaft couplings.	A loose or incorrect shaft coupling will produce vibrations that could result in system noise.	Ensure that the correct coupling is used and that it fits properly onto the shaft.
Inspect the output shaft alignment.	Misaligned shafts create excessive frictional vibration that could result in system noise.	Ensure that the shafts are properly aligned.
Hydraulic oil viscosity above limits.	Viscosity above acceptable limits will result in cavitation that would lead to system noise.	Replace hydraulic oil with appropriate fluid for operating conditions.

Table 3-4. System Operating Hot

Item	Description	Action
Check oil level in reservoir and oil supply to the pump.	Insufficient amount of hydraulic fluid will not meet the cooling demands of the system.	Fill the reservoir to the proper level.
Inspect the heat exchanger (if so equipped).	If the heat exchanger fails, or becomes obstructed, it may not meet the cooling demands of the system.	Ensure that heat exchanger is receiving adequate air flow and that the heat exchanger is in good operating condition. Repair or replace as necessary.
Check the system relief valves.	If a system relief valve becomes unseated for an extended period of time or fails for any other reason, the system could become overheated.	Repair or replace any malfunctioning relief valves as applicable and verify that the loads on the machine are not excessive.

Table 3-5. Won't Shift or Slow to Start

Item	Description	Action
Check the signal line to the servo control port.	Obstructed or restricted flow through the servo control signal lines could result in slow shift or no shift conditions within the motor.	Ensure that the signal lines are not obstructed or restricted and that signal pressure is adequate to shift the motor.
Check that the correct supply and drain orifices are properly installed, and are not obstructed.	Supply and drain orifices determine the shift rate of the motor. The smaller the orifice, the longer the time it takes to shift the motor. Obstruction will also increase shift times.	Ensure that the proper control orifices are installed in the motor and verify that they are not obstructed. Clean or replace as necessary.

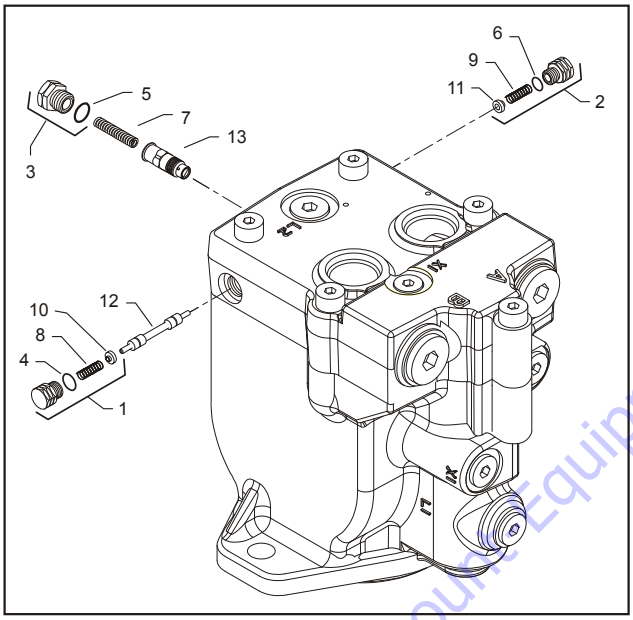
Disassembly

NOTE: *Removal of the end cap voids warranty.*

During assembly, coat all moving parts with a film of clean hydraulic oil. This assures that these parts will be lubricated during start-up.

Replace all o-Rings and gaskets.

It is recommended that all o-rings be replaced. Lightly lubricate all o-rings with clean petroleum jelly prior to assembly.



1. Plug
2. Plug
3. Plug
4. O-ring
5. O-ring
6. O-ring
7. Spring
8. Spring
9. Spring
10. Washer
11. Washer
12. Shift Spool
13. Orifice Poppet

Figure 3-18. Loop Flushing Spool

1. Using a 11/16 in wrench remove plug (1) and (2).

2. Using a 5/8 in hex wrench remove plug (3).

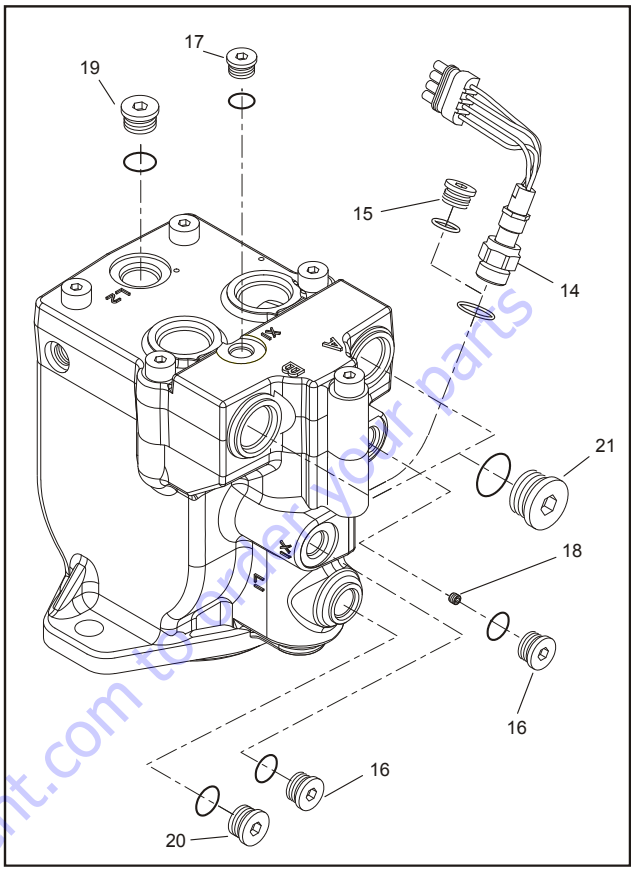
3. Remove o-rings (4, 5, and 6).

4. Using pliers, remove centering springs (7, 8, and 9).

5. Remove spring retaining washers (10 and 11).

6. Remove shift spool (12).

7. Remove orifice poppet (13).



14. Lock Nut
15. O-ring Plug
16. Control Line Plug
17. Control Line Plug
18. Cavity Plug
19. Drain Plug
20. Drain Plug
21. Work Port Plug

Figure 3-19. Plugs, Fittings, and Speed Sensor

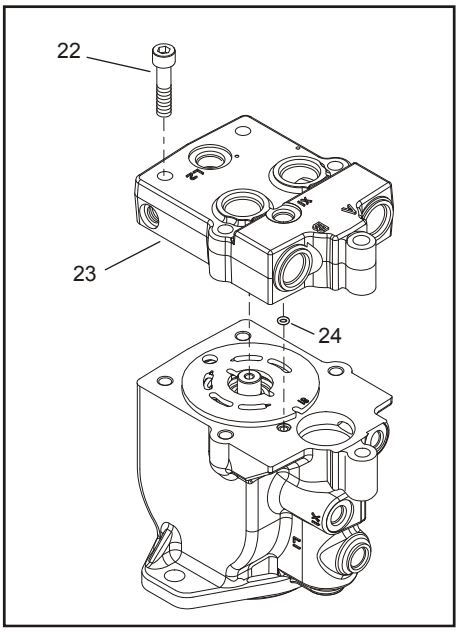
8. Remove all fittings from the unit. Discard any o-rings on the fittings.

9. Using an 11/16 in. hex wrench, loosen the speed sensor lock nut (14) if equipped. Then remove the speed sensor using a Vi in. hex wrench. Units without speed sensor have an o-ring plug (15) installed in that location. Remove it with a Va inch internal hex wrench.

10. Using a 1/4 in. internal hex wrench, remove control line plugs (16, 17). Discard o-rings. Using a 3 mm hex wrench, remove cavity plug (18, if equipped with two-line control) from X2 cavity.

11. Using a 5/16 in. internal hex wrench, remove drain plugs (19, 20). Discard o-rings.

12. Using a 9/16 in. internal hex wrench, remove work port plugs (21, if equipped with axial ports). Discard o-rings.



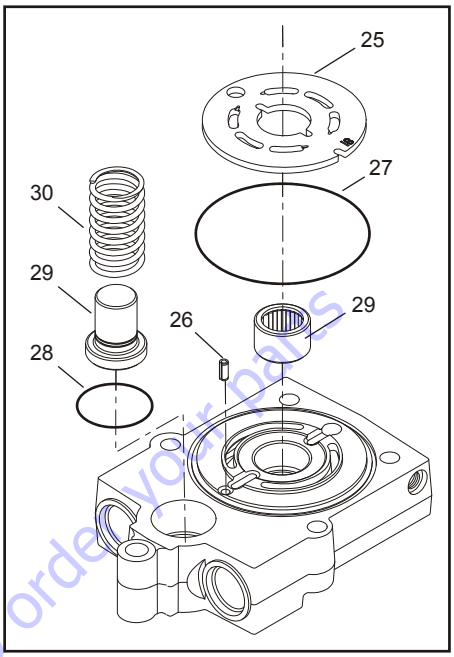
22. Screw
23. End Cap
24. O-ring

Figure 3-20. End Cap

13. Using an 8 mm internal hex wrench, remove the end cap screws (22).

14. Remove the end cap (23). Remove o-ring (24) from the housing or end cap.

When the end cap screws are removed, pressure from the servo spring will cause the end cap to bind on the shaft. Press down on the portion of the end cap covering the servo piston and hold the end cap level while removing.



25. Valve Plate
26. End Cap
27. O-ring
28. O-ring
29. Angle Stop
30. Servo Spring

Figure 3-21. Valve Plate & Rear Shaft Bearing

NOTICE

TAKE CARE NOT TO SCRATCH THE SURFACE OF THE VALVE PLATE.

15. Remove the valve plate (25) and timing pin (26) from the end cap.

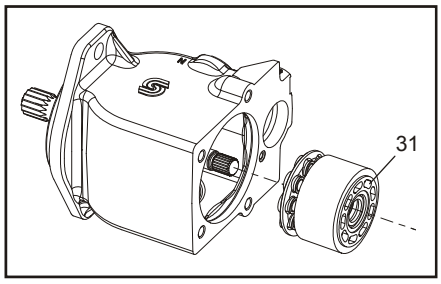
Each displacement has a unique valve plate. For identification, the last two digits of the valve plate part number are stamped on its surface.

16. Remove and discard the o-rings (27, 28).

17. Remove the rear shaft bearing (29) from the end cap with a bearing puller.

The bearing may be difficult to remove with a puller. Try this as an alternative: Pack the bearing cavity with heavy grease. After the shaft is removed, insert it into the bearing cavity and tap lightly with a soft mallet on the splined end. The grease will force the bearing out. Use caution not to drive the bearing past the rear shaft journal as the bearing may become trapped on the shaft and damaged.

18. Remove minimum angle stop (29) and servo spring (30) from the housing.



31. Cylinder Kit Assembly

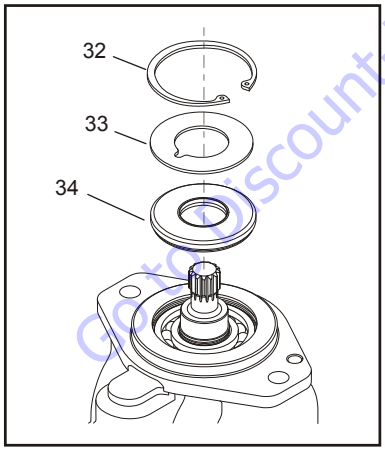
Figure 3-22. Cylinder Kit

19. Turn the housing on its side and remove the cylinder kit assembly (31). Set the assembly aside, being careful not to scratch the running surface.

NOTE: *Grooves on the surface of the cylinder kit identify its displacement:*

Table 3-6. Displacement Identifiers

# of Grooves	Frame L	Frame K
1	25	38
2	30	45
3	35	--

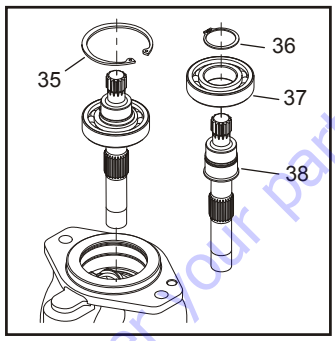


32. Snap Ring
33. Support Washer
34. Shaft Seal

Figure 3-23. Shaft Seal

20. Turn the housing over and remove the snap ring (32) retaining the shaft seal and support washer. Remove the support washer (33) and carefully pry out the shaft seal (34). Discard the seal.

To avoid damaging the shaft during seal removal, install a large sheet metal screw into the chuck of a slide hammer. Drive the screw into the seal surface and use the slide hammer to pull the seal.

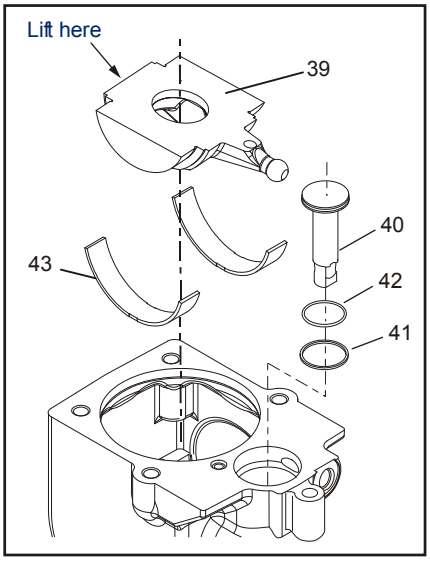


35. Inner Snap Ring
36. Snap Ring
37. Bearing
38. Shaft

Figure 3-24. Shaft & Front Bearing

21. Remove the inner snap ring (35) and the shaft / bearing assembly.

22. Remove the snap-ring (36) retaining the shaft front bearing. Pull the bearing (37) off of the shaft (38).



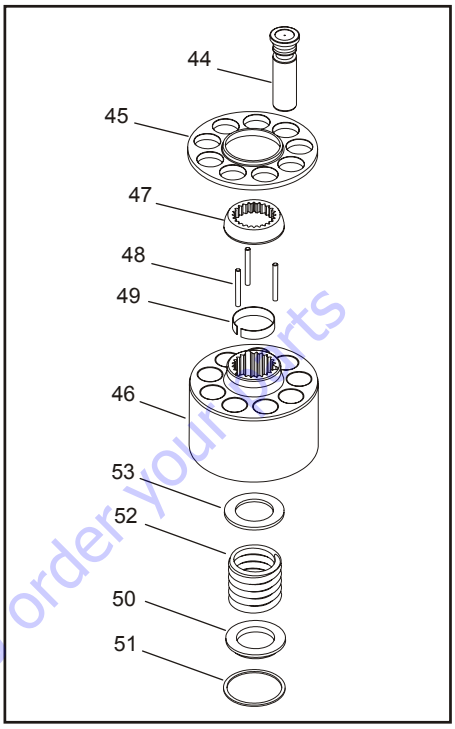
39. Swashplate
40. Servo Piston
41. Piston Seal
42. O-ring
43. Journal Bearings

Figure 3-25. Swashplate & Servo Piston

23. Turn housing over and remove the swashplate (39) by lifting on the end opposite the servo lever.

24. Remove the servo piston (40). Remove the piston seal (41) and o-ring (42) from the servo piston. Discard the seal and o-ring.

25. Remove the journal bearings (43) from the housing. If the bearings are to be reused, note the location and orientation of each bearing for reassembly.



44. Piston
45. Slipper Retainer
46. Cylinder Block
47. Ball Guide
48. Holddown Pins
49. Retaining Ring
50. Block Spring Washer
51. Spiral Retaining Ring
52. Block Spring
53. Inner Block Spring Washer

Figure 3-26. Cylinder Kit Disassembly

26. Remove pistons (44) and slipper retainer (45) from the cylinder block (46).

The pistons are not selectively fitted, however units with high hourly usage may develop wear patterns. Number the pistons and bores for reassembly if they are to be reused.

27. Remove the ball guide (47), hold-down pins (48), and retaining ring (49) from the cylinder block.

NOTE: *Most repairs do not require block spring removal. Perform this procedure only if you suspect problems with the block spring.*

⚠ CAUTION

RISK OF PERSONAL INJURY: COMPRESSING THE BLOCK SPRING REQUIRES FORCE OF ABOUT 80 TO 90 LBF (350 TO 400 N). USE A PRESS SUFFICIENT TO MAINTAIN THIS FORCE WITH REASONABLE EFFORT. ENSURE THE SPRING IS SECURE BEFORE ATTEMPTING TO REMOVE THE SPIRAL RETAINING RING. RELEASE THE PRESSURE SLOWLY AFTER THE RETAINING RING IS REMOVED.

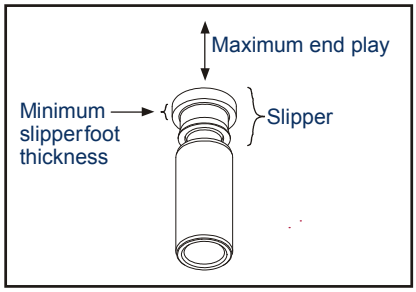
28. Turn the block over. Using a press, apply pressure on the block spring washer (50) to compress the block spring. Compress the spring enough to safely remove the spiral retaining ring (51). While maintaining pressure, unwind the spiral retaining ring (51). Carefully release the pressure and remove the outer block spring washer (50), block spring (52), and inner block spring washer (53) from the cylinder block.

Inspection

After disassembly, wash all parts (including the end-cap and housing) thoroughly with clean solvent and allow to air dry. Blow out oil passages in the housing and end cap with compressed air. Conduct inspection in a clean area and keep all parts free from contamination. Clean and dry parts again after any rework or resurfacing.

PISTON

Inspect the pistons for damage and discoloration. Discolored pistons may indicate excessive heat; do not reuse.



SLIPPERS

Inspect the running surface of the slippers. Replace any piston assemblies with scored or excessively rounded slipper edges. Measure the slipper foot thickness. Replace any piston assemblies with excessively worn slippers. Check the slipper axial end-play. Replace any piston assemblies with excessive end-play.

Minimum slipper foot thickness and maximum axial end-play are given in the table below.

Table 3-7. Slipper Foot Thickness & End Play

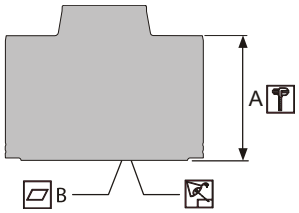
Measurement		L Frame	K Frame
Slipper Foot Thickness	mm (in.)	2.71 (0.11)	4.07 (0.16)
Piston/Slipper End Play		0.15 (0.006)	

CYLINDER BLOCK

Measure the cylinder block height. Replace blocks worn beyond the minimum height specification. Inspect the running surface of the cylinder block. Replace or resurface worn or scratched blocks. Blocks may be resurfaced to the specifications shown in the drawing, provided resurfacing will not reduce the block height below the minimum specification. Table 3-8, Cylinder Block Measurements.

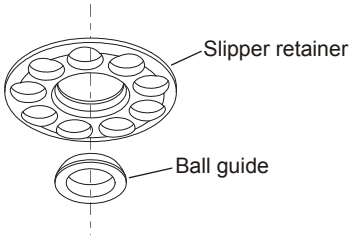
Table 3-8. Cylinder Block Measurements

Measurement	L25	L30	L35	K38	K45
Minimum Cylinder Block Height (A)	50.8 (2.00)	50.8 (2.00)	50.8 (2.00)	54.4 (2.14)	54.4 (2.14)
Cylinder Block Surface Flatness	0.002 (0.0000079)	0.002 (0.0000079)	0.002 (0.0000079)	0.002 (0.0000079)	0.002 (0.0000079)



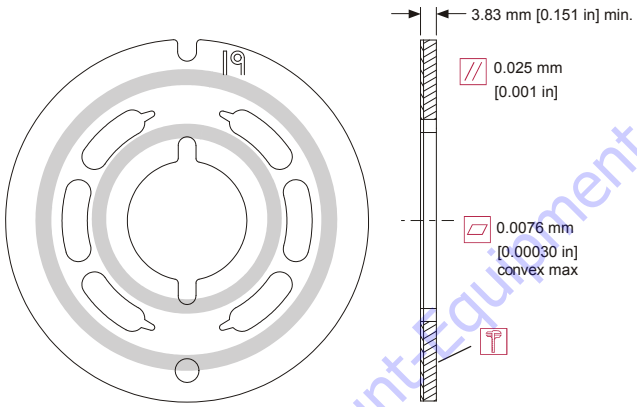
BALL GUIDE AND SLIPPER RETAINER

Inspect the ball guide and slipper retainer for damage, discoloration, or excessive wear. A discolored ball guide or slipper retainer indicates excessive heat. Do not reuse.



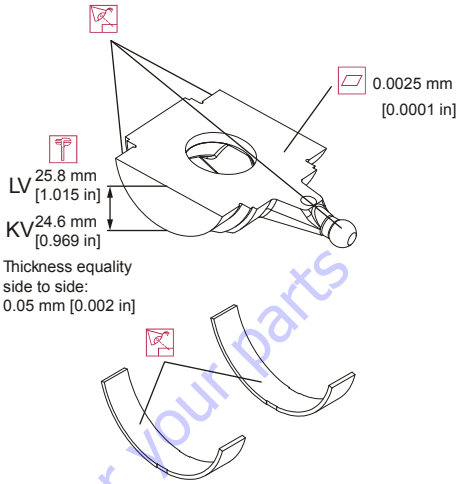
VALVE PLATE

The condition of the valve plate is critical to the efficiency of the motor. Inspect the valve plate surfaces carefully for excessive wear, grooves, or scratches. Replace or resurface grooved or scratched valve plates. Measure the valve plate thickness and replace if worn beyond the minimum specification. Valve plates may be resurfaced to the specifications shown in the drawing, provided resurfacing will not reduce the thickness below the minimum specification.



SWASHPLATE AND JOURNAL BEARINGS

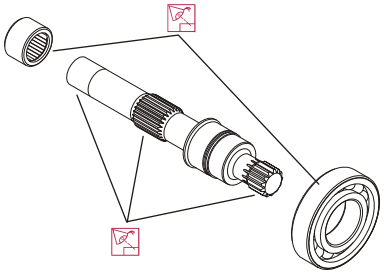
Inspect the running face, servo ball-joint, and swashplate journal surfaces for damage or excessive wear. Some material transfer may appear on these surfaces and is acceptable providing the surface condition meets specifications shown. Measure the swashplate thickness from the journals to the running face. Replace swashplate if damaged or worn beyond minimum specification. Replace swashplate if the difference in thickness from one side to the other exceeds specification.



Inspect the journal bearings for damage or excessive wear. Replace journal bearings if scratched, warped, or excessively worn. The polymer wear layer must be smooth and intact.

SHAFT BEARINGS

Inspect bearings for excessive wear or contamination. Rotate the bearings while feeling for uneven movement. Bearings should spin smoothly and freely. Replace bearings that appear worn or do not rotate smoothly.

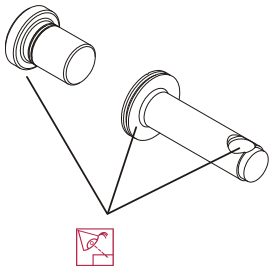


SHAFT

Inspect the motor shaft. Look for damage or excessive wear on the output and block splines. Inspect the bearing surfaces and sealing surface. Replace shafts with damaged or excessively worn splines, bearing surfaces, or sealing surfaces.

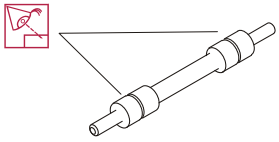
SERVO PISTON AND MINIMUM ANGLE STOP

Inspect the minimum angle stop, servo piston head, and servo piston ball-socket for damage or excessive wear. Replace if necessary.



LOOP FLUSHING SPOOL

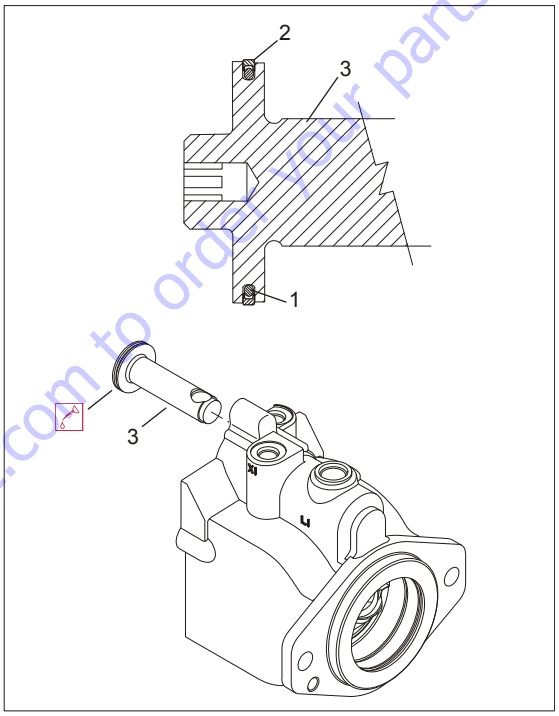
Inspect the loop flushing spool. Check for cracks or damage. Replace if necessary.



Assembly

1. Install new o-ring (1) and piston seal (2) to the servo piston (3). Install the piston seal over the o-ring.

   Installing the piston seal stretches it, making it difficult to install the servo piston in its bore. Allow 30 minutes for the seal to relax after installation. To speed up seal relaxation, compress the seal by installing the piston head into the servo cavity in the end-cap and let it stand for at least five minutes.



1. O-ring
2. Piston Seal
3. Servo Piston

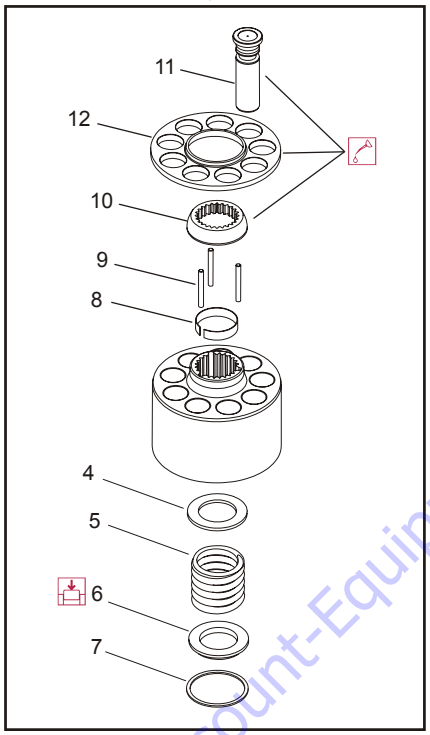
Figure 3-27. Servo Piston

2. After piston seal has relaxed, lubricate and install servo piston into the housing bore. Align the piston with the ball socket facing the inside of the housing.

⚠ CAUTION

RISK OF PERSONAL INJURY: COMPRESSING THE BLOCK SPRING REQUIRES ABOUT 80 TO 90 LBF (350 TO 400 N) OF FORCE. USE A PRESS SUFFICIENT TO MAINTAIN THIS FORCE WITH REASONABLE EFFORT. ENSURE THE SPRING IS SECURE BEFORE ATTEMPTING TO INSTALL THE SPIRAL RETAINING RING. RELEASE THE PRESSURE SLOWLY AFTER THE RETAINING RING IS INSTALLED.

3. Install the inner block spring washer (4), block spring (5), and outer washer (6) into the cylinder block. Using a press, compress the block spring enough to expose the retaining ring groove. Wind the spiral retaining ring (7) into the groove in the cylinder block.



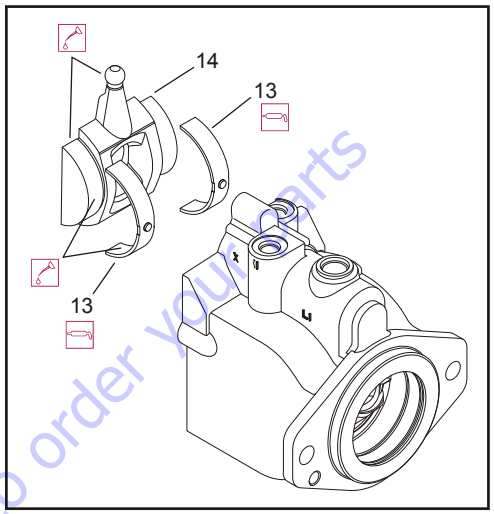
4. Block Spring Washer
5. Block Spring
6. Outer Washer
7. Spiral Retaining Ring
8. Retaining Ring
9. Holddown Pins
10. Ball Guide
11. Piston
12. Slipper Retainer

Figure 3-28. Cylinder Kit Assembly

4. Turn the block over and install the retaining ring (8), hold-down pins (9), and ball guide (10) to the cylinder block.

5. Install the pistons (11) to the slipper retainer (12). Install the piston/retainer assembly into the cylinder block. Ensure the concave surface of the retainer seats on the ball guide. If you're reusing the pistons, install them to the original block bores. Lubricate the pistons, slippers, retainer, and ball guide before assembly. Set the cylinder kit aside on a clean surface until needed.

6. Install the journal bearings (13) into the housing seats. Use assembly grease to keep the bearings seated during assembly. Ensure the locating nubs drop into the cavities in the seats. If you're reusing the bearings, install them in the original location and orientation. Lubricate the journal bearings.

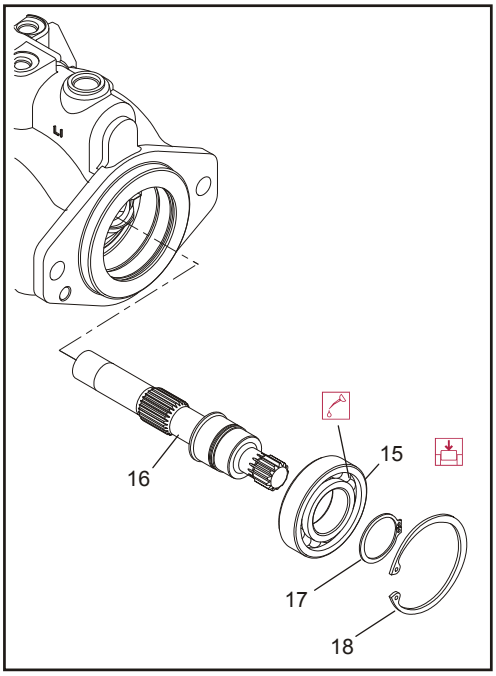


13. Journal Bearings
14. Swashplate

Figure 3-29. Swashplate and Journal Bearing

7. Install the swashplate (14) into the housing. Tilt the swashplate and guide the servo lever ball into its socket in the servo piston rod. Ensure the swashplate seats into the journal bearings and moves freely. Lubricate the running surface of the swashplate.

8. Press front shaft bearing (15) onto shaft (16). Press bearing onto shaft with lettering facing out. Lubricate bearing rollers. Install snap-ring (17) onto shaft.

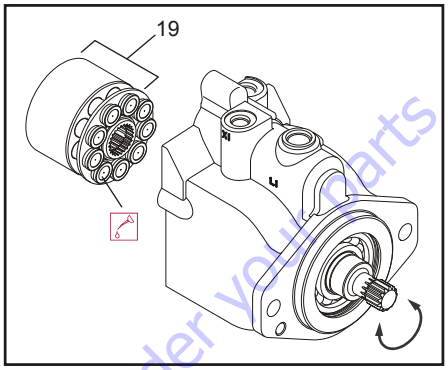


15. Front Shaft Bearing
16. Shaft
17. Snap Ring
18. Snap Ring

Figure 3-30. Shaft and Front Bearing

9. While holding the swashplate in place, turn the housing on its side. Install the install shaft/bearing assembly into housing from the flange end. Install the snap-ring (18).

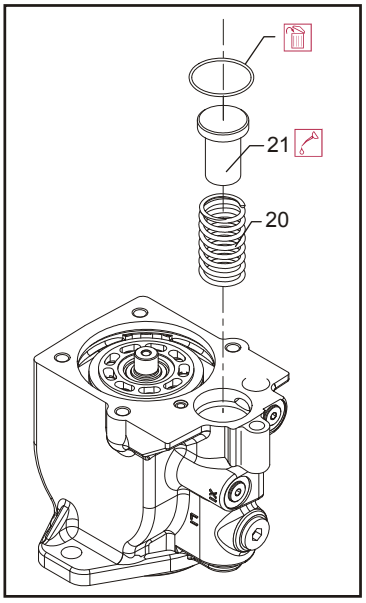
10. Verify swashplate and bearings are properly seated. Install the cylinder kit (19) onto the shaft. Install with the slippers facing the swashplate. Rock the shaft to align the block splines and slide the cylinder kit into place. Orient the motor with the shaft pointing downward and verify the cylinder kit, swashplate, journal bearings, and servo piston are all secure and properly installed.



19. Cylinder Kit

Figure 3-31. Cylinder Kit Installation

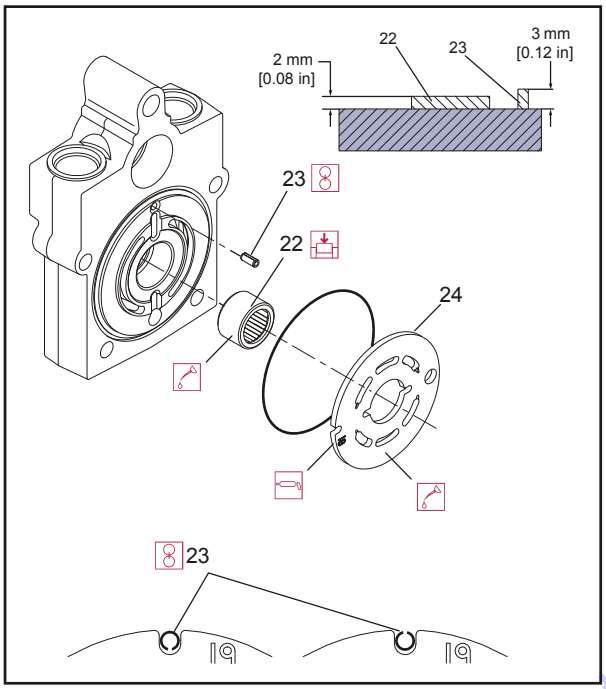
11. Lubricate and install the servo spring (20), and minimum angle stop (21) into the housing bore.



20. Servo Spring
21. Minimum Angle Stop

Figure 3-32. Servo Spring and Minimum Angle Stop

12. Press the rear shaft bearing (22) into the end cap. Install the bearing with letters facing out. Press until bearing surface is 0.08 ±0.01 in (2 ±0.25 mm) above end cap surface.



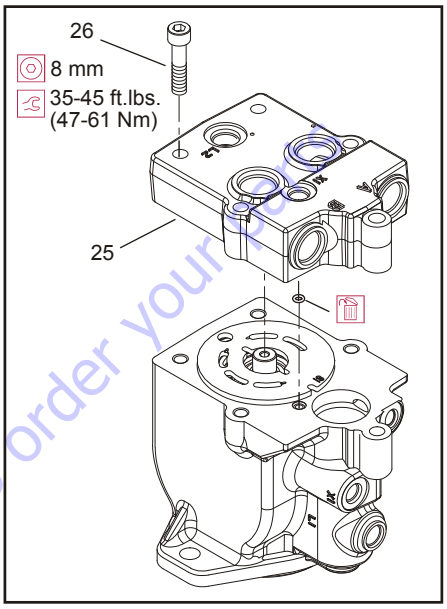
22. Rear Shaft Bearing
23. Timing Pin
24. Valve Plate

Figure 3-33. Valve Plate and Rear Bearing

13. Install timing pin (23) into its bore in the end cap. Install the pin with its groove facing toward or away from the shaft. Press the pin until the end protrudes 0.12 ±0.01 in (3 ±0.25 mm) above end cap surface.

14. Install the valve plate (24) onto the end cap. Install the valve plate with the yellow surface toward the cylinder block. Align the slot in the valve plate with the timing pin. Apply a liberal coat of assembly grease to the end cap side of the valve plate to keep it in place during installation.

15. Install the end cap (25) onto the housing with the end cap screws (26). Check to ensure the end cap will properly seat onto the housing without interference. Improper assembly of the internal components may prevent the end cap from seating properly. Ensure the o-rings seat properly when installing the end cap.



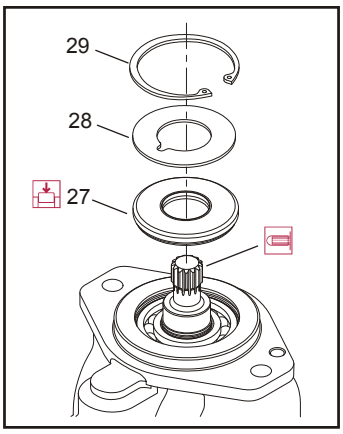
25. End Cap
26. Screw

Figure 3-34. End Cap

16. Using an 8 mm internal hex wrench, tighten the end cap screws. Tighten the screws in opposite corners slowly and evenly to compress the servo spring and properly seat the end cap. Torque end cap screws 35-45 ft. lbs. (47-61 Nm).

17. Before installing the shaft seal, ensure the shaft turns smoothly with less than 120 in. lbs. (13.5 Nm) of force. If the shaft does not turn smoothly within the specified maximum force, disassemble and check the unit.

18. Cover shaft splines with an installation sleeve. Install a new shaft seal (27) with the cup side facing the motor. Press seal into housing until it bottoms out. Press evenly to avoid binding and damaging the seal. Install seal support washer (28) and snap ring (29).



27. Shaft Seal
28. Seal Support Washer
29. Snap Ring

Figure 3-35. Shaft Seal

19. Install remaining plugs and fittings to the housing. Refer to the drawing below for wrench sizes and installation torques.

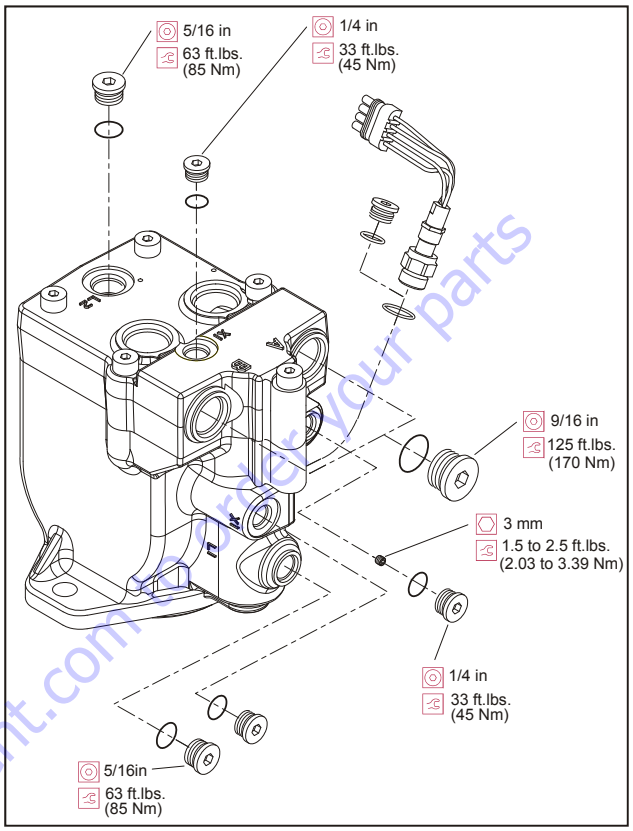
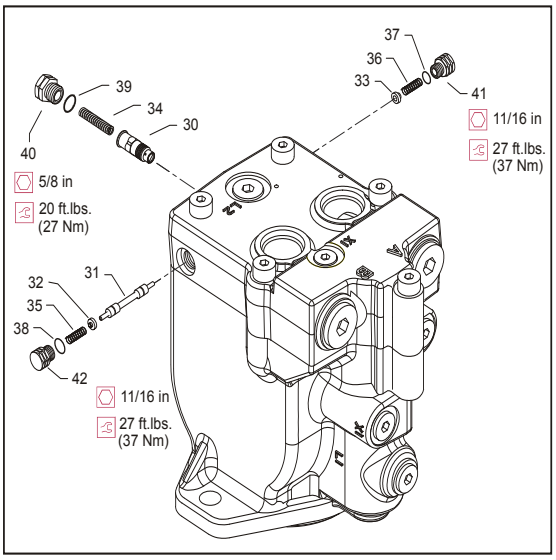


Figure 3-36. Plugs and Fittings Installation

20. Install orifice poppet (30).



30. Orifice Poppet	34. Spring	37. O-ring	40. Plug
31. Shift Spool	35. Spring	38. O-ring	41. Plug
32. Spring	36. Spring	39. O-ring	42. Plug
33. Spring			

Figure 3-37. Loop Flushing Spool

21. Install shift spool (31).

22. Install spring retaining washers onto springs (32 and 33).

23. Carefully install centering springs (34, 35, and 36).

24. Install new o-rings (37, 38, and 39).

25. Using a 5/8 in wrench torque plug (40) to 20 ft. lbs. (27 Nm).

26. Using a 11/16 in wrench, torque plugs (41 and 42) to 27 ft.lbs. (37 Nm).

Initial Start-up Procedures

Follow this procedure when starting-up a new motor or when installing a motor that has been removed.

NOTICE

INSPECT MOTOR FOR DAMAGE BEFORE INSTALLATION. MAKE CERTAIN ALL SYSTEM COMPONENTS (RESERVOIR, HOSES, VALVES, FITTINGS, HEAT EXCHANGER, ETC.) ARE CLEAN BEFORE FILLING WITH FLUID.

1. Fill the reservoir with recommended hydraulic fluid. Always filter fluid through a 10 micron filter when pouring into the reservoir. Never reuse hydraulic fluid.

2. Fill the inlet line leading from the pump to the reservoir. Check the inlet line for properly tightened fittings and be certain it is free of restrictions and air leaks.

3. Fill the pump and motor housing with clean hydraulic fluid. Pour filtered oil directly into the upper most case drain port.

4. To ensure the pump and motor stay filled with oil, install case drain lines into the upper most case drain ports.

5. Install a 0 to 500 psi (0 to 35 bar) gauge in the charge pressure gauge port of the pump to monitor system pressure during start up.

6. While watching the pressure gauge, run the engine at the lowest possible speed until system pressure builds to normal levels (minimum 160 psi [11 bar]). Once system pressure is established, increase to full operating speed. If system pressure is not maintained, shut down the prime mover, determine cause, and take corrective action.

7. Operate the hydraulic system for at least fifteen minutes under light load conditions.

8. Check and adjust control settings as necessary after installation.

9. Shut down the prime mover and remove the pressure gauge. Replace plug at the charge pressure gauge port.

10. Check the fluid level in the reservoir; add clean filtered fluid if necessary. The motor is now ready for operation.

3.13 DRIVE HUB (4WD MACHINES W/ INTEGRAL BRAKE) (PRIOR TO SN 0300083331)

Roll, Leak and Brake Testing

Drive Hub units should always be roll and leak tested before disassembly and after assembly to make sure that the unit's gears, bearings and seals are working properly. The following information briefly outlines what to look for when performing these tests.

NOTE: *The brake must be released before performing the roll test. This can be accomplished by either pressurizing the brake using the Brake Leak Test procedure below or by tightening the bolts into the piston through the end plate (See Brake Disassembly Procedure).*

NOTE: *Bolts must be removed while performing brake release test.*

THE ROLL TEST

The purpose of the roll test is to determine if the unit's gears are rotating freely and properly. You should be able to rotate the gears in your unit by applying constant force to the roll checker. If you feel more drag in the gears only at certain points, then the gears are not rolling freely and should be examined for improper installation or defects. Some gear packages roll with more difficulty than others. Do not be concerned if the gears in your unit seem to roll hard as long as they roll with consistency.

THE LEAK TEST (MAIN UNIT)

The purpose of a leak test is to make sure the unit is air tight. You can tell if your unit has a leak if the pressure gauge reading on your leak checking fitting starts to fall after the unit has been pressurized and allowed to equalize. Leaks will most likely occur at the pipe plugs, the main seal or wherever o-rings or gaskets are located. The exact location of a leak can usually be detected by brushing a soap and water solution around the main seal and where the o-rings or gaskets meet on the exterior of the unit, then checking for air bubbles. If a leak is detected in a seal, o-ring or gasket, the part must be replaced, and the unit rechecked. Leak test at 10 psi for 20 minutes.

THE BRAKE TEST

Input Brake - 1,850 in-lb (208 Nm) Static,
225 psi (15.5 bar) Full Release,
3000 psi (207 bar) maximum o-ring check.

If brake does not release at these pressure values, brake has to be inspected, repaired or replaced.

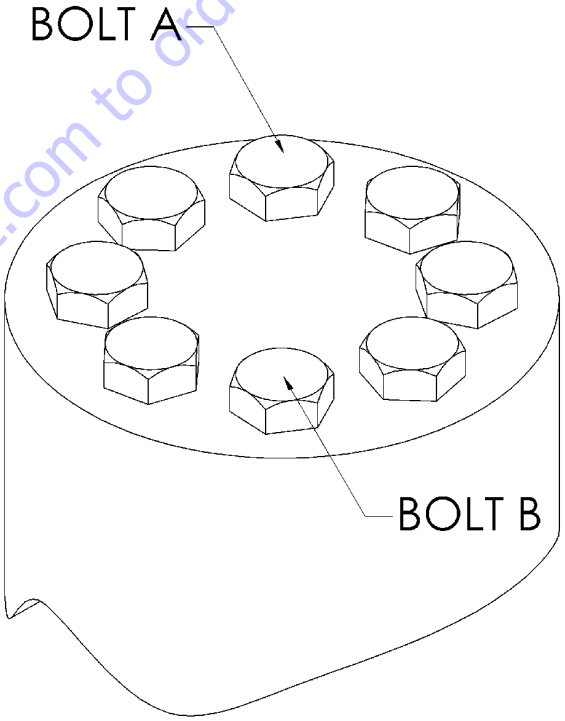
NOTE: *Failure to perform this test may result in damaged or ineffective brake parts.*

Tightening and Torquing Bolts

If an air impact wrench is used to tighten bolts, extreme care should be taken to ensure that the bolts are not tightened beyond their specified torque.

The following steps describe how to tighten and torque bolts or socket head capscrews in a bolt circle.

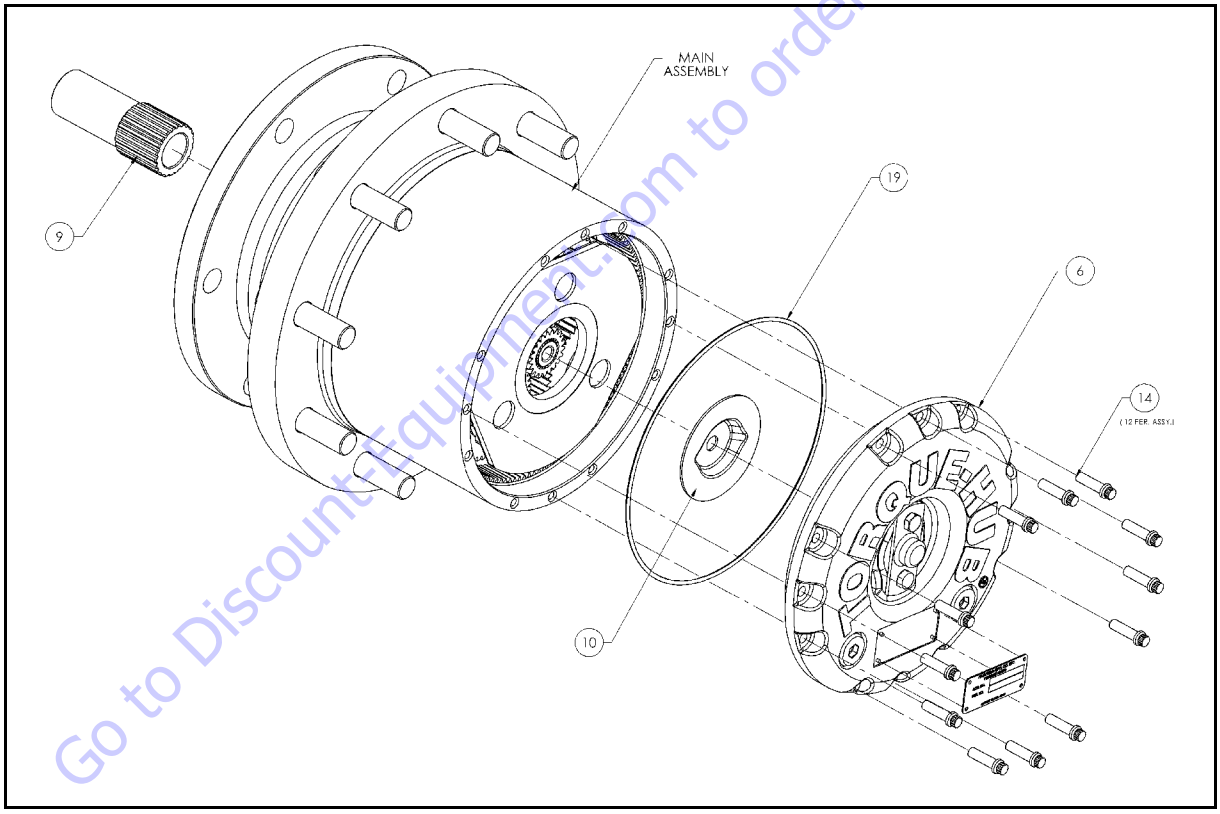
1. Tighten (but do not torque) bolt “A" until snug.
2. Go to the opposite side of the bolt circle and tighten bolt "B" until equally snug.
3. Crisscross around the bolt circle and tighten remaining bolts.
4. Now use a torque wrench to apply the specified torque to bolt "A".
5. Using the same sequence, crisscross around the bolt circle and apply an equal torque to the remaining bolts.



Main Disassembly

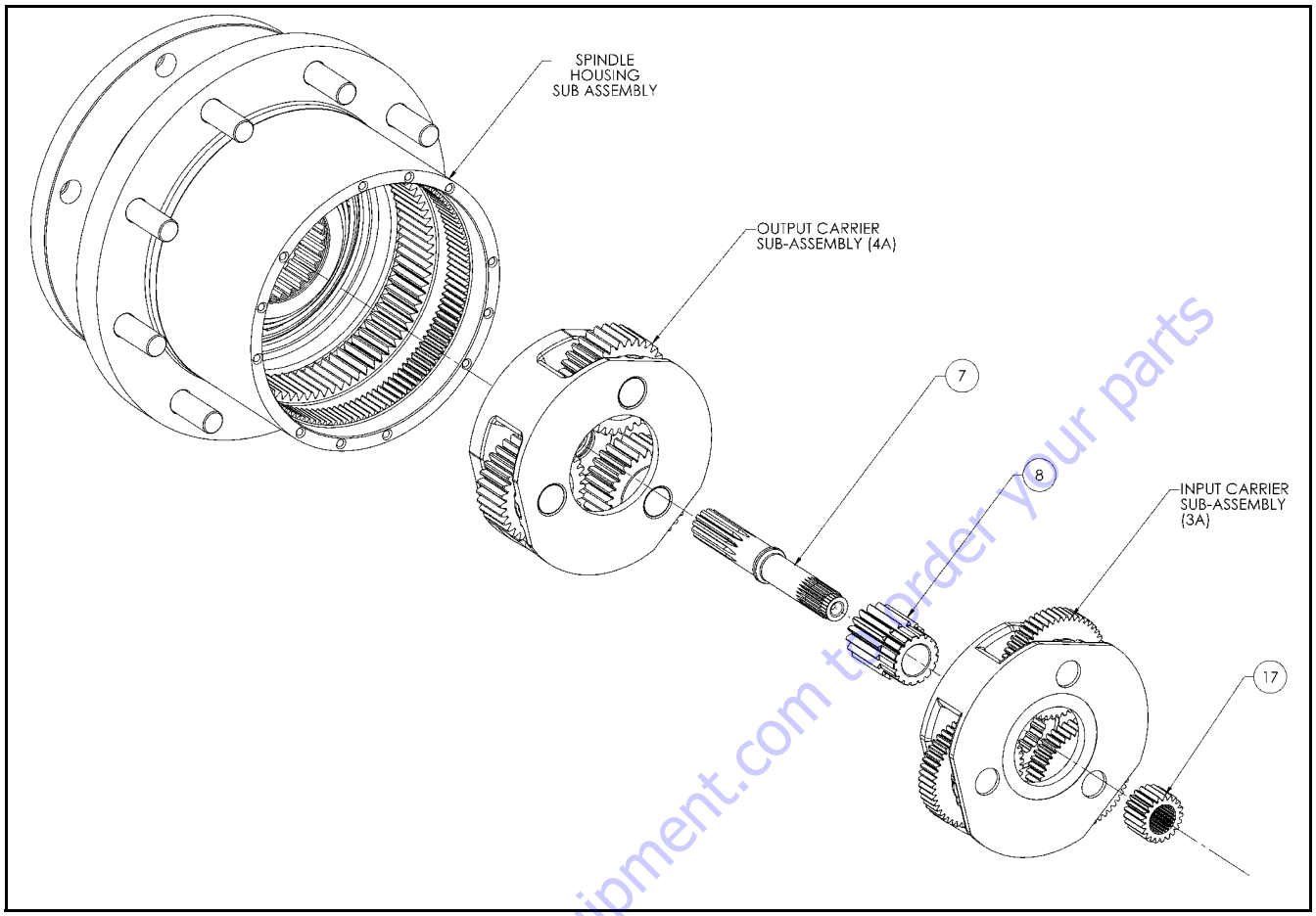
NOTE: *Refer to Figure 3-38., Main Disassembly - Sheet 1 of 2 and Figure 3-39., Main Disassembly- Sheet 2 of 2.*

1. Perform Roll Check, Leak Check and Brake Check if applicable prior to disassembling the unit.
2. Drain oil from unit. Note the condition and volume of the oil.
3. Remove Input Coupling (9) from Spindle (1A) end of unit.
4. Remove Cover Bolts (14) and remove Cover (6).
5. Remove O-ring (19) and Thrust Spacer (10) from the Cover (6).
6. Remove Input Sun Gear (17) from Input Carrier Sub-Assembly (3A).
7. Remove Input Carrier Sub-Assembly (3A) from Housing (1E).
8. Remove Output Sun Gear (8) from Output Carrier Sub-Assembly (4A).
9. Remove Input Shaft (7) from Output Carrier Sub-Assembly (4A).
10. Remove Output Carrier Sub-Assembly (4A) from Housing (1E).



6. Cover
9. Input Coupling
10. Thrust Spacer
14. Cover Bolts
19. O-ring

Figure 3-38. Main Disassembly - Sheet 1 of 2



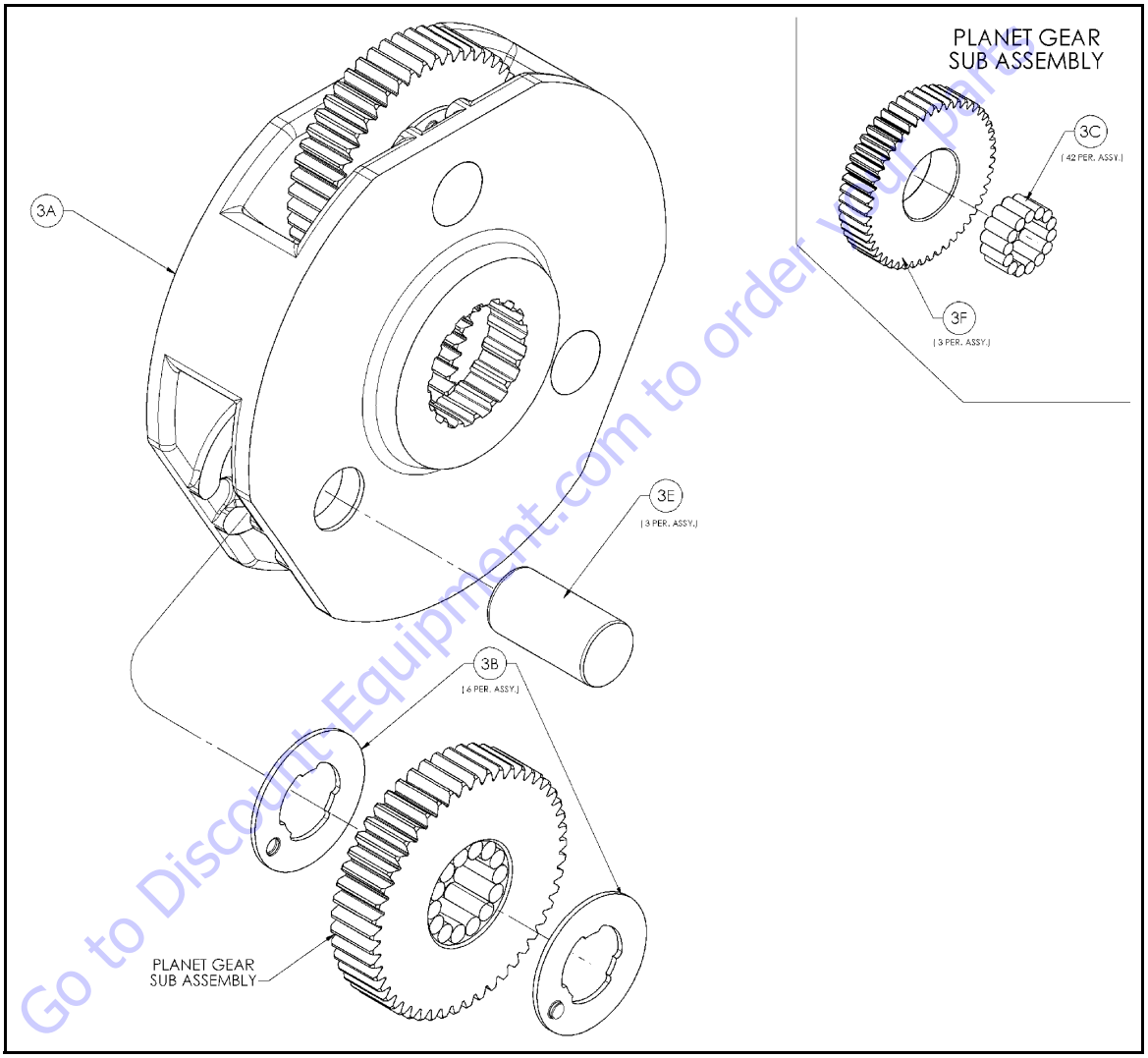
7. Input Shaft
8. Output Sun Gear
17. Input Sun Gear

Figure 3-39. Main Disassembly- Sheet 2 of 2

Input Carrier Disassembly

NOTE: *Refer to Figure 3-40., Input Carrier Disassembly.*

1. Place the Carrier (3A) on a press with the spline end up and drive the Planet Shaft (3E) out of the Carrier (3A).
2. Slide the Planet Gear (3F) and the two Thrust Washers (3B) out of the Carrier (3A).
3. Remove the 14 needle Bearings (3C) from the bore of the Planet Gear (3F).
4. Repeat steps 1 through 3 for each of the two remaining planet gears.



3A. Carrier
3B. Thrust Washers
3C. Needle Bearings
3E. Planet Shaft
3F. Planet Gear

Figure 3-40. Input Carrier Disassembly

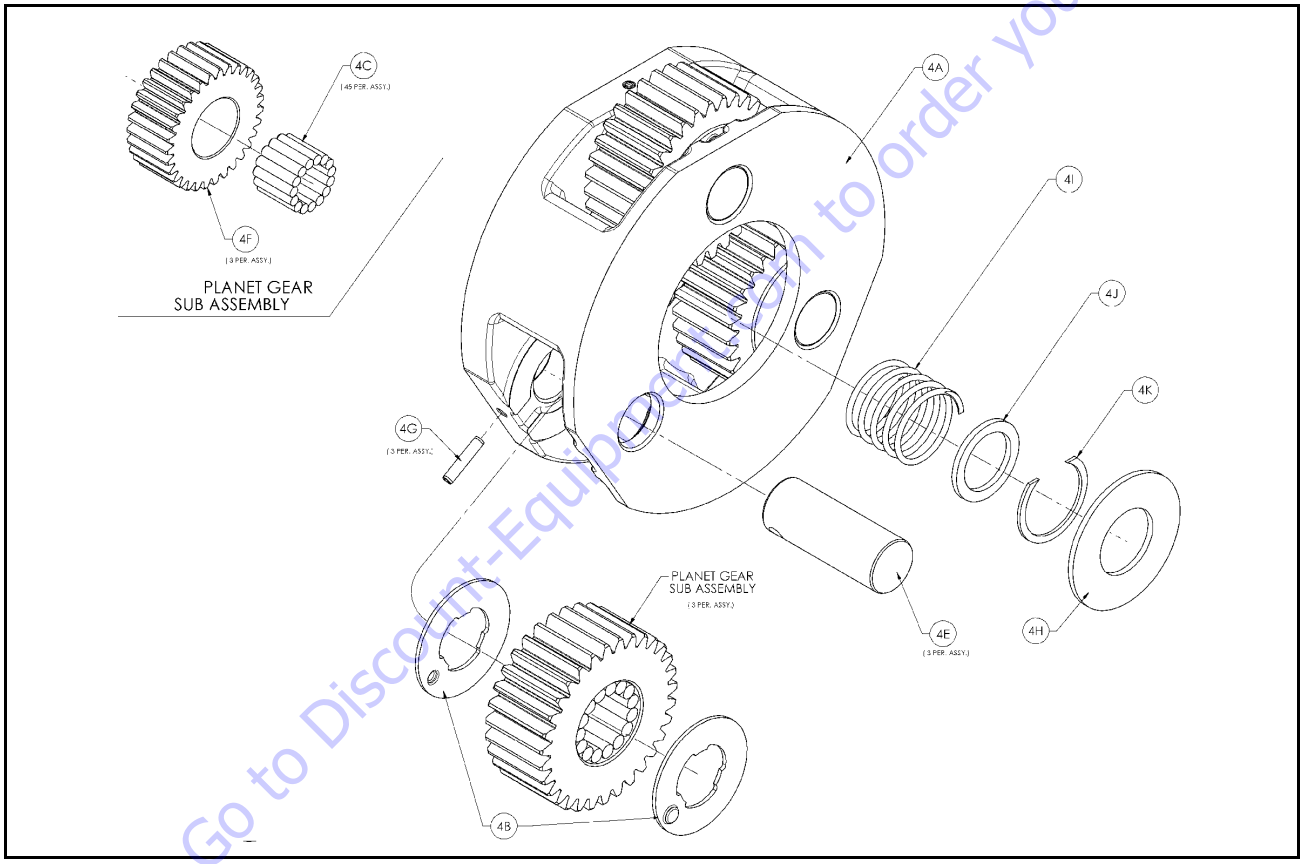
Output Carrier Disassembly

NOTE: *Refer to Figure 3-41., Output Carrier Assembly.*

1. Using a small diameter punch, Drive the Roll Pin (4G) which holds the Planet Shaft (4E) in the Carrier (4A) down into the Planet Shaft (4E) until it bottoms.

NOTE: *Make sure that the Roll Pin has bottomed. Otherwise, damage to the carrier could occur when the Planet Shaft is removed.*

2. Remove the Planet Shaft (4E) from the Carrier (4A). Use a small punch to remove the Roll Pin (4G) from the Planet Shaft (4E).
3. Slide the Planet Gear (4F) and the two Thrust Washers (4B) out of the Carrier (4A).
4. Remove the 15 needle Bearings (4C) from the bore of the Planet Gear (4F).
5. Repeat steps 1 through 4 for each of the two remaining planet gears.
6. Remove the Thrust Washer (4H) from the Carrier (4A).
7. Using retaining ring pliers, remove the Retaining Ring (4K) from the Carrier (4A) and pull the Thrust Washer (4J) and Spring (4I) out of the Carrier (4A).



4A. Carrier
4B. Thrust Washers
4C. Needle Bearings
4E. Planet Shaft
4F. Planet Gear
4G. Roll Pin
4H. Thrust Washer
4I. Spring
4J. Thrust Washer
4K. Retaining Ring

Figure 3-41. Output Carrier Assembly

Housing-Spindle Disassembly

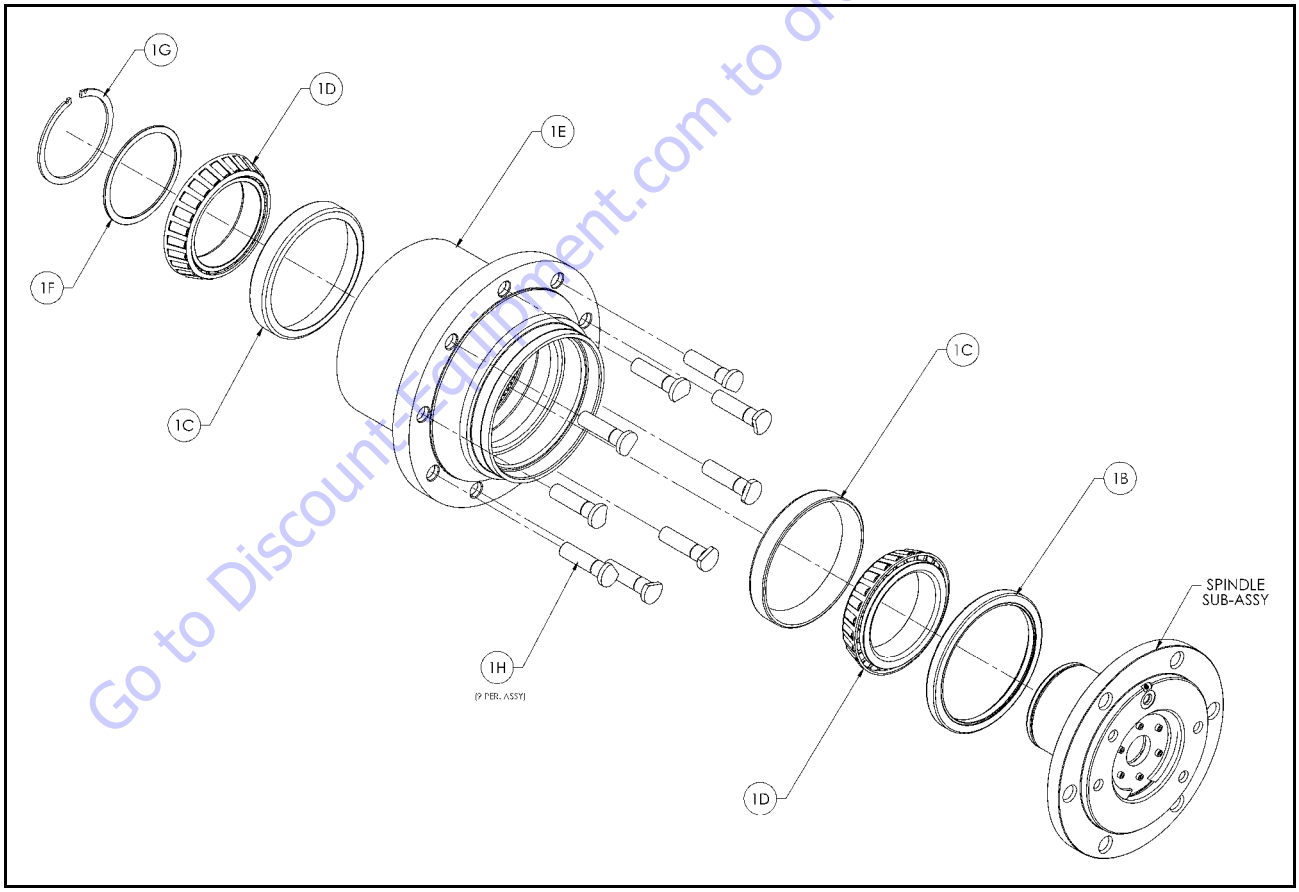
NOTE: *Refer to Figure 3-42., Housing-Spindle Disassembly.*

1. Place unit on bench with Spindle (1A) end down.

⚠ CAUTION

EYE PROTECTION MUST BE WORN WHILE PERFORMING THE NEXT STEP IN THIS PROCEDURE.

2. Using retaining ring pliers, remove Retaining Ring (1G) from the groove in Spindle (1A).
3. Remove Bearing Spacer (1F) from top of Bearing Cone (1D).
4. While supporting the unit on Housing (1E) flange, press Spindle (1A) out of Housing (1E). The Seal (1B) and "B" position Bearing Cone (1D) should come out of Housing (1E) with Spindle (1A).
5. Remove "A" position Bearing Cone (1D) from Bearing Cup (1D) in Housing (1E).
6. Lift Housing (1E) off of Spindle (1A).
7. If necessary, press Studs (1N) out of Housing (1E). Locate Housing (1E) on Seal (1B) end.
8. Remove "B" position Bearing Cone (1D) from Spindle (1A).
9. Remove Seal (1B) from the Spindle (1A).
10. Using a soft steel rod, knock both Bearing Cups (1C) out of Housing (1E).



1B. Seal
1C. Bearing Cups
1D. Bearing Cone
1E. Housing
1F. Bearing Spacer
1G. Retaining Ring
1H. Wheel Stud

Figure 3-42. Housing-Spindle Disassembly

Spindle-Brake Disassembly

NOTE: *Refer to Figure 3-43., Spindle Brake Disassembly.*

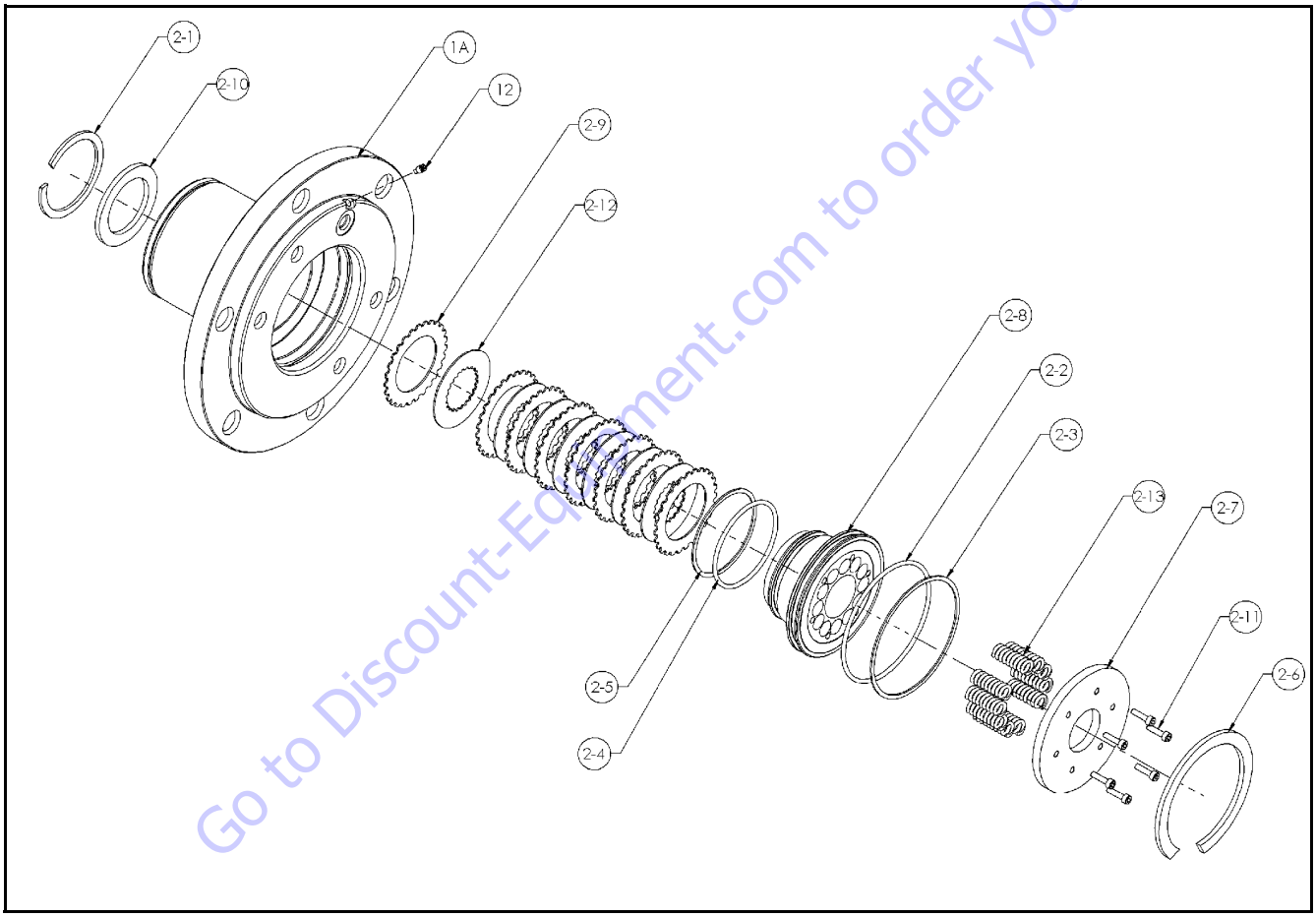
NOTE: *This procedure applies only to units with integral input brake (2).*

NOTE: *For this procedure, use the Brake Assembly Drawing, which will show the proper balloon numbers for the individual brake components. In the following instructions, if the number has a "-" between two numbers, it refers to the Brake Assembly Drawing only and NOT the Drive Hub Assembly Drawing.*

NOTE: *The Pressure Plug (12) requires a special tool for installation. It is not recommended to remove this plug unless it is leaking. The plug is called a Koenig Expander. The installation tool is not supplied by Fairfield manufacturing, but can be supplied by the manufacturer of the Koenig Expander, Sherex Industries, or one of their distributors.*

⚠ CAUTION

EYE PROTECTION MUST BE WORN WHILE PERFORMING STEPS 1-3 IN THIS PROCEDURE.



1-A. Spindle
12. Pressure Plug
2-1. Internal Circlip
2-2. O-ring
2-3. Backup Ring
2-4. O-ring
2-5. Backup Ring
2-6. Internal Circlip
2-7. End Plate
2-8. Piston
2-9. Stator
2-10. Spacer
2-11. Capscrew
2-12. Rotor
2-13. Compression Spring

Figure 3-43. Spindle Brake Disassembly

1. Compress the Compression Springs (2-13) by installing a minimum of three M4 x 16mm Socket Head Capscrews (2-11) equally spaced through End Plate (2-7) and into Piston (2-8) and tightening incrementally until spring force has been taken off of the Retaining Ring (2-6).
2. Using a small pry bar or screwdriver, pry one end of the Retaining Ring (2-6) out of the groove in Spindle (1A), then, using pliers, pull Retaining Ring (2-6) the rest of the way out of the groove.
3. Back Socket Head Capscrews (2-11) incrementally out of Piston (2-8) until spring force is relieved from the End Plate (2-7).
4. Remove Socket Head Capscrews (2-11) and End Plate (2-7) from brake cavity in Spindle.
5. Remove Compression Springs (2-13) from Piston (2-8).

⚠ CAUTION

EYE PROTECTION MUST BE WORN WHILE PERFORMING THE NEXT STEP IN THIS PROCEDURE.

6. Using an air hose, slowly and carefully pressurize the brake port in the Spindle (1A) until the Piston (2-8) comes out of piston bore of Spindle (1A), Then pull the Piston (2-8) the rest of the way out of the Spindle (1A) by hand.
7. Remove Backup Rings (2-3) & (2-5) and O-rings (2-2) & (2-4) from Piston (2-8).
8. Remove Rotors (2-12) and Stators (2-9) from Spindle (1A).

⚠ CAUTION

EYE PROTECTION MUST BE WORN WHILE PERFORMING THE NEXT STEP IN THIS PROCEDURE.

9. Invert Spindle (1A) and, using retaining ring pliers, remove Retaining Ring (2-1).
10. Remove Spacer (2-10) from Spindle.

Input Carrier Sub-Assembly

NOTE: *Refer to Figure 3-44., Input Carrier Sub-Assembly.*

1. Apply a liberal coat of grease to the bore of one Input Planet Gear (3F).
2. Line the inside of the Planet Gear (3F) with 14 Needle Rollers (3C).

NOTE: *The last roller installed must be installed end wise. That is, the end of the last roller must be placed in between the ends of the two rollers that form the space, and then slid, parallel to the other rollers, into place.*

3. Set Carrier (3A) in an upright position.
4. Insert a Planet Shaft (3E) into the planet shaft hole in the end of the Carrier (3A) opposite the splined end.
5. Place one Thrust Washer (3B) onto the end of Planet Shaft (3E). Make sure the flat faces towards the inside of the carrier and make sure the button fits in the pocket inside the Carrier (3A).
6. Place one more Thrust Washer (3B) into the Carrier (3A). Align the Thrust Washer (3B) in the same manner described in Step 5.

NOTE: *Some grease may need to be applied to the Thrust Washers (3B) to hold them in place while installing the planet gear. Instead of using grease, the washers could be inserted from the ID of the carrier for the buttons to fit into pockets of the carrier.*

7. Following the thrust washers, place Planet Gear (3F) with needle rollers, into the Carrier (3A) between the Thrust Washers (3B).
8. Push the Planet Shaft (3E) through the Planet Gear (3F) and the other Thrust Washer (3B) until it touches the other side of the Carrier (3A).

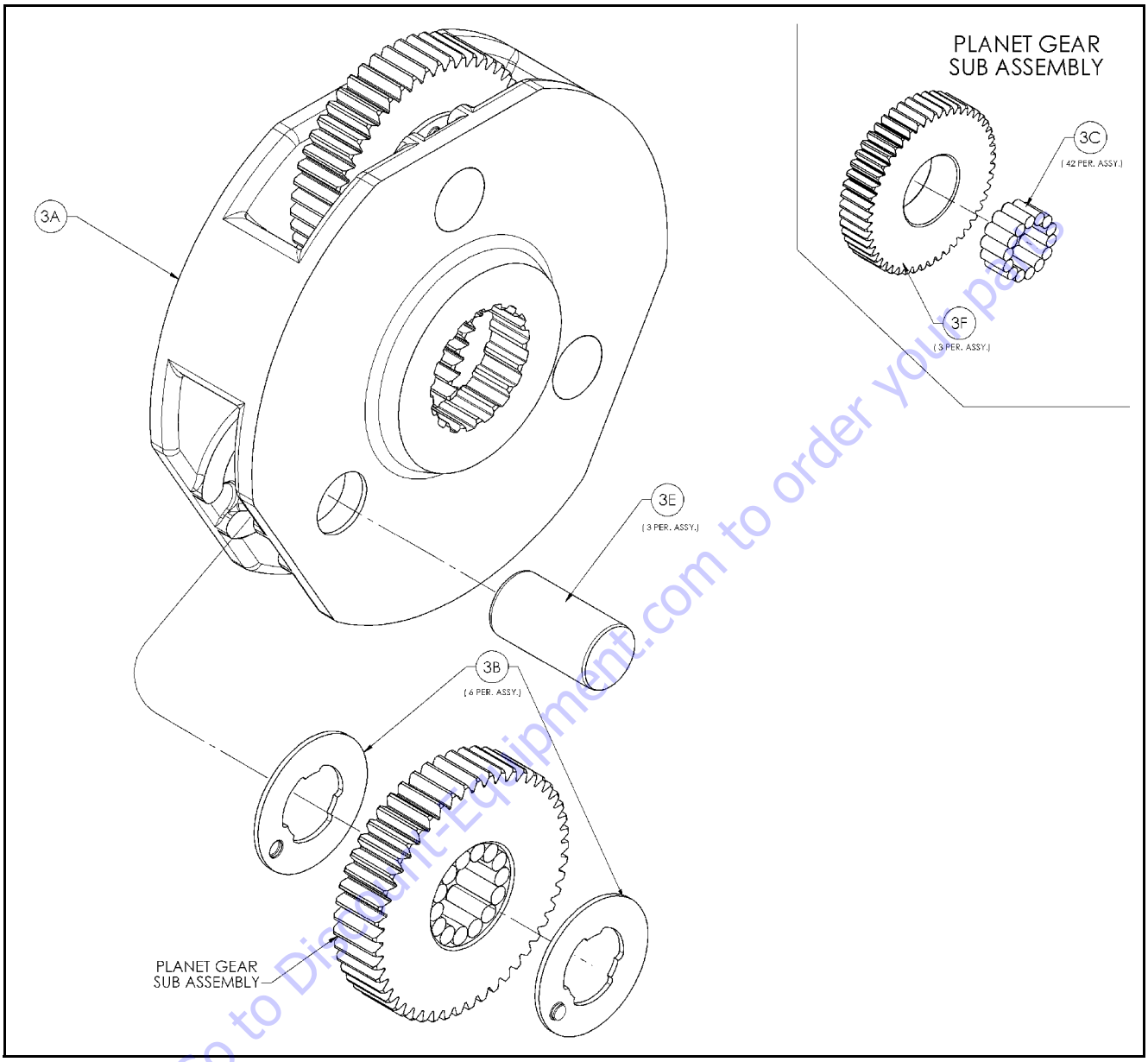
⚠ CAUTION

SAFETY GLASSES MUST BE WORN DURING THE NEXT STEP.

9. Press the Planet Shaft (3E) until it is pressed to the appropriate depth.

NOTE: *If planet shaft locating tooling is not available, press lightly on Planet Shaft (3E) and make sure not to press Planet Shaft (3E) through the small shoulder in Carrier (3A). This shoulder is intended to keep the planet pin from working loose in that direction during proper operation of the unit. It is **NOT** intended to keep the planet pin from being pressed through the carrier.*

10. On the side of the Carrier (3A) where the Planet Shaft (3E) was inserted, stake the Carrier (3A) in 3 places using a punch and a hammer around the Planet Shaft (3E) to assure the shaft stays in place during operation of the unit.
11. Repeat Steps 1 through 10 for the installation of the two remaining Planet Gears (3F).



3A. Carrier
3B. Thrust Washers
3C. Needle Bearings
3E. Planet Shaft
3F. Planet Gear

Figure 3-44. Input Carrier Sub-Assembly

Output Carrier Sub-Assembly

NOTE: *Refer to Figure 3-45., Output Carrier Sub-Assembly.*

1. Place Spring (4I) into the deep counterbore of the Output Carrier (4A).
2. Place Washer (4J) on top of Spring (4I).

⚠ CAUTION

SAFETY GLASSES MUST BE WORN DURING THE NEXT STEP.

3. With Retaining Ring (4K) installed on snap ring pliers, place on top of Washer (4J) and compress Spring (4I) until Retaining Ring (4K) is seated completely in groove.
4. Apply a liberal coat of grease to the bore of one Output Planet Gear (4F).
5. Line the inside of the Planet Gear (4F) with 15 Needle Rollers (4C).

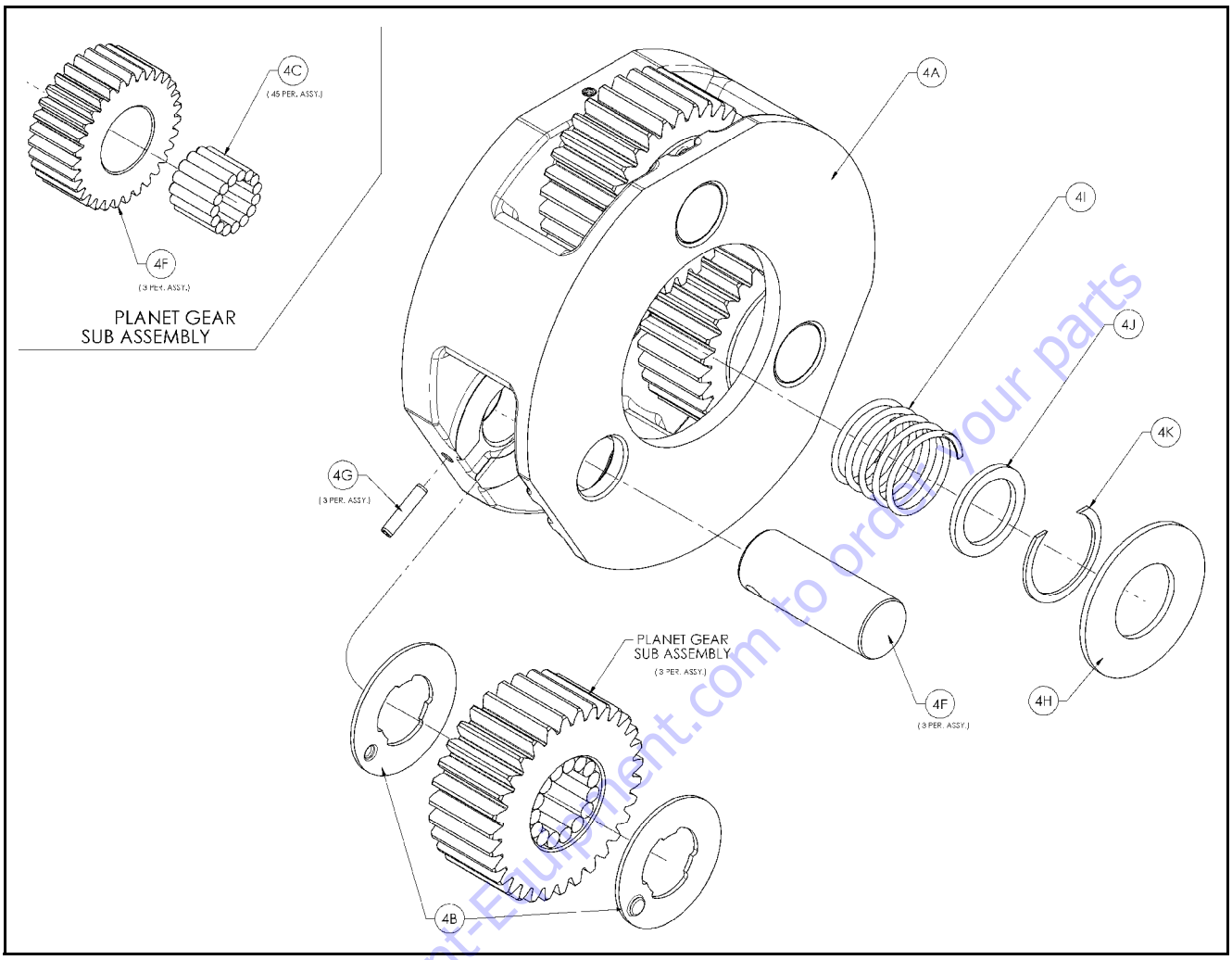
NOTE: *The last roller installed must be installed end wise. That is, the end of the last roller must be placed in between the ends of the two rollers that form the space, and then slid, parallel to the other rollers, into place.*

6. Place Thrust Washer (4H) into the shallow counterbore of the Output Carrier (4A).
7. Set Carrier (4A) in an upright position.
8. Insert a Planet Shaft (4E) into one of the planet shaft holes on the Carrier (4A). The end of the planet shaft that does **NOT** have the roll pin hole should be inserted in the carrier **FIRST**.
9. Place one Thrust Washer (4B) onto the end of Planet Shaft (4E). Make sure the flat faces towards the inside of the carrier and make sure the button fits in the pocket inside the Carrier (4A).
10. Following the thrust washer, place Planet Gear (4F) with needle rollers, onto Planet Shaft (4E).
11. Following the planet gear, place one more Thrust Washer (4B) onto Planet Shaft (4E). Align the Thrust Washer (4B) in the same manner described in Step 6.
12. Now insert Planet Shaft (4E) through the opposite planet shaft hole on Carrier (4A). Use an alignment punch or similar tool to align the roll pin holes on Carrier (4A) and Planet Shaft (4E).

⚠ CAUTION

SAFETY GLASSES MUST BE WORN DURING THE NEXT STEP.

13. Drive Roll Pin (4G) down into the aligned roll pin holes. Pin should be flush with OD of carrier.
14. Repeat Steps 4,5, & 8-13 for the installation of the two remaining Planet Gears (4F).



4A. Output Carrier
4B. Thrust Washer
4C. Needle Rollers
4E. Planet Shaft
4F. Planet Gear
4G. Roll Pin
4H. Thrust Washer
4I. Spring
4J. Washer
4K. Retaining Ring

Figure 3-45. Output Carrier Sub-Assembly

Spindle Brake Sub-Assembly

NOTE: *Refer to Figure 3-46., Spindle Brake Sub-Assembly.*

NOTE: *This procedure applies only to units with integral input brake (2).*

NOTE: *For this procedure, use the Brake Assembly Drawing (Figure 3-46.), which will show the proper balloon numbers for the individual brake components. In the following instructions, if the number has a "-" between two numbers, it refers to the Brake Assembly Drawing only and NOT the Drive Hub Assembly Drawing.*

NOTE: *The Pressure Plug (12) requires a special tool for installation. It is not recommended to remove this plug unless it is leaking. The plug is called a Koenig Expander. The installation tool is not supplied by Fairfield manufacturing, but can be supplied by the manufacturer of the Koenig Expander, Sherex Industries, or one of their distributors.*

1. Install Pressure Plug (12) into Spindle (1A) using following procedure:

- Clean hole in spindle using appropriate Loctite spray.
- Dip collar of plug in Loctite 290 or 680 (keep unplugged portion of hole free of Loctite).
- Using appropriate tool, install plug flush with surface of spindle.

⚠ CAUTION

SAFETY GLASSES MUST BE WORN DURING THE NEXT STEP.

2. Place Spindle (1A) such that the splined end is facing down. Using appropriate tool (See back of manual), install Retaining Ring (2-1) into the spindle groove within the splines.

3. Place Washer (2-10) on top of Retaining Ring (2-1).

4. Place Stator (2-9) on top of Washer (2-10).

5. Place Rotor (2-12) on top of Stator (2-9).

6. Repeat steps 3 & 4 until there are a total of 8 Stators (2-9) and 7 Rotors (2-12) installed.

7. Place Piston (2-8) such that the smaller O.D. end is facing upward.

8. Grease the large Backup Ring (2-3) and install in the large-diameter groove at the bottom of the Piston (2-8).

9. Grease the large O-Ring (2-2) and install in the large-diameter groove at the bottom of the Piston (2-8), on top of the large Backup Ring (2-3).

10. Grease the small O-Ring (2-5) and install in the small-diameter groove near the top of the Piston (2-8). Make sure the o-ring is seated on the bottom of the groove.

11. Grease the small Backup Ring (2-4) and install in the small-diameter groove near the top of the Piston (2-8), on top of the small O-Ring (2-5).

NOTE: *If piston comes pre-assembled with shipping bolts (2-11), skip to Step 15.*

12. Insert Piston (2-8) into Spindle (1A) until it contacts the Stator (2-9).

13. Insert the appropriate number of Springs (2-13) into Piston (2-8) counterbore. Use the brake spring chart below and a bill of materials for your particular model number to determine the number of springs.

BRAKE CODE	BRAKE P/N	NUMBER OF SPRINGS
A	902337	12
B	902341	10
C	902342	8
D	902343	6
E	902345	9

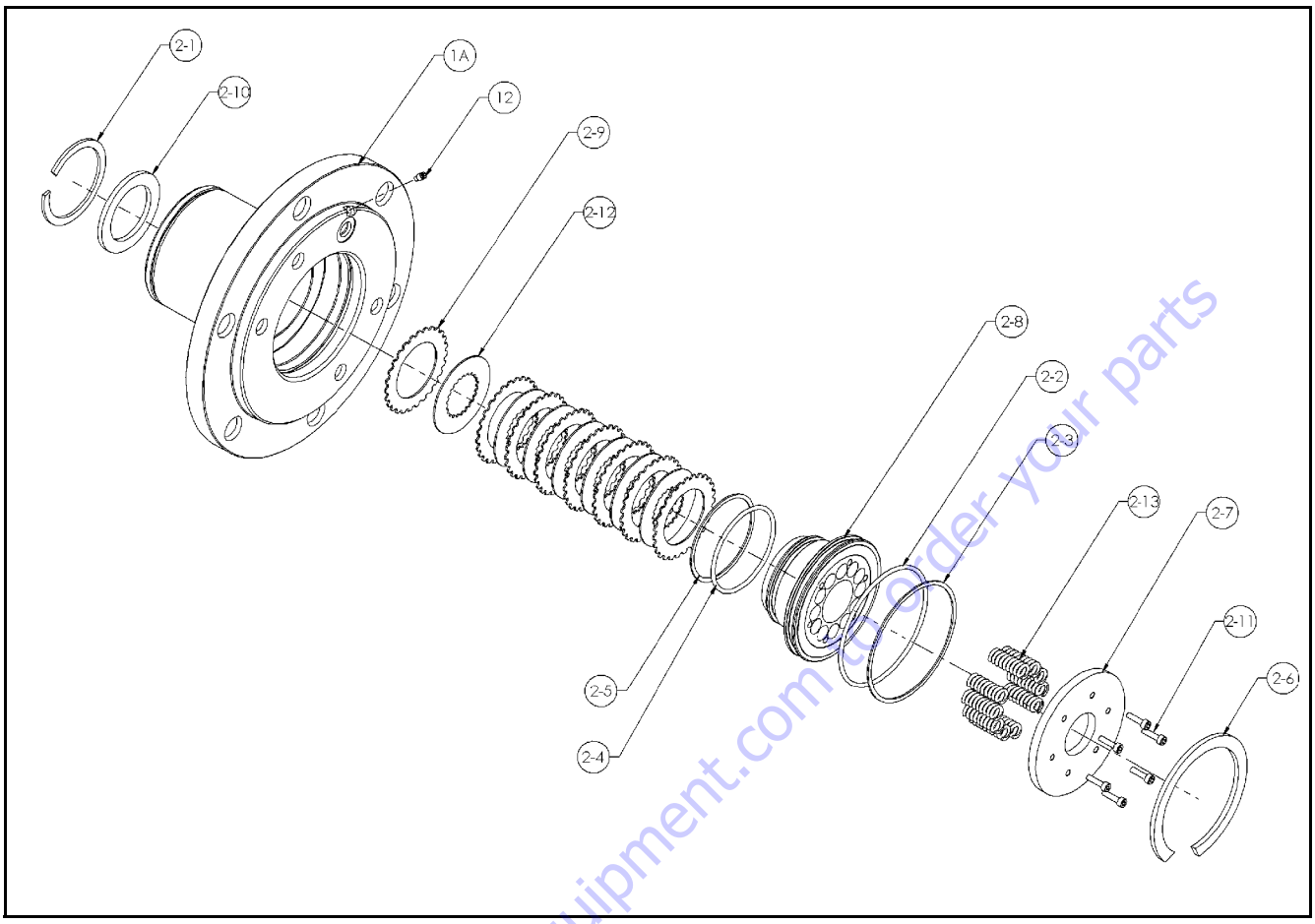
14. Place Pressure Plate (2-7) on top of Springs (2-13).

⚠ CAUTION

SAFETY GLASSES MUST BE WORN DURING THE NEXT TWO STEPS.

15. Using snap ring pliers, install Retaining Ring (2-6) into groove in Spindle (1A) and on top of Pressure Plate (2-7). Make sure that Retaining Ring (2-6) is seated properly in the groove.

16. Remove Shipping Bolts (2-11) in brake pressure plate to release springs in brake. Before removing bolts, use the Coupling (9) (See Assembly Drawing at back of manual) to center and align the Brake Rotors (2-12) with the Spindle (1A).



1-A. Spindle
12. Pressure Plug
2-1. Internal Circlip
2-2. O-ring
2-3. Backup Ring
2-4. O-ring
2-5. Backup Ring
2-6. Internal Circlip
2-7. End Plate
2-8. Piston
2-9. Stator
2-10. Spacer
2-11. Capscrew
2-12. Rotor
2-13. Compression Spring

Figure 3-46. Spindle Brake Sub-Assembly

Housing-Spindle Sub-Assembly

NOTE: *Refer to Figure 3-47., Housing-Spindle Assembly.*

NOTE: *Spray a light film of oil on all component parts during assembly.*

⚠ CAUTION

SAFETY GLASSES MUST BE WORN DURING THE ENTIRE HOUSING-SPINDLE SUBASSEMBLY.

1. Press Bearing Cup (1C), position A, into Housing (1E) using appropriate pressing tool (See back of manual).
2. Turn Housing (1E) over and place into pressing base. Press nine Studs (1H) into Housing (1E).

NOTE: *Use enough pressure to press in studs. Don t use excessively high pressure to press in studs or Housing may crack. Make sure head of stud contacts face of flange on Housing.*

NOTE: *Spray a generous amount of oil on bearings during installation.*

3. Press Bearing Cup (1C), position "B", into Housing (1E) using “B” Bearing Cone pressing tool (see back of manual).
4. Place Bearing Cone (1D), into Bearing Cup (1C), position "B".
5. Grease Seal (1B) lip and press seal into Housing (1E) using seal pressing tool (see back of manual) until seal is flush with end of Housing.
6. Turn Housing (1E) over and lower onto Spindle (1A).
7. Install Bearing Cone (1D) into Bearing Cup (1C), position "A". and lightly press on Bearing Cup using the “A” Bearing Cone pressing tool (see back of manual) while rotating Housing (1E) in both directions to seat bearings.
8. Place Bearing Spacer (1F) on top of Bearing Cone (1D).
9. Using retaining ring pliers, install Retaining Ring (1G) into Spindle (1A) groove. Make sure ring is completely seated in groove.

NOTE: *Extra bearing pre-load caused by pressing “A” Bearing Cone (1D) must be removed. This should be done by placing a flat piece of steel or a pressing tool on the end of the spindle, and then lightly striking the tool with a piece of barstock. This should be adequate to remove any additional bearing pre-load.*

DW2B Integral Brake Check

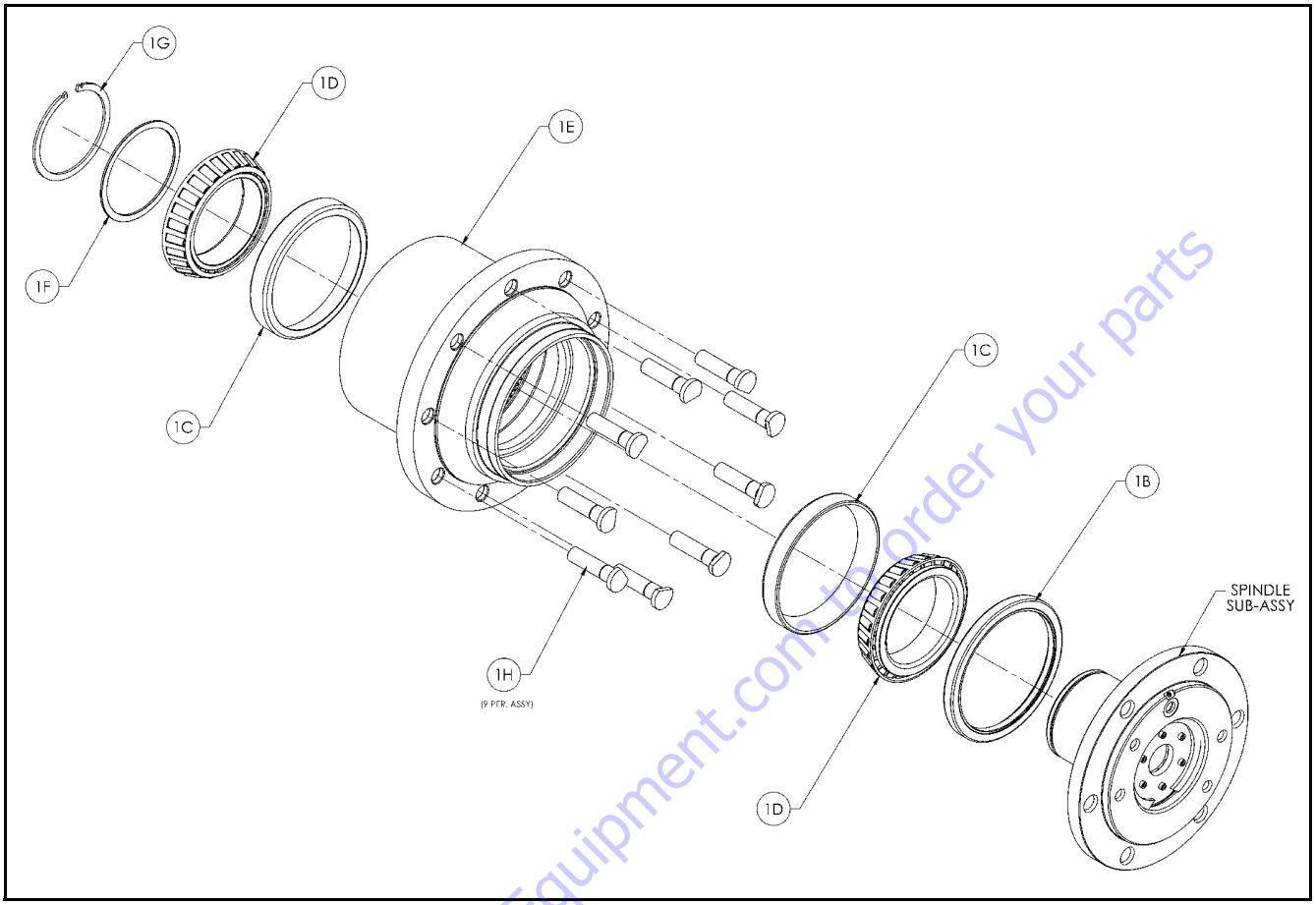
1. Using appropriate fittings, connect hydraulic line from hand pump to brake port.
2. Check to see that brake is set by trying to rotate Input Shaft (7). This can be accomplished by installing an appropriate tool (any tool that can locate on the splines of the Input Coupling (9), such as a mating splined shaft) into Input Coupling (9).
3. Bleed brake. Increase hydraulic pressure gradually while trying to rotate the input until brake just starts to release. Note this pressure. Make sure the pressure falls into the appropriate range below.

BRAKE CODE	BRAKE P/N	JUST RELEASE PRESSURE RANGE (psi)
A	902337	185-230
B	902341	155-192
C	902342	125-155
D	902343	93-115
E	902345	132-172

4. Increase pressure to 3,000 psi and hold for 30 seconds to check for leaks. Repair leaks if necessary.

NOTE: *Make sure that brake re-engages when pressure is released.*

NOTE: *When done, make sure Input Coupling (9) is centered in Spindle (1A) to make installation of motor possible without release of brake.*



1B. Seal
1C. Bearing Cups
1D. Bearing Cone
1E. Housing
1F. Bearing Spacer
1G. Retaining Ring
1H. Wheel Stud

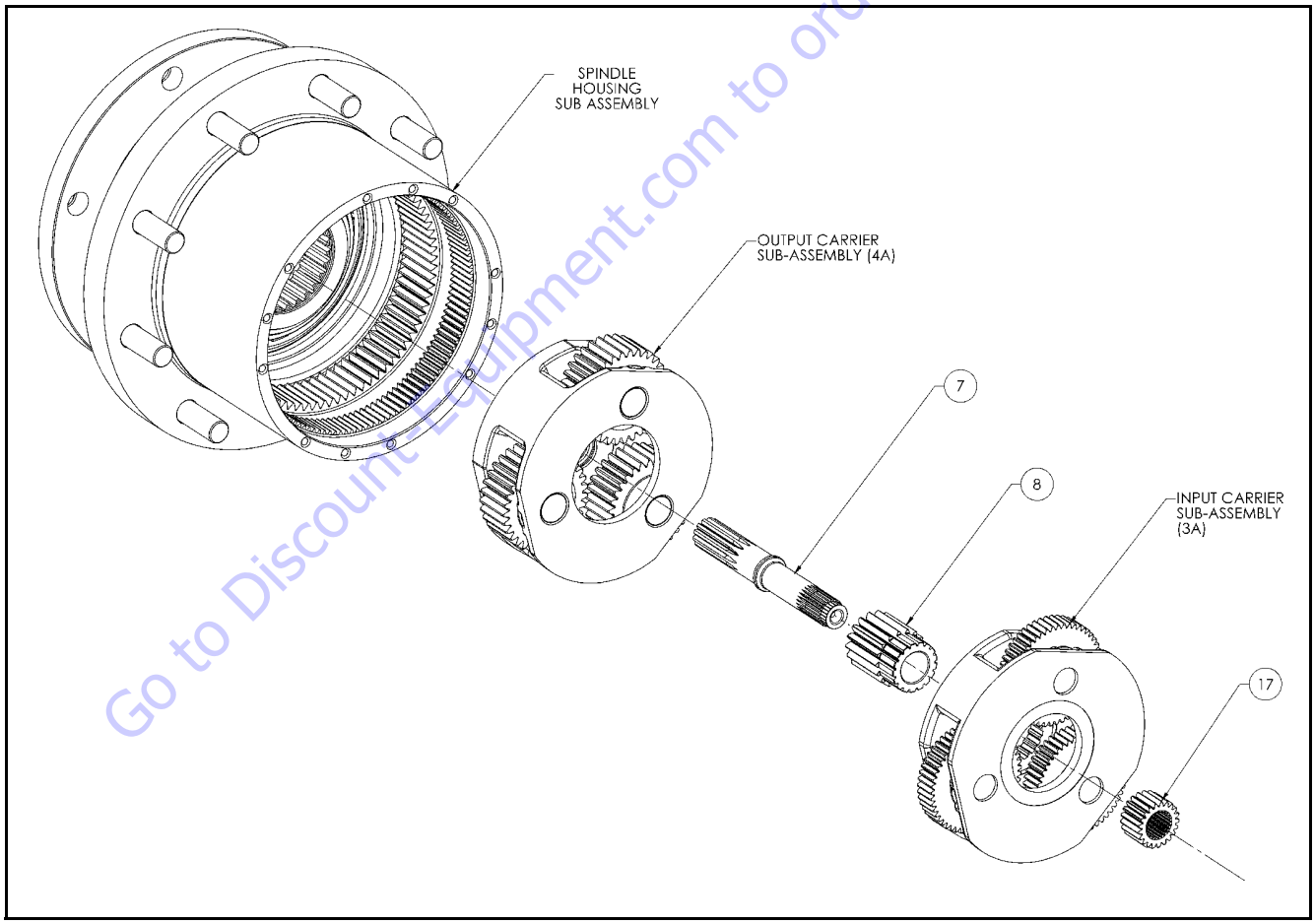
Figure 3-47. Housing-Spindle Assembly

Main Assembly

NOTE: *Refer to Figure 3-48., Main Assembly - Sheet 1 and Figure 3-49., Main Assembly - Sheet 2.*

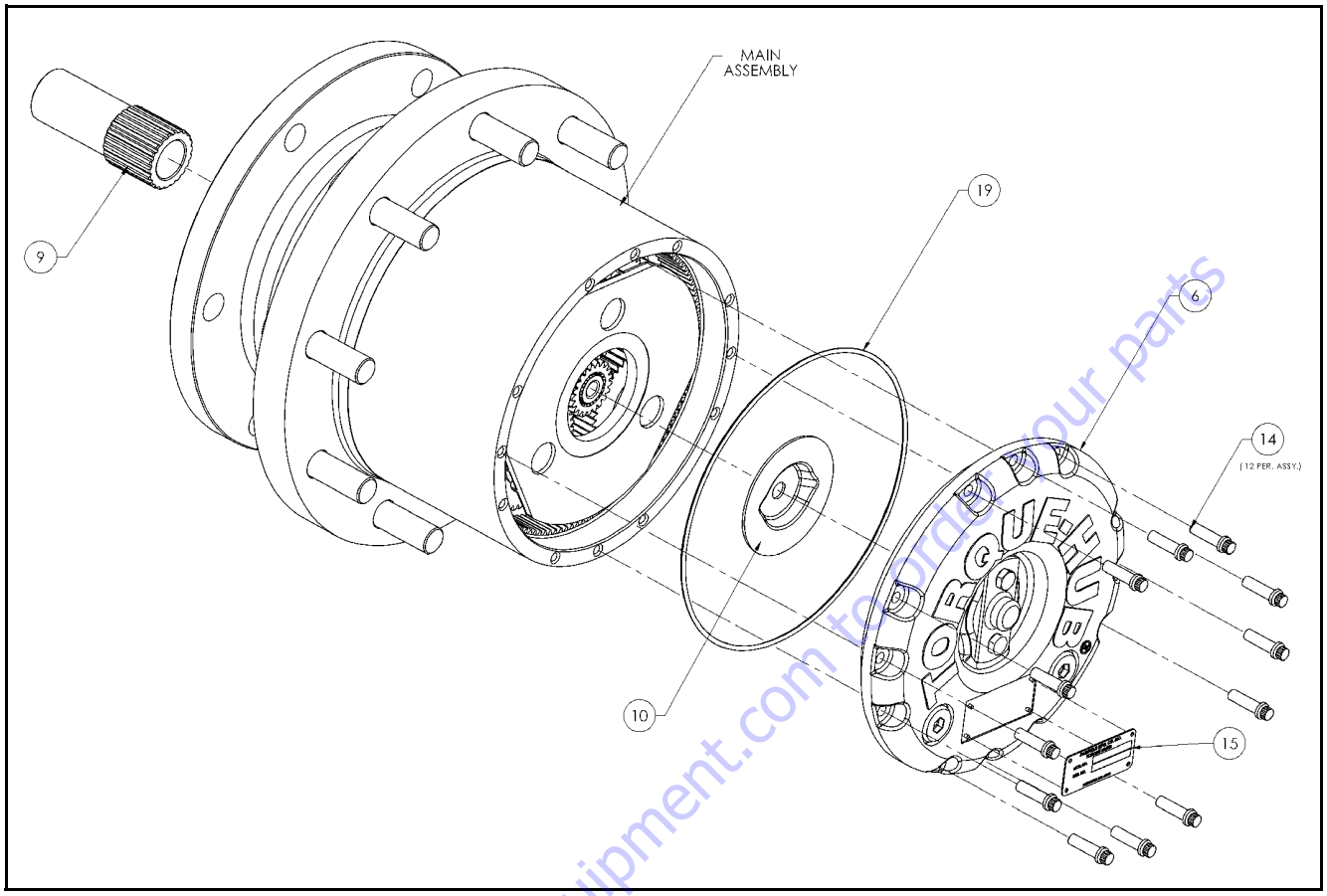
NOTE: *All components should receive a generous amount of lubricant oil as they are being assembled.*

1. Place Housing-Spindle Sub-Assembly on the bench with Spindle (1A) side down.
2. Place Output Carrier Sub-Assembly into Housing (1E) and onto Spindle (1A).
3. Insert the larger diameter splined end of Input Shaft (7) through bore of Output Carrier Sub Assembly (4A) until shoulder of Input Shaft (7) contacts Thrust Washer (4J) (See assembly drawing at back of manual).
4. With the modified spline end facing up, place the Output Sun Gear (8) into mesh with the planet gears from the Output Carrier Sub-Assembly (4A).
5. Place Input Carrier Sub-Assembly (3A) onto Output Sun Gear (8) splines.
6. Grease O-Ring (19) and insert into groove in Cover Sub-Assembly (6).
7. Install Cover Sub-Assembly (6) onto Housing (1E) and install twelve Bolts (14) into Cover (6). Torque bolts to 70-80 in. lbs. (8-9 Nm).
8. Attach ID Tag (15) onto unit. If Cover has knobs as part of the cover, peen the top of each knob to form a head to hold on the Tag. If the cover has no such knobs, use drive screws.
9. Check disconnect, roll and leak check unit, leak check brake, check brake release pressure.



7. Input Shaft
8. Output Sun Gear
17. Input Sun Gear

Figure 3-48. Main Assembly - Sheet 1



6. Cover
9. Input Coupling
10. Thrust Spacer
14. Cover Bolts
19. O-ring

Figure 3-49. Main Assembly - Sheet 2

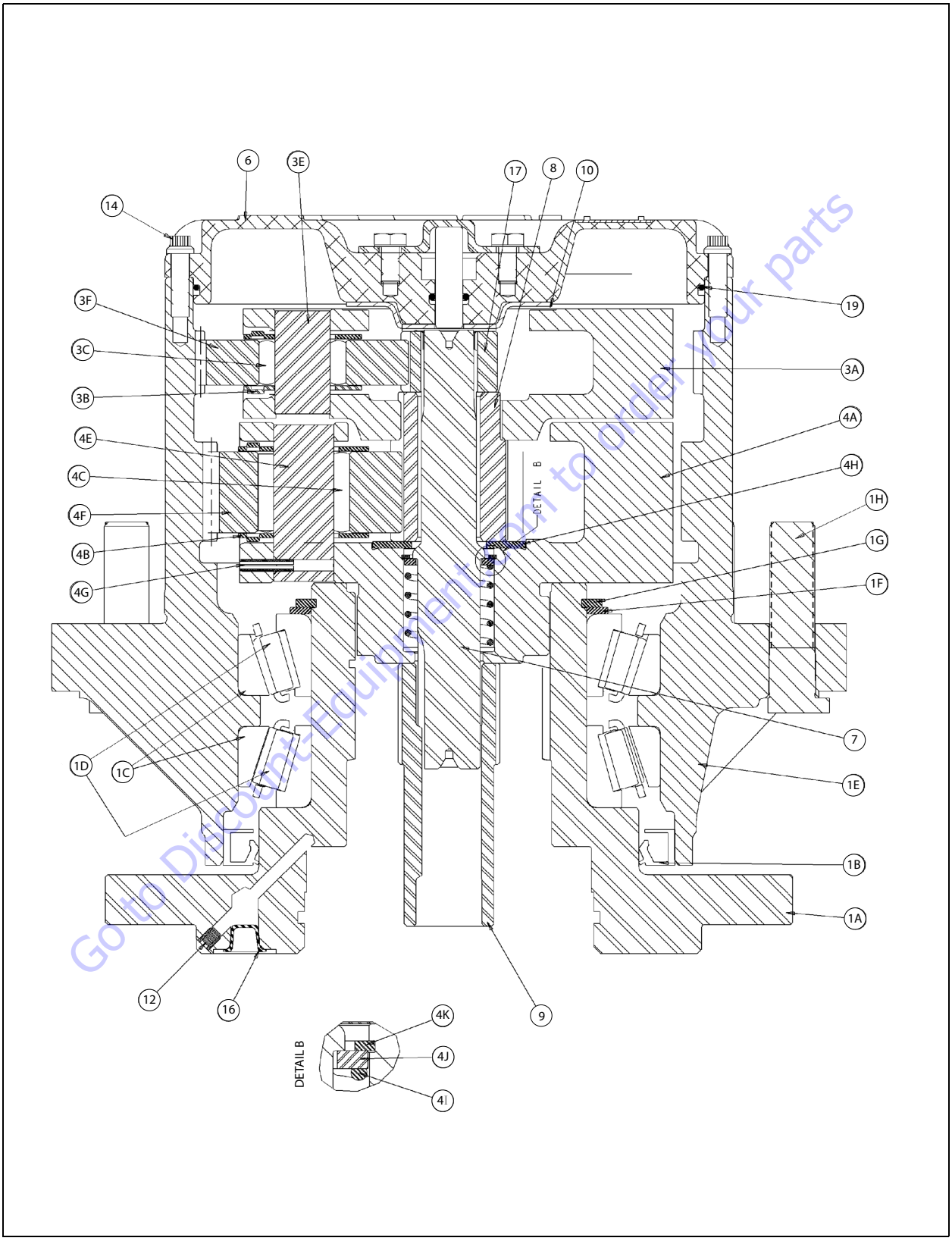


Figure 3-50. Assembly Drawing - Without Integral Input Brake - Sheet 1 of 2

1A. Spindle	1B. Lip Seal	4C. Needle Bearing	7. Input Shaft
1G. Retaining Ring - Ext	3A. Carrier	4I. Spring	9. Coupling
12. Pressure Plug	3F. Planet Gear	4K. Retaining Ring - Int	6. Cover Subassembly
16. O-ring Pipe Plug	3E. Planet Shaft	4G. Roll Pin	10. Thrust Spacer
1F. Thrust Washer	3C. Needle Bearing	4B. Thrust Washer	15. Id Plate
1E. Housing/Ring Gear	3B. Thrust Washer	4H. Thrust Washer	14. 12 Pt Flange Bolt
1N. Stud	4A. Carrier	4J. Thrust Washer	19. O-ring
1C. Tapered Bearing - Cup	4F. Planet Gear	17. Sun Gear	
1D. Tapered Bearing - Cone	4E. Planet Shaft	8. Sun Gear	

Figure 3-51. Assembly Drawing - Without Integral Input Brake - Sheet 2 of 2

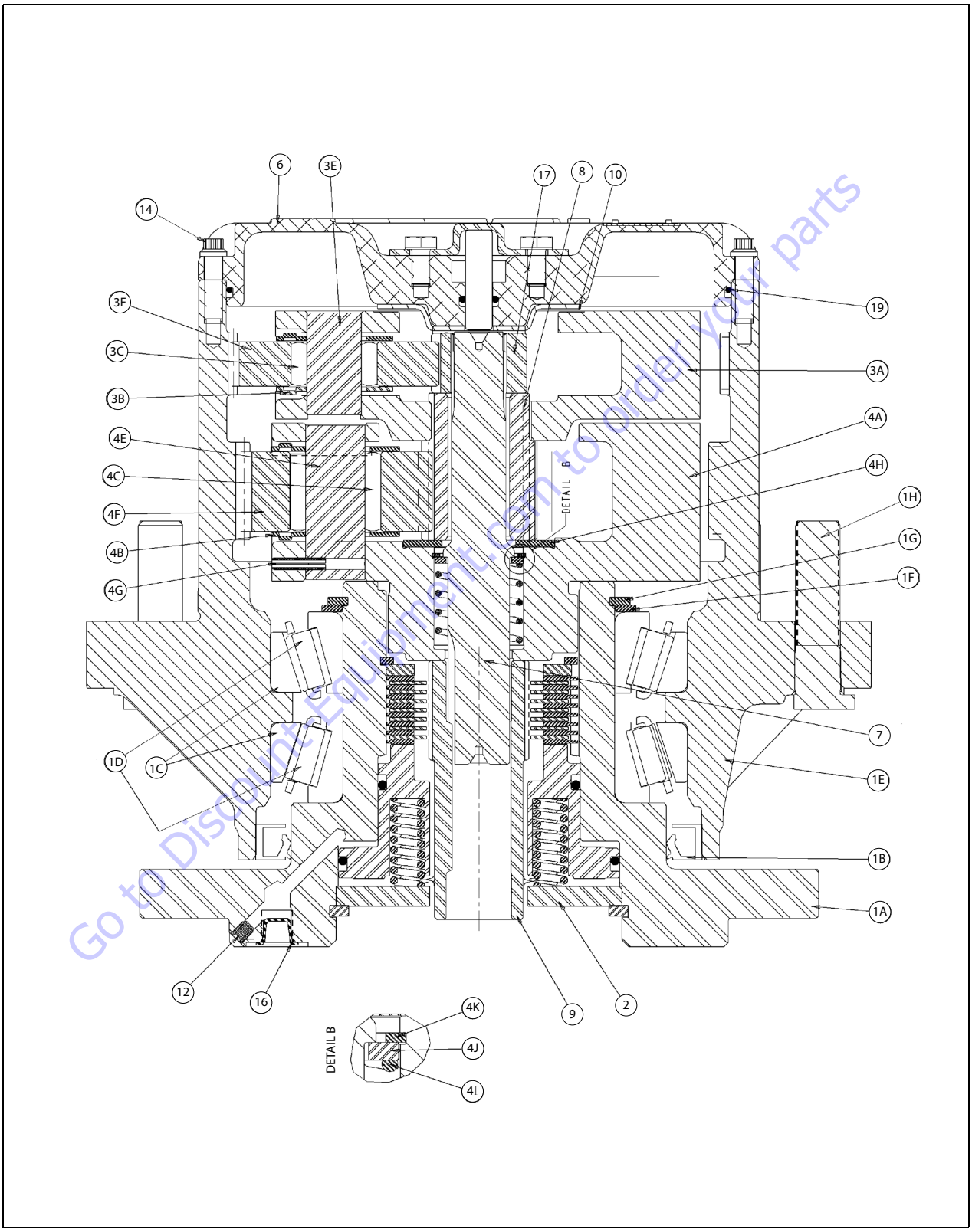


Figure 3-52. Assembly Drawing - With Integral Input Brake - Sheet 1 of 2

1A. Spindle	1D. Tapered Bearing - Cone	4E. Planet Shaft	8. Sun Gear
2. Input Brake	1B. Lip Seal	4C. Needle Bearing	7. Input Shaft
1G. Retaining Ring - Ext	3A. Carrier	4I. Spring	9. Coupling
12. Pressure Plug	3F. Planet Gear	4K. Retaining Ring - Int	6. Cover Subassembly
16. O-ring Pipe Plug	3E. Planet Shaft	4G. Roll Pin	10. Thrust Spacer
1F. Thrust Washer	3C. Needle Bearing	4B. Thrust Washer	15. Id Plate
1E. Housing/Ring Gear	3B. Thrust Washer	4H. Thrust Washer	14. 12 Pt Flange Bolt
1N. Stud	4A. Carrier	4J. Thrust Washer	19. O-ring
1C. Tapered Bearing - Cup	4F. Planet Gear	17. Sun Gear	

Figure 3-53. Assembly Drawing - With Integral Input Brake - Sheet 2 of 2

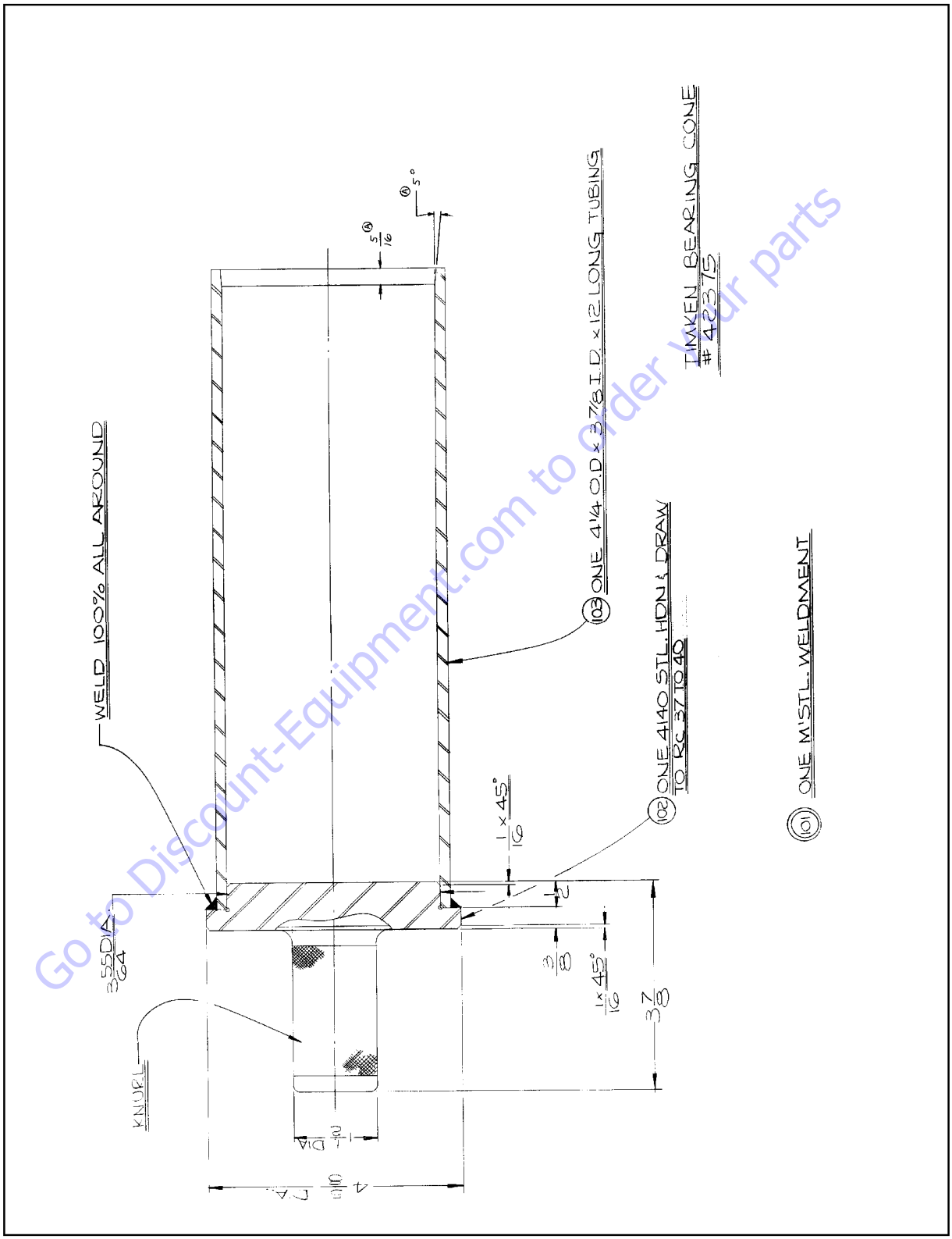


Figure 3-54. Assembly Tools - Bearing Cone Pressing - "B" Bearing

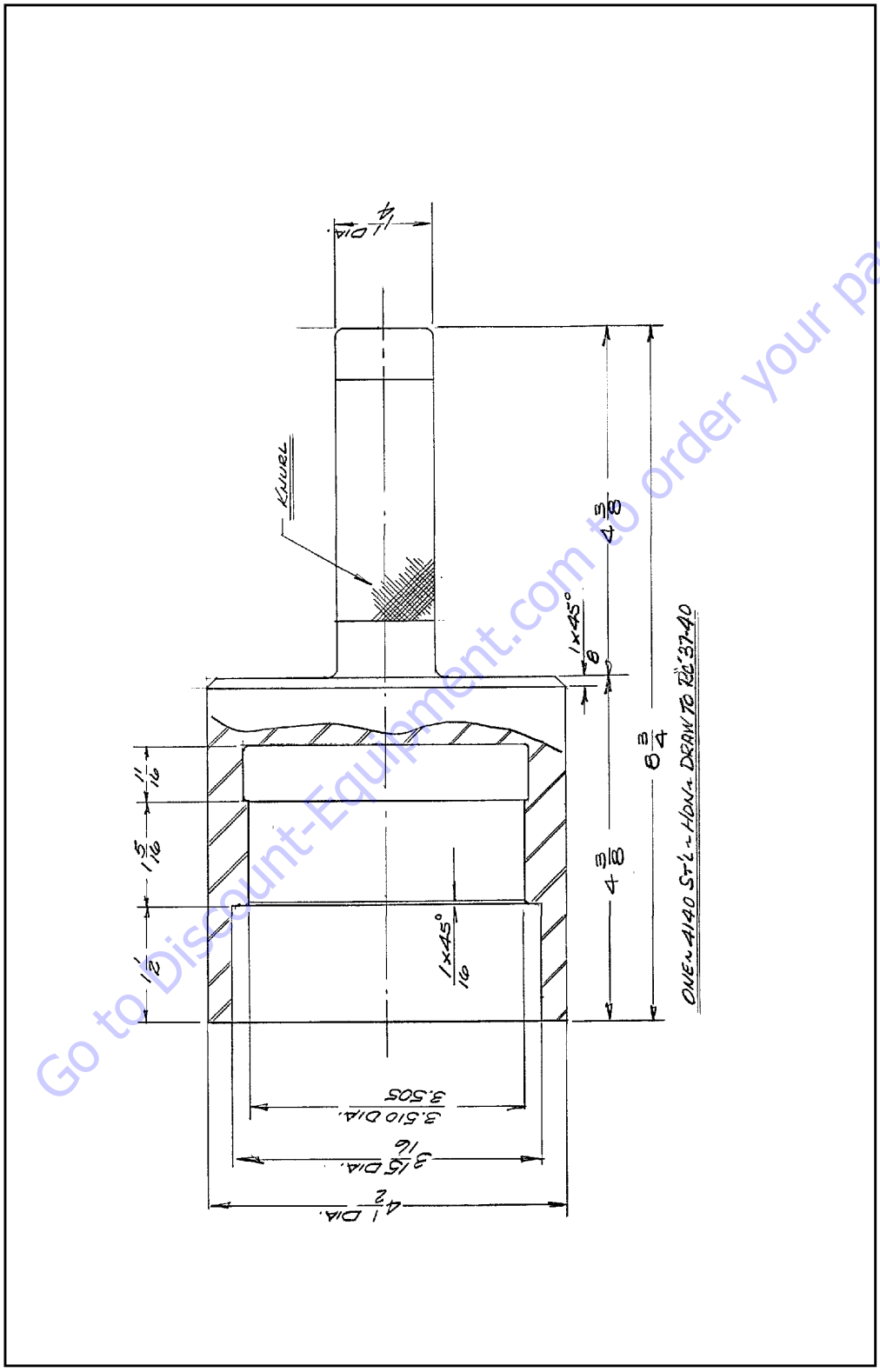


Figure 3-55. Assembly Tools - Bearing Cone Pressing - "A" Bearing

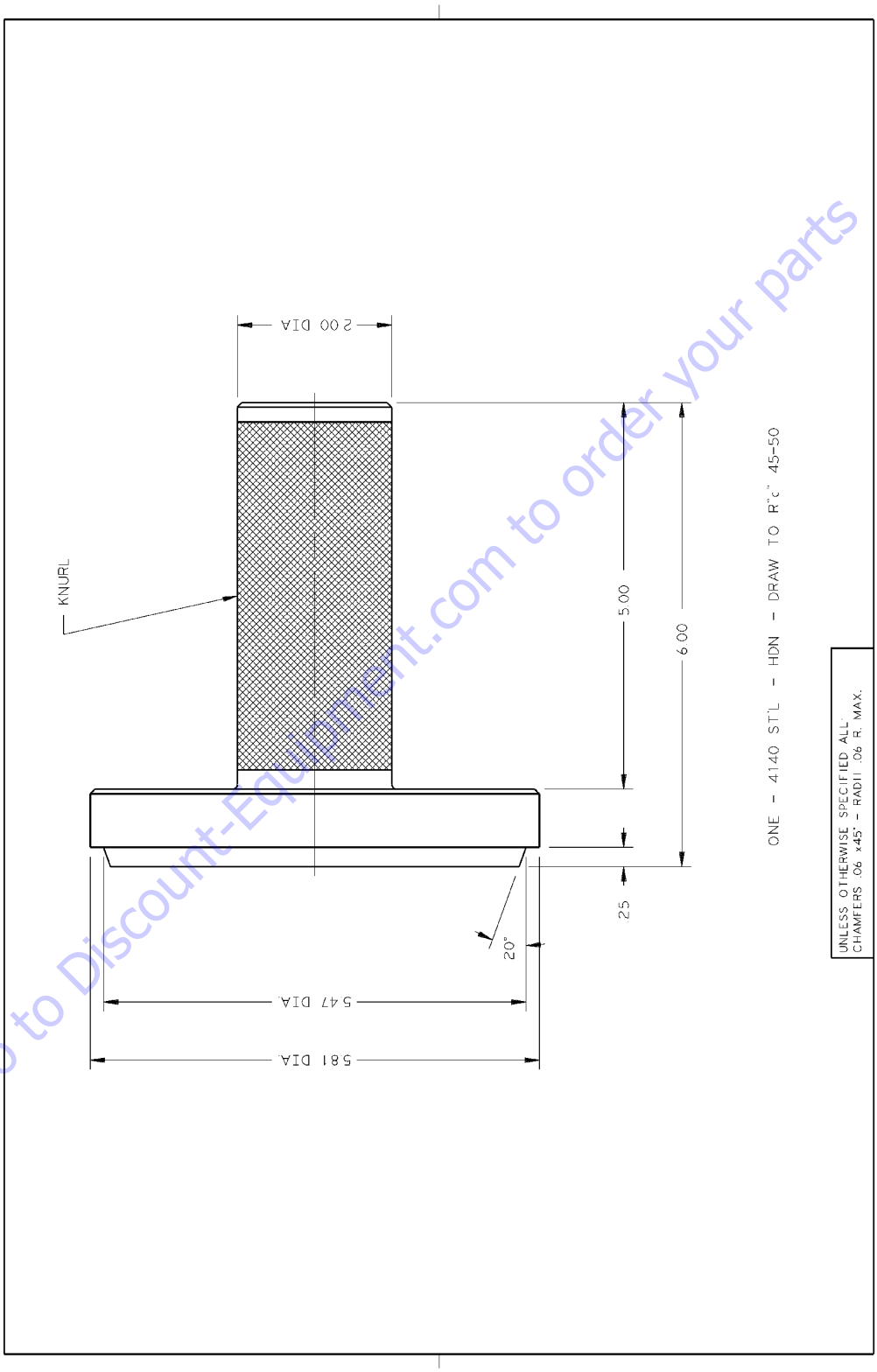


Figure 3-56. Assembly Tools - Bearing Cup Pressing - "A" & "B" Bearings

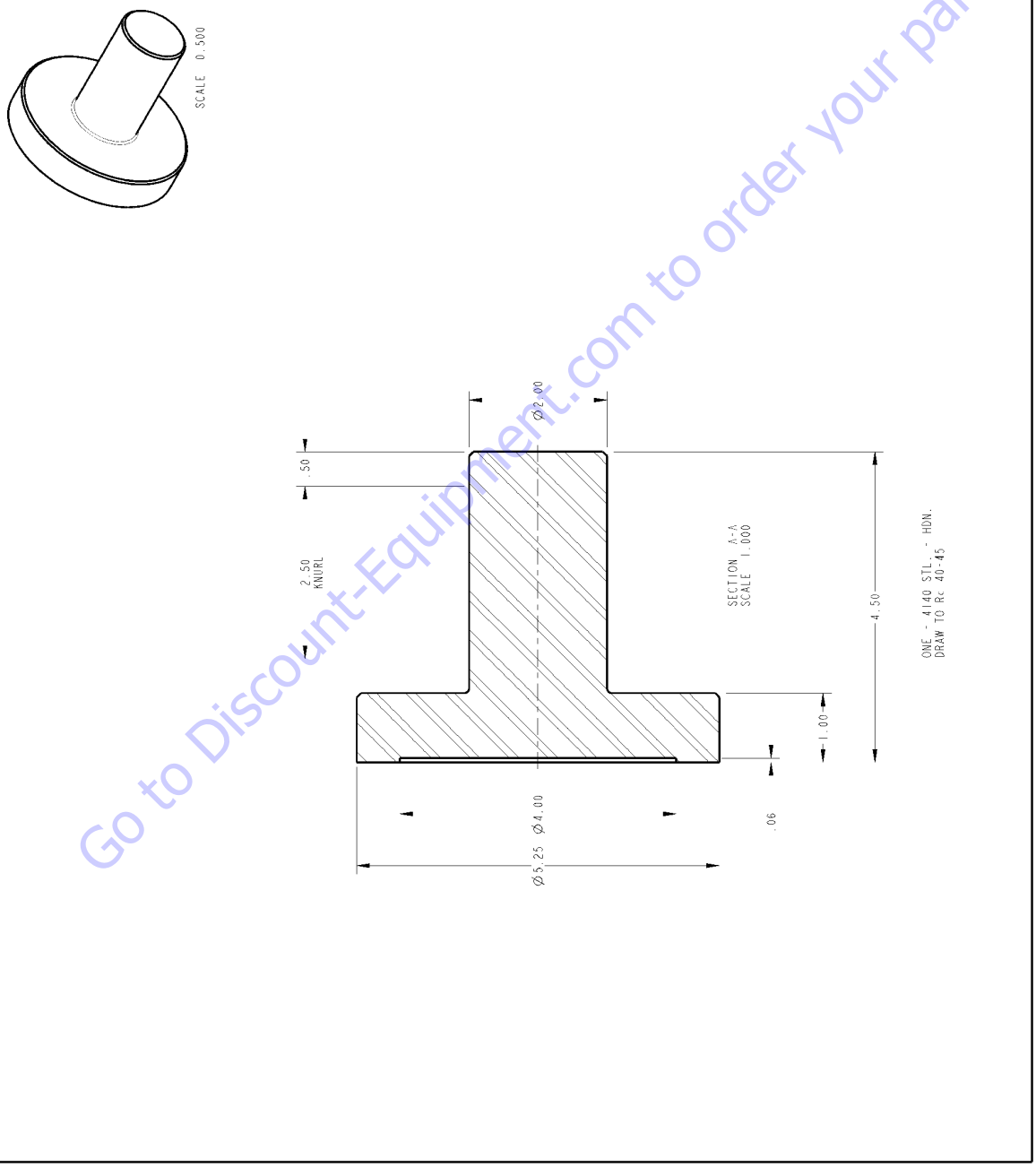


Figure 3-57. Assembly Tools - Seal Pressing

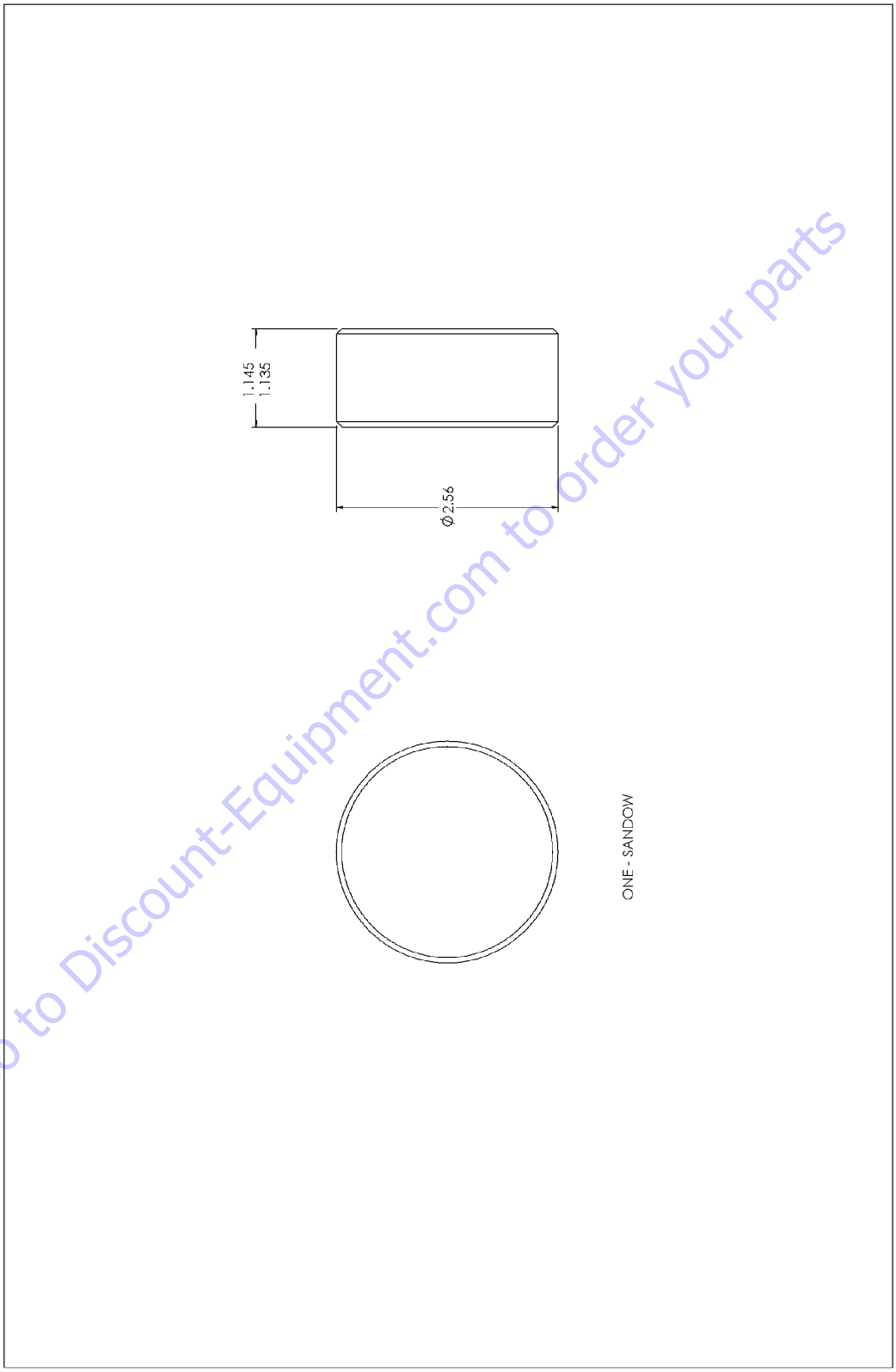


Figure 3-58. Assembly Tools - Spacer - Brake Disc Installation

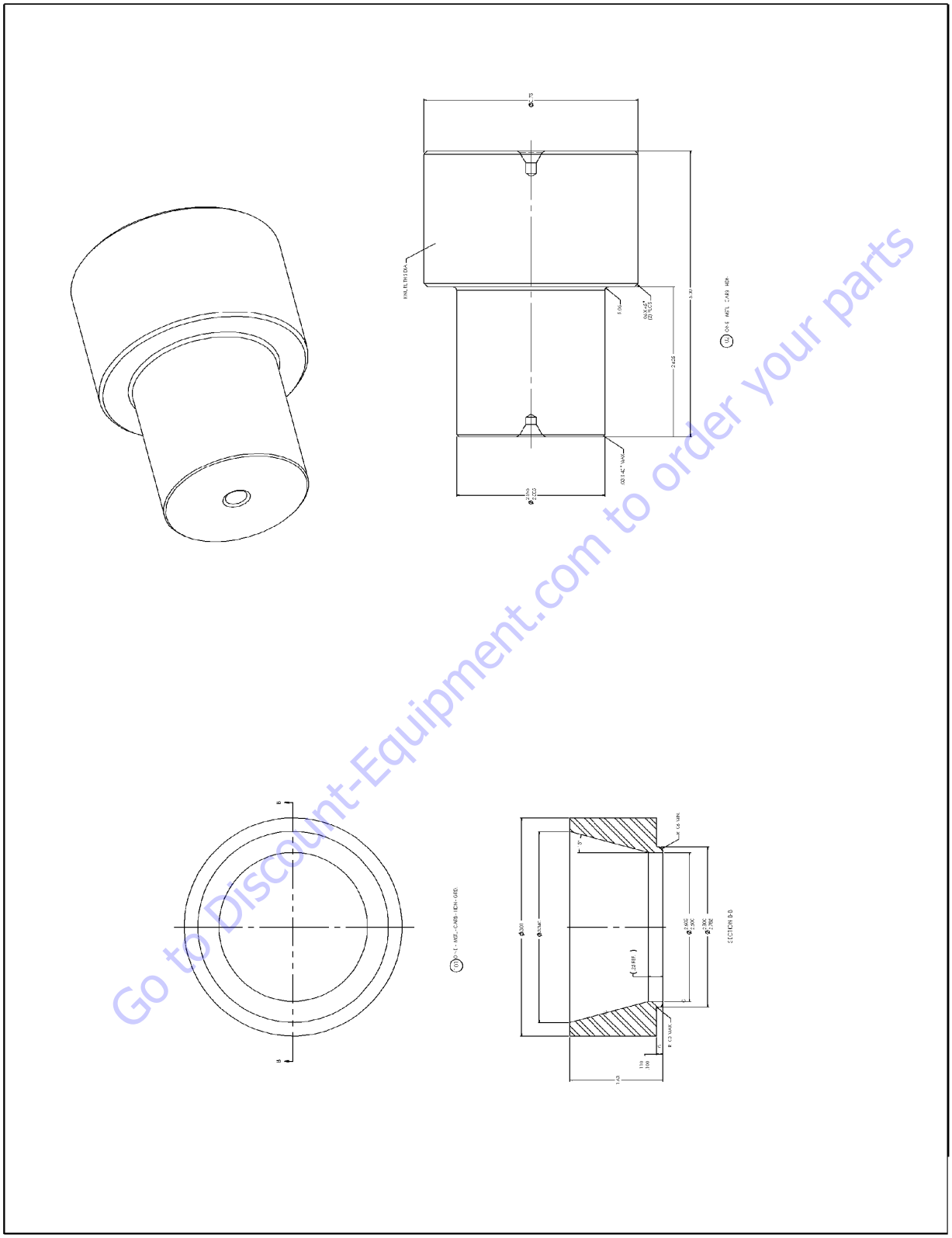


Figure 3-59. Assembly Tools - Brake Retaining Ring Installation

3.14 RE-ALIGNING DRIVE HUB INPUT COUPLING

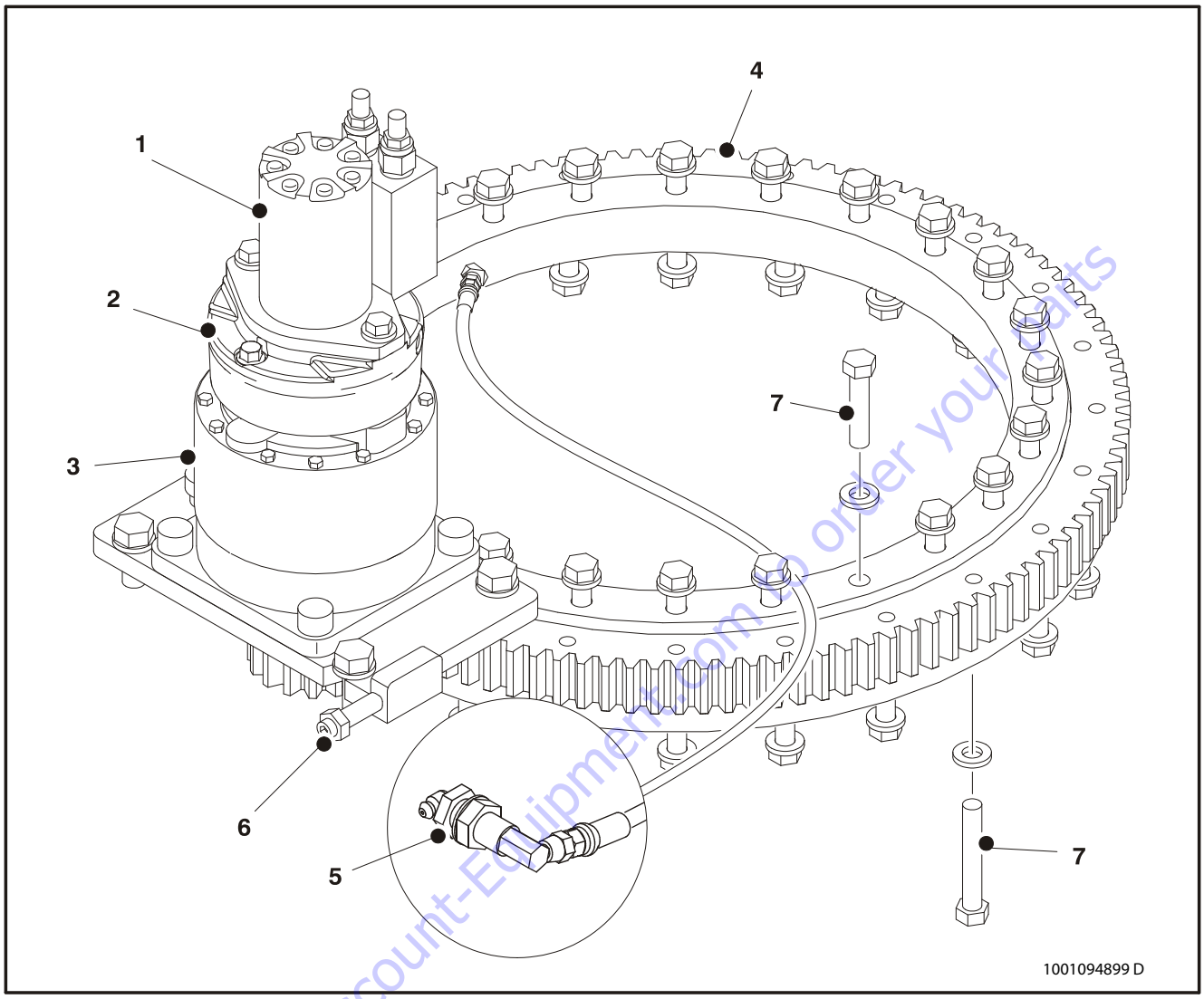
The following procedure applies to drive hubs with integral brakes.

Equipment Required

1. Hydraulic power supply (hand pump) capable of producing 200 psi (13.8 bar).
2. Hydraulic fittings to adapt hydraulic supply to brake release port on hub.

Procedure

1. Using appropriate fittings, connect a line from the hydraulic power supply to the brake port.
2. Pressurize the brake release port 155 to 200 psi (10.6 to 13.8 bar) to release the brake.
3. Verify that the brake is released by rotating the input coupling or hub spindle.
4. Once the brake is released, the input coupling will be free to re-align with the drive motor.
5. Install the drive motor on the hub, then release the hydraulic pressure at the brake release port. The coupling will remain in position.
6. Disconnect the hydraulic power supply and reconnect the line going into the brake release port.



1. Swing Motor
2. Swing Brake
3. Swing Drive
4. Swing Bearing
5. Remote Lube Fitting
6. Backlash Adjuster
7. Bearing Bolt

Figure 3-60. Swing Drive and Turntable Bearing

3.15 SWING DRIVE (PRIOR TO SN 0300066417)

Disassembly

1. Loosen all 12 cover bolts (12) & (13) and drain the oil from the unit.
2. Remove the 12 cover bolts (12) & (13) and lift off the cover (6). Remove and discard the o-ring (5) from the counterbore of the cover (6).
3. Remove the input gear (8) and thrust washer (10).
4. Lift out the carrier assembly (3) and top thrust washer (11). The thrust washer (11) may stick to the inside of the carrier (3).
5. Remove the input thrust spacer (9).
6. Lift out the internal gear (2) and thrust washer (11). The thrust washer (11) may stick to the under side of the carrier (3).
7. Remove the retaining ring (1I) from the output shaft (1A) and discard.

⚠ CAUTION

EYE PROTECTION SHOULD BE WORN DURING RETAINING RING (1I) REMOVAL.

8. Remove bearing shim (1H) from the output shaft (1A).
9. The output shaft (1A) may now be pressed out of the hub (1G).
10. The bearing cups (1C) & (1E) will remain in hub (1G) as will bearing cone (1F). Bearing cone (1D) will remain on the same output shaft (1A). The seal (1B) will be automatically removed during this procedure.

NOTE: *If bearing replacement is necessary, the bearing cups can be removed with a slide hammer puller driven out with a punch.*

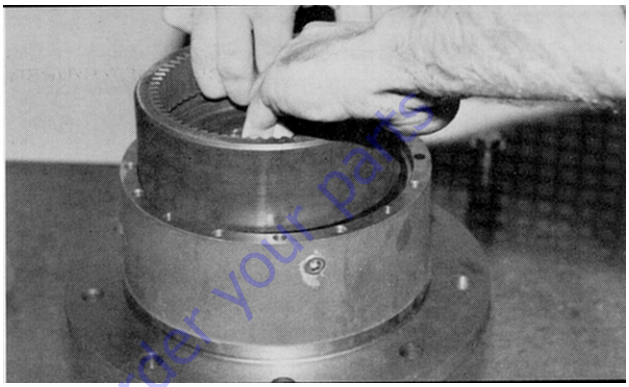
11. To remove the cluster gears (3F) from the carrier (3A), drive the anti-roll pin (3G) into the planet shaft (3E) may now be tapped out of the carrier. After planet shaft (3E) has been removed the roll pin (3G) can be driven out.
12. The cluster gear (3F) can now be removed from the carrier (3A). The thrust washers (3B) will be removed with the cluster gear (3F).
13. The needle rollers (3C) and spacer (3D) are now removed from the cluster gear (3F).

NOTICE

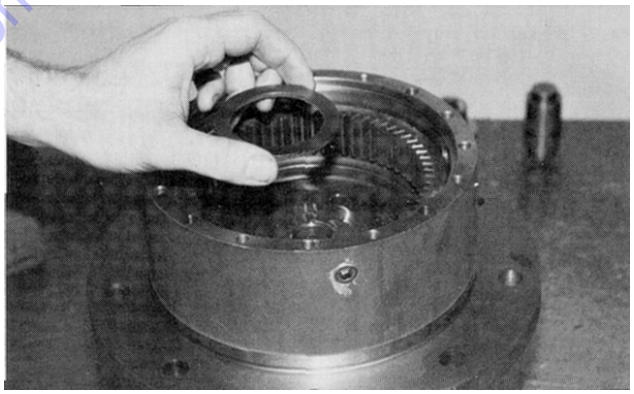
WHEN REBUILDING OR REPAIRING THE UNIT, THE RETAINING RING (1I), O-RINGS (5) AND SEAL (1B) SHOULD ALWAYS BE REPLACED.

Main Assembly Procedure

1. With the hub shaft sub-assembly resting on the shaft (1A) install internal gear (2). The spline of the internal gear (2) bore will mesh the spline of the output shaft (1A).



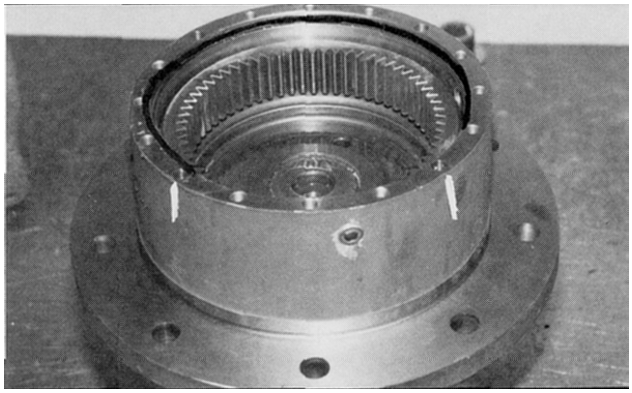
2. Thrust washer (11) is installed on the face of the output shaft (1A). Sufficient grease or petroleum jelly should be used to hold thrust washer in place.



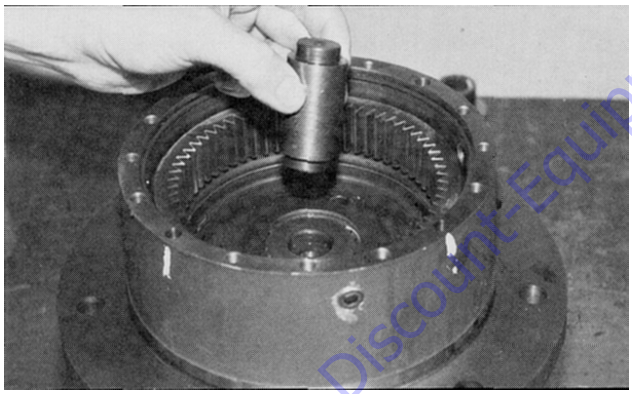
3. Place o-ring (5) into hub counterbore. Use petroleum jelly to hold o-ring in place. Also at this time locate and mark the 4 counter beamed holes in the face of the hub (1G). This is for identification later in the assembly.

⚠ CAUTION

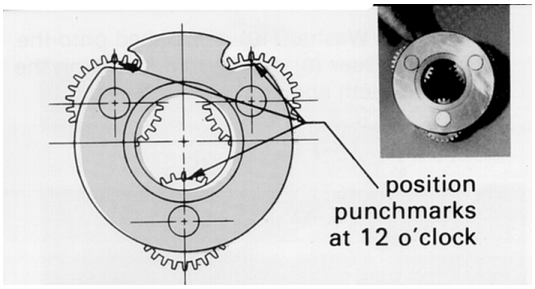
BEWARE OF SHARP EDGES OF THE COUNTERBORE WHILE SEATING THIS O-RING.



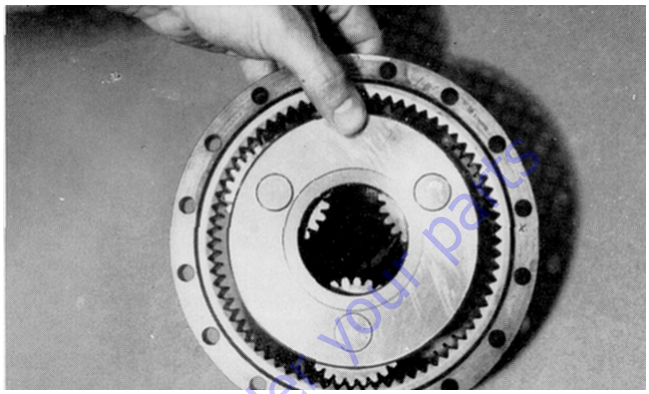
4. Thrust spacer (9) is installed into the bore of the output shaft (1A). This should be a slip fit and thrust spaces should rotate in this location.



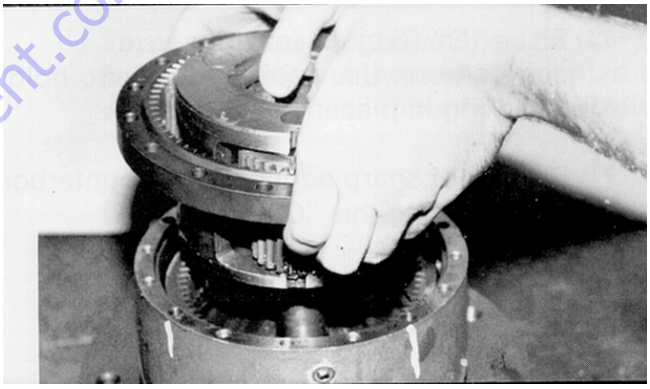
5. Place carrier assembly (3) on a flat surface with the large gears (3F) up and positioned as shown. Find the punch marked tooth on each large gear (3F) and locate at 12 0'clock (straight-up) from each planet pin. Marked tooth will be located just under the carrier (3A) on upper two gears (3F).



6. With shoulder side of ring gear (4) facing down, place ring gear over (into mesh with) large gears. Be sure that punch marks remain in correct location during ring gear installation. The side of the ring gear with an X stamped on it should be up.

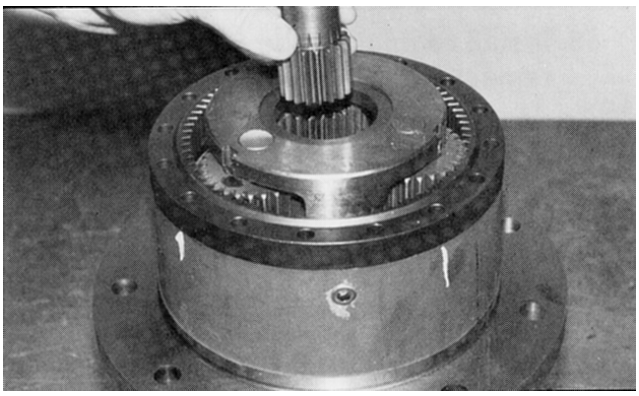


7. While holding ring gear (4) and cluster gears (3F) in mesh, place small side of cluster gears (3F) into mesh with the internal gear (2) and input gear (13). On the ring gear locate the hole marked "x" over one of the marked counterbore holes (step 3) in hub (1G).

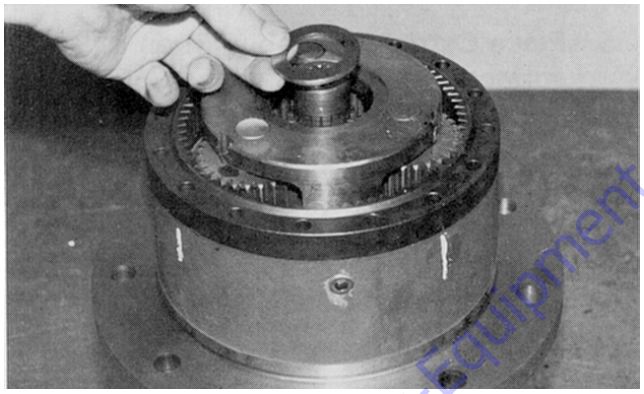


NOTE: *If gears do not mesh easily or carrier assembly does not rotate freely, then remove the carrier and ring gear and check the cluster gear timing.*

8. Input gear (8) is installed, meshing with teeth of the large diameter cluster gear (3F). The counterbore on the input gear (8) locates on the shoulder of the thrust spacer (9). This is to be a slip fit and operate freely.



9. Thrust washer (10) is installed onto the input gear (8) and should locate on the gear teeth shoulder.



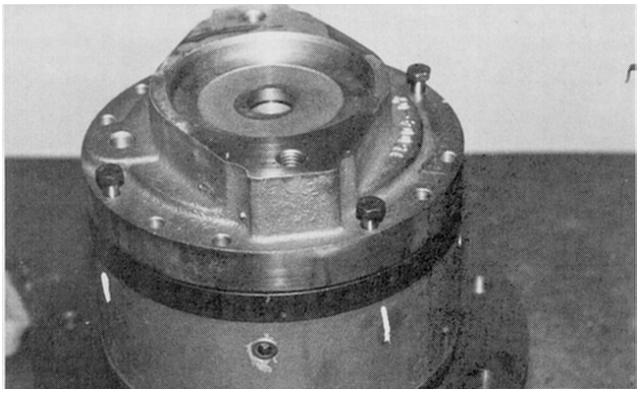
10. Thrust washer (11) is installed into the counterbore of the carrier (3).

11. Place o-ring (5) into cover (6) counterbore. Use petroleum jelly to hold o-ring in place.

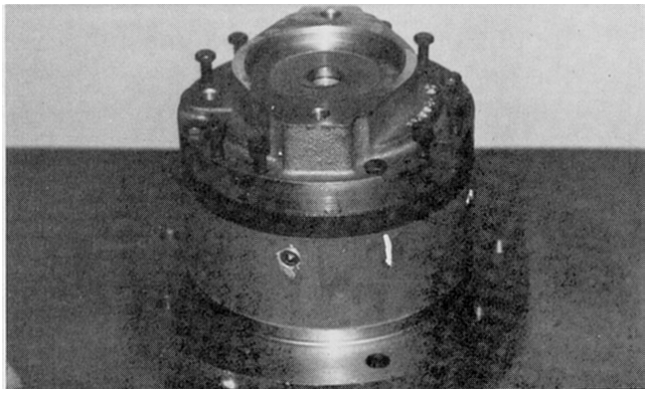
⚠ CAUTION

BEWARE OF SHARP EDGES OF THE COUNTERBORE WHILE SEATING THIS O-RING.

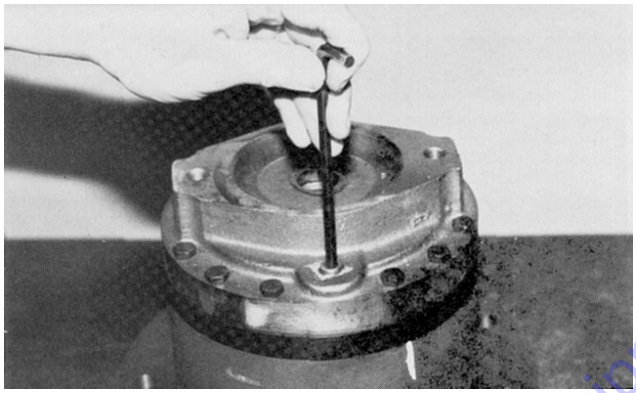
12. The cover (6) is now installed on this assembly. Taking care to correctly align pipe plug hole (20) with those in the hub (1J), usually 90° to one another.
Locate the 4 counterbore holes in hub (1G) (marked in step 3) and install 4 shoulder bolts (13). A slight tap with a hammer may be necessary to align shoulder bolt with hub (1G) counterbore.



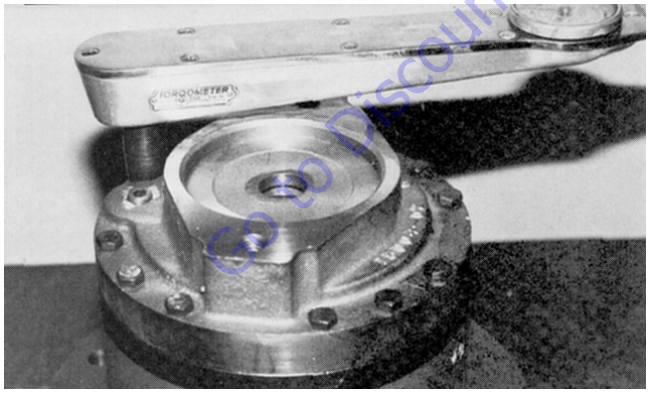
13. Install regular grade 8 bolts (12) into remaining holes.



14. Pipe plugs (20) are to be installed into cover (6) using a lubricant of some sort.



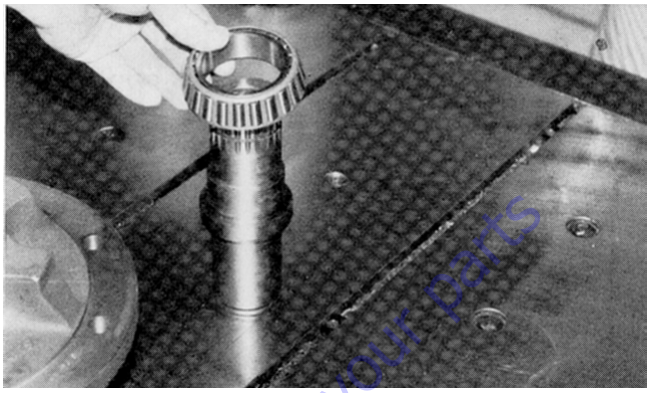
15. Torque shoulder bolts (13) to 23-27 ft. lbs. (31-37 Nm) and regular grade 8 bolts (12) to 23-27 ft. lbs. (31-37 Nm).



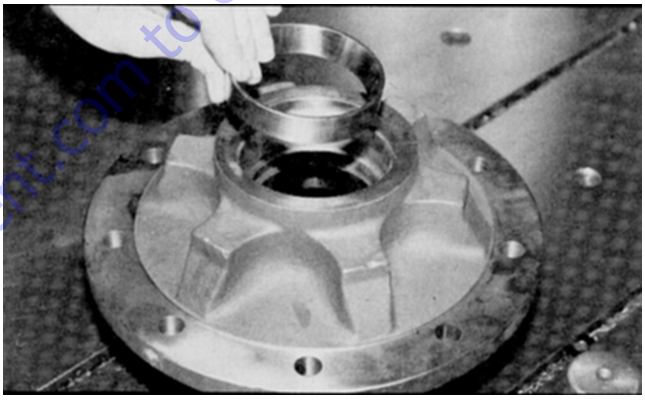
This completes the assembly. The unit must be filled one-half full of EP 90 lubricant before operation if the unit is mounted horizontally, and completely filled if mounted vertically. In vertical mounting application case oil circulation is recommended.

Hub Shaft Sub-Assembly

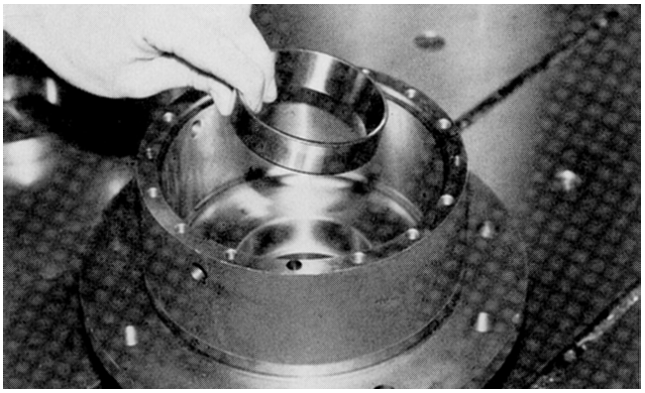
1. Press bearing cone (1D) onto shaft (1A).



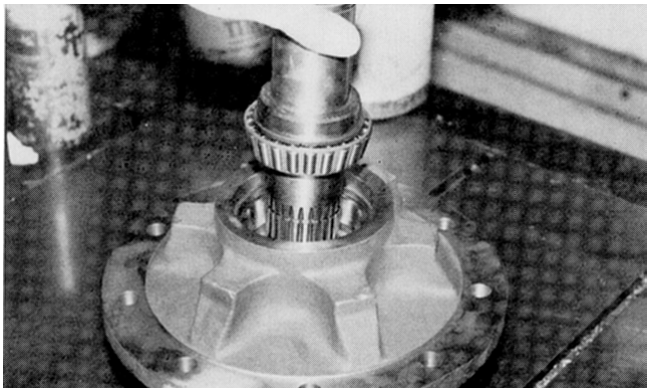
2. Press bearing cup (1C) into hub (1G) taking care to insure cup start square with the bore of the hub.



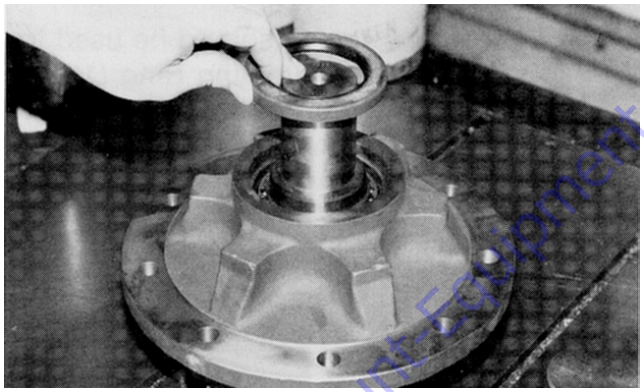
3. Invert hub (1G) and press bearing cup (1E) into inter counterbore of hub (1G).



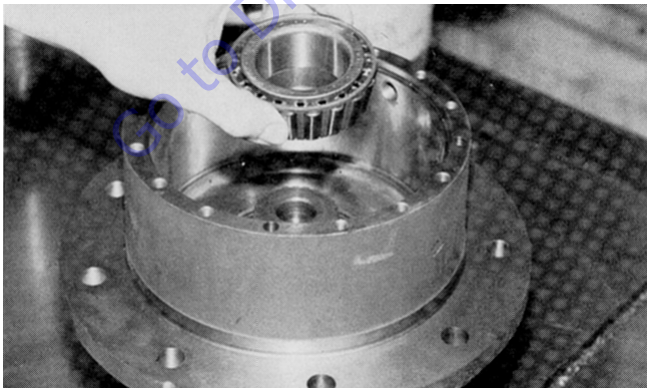
4. Returning the hub (1G) to locate on the large diameter end, the output shaft (1A) is carefully installed into the hub (1G).



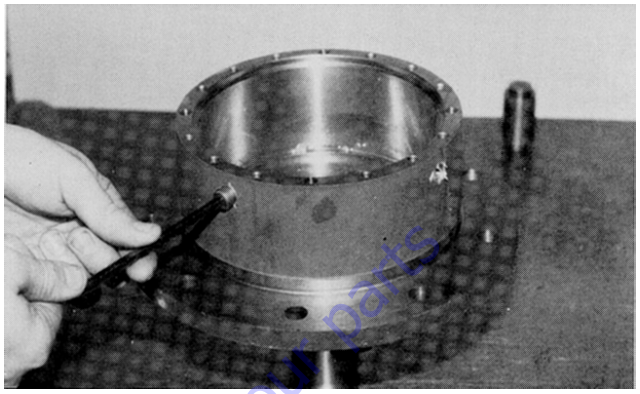
5. The shaft seal (1B) is installed over the output shaft (1A) and into the counterbore of the hub (1G). Care should be taken to insure the seal (1B) is being correctly installed (smooth face up and located just flush with the counterbore face).



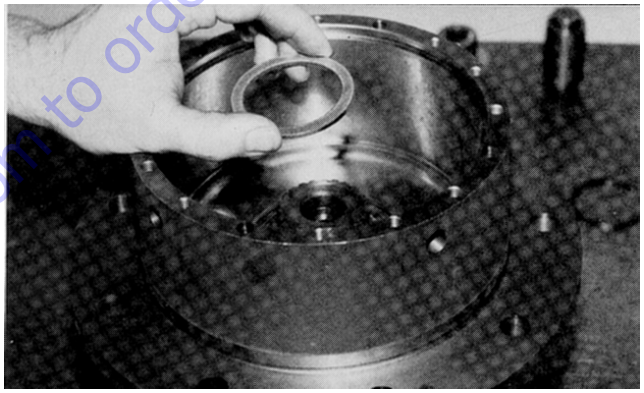
6. The bearing cone (1F) is an interference fit and has to be pressed or tapped on.



7. Pipe plugs (1J & 1K) should be checked and/ or installed at this time in the assembly.



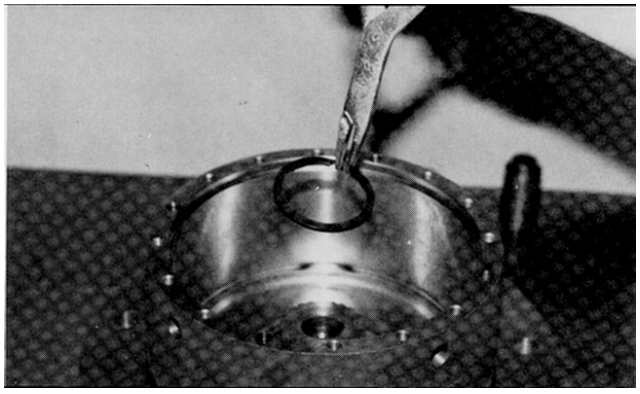
8. Bearing spacer (1H) is installed around the output shaft (1A) and locates on bearing cone (1F).



9. Retaining ring (1I) installed into groove provided in the output shaft (1A). This retaining ring (1I) should never be reused in a repair or rebuild.

⚠ CAUTION

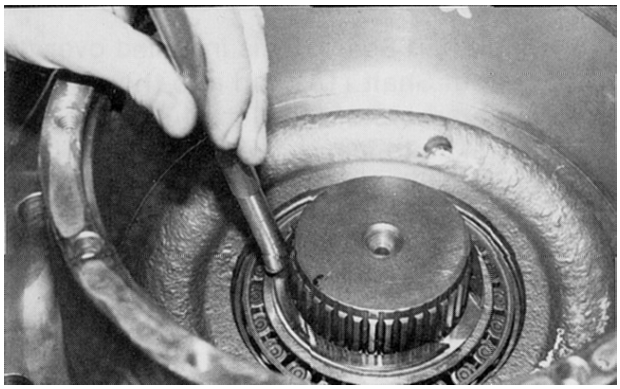
EYE PROTECTION SHOULD BE WORN DURING THIS PROCEDURE.



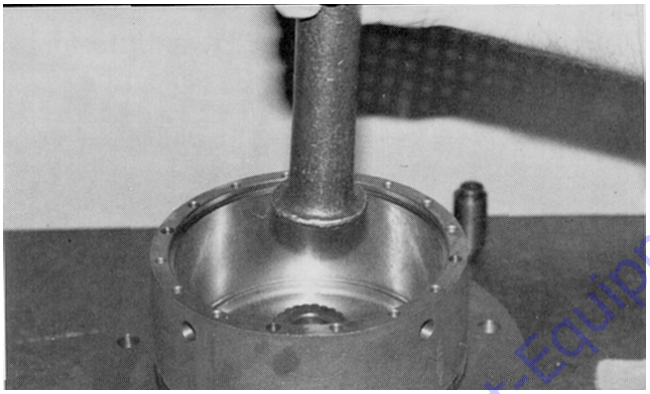
10. A soft metal punch should be used to ensure that this retaining ring (1I) is completely seated in the groove of the output shaft (1A).

⚠ CAUTION

EYE PROTECTION SHOULD BE WORN DURING THIS PROCEDURE.



11. Upon completion of step 10, rap the internal end of the output shaft (1A) twice with a piece of soft metal rod. This will release the preload which was on the bearings.

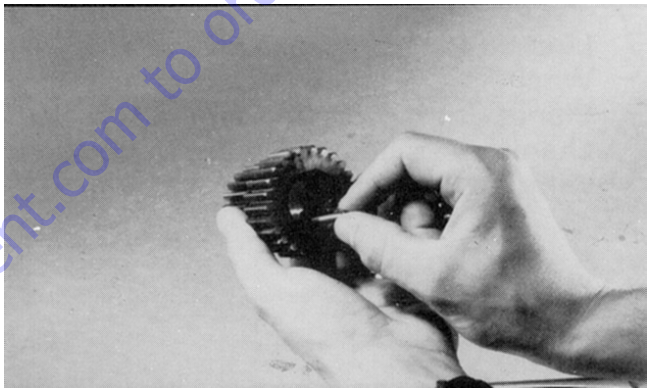


This completes the hub shaft sub-assembly —items (1A) through (1J). If this assembly is not going to be used right away, it should be oiled and covered to help prevent rusting,

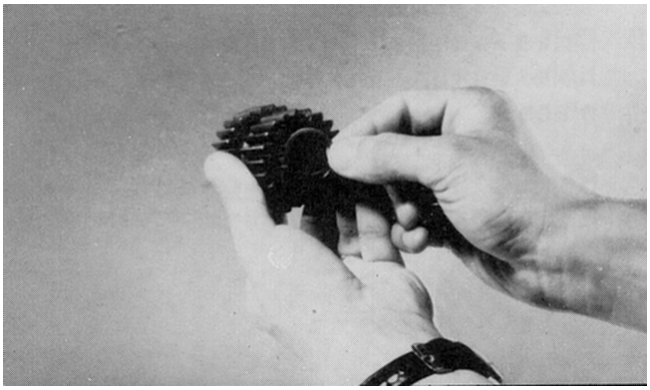
Carrier Sub-Assembly

1. Apply a coat of grease or petroleum jelly to cluster gear bore.

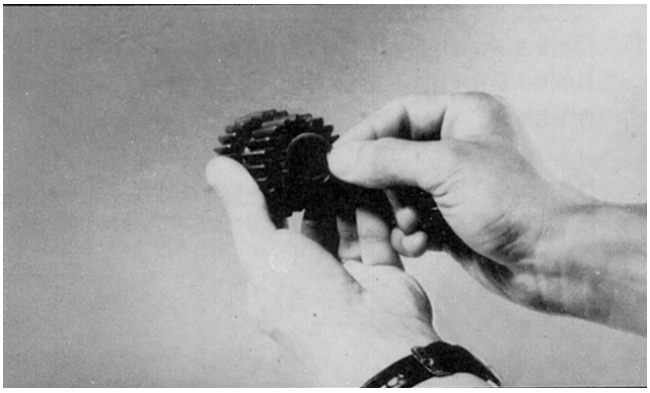
2. Place sixteen needle rollers into cluster gear bore.



3. Place spacer washer into opposite side of cluster gear and against needle rollers.

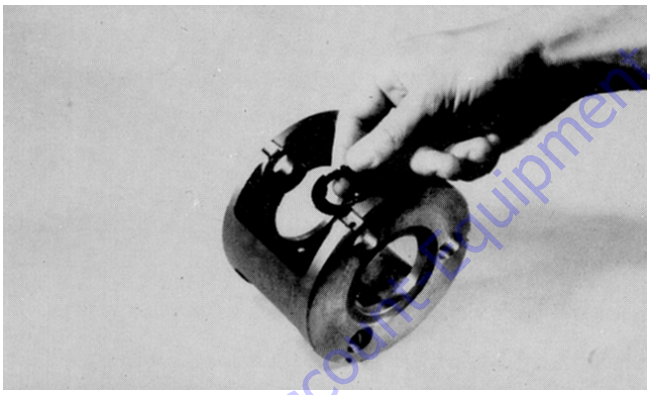


4. Place second set of sixteen needle rollers into cluster gear.

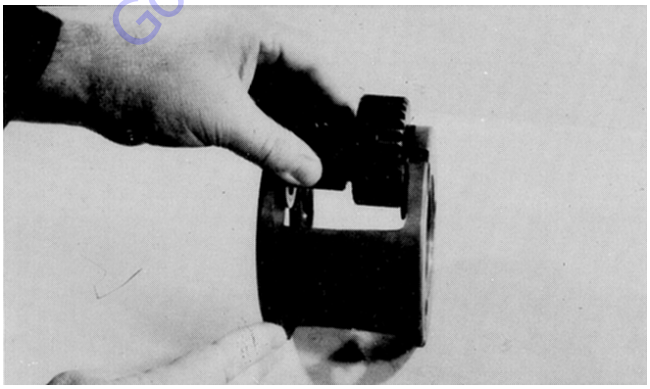


5. Apply grease or petroleum jelly to the tang side of two thrust washers. Place thrust washers against bosses in carrier with washer tang fitting into slot in carrier outside diameter.

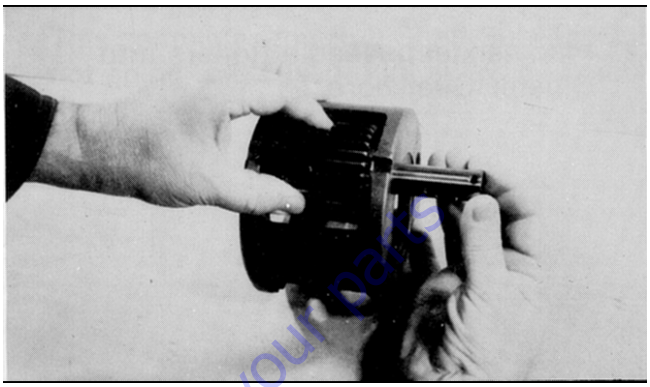
NOTE: *Some old style carriers will not have slots and tangs should be located inside boss relief.*



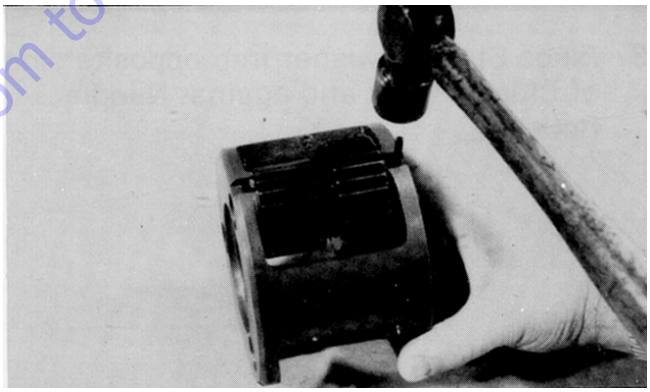
6. While keeping thrust washers in place, slide cluster gear into carrier with the larger gear on the side with the small pin hole.



7. Line up cluster gear and thrust washer with hole in carrier and slide planet shaft through. Line up chamfered side of hole in planet shaft with pin hole in carrier.



8. Drive anti-roll pin flush into carrier hole, thereby locking planet shaft into place.
Repeat these steps for remaining two cluster gears to complete carrier assembly.



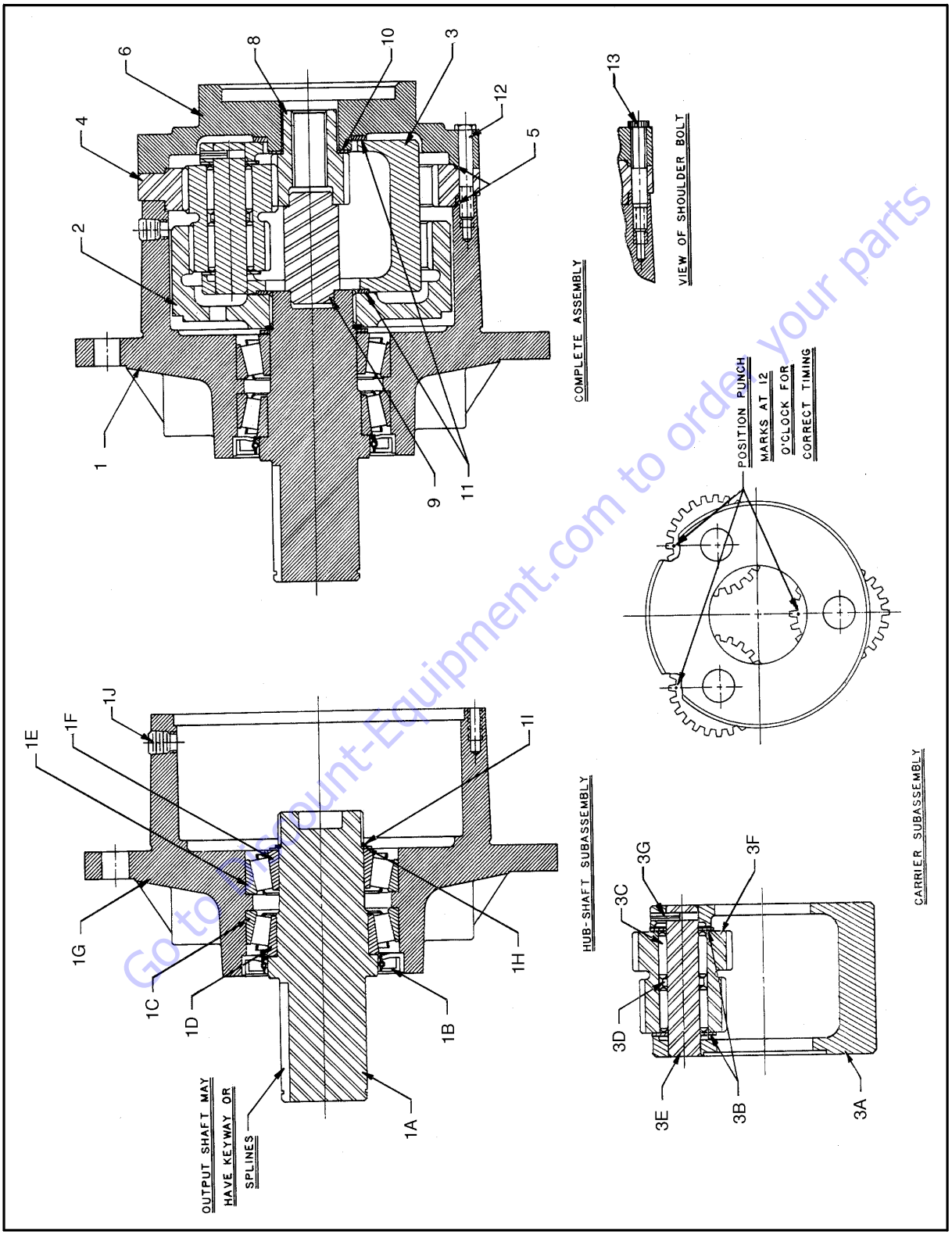


Figure 3-61. Swing Drive (Prior to SN 0300066417)

3.16 SWING DRIVE BRAKE - MICO (PRIOR TO SN 0300066417)

Disassembly

1. Remove pressure plate (3) from cover plate (16) by removing capscrews (1) and washers (2).

⚠ CAUTION

PRESSURE PLATE IS UNDER SPRING TENSION OF APPROXIMATELY 2000 LBS (907 KGF). THE TWO CAPSCREWS MUST BE LOOSENED EVENLY TO RELIEVE THIS FORCE. IF A HYDRAULIC PRESS IS AVAILABLE, 3000 LBS (1361 KGF) MINIMUM, THE PRESSURE PLATE CAN BE HELD IN POSITION WHILE REMOVING THE CAPSCREWS. COVER PLATE (16) MUST BE SUPPORTED AS SHOWN IN FIGURE 3-9.

2. Remove case seal (4) from cover plate (16).
3. Remove piston (7) from pressure plate (3).
4. Remove o-ring (5), backup ring (6), o-ring (8) and backup ring (9) from piston (7).
5. Remove stator disc (11), rotor disc (12) and return plate (13) from cover (16).
6. Remove dowel pins (15) and springs (14) from cover plate (16). Record this information for assembly purposes.

NOTE: *Not all models use the same number of springs or spring pattern. Record this information for assembly purposes.*

7. Remove retaining ring (19) from cover plate (16).
8. Remove shaft (10) by pressing or using a soft mallet on male end of shaft (10).

NOTE: *Cover plate (16) must be supported as shown in Figure 3-62.*

9. Remove retaining ring (20) from cover plate (16) and press out oil seal (17) and bearing (18) if required.

NOTE: *Cover plate (16) must be supported as indicated in Figure 3-62.*

Assembly

NOTICE

LUBRICATE ALL RUBBER COMPONENTS FROM REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM.

1. Use an alkaline wash to clean parts before assembly.
2. Press oil seal (17) into cover plate (16) until it is flush with bearing shoulder. Note direction of seal.
3. Press bearing (18) into position until it bottoms out on borestep.

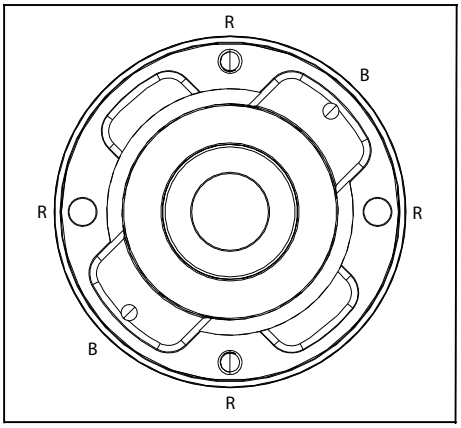
NOTE: *Cover plate (16) must be supported as indicated in Figure 3-62.*

4. Install retaining ring (20) in cover plate (16).
5. Press shaft (10) into bearing (18) until it bottoms on shoulder.

NOTE: *Bearing (18) inner race and cover plate (16) must be supported as indicated in Figure 3-62. during this operation.*

6. Install retaining ring (19) on shaft (10).
7. Insert dowel pins (15) and springs (14) in cover plate (16).

NOTE: *Be sure to use the same number of springs and spring pattern as recorded during disassembly.*



NOTE: *Start with the red springs and space them as evenly as possible throughout the spring retainer, then take the first blue spring and put it in any one of the remaining empty holes, second blue spring should be placed as directly across from the first blue spring as possible.*

8. Position return plate (13) on springs (14).

NOTE: *Discs (11 & 12) and return plate (13) must remain dry during installation. No oil residue must be allowed to contaminate disc surfaces.*

9. Install rotor disc (12) and stator disc (13).

10. Install o-ring (5), backup ring (6), o-ring (8) and backup ring (9) on piston (7). Note order of o-rings and backup rings. Insert piston (7) into pressure plate (3).

NOTE: *Be careful not to shear o-rings or backup rings. Be careful not to scratch or mar piston.*

11. Install new case seal (4) in cover plate (16).

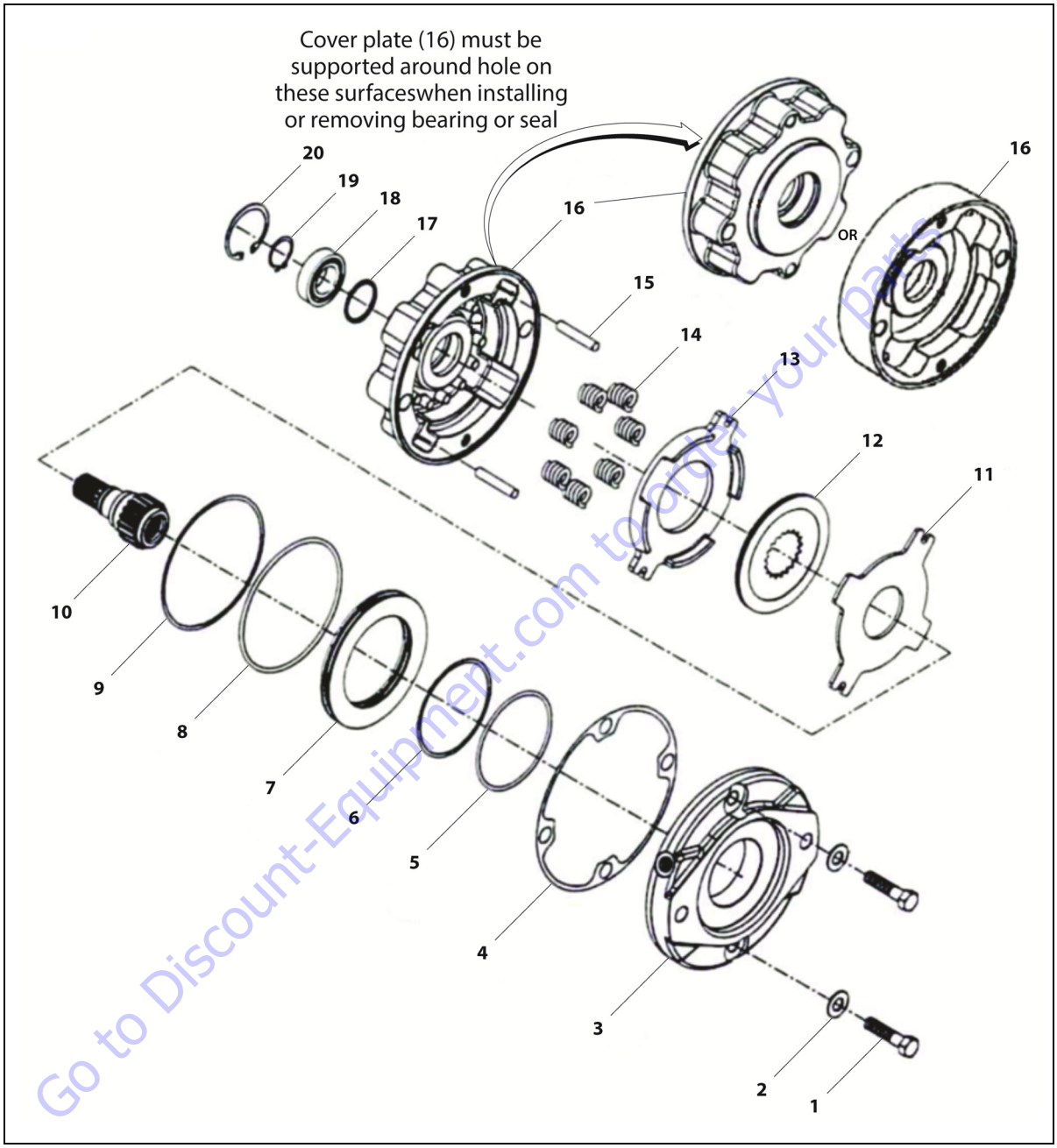
12. Position pressure plate (3) on cover plate (16) aligning dowel pins (15) with holes in pressure plate.

13. Install capscrews (1) and washers (2) and tighten evenly to draw pressure plate (3) to cover plate (16). Torque capscrews 48-50 ft. lbs. (65.1-67.8 Nm).

NOTE: *A hydraulic press will simplify installation of pressure plate on cover. Clamp pressure plate in position while tightening the capscrews. Cover plate (16) must be supported as indicated in Figure 3-9.*

⚠ CAUTION

IF HYDROSTATIC BENCH TESTING IS PERFORMED ON THE BRAKE ASSEMBLY, RELEASE PRESSURE MUST NOT EXCEED 500 PSI (134.5 BAR).



1. Capscrew
2. Washer
3. Pressure Plate
4. Case Seal
5. O-ring
6. Backup Ring
7. Piston
8. O-ring
9. Backup Ring
10. Shaft
11. Stator Disc
12. Rotor Disc
13. Return Plate
14. Springs
15. Dowel Pin
16. Cover Plate
17. Oil Seal
18. Bearing
19. Retaining Ring
20. Retaining Ring

Figure 3-62. Swing Drive Brake - Mico (Prior to SN 0300066417)

Bleeding

1. Install brake in system and connect pressure lines.
2. Bleed pressure release section of brake by pressurizing side inlet port and allowing air to escape from top port. Pressure should not exceed 6.9 bar (100 psi) during bleeding.
3. Apply sufficient pressure to release brake and check for proper operation in system.

Table 3-9. Troubleshooting

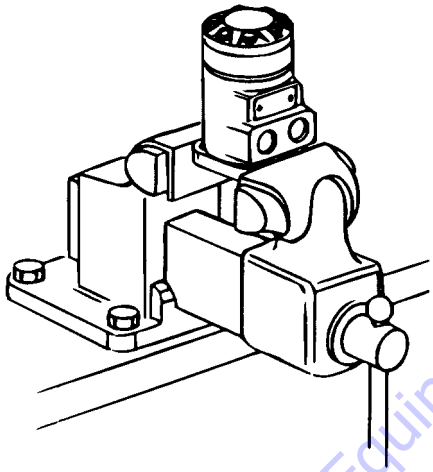
PROBLEM	CAUSE	EXPLANATION	ACTION
Brake slips	Excessive pressure in hydraulic system	If there is back pressure in the actuation line of the brake, holding torque will be reduced.	Check filters, hose size, restrictions in other hydraulic components.
	Oil in brake if designed for dry use	Wet linings generate 67% of the dry torque rating. If the brake has oil in it, check the type of oil hydraulic or gearbox. 1 . Gearbox oil 2. Hydraulic oil	Replace oil seal in brake. Check motor seal Check piston seals ***NOTE:*** *Internal components will need to be inspected, cleaned and replaced as required.*
	Disc plates worn	The thickness of the disc stack sets the torque level. A thin stack reduces torque.	Check disc thickness.
	Springs broken or have taken a permanent set	Broken or set springs can cause reduced torque - a rare occurrence.	Check release pressure. (See spring replacement).
Brake drags or runs hot	Low actuation pressure	The brake should be pressurized to minimum of 1.38 bar (20 psi) over the full release pressure under normal operating conditions. Lower pressures will cause the brake to drag thus generating heat.	Place pressure gauge in bleed port & check pressure with system on.
	Bearing failure	If the bearing should fail, a large amount of drag can be generated.	Replace bearing.
Brake will not release	Stuck or clogged valve	Brakes are designed to come on when system pressure drops below stated release pressure. If pressure cannot get to brake, the brake will not release.	Place pressure gauge in bleed port - check for adequate pressure. Replace inoperative line or component.
	Bad o-rings	If release piston will not hold pressure, brake will not release.	Replace o-rings.
	Discs frozen	These brakes are designed for only limited dynamic braking. A severe emergency stop or prolonged reduced release pressure operation may result in this type of damage.	Replace disc stack.

3.17 SWING MOTOR (PRIOR TO SN 0300066417)

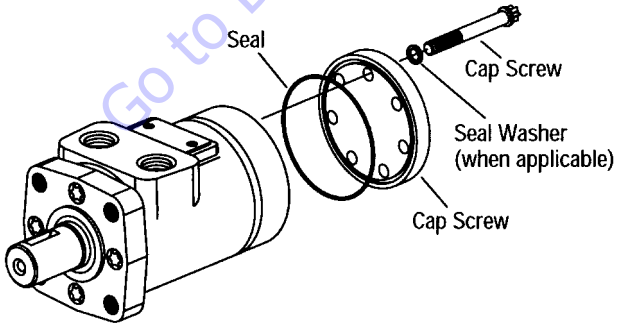
Disassembly

Cleanliness is extremely important when repairing these motors. Work in a clean area. Before disconnecting lines, clean port area of motor. Remove key when used. Check shaft and key slot. Remove burrs, nicks and sharp edges. Before disassembly, drain oil from motor. Then plug ports and thoroughly clean exterior of motor.

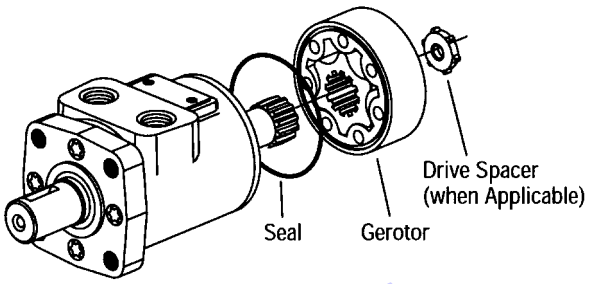
Although not all drawings show motor in a vise, we recommend that you keep the motor in a vise during disassembly. Follow the clamping procedures explained throughout the manual.



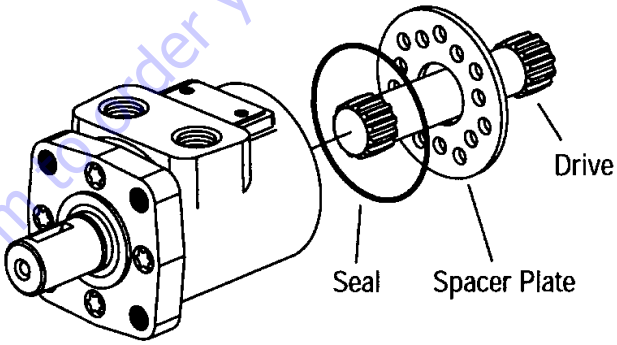
1. Place motor in vice and clamp across edge of flange with output shaft down. When clamping, use protective device on vice such as special soft jaws, pieces of hard rubber or board.



2. remove capscrews and seal washers.
3. Remove end cap.
4. Remove seal from end cap.

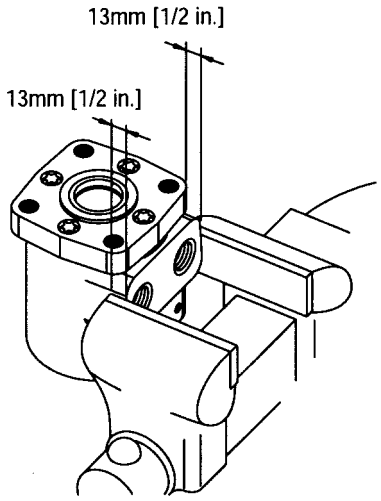


5. Remove gerotor.
6. Remove seal from gerotor.
7. Remove drive spacer if applicable.



8. Remove drive.
9. Remove spacer plate.
10. Remove seal from housing.
11. Remove output shaft from housing.

12. Remove needle thrust bearing from shaft or housing.



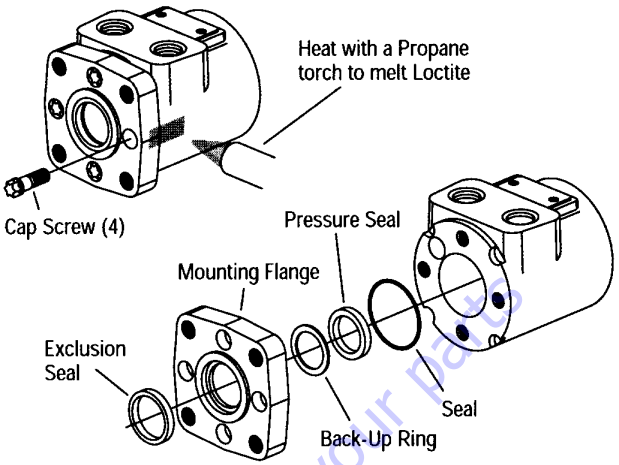
13. Reposition motor in vise. Clamp across ports as shown above. Do not clamp side of housing. Excessive clamping pressure on side of housing causes distortion.

14. Remove capscrews from mounting flange. These screws are assembled with Loctite to hold them in place.

The screws will require 300-400 in. lbs. (35-45 Nm) of torque to break loose and 100 in. lbs. (11 Nm) torque to remove. Do not use impact wrench on screws that have been secured with Loctite. This could result in rounded heads or broken sockets.

NOTE: *If torque higher than given above is required to break screws loose, apply heat according to following instructions.*

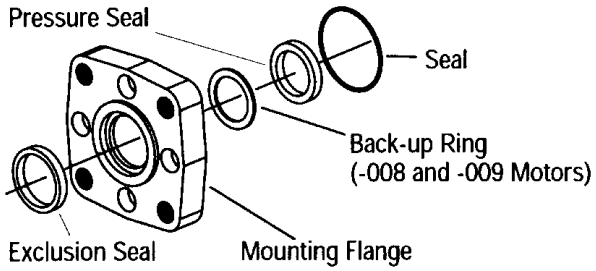
NOTE: *When heated, Loctite partially melts. This reduces the torque required to remove screw. Use small flame propane torch to heat small area of housing where screw enters (see figure below). Be careful not to overheat housing and damage motor. Gradually apply torque to screw with socket wrench as heat is applied for 8 to 10 seconds. As soon as screw breaks loose, remove heat from housing. Continue turning screw until it is completely removed.*



15. Carefully remove flange from housing.

NOTICE

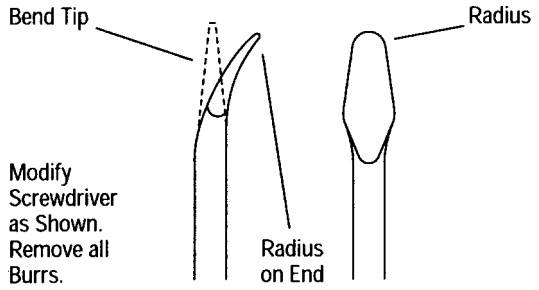
SOME MOTORS MAY HAVE A QUAD SEAL AND BACKUP RING IN PLACE OF THE PRESSURE SEAL. THE QUAD SEAL AND BACKUP RING ARE NO LONGER AVAILABLE AND ARE REPLACED BY THE PRESSURE SEAL. THEY ARE INTERCHANGEABLE, BUT SOME PRECAUTIONS MUST BE TAKEN TO INSURE PROPER INSTALLATION. FOLLOW THE REASSEMBLY INSTRUCTIONS.

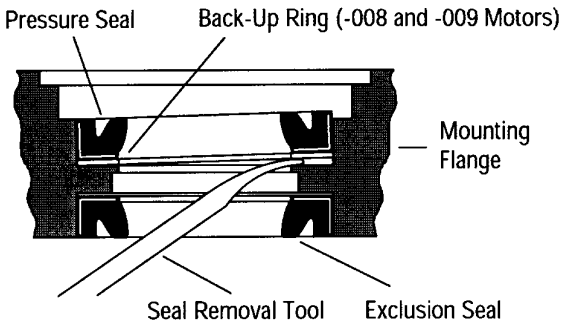


16. Exclusion seal, backup ring, pressure seal and seal will come off with flange. Use seal removal tool as shown to remove exclusion and pressure seals.

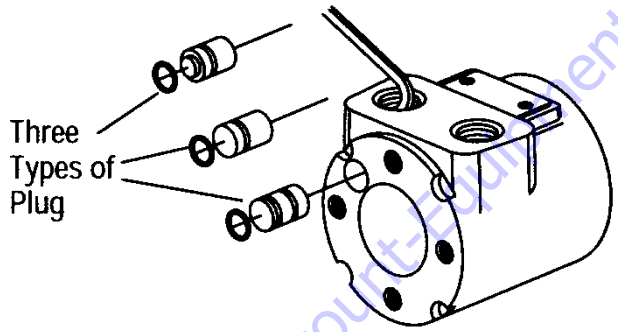
NOTICE

BE CAREFUL NOT TO SCRATCH SEAL CAVITY O.D. THIS COULD CREATE A LEAK PATH.





Work from outer side for both (either) Seals.



17. A metal plug, with seal, plugs a machining hole in the housing. It is not necessary to remove plug and replace seal unless leakage occurs around plug. To remove plug, insert 5 mm (.187 in.) hex key through port opening and push it out. The 009 plug is not interchangeable with 007 and 008 plugs.

Inspection and Cleaning

Check all mating surfaces. Replace any parts with scratches or burrs that could cause leakage or damage. Clean all metal parts in clean solvent. Blow dry with air. Do not wipe parts with cloth or paper towel because lint or other matter could get into the hydraulic system and cause damage.

Check around key slot and chamfered area of shaft for burrs, nicks or sharp edges that could damage seals during reassembly. Remove nicks or burrs with hard smooth stone (such as an Arkansas stone). Do not file or grind motor parts.

NOTE: *Lubricate all seals with petroleum jelly. Use new seals when reassembling motor.*

NOTICE

DO NOT STRETCH SEALS BEFORE INSTALLING THEM.

Cleanliness is extremely important in the successful application of Loctite. Before Loctite can be applied, the parts should be cleaned as follow:

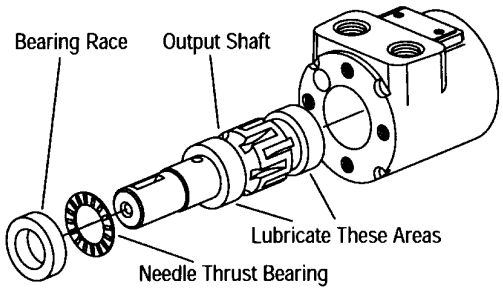
NOTE: *Fully cured Loctite resists most solvents, oils, gasoline and kerosene and is not affected by cleaning operations. It is not necessary to remove cured Loctite that is securely bonded in tapped holes; however, any loose particles of cured Loctite should be removed.*

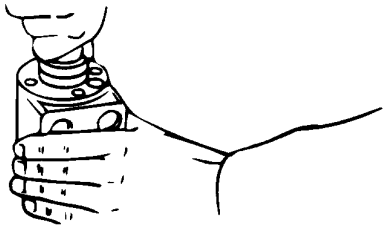
- **a.** Wash the housing with solvent to remove oil, grease and debris. Pay particular attention to four tapped holes on flanged end.
- **b.** Blow dry with compressed air. Clean and dry tapped holes.
- **c.** Wire brush screw threads to remove cured Loctite and other debris. Discard any screws that have damaged threads or rounded heads.
- **d.** Wash screws with non-petroleum base solvent. Blow dry with compressed air.

Assembly

SHAFT END

1. If you remove plug and seal, lubricate seal and install on plug. Some plugs have two o-ring grooves but require only one o-ring. Install o-ring in groove closest to end of plug. Push plug into housing. Be careful not to damage seal.



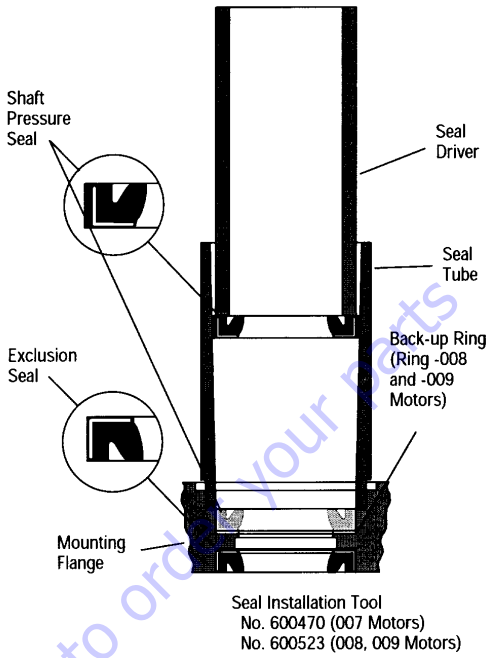


2. Lubricate output shaft with hydraulic oil, then install shaft in housing.

NOTICE

DO NOT PERMIT OIL TO GET INTO THE FOUR TAPPED HOLES.

3. Install needle thrust bearing, then bearing race on shaft. Pull shaft partially out of housing. Push all three parts in housing together. The bearing race must rotate freely when in position.



4. Install exclusion seal in flange. Carefully press exclusion seal into place.

5. Visually check seal seat in mounting flange for scratches or other marks that might damage the pressure seal. Check for cracks in flange that could cause leakage.

6. Lubricate I.D. of seal tube and O.D. of shaft pressure seal with light film of petroleum jelly. Align small I.D. end of seal tube with seal seat in mounting flange. Install backup ring and pressure seal in tube with lip seal face up. Insert seal driver in tube and firmly push seal seat with a rotating action.

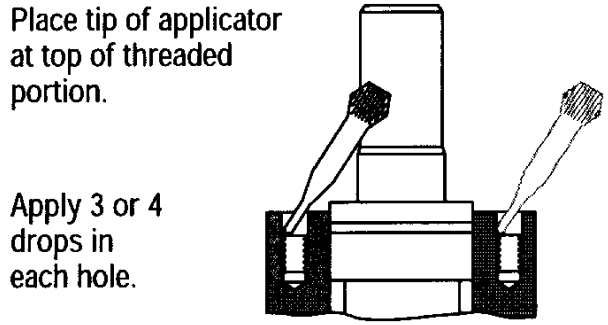
NOTICE

AFTER INSTALLING SEAL IN FLANGE, EXAMINE SEAL CONDITION. IF DAMAGED OR IMPROPERLY INSTALLED, YOU MUST REPLACE IT BEFORE CONTINUING WITH REASSEMBLY.

7. Install 49 mm (1.937 in.) I.D. seal in flange.

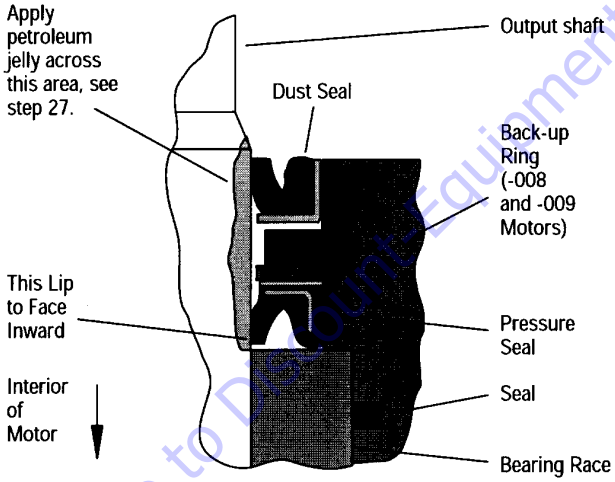
8. It is recommended to apply a light coat of Loctite Primer NF in tapped holes of housing. Allow primer to dry for at least 1 minute. Do not force dry with air jet; the primer will blow away.

   Use of primer is optional. With primer, curing time is approximately 15 minutes. Without primer curing time is approximately 6 hours.



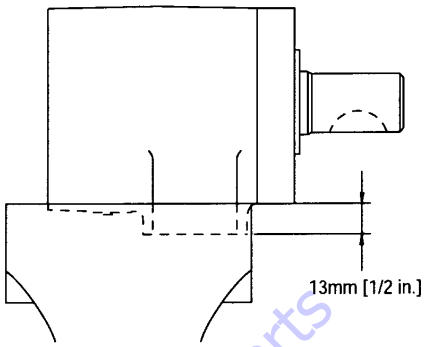
9. Apply 3 or 4 drops of Loctite sealant at top of threads for each of the four holes in housing. Do not allow parts with Loctite applied to come on contact with metal parts other than those for assembly. Wipe off excess Loctite from housing face, using a non petroleum base solvent.

Do not apply Loctite to threads more than 15 minutes before installing screws. If housing stands for more than 15 minutes, repeat application. No additional cleaning or removal of previously applied Loctite is necessary.



10. Before installing flange and seal assembly over shaft, place protective sleeve or bullet over shaft. Then lubricate space between exclusion seal and pressure seal, as well as lips of both seals.

Install flange. Rotate flange slowly while pushing down over shaft. Be careful not to invert or damage seals.



11. After removing bullet, clamp motor in vise as shown above. Make sure shaft cannot fall out. Install dry screws and alternately torque them immediately to 250 in. lbs. (28 Nm). If you use primer, allow to cure 10 to 15 minutes. Without primer, allow 6 hours curing time before subjecting to high torque reversals. On all other applications, you can run motor immediately.
If you use new screws, make sure they are correct length: 22 mm (0.875 in.) under head length. See parts book for correct part number.

GEROTOR END

1. Reposition motor with gerotor end up, then clamp across ports. Do not clamp on side of housing.

NOTICE

TO AID INSTALLATION OF SEALS, APPLY LIGHT COAT OF CLEAN PETROLEUM JELLY TO SEALS. DO NOT STRETCH SEALS BEFORE INSTALLING THEM IN GROOVE.

2. Pour approximately 35 cc of clean hydraulic oil in output shaft cavity.

3. Install 73 mm (2.875 in.) I.D. seal in housing seal groove. Avoid twisting seal.

Timing Procedure

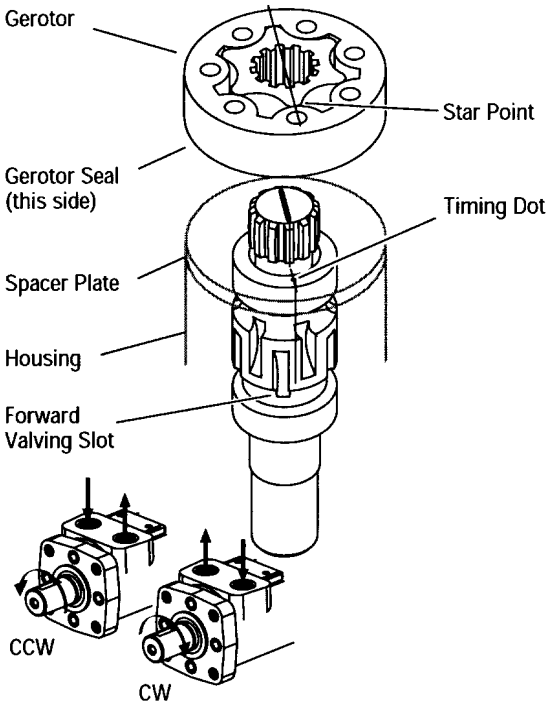
a. Install drive. Use felt tip marker to mark or drive tooth. Align this tooth with timing dot on shaft.

NOTE: *If drive is not symmetrical, install larger splined end into shaft.*

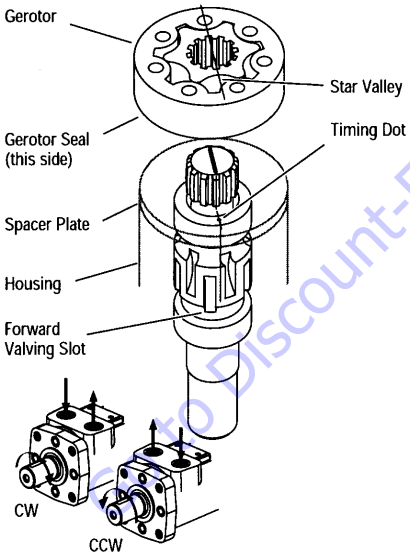
b. Install spacer plate.

c. Install 73 mm (2.875 in) I.D. seal in gerotor seal groove. Carefully place gerotor on spacer plate, seal side toward spacer plate.

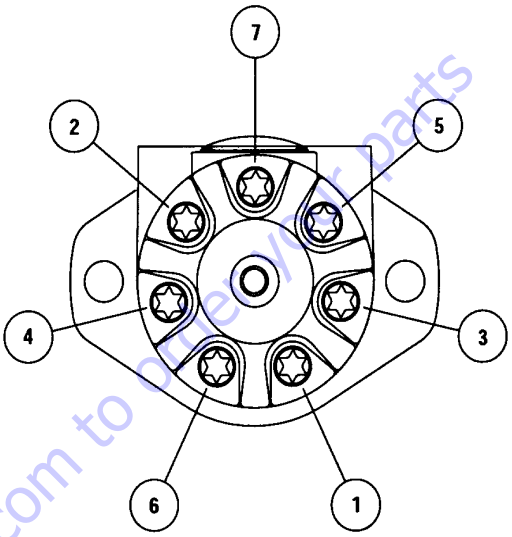
Standard rotation align any star point with tooth marked on drive (see figure below).



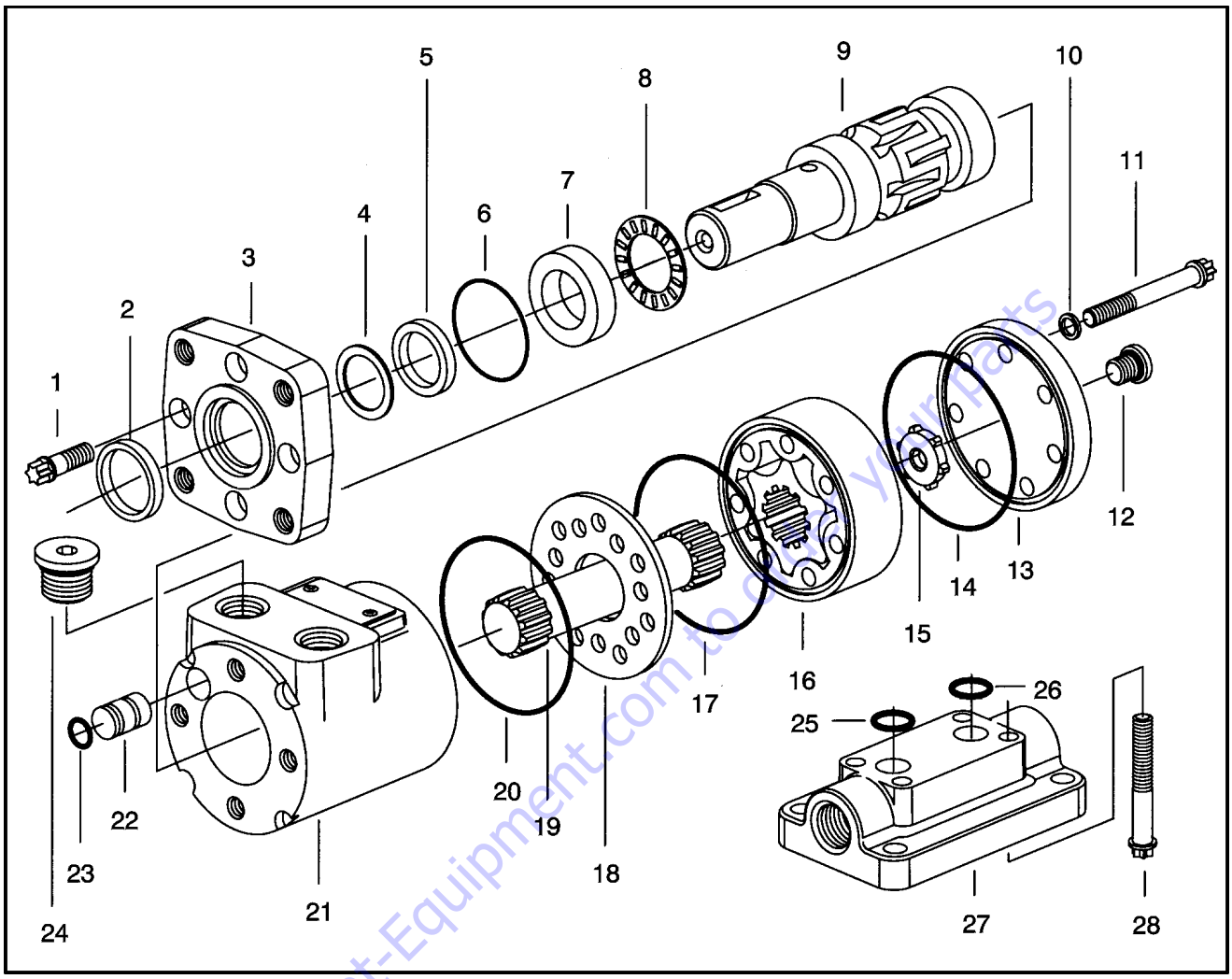
Reverse rotation align any star valley with marked tooth (see figure below).



1. Rotate gerotor to line up with bolt holes. Be careful not to disengage star from drive or disturb gerotor seal.
2. Install drive spacer if applicable.
3. Install 73 mm (2.875 in.) seal in end cap. Carefully place end cap on gerotor.



4. Install capscrews and seal washers (if applicable) in end cap. Pre-tighten screws to 40 in. lbs. (7.4 Nm). Make sure seal washers are properly seated. Then torque screws to 235-250 in. lbs. (27-28 Nm) in sequence, as shown above.



1. Capscrew
2. Exclusion Seal
3. Mounting Flange
4. Backup Ring (-008, -009 Motors)
5. Pressure Seal
6. Seal
7. Bearing Race
8. Needle Bearing Thrust
9. Output Shaft
10. Seal Washer (When Applicable)
11. Capscrew
12. Plug/O-ring S/A
13. End Cap
14. Seal
15. Drive Spacer (When Applicable)
16. Geroter
17. Seal
18. Spacer Plate
19. Drive
20. Seal
21. Housing
22. Plug
23. Seal
24. Plug/O-ring S/A (End Ported Motors)
25. O-ring
26. O-ring
27. Optional - Base Block Mounting Kit
28. Capscrew

Figure 3-63. Swing Motor (Prior to SN 0300066417)

3.18 SWING DRIVE (SN 0300066417 THROUGH 0300182743, B300000100 THROUGH B300001091)

Roll, Leak And Brake Testing

Drive Hub units should always be roll and leak tested before disassembly and after assembly to make sure that the unit's gears, bearings and seals are working properly. The following information briefly outlines what to look for when performing these tests.

NOTE: *The brake must be released before performing the roll test. This can be accomplished by either pressure testing using the Brake Leak Test procedure below or by tightening the 12 bolts into the piston through the end plate (See Brake Disassembly Procedure).*

NOTE: *Bolts must be removed while performing brake release test.*

Roll Test

The purpose of the roll test is to determine if the unit's gears are rotating freely and properly. You should be able to rotate the gears in your unit by applying constant force to the roll checker. If you feel more drag in the gears only at certain points, then the gears are not rolling freely and should be examined for improper installation or defects. Some gear packages roll with more difficulty than others. Do not be concerned if the gears in your unit seem to roll hard as long as they roll with consistency. Release the pressure at the Brake Housing (6) and remove the test fixtures.

Leak Test (Main Unit)

The purpose of a leak test is to make sure the unit is air tight. You can tell if your unit has a leak if the pressure gauge reading on your air checker starts to fall after the unit has been pressurized and allowed to equalize. Leaks will most likely occur at the pipe plugs, the main seal or wherever o-rings or gaskets are located. The exact location of a leak can usually be detected by brushing a soap and water solution around the main seal and where the o-rings or gaskets meet on the exterior of the unit, then checking for air bubbles. If a leak is detected in a seal, o-ring or gasket, the part must be replaced, and the unit rechecked. Leak test at 10 psi (0.7 bar) for 20 minutes.

Brake Test

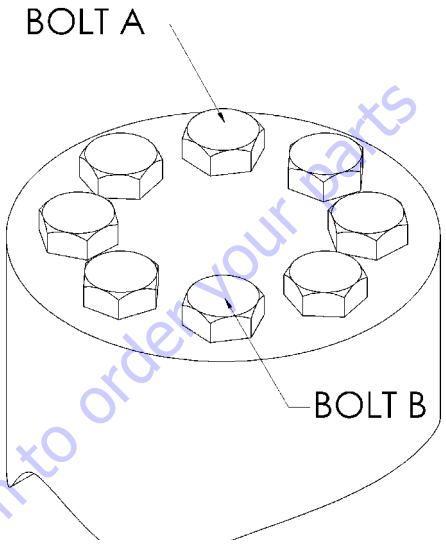
The brake test must be performed with the Motor removed and the Brake Test Plate (T-214404) installed. Install the Hex Bolts through Brake Test Plate and torque to 80-100 ft. lbs. (108-135 Nm). Install Roll Checking Tool (T-212731) and apply 210 psi (14 bar) to the o-ring port in the side of the Brake Housing. The roll checking fixture should roll freely. Increase the pressure to 3000 psi (207 bar) and perform the Roll Test.

NOTE: *Failure to perform this lest may result in damaged or ineffective brake parts.*

Tightening and Torquing Bolts

If an air impact wrench is used to tighten bolts, extreme care should be taken to ensure that the bolts are not tightened beyond their specified torque.

The following steps describe how to tighten and torque bolts or socket head capscrews in a bolt circle.

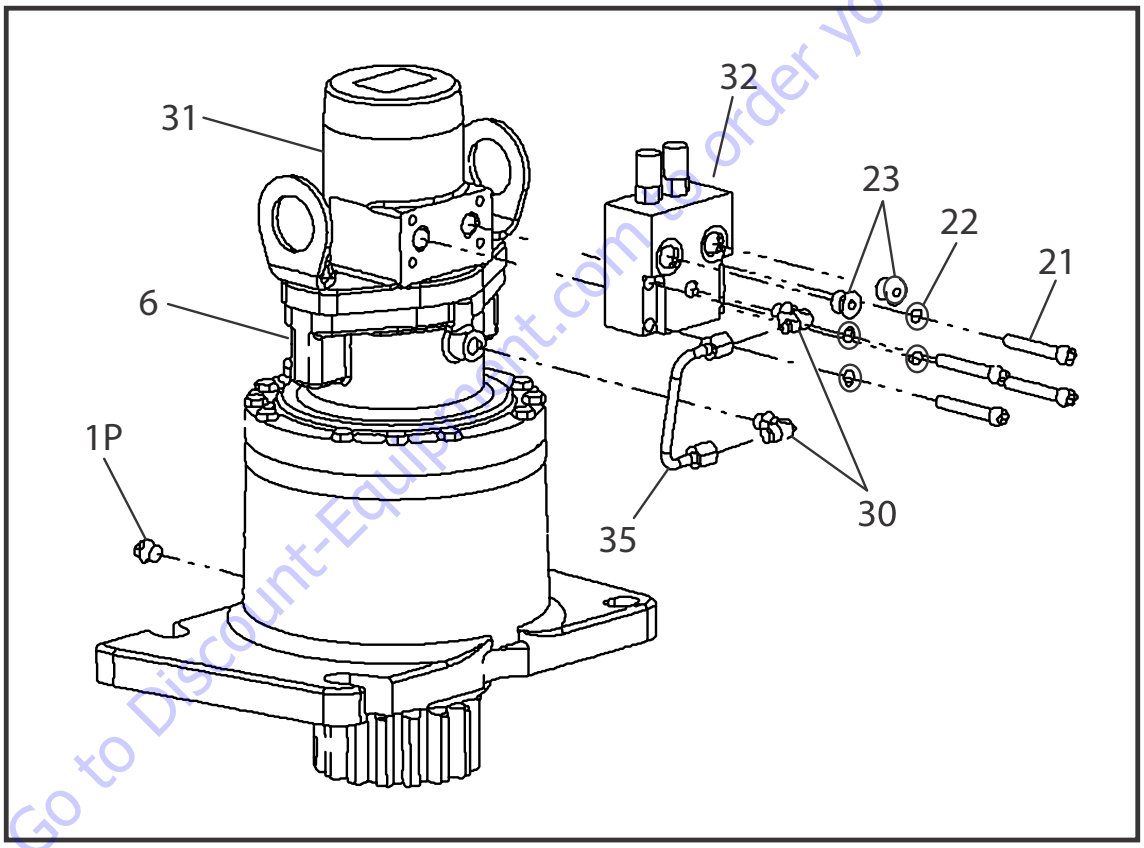


1. Tighten (but do not torque) bolt “A" until snug.
2. Go to the opposite side of the bolt circle and tighten bolt “B” until equally snug.
3. Crisscross around the bolt circle and tighten remaining bolts.
4. Now use a torque wrench to apply the specified torque to bolt “A”.
5. Using the same sequence, crisscross around the bolt circle and apply an equal torque to the remaining bolts.

Motor Control Valve Disassembly

NOTE: *Refer to Figure 3-64., Motor Control Valve.*

1. Place unit on bench with the motor end up.
2. Remove O-ring Plug (1P) and drain the oil from the gearbox.
3. Remove Hydraulic Tubing Assembly (35) by loosening fittings on both ends of tube with a wrench.
4. Using a wrench, loosen jam nuts on Elbow Fittings (30) and remove fittings from Brake (6) and Motor Control Valve (32).
5. Remove O-ring Plugs (23) from Motor Control Valve (32).
6. Remove Motor Control Valve (32) from Motor (31) by removing the four Bolts (21) and washers (22).



1P. O-ring Plug
6. Hydraulic Brake
21. Hex Bolt
22. Lockwasher
23. Plug
30. Elbow Fitting
31. Hydraulic Motor
32. Motor Control Valve
35. Hydraulic Tubing

Figure 3-64. Motor Control Valve

Motor and Brake Disassembly

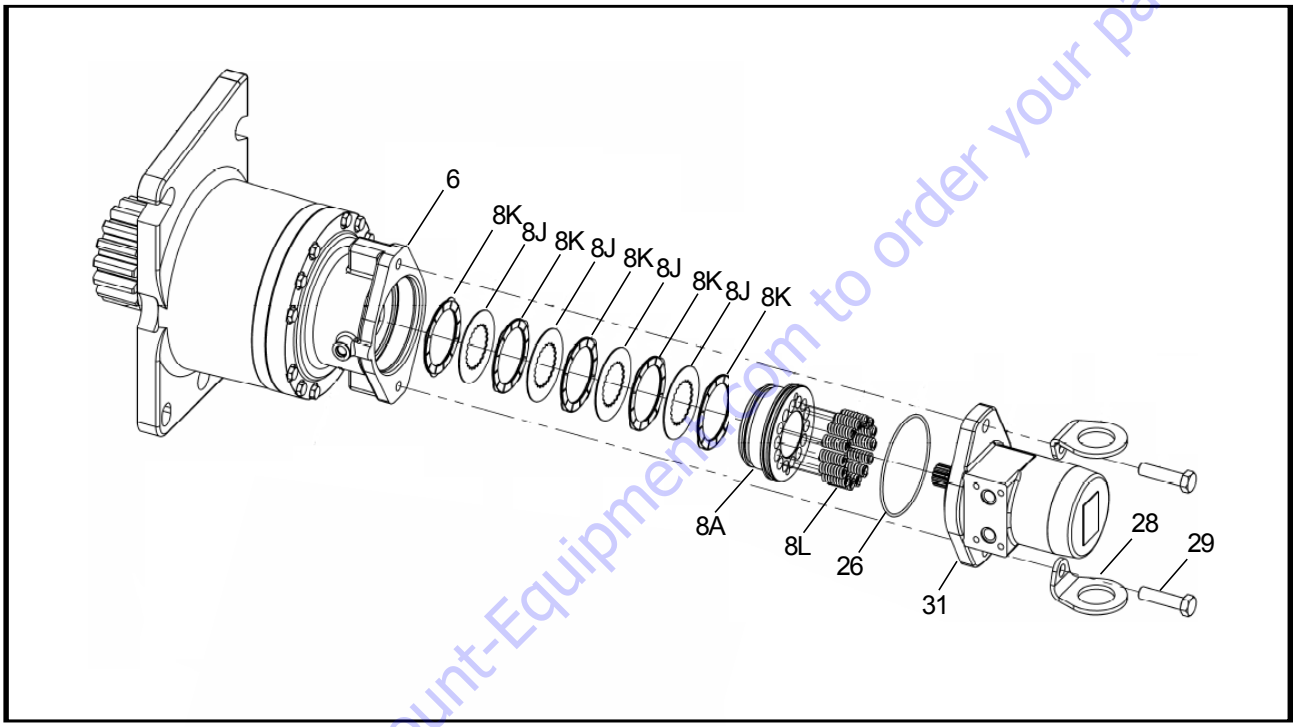
NOTE: *Refer to Figure 3-65., Motor and Brake.*

1. With unit resting on bench with Motor (31) end up, loosen Hex Bolts (29) and remove Lift Lugs (28) from the Motor (31).
2. Pull Motor (31) straight up and remove Motor (31) from Brake Housing (6).
3. Remove O-ring (26) from between Motor (31) and Brake Housing (6).
4. Remove the Springs (8L) from the piston.
5. Apply less than 50 psi (3.45 bar) air to the "brake port" to remove Brake Piston (8A).

⚠ CAUTION

THE PISTON MAY MOVE QUICKLY. EYE PROTECTION SHOULD BE WORN DURING THIS PROCEDURE.

6. Remove Rotors (8J) and Stators (8K) from Brake Housing (6).



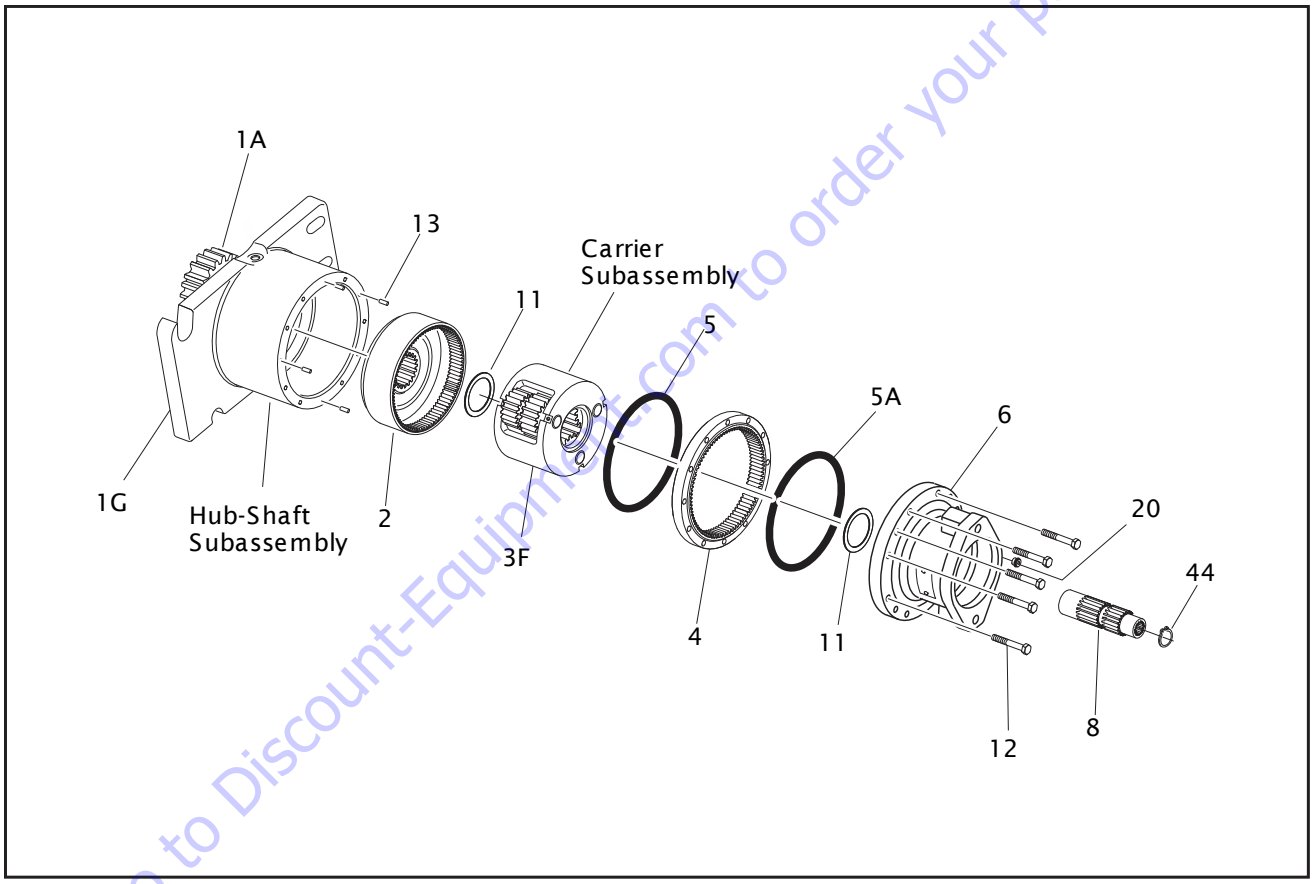
6. Brake Housing
8A. Brake Piston
8L. Spring
8J. Rotors
8K. Stator
26. O-ring
28. Lift Lug
29. Hex Bolt
31. Motor

Figure 3-65. Motor and Brake

Main Drive Disassembly

NOTE: *Refer to Figure 3-66., Main Drive Assembly.*

1. Remove Sun Gear (8) with Retaining Ring (44) inside.
2. With the unit resting on the Output Shaft (Pinion) (1A), remove the Bolts (12) from the Brake Housing (6).
3. Remove the Brake Housing (6) from the main assembly.
4. Remove O-ring (5A) from between Brake Housing (6) and Ring Gear (4).
5. Remove Thrust Washer (11) from between Brake Housing (6) and Carrier Subassembly.
6. Remove Ring Gear (4) from Housing (1G).
7. Remove O-ring (5) from between Ring Gear (4) and Housing (1G).
8. Remove Carrier Sub-Assembly.
9. Remove Thrust Washer (11) from between Carrier Sub-Assembly and Internal Gear (2).
10. Remove Internal Gear (2).



1A. Output Shaft (Pinion)	5. O-ring	12. Bolt
1G. Housing	5A. O-ring	13. Dowel Pin
2. Internal Gear	6. Brake Housing	20. Pipe Plug
3F. Carrier subassembly	8. Sun Gear	44. Ring
4. Ring Gear	11. Thrust Washer	

Figure 3-66. Main Drive Assembly

Hub-Shaft Disassembly

NOTE: *Refer to Figure 3-67., Hub-Shaft.*

1. Using retaining ring pliers remove Retaining Ring (1I) from groove in Output Shaft (1A) and discard.

⚠ CAUTION

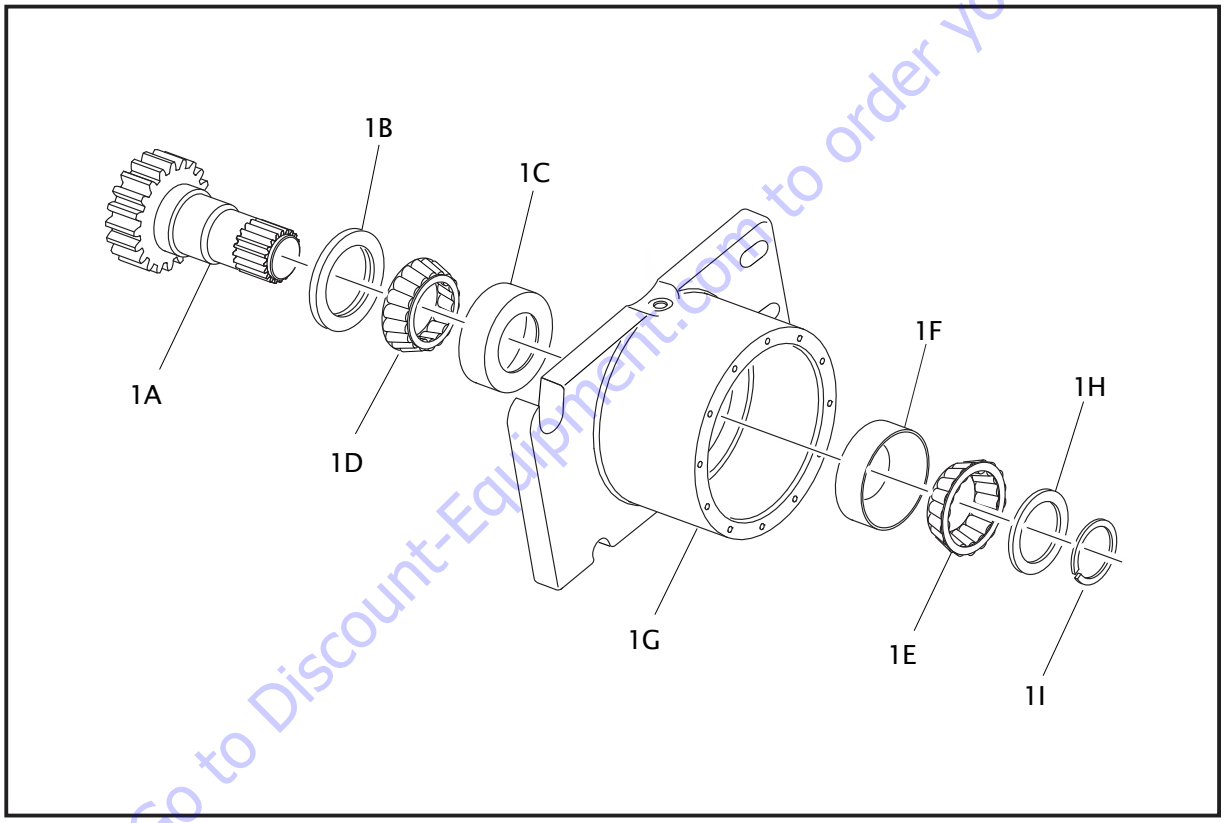
EYE PROTECTION SHOULD BE WORN DURING THIS PROCEDURE.

2. Remove Thrust Washer (1H).
3. While supporting the Housing (1G) on the Output Shaft (1A) end, press the Output Shaft (1A) out of the Housing (1G).

NOTE: *The Lip Seal (1B) will be pressed out of the Housing (1G) by the Bearing Cone (1D) during this step.*

4. Remove the Bearing Cone (1E) from the Housing (1G).
5. Use a bearing puller to remove the Bearing Cone (1D) from the Shaft (1A).
6. Bearing Cups (1C & 1F) will remain in Housing (1G)

NOTE: *If bearing replacement is necessary, the Bearing Cups (1C & 1F) can be removed with a slide hammer puller or driven out with punch.*



1A. Output Shaft
1B. Lip Seal
1C. Bearing Cup
1D. Bearing Cone
1E. Bearing Cone
1F. Bearing Cup
1G. Housing
1H. Thrust Washer
1I. Retaining Ring

Figure 3-67. Hub-Shaft

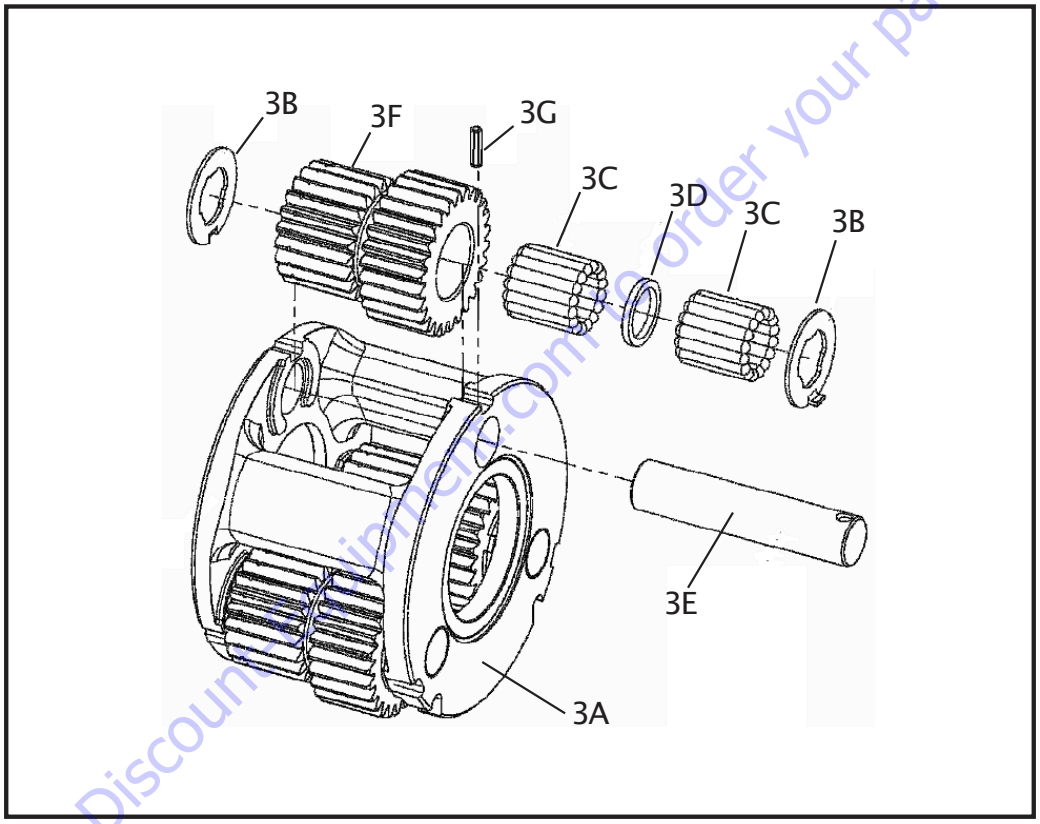
Carrier Disassembly

NOTE: *Refer to Figure 3-68., Carrier.*

1. Using a 3/16" punch drive the Roll Pin (3G) which holds the Planet Shaft (3E) in the Carrier (3A) down into the Planet Shaft (3E) until it bottoms.

NOTE: *Make sure that the Roll Pin has bottomed. Otherwise, damage to the carrier could occur when the Planet Shaft is removed.*

2. Remove the Planet Shaft (3E) from the Carrier (3A). Use a small punch to remove the Roll Pin (3D) from the Planet Shaft (3E).
3. Slide the Planet Gear (3F), the two Thrust Washers (3B) out of the Carrier (3A).
4. Remove both rows of Needle Bearings (3C) and the Spacer (3D) from the bore of the Planet Gear (3F).
5. Repeat Steps 1 through 4 for the remaining two Cluster Gears (3F).



3A. Carrier
3B. Thrust Washers
3C. Needle Bearing
3D. Spacer
3E. Planet Shaft
3F. Cluster Gear
3G. Roll Pin

Figure 3-68. Carrier

Hub-Shaft Assembly

NOTE: *Refer to Figure 3-67., Hub-Shaft.*

1. Press Bearing Cup (1C) into Housing (1G) taking care to ensure cup starts square with the bore of Hub (1G).
2. Place Bearing Cone (1D) in Bearing Cup (1C) in Housing (1G).
3. Press or tap Seal (1B) Into the counterbore of Housing (1G) to the point where it becomes flush with the Housing (1G) face. Care should be taken to insure Seal (1B) is being correctly installed (smooth face up). Apply grease to the rubber portion of the seal bore.
4. Invert Hub (1G) and press Bearing Cup (1E) into counterbore of Housing (1G).
5. Carefully lower Housing (1G) onto the Output Shaft (1A) until Bearing Cone (1D) contacts the Output Shaft (1A).
6. Press on the small end of the Bearing Cone (1D), being careful not to contact the bearing cage, until the Bearing Cone (1D) seats on the shoulder of the Output Shaft (1A).
7. Start the Bearing Cone (1F) onto the Output Shaft (1A).
8. Press or tap the Bearing Cone (1F) onto the Output Shaft (1A) until it is just seated in the Bearing Cup (1E). while rotating the Housing (G).
9. Install Bearing Spacer (1H) onto Output Shaft (1A) and against Bearing Cone (1F).
10. Install Retaining Ring (1I) into the groove in the Output Shaft (1A). This Retaining Ring (1I) should never be reused in a repair or rebuild.

⚠ WARNING

EYE PROTECTION SHOULD BE WORN DURING THIS PROCEDURE.

11. Tap the Retaining Ring (1I) with a soft metal punch to ensure that the Retaining Ring (1I) is completely seated in the groove of the Output Shaft (1A).

⚠ WARNING

EYE PROTECTION SHOULD BE WORN DURING THIS PROCEDURE.

12. Install O-ring Plug (1P) and torque to 23-24 ft. lbs. (31-32 Nm).

Carrier Assembly

NOTE: *Refer to Figure 3-68. Carrier.*

1. Apply a liberal Coat of grease to the bore of Cluster Gear (3F). This will enable the Needle Rollers (3C) to be held in place during assembly.
2. Install the first row of Needle Rollers (3C) into the bore of Cluster Gear (3F).
3. Insert Spacer (3D) into bore of Cluster Gear (3F) on top of the Needle Rollers (3C).
4. Place second row of Needle Rollers (3C) into bore of Cluster Gear (3F) against Spacer (3D).
5. Place Carrier (3A) so that one of the roll pin holes is straight up.
6. Start Planet Shaft (3E) through the hole in Carrier (3A). Using ample grease to hold it in position, slide one Thrust Washer (3B) over the Planet Shaft (3E) with the tang resting in the cast slot of the Carrier (3A).
7. With large end of Cluster Gear (3F) facing the roll pin hole in the Carrier, place the Cluster Gear into position in carrier (3A) and push Planet Shaft (3E) through the Cluster Gear (3F) without going all the way through.
8. Slide the second Thrust Washer (3B) between the Cluster Gear (3F) and the Carrier (3A) with the tang of the washer located in the cast slot of the Carrier (3A). Finish sliding the Planet Shaft (3E) through the Thrust Washer (3B) and into the Carrier (3A).
9. Position the non-chamfered side on the Planet Shaft (3E) roll pin hole so that it is in line with the hole in the Carrier (3A) using a 1/8" (3 mm) diameter punch.
10. After using a 3/16" (5 mm) punch to align the two roll pin holes. Drive the Roll Pin (3G) through Carrier (3A) and into the Planet Shaft (3E) until the Roll Pin (3G) is flush with the bottom of the cast slot in the Carrier (3A) outside diameter at the thrust washer (3B) tang. Use a 1/4" (6 mm) pin punch to make sure the Roll Pin (3G) is flush in the slot.
11. Repeat Steps 1 through 10 for the remaining two Cluster Gears(3F).

Main Drive Assembly

NOTE: *Refer to Figure 3-66., Main Drive Assembly.*

1. With the Hub Shaft Sub-Assembly resting on the Shaft (1A) install Internal Gear (2). The spline of the Internal Gear (2) bore will mesh with the spline of the Output Shaft (1A). This will be a tight fit.
2. Inspect the location of the Internal Gear (2) on the Output Shaft (1A). The portion of the Output Shaft (1A) should protrude through the Internal Gear (2) bore.
3. Install 4 Dowel Pins (13) into counterbore holes in Hub (IG).
4. Install Thrust Washer (11) in counterbore of Carrier Sub-Assembly (Small Cluster-Gear end) Use grease to hold in place.
5. Place O-ring (5) into Hub counter-bore. Use grease to hold o-ring in place.

⚠ WARNING

BEWARE OF SHARP EDGES OF THE COUNTERBORE WHILE SEATING THIS ORING.

6. Place Carrier Sub-Assembly on bench with the large end of Cluster Gears (3F) facing up with one at the 12 o'clock position. Find the punch marked tooth on each gear at the large end and locate at 12 o'clock (straight up) from each planet pin. Marked tooth will be located just under the Carrier on upper two gears. Check the timing through the slots in the carrier (See Carrier Sub-Assembly).
7. With large shoulder side of Ring Gear (4) facing down, place Ring Gear (4) over (into mesh with) cluster gears (3F). Be sure that cluster gear timing marks (punch marks) remain in correct location during Ring Gear (4) installation. The side of the Ring Gear (4) with an "X" or punch mark stamped on it should be up.
8. While holding Ring Gear (4) and Cluster Gears (3F) in mesh, place small end of Cluster Gears (3F) into mesh with the Internal Gear (2). On the Ring Gear (4) locate the hole marked "X", or punch marked, over one of the marked counter-bored holes (Step 5) in Hub (1G). Check timing through the slots in the carrier. Rotate carrier in assembly to check for freedom of rotation.

NOTE: *If gears do not mesh easily or Carrier Assembly does not rotate freely, then remove the Carrier and Ring Gear and check the Cluster Gear timing.*

9. Install Thrust Washer (11) into the counterbore on the face of the carrier. Use grease to hold in place.
10. Place O-ring (5A) into counterbore of Brake Housing (6). Use grease to hold o-ring in place.

⚠ CAUTION

BEWARE OF SHARP EDGES OF THE COUNTER-BORE WHILE SEATING THIS O-RING.

11. Install the Brake Housing (6), taking care to correctly align Pipe Plug hole (20) with those in the Hub (I G).
12. Install Bolts (12) through the Brake Housing (6) into the Hub (1G) and torque to 23-27 ft. lbs. (31-37 Nm).
13. With gearbox standing on the pinion end fill gearbox with 43 oz. of ISO VG150/VG220 gear Oil.
14. Install Retaining Ring (44) into the groove in the Sun Gear (8).
15. Install the Sun Gear (8) into mesh with the Planet Gears (3F).
16. Install Pipe Plug (20) into Cover (6) torque to 23-24 ft. lbs. (31-32 Nm).

Motor and Brake Assembly

NOTE: *Refer to Figure 3-65., Motor and Brake.*

1. Alternate Stators (8K) (O.D. lobes) with Rotors (8J) (I.D. splines) into bore of Brake Housing (6). starting with a Stator (8K) and ending with a Stator (8K).
2. Grease the o-rings (8F) & (8D) and backup rings (8H) & (8E). and place them in their respective grooves in the Brake Housing (6) and Piston (8A). Make sure the backup rings are correctly positioned.
3. Apply grease sparingly to the Piston O.D. (8A) and the bore of the Brake Housing (6). Insert Piston (8A) into Brake Housing (6) be sure not to damage the o-rings.
4. Install Springs (8L) into the spring pockets of the Piston (8A).
5. Test the brake and perform the roll test. Remove the Brake Test Plate.
6. Install the O-ring (26) onto the pilot of the Motor (31), use grease to keep the o-ring in place.
7. Place Motor (31) into Brake pilot, and line up holes.
8. Assemble Lift Lugs (28) onto Hex Bolts (29). Assemble Hex Bolts (29) with Lift Lugs (28) through the Motor (31) and Brake (6) against Motor flange. Torque to 80-100 ft. lbs. (108-136 Nm).

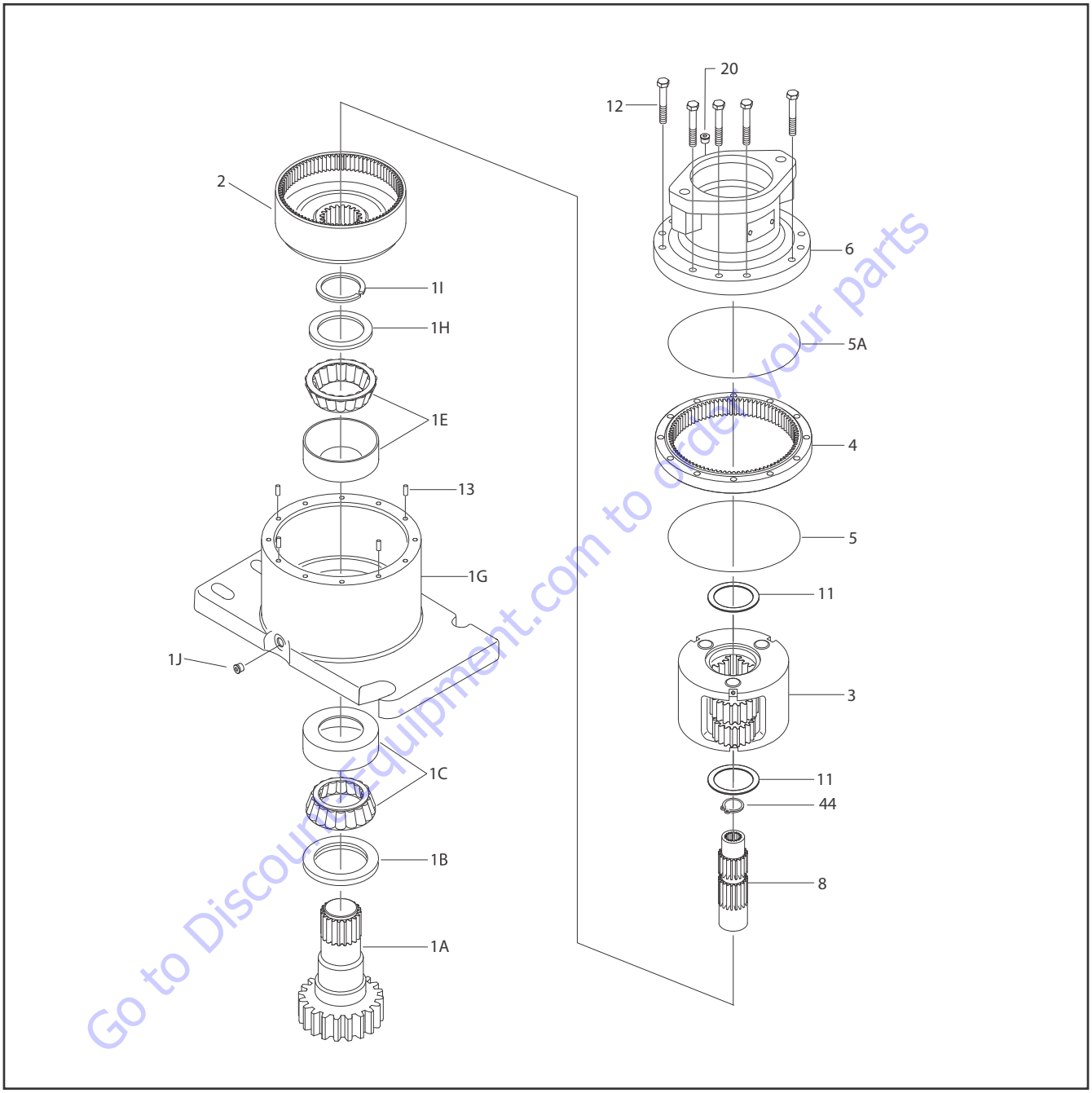
Motor Control Valve Assembly

NOTE: *Refer to Figure 3-64., Motor Control Valve.*

1. Lay assembly down with motor ports facing up. Remove the two plastic plugs in the motor ports, being careful not to lose the o-ring in each port. Assemble the Motor control Valve (32) onto the Motor (31) with Bolt (21) and Lock Washers (22). Torque Bolts (21) to 23-27 ft. lbs. (31-37 Nm).

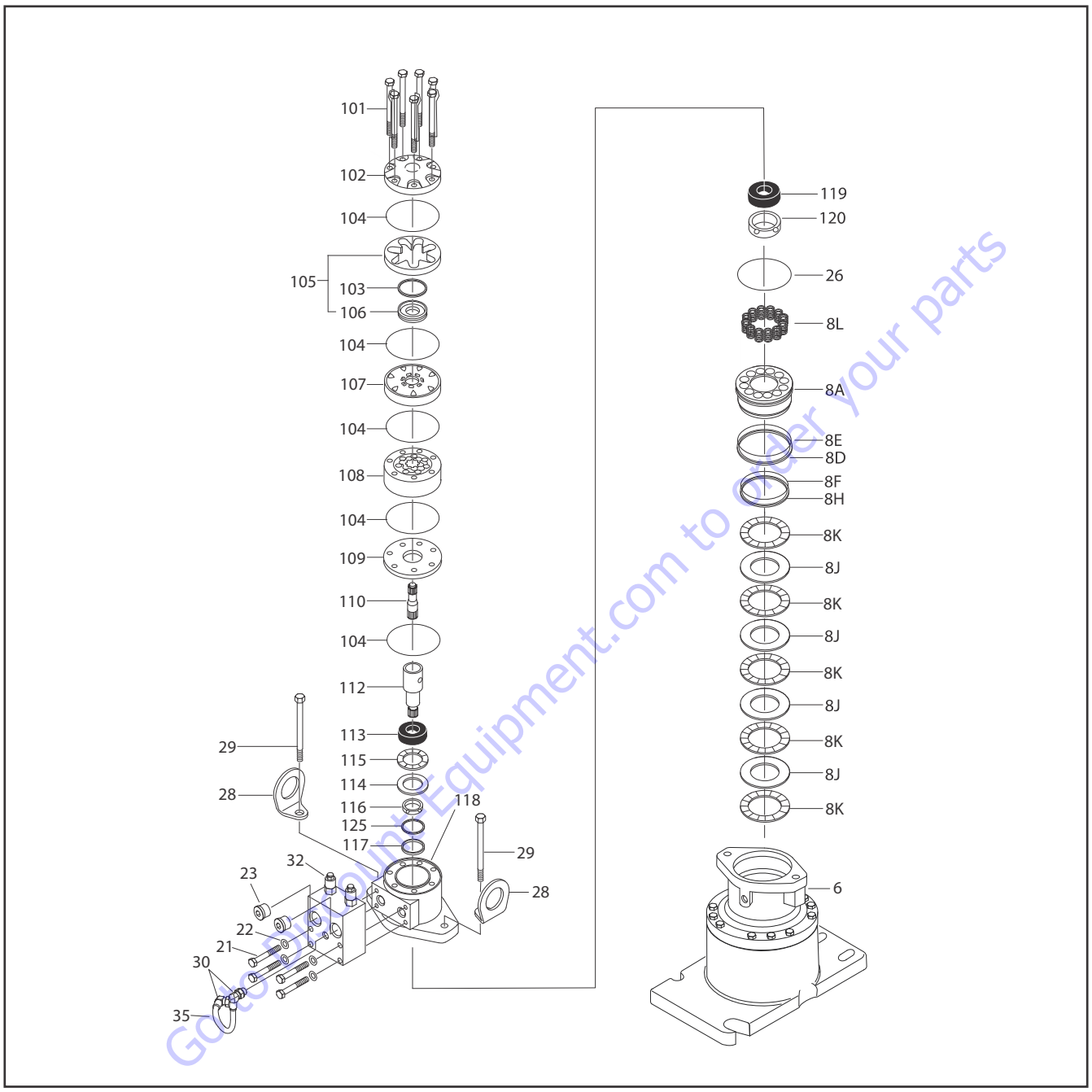
NOTE: *Be sure to align the holes in the control valve with the motor ports.*

2. Install Elbow Fittings (30) into Brake (6). Do not tighten jam nuts.
3. Install Elbow Fittings (30) into Motor Control Valve (32). Do not tighten jam nuts.
4. Assemble Tube (35) into Elbow Fittings (30) and torque to 13-15 ft. lbs (18-20 Nm). Tighten the jam nuts on the Elbow Fittings (30) and torque to 13-15 ft. lbs. (18-20 Nm).
5. Install one O-ring Plug (23) into Motor Control Valve (32) and torque to 30-31 ft. lbs. (41-42 Nm).
6. Pressure test brake, tube and control valve connections by applying 3000 psi (207 bar) pressure to the open port in the Motor Control Valve (32) and holding for 1 minute. Check for leaks at the control-valve-motor interface and the tube connections. Release pressure and install the remaining O-ring Plug (23) into Motor Control Valve (32) and torque to 30-31 ft. lbs. (41-42 Nm).



1A. Output Shaft
1B. Lip Seal
1C. Bearing
1D. Bearing
1G. Housing
1H. Thrust Washer
1I. Retaining Ring
1J. Pipe Plug
2. Internal Gear
3. Carrier Assembly
4. Ring Gear
5. O-Ring
5A. O-Ring
6. Brake Housing
8. Sun Gear
11. Thrust washer
12. Bolt
13. Dowel Pin
20. Pipe Plug
44. Internal Retaining Ring

Figure 3-69. Swing Drive Assembly



6. Brake Housing
8A. Piston
8D. O-Ring
8E. Backup Ring
8F. O-Ring
8H. Backup Ring
8J. Rotor Disc
8K. Stator Disc
8L. Spring
21. Thrust Washer
22. Lock washer
23. Pipe Plug
26. O-Ring
28. Lifting lug
29. Bolt
30. Elbow
35. Tube
101. Bolt
102. End Cover
103. Commutator Seal
104. Ring Seal
105. Commutator and Ring Assy
106. Ring
107. Manifold
108. Rotor Set
109. Wear Plate
110. Drive Link
112. Coupling Shaft
113. Inner Bearing
114. Thrust Washer
115. Thrust Bearing
116. Inner Seal
117. Backup Washer
118. Housing
119. Outer Bearing
120. Seal
125. Backup Washer

Figure 3-70. Swing Motor and Brake Assembly

3.19 SWING DRIVE BRAKE (SN 0300066417 THROUGH 0300182743, B300000100 THROUGH B300001091)

Disassembly

1. Supporting brake: remove the six socket head capscrews and washers (13 & 14) in equal increments to ensure the spring pressure within the brake is reduced gradually and evenly.

   If a press is available, the cylinder housing (8) can be restrained while removing the six capscrews and washers (13 & 14).

   The brake assembly can now be fully dismantled and the parts examined.
2. Remove cylinder housing (8) and piston (9) subassembly and dismantle if required, removing o-ring seals (15 & 17) and backing rings (16 & 18) as necessary.
3. Remove gasket (7) from housing (2).
4. Remove friction plates (3 & 6) and pressure plate (4).
5. Remove two dowel pins (19).
6. Remove springs (22 & 23).
7. Should it be necessary to replace ball bearing (10) or shaft seal (12), reverse remainder of brake subassembly, supporting on face C of housing (2).
8. Remove internal retaining ring (11).
9. Using arbor press or similar to break Loctite seal, remove brake shaft (1) from housing (2) and lay aside.
10. Reverse housing (2) and press out ball bearing (10). Shaft seal (12) can also be removed if necessary.

Inspection

1. Inspect friction plates (3 & 6) and friction surface on pressure plate (4) for wear or damage.
2. Examine friction plates (3) and brake shaft (1) for wear or damage to the splines.
3. Examine input and output splines of brake shaft (1) for wear or damage.
4. Examine compression springs (22 & 23) for damage or fatigue.
5. Check ball bearing (10) for axial float or wear.
6. Examine o-ring seals (15 & 17) and backing rings (16 & 18) for damage.

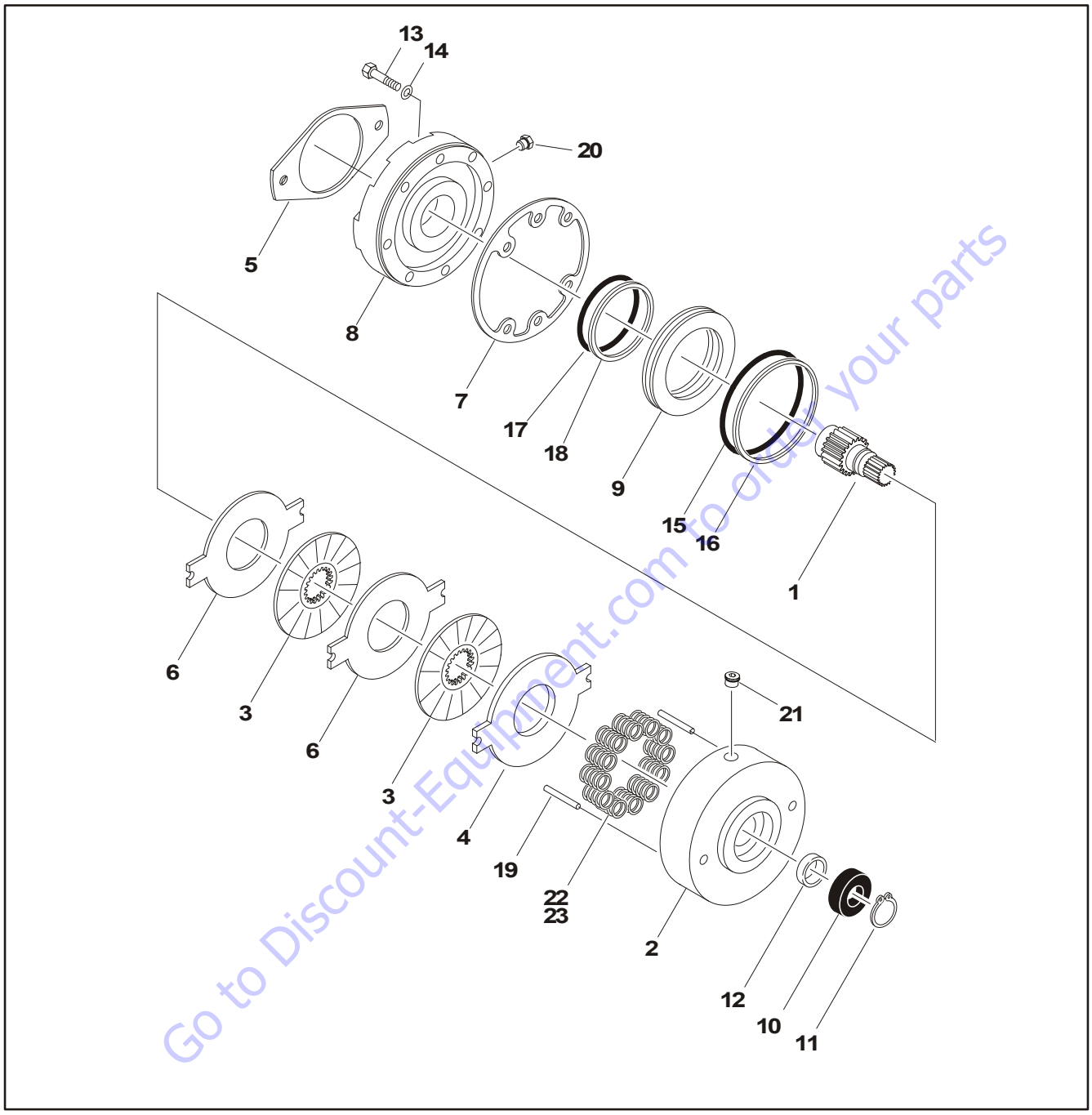
Assembly

1. Lightly lubricate rotary shaft seal (12) and assemble to housing (2) taking care not to damage seal lip.
2. Apply ring of Loctite 641 or equivalent adhesive to full circumference of housing (2) bearing recess adjacent to shoulder.

   Apply complete coverage of Loctite 641 to outside diameter of bearing (10) and assemble fully In housing (2), retaining with internal retaining ring (11). Remove excess adhesive with a clean cloth.

   Press shaft (1) through bearing (10), ensuring bearing inner ring Is adequately supported.
3. Assemble correct quantity of springs (22 & 23) in orientation required.
4. Lubricate o-ring seals (15 & 17) with Molykote 55M (or equivalent) silicon grease and assemble together with backing rings (16 & 18) to piston (9). To ensure correct brake operation. It is important that the backing rings are assembled opposite to the pressurized side of piston.
5. Correctly orientate piston (9) aligning spaces with the two dowel pin holes and, assemble into cylinder housing (8) taking care not to damage seals and carefully lay aside.
6. Locate 2-off pins (19) in housing (2) followed by pressure plate (4) and friction plates i.e. an inner (3) followed by an outer (6) in correct sequence.
7. Position gasket (7) in correct orientation.
8. Align two holes in cylinder with dowel pins (19) and assemble piston & cylinder sub-assembly to remainder of brake securing with 6 capscrews and washers (13 & 14). Torque to 55 ft.lbs. (75 Nm).

NOTE: *The use of a suitable press (hydraulic or arbor) pressing down on cylinder end face B will ease assembly of the capscrews (13).*



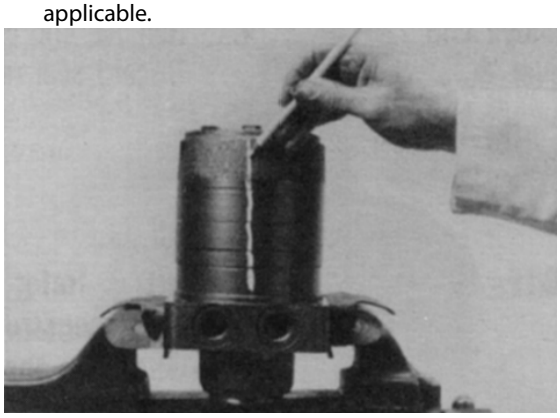
1. Shaft
2. Housing
3. Friction Plate
4. Pressure Plate
5. Gasket
6. Outer Plate
7. Gasket
8. Cylinder
9. Piston
10. Ball Bearing
11. Retaining Ring
12. Shaft Seal
13. Capscrew
14. Lockwasher
15. O-ring
16. Backup Ring
17. O-ring
18. Backup Ring
19. Dowel Pin
20. Plug
21. Plug
22. Spring (Natural)
23. Spring (Blue)

Figure 3-71. Drive Brake (SN 0300066417 through 0300134351)

3.20 SWING MOTOR (SN 0300066417 THROUGH 0300134351)

Disassembly and inspection

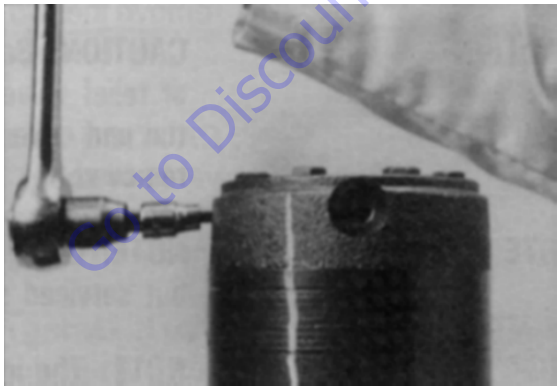
1. Place the Torqlink™ in a soft jawed vice, with coupling shaft (12) pointed down and the vise jaws clamping firmly on the sides of the housing (18) mounting flange or port bosses. Remove manifold port o-rings (18A) if applicable.

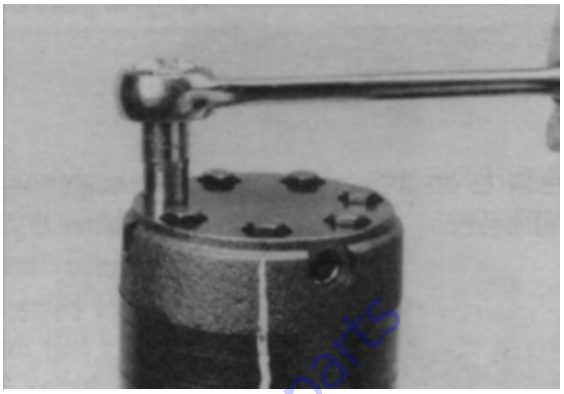


⚠ CAUTION

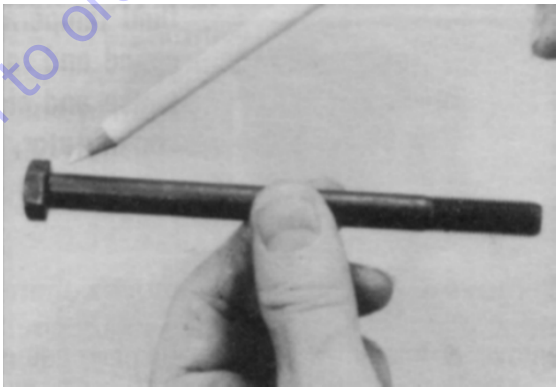
IFTHETORQLINK™ IS NOT FIRMLY HELD IN THE VISE, IT COULD BE DISLODGED DURINGTHE SERVICE PROCEDURES, CAUSING INJURY.

2. Scribe an alignment mark down and across the Torqlink™ components from end cover (2) to housing (18) to facilitate reassembly orientation where required. Loosen two shuttle or relief valve plugs (21) for disassembly later if included in end cover. 3/16 or 3/8 in. (4.76 or 9.52 mm) Allen wrench or 1 in. hex socket required.

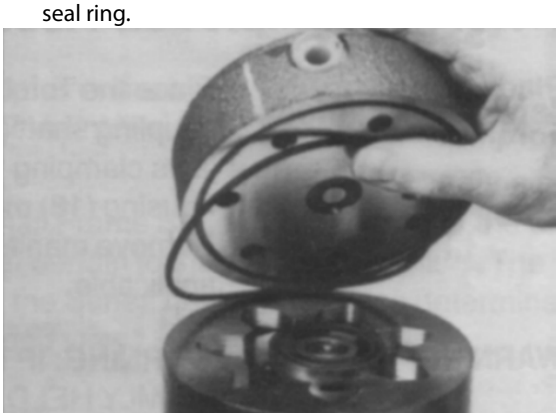




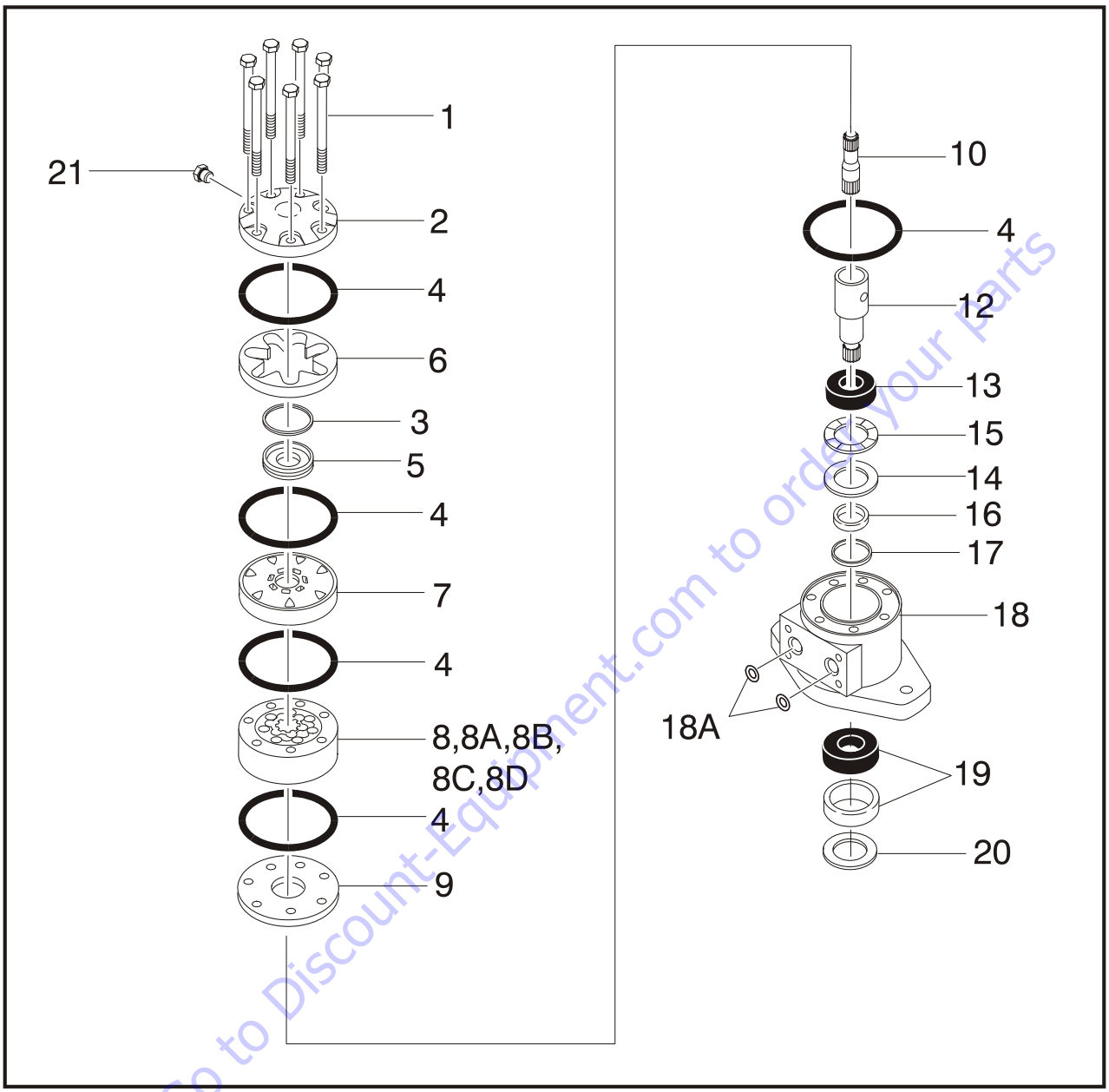
3. Remove the five, six, or seven special ring head bolts (1) using an appropriate 1/2 or 9/16 in. (12.7 or 14.28 mm) size socket. Inspect bolts for damaged threads, or sealing rings, under the bolt head. Replace damaged bolts.



4. Remove end cover assembly (2) and seal ring (4). Discard seal ring.



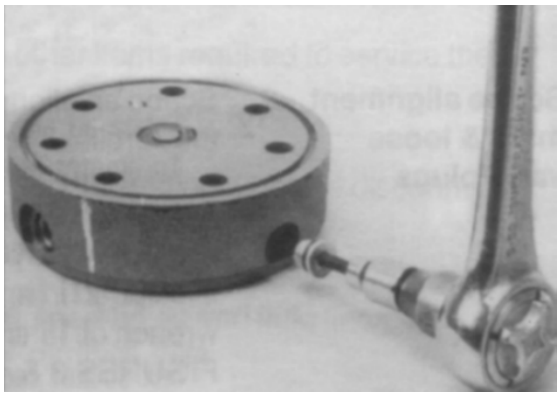
NOTE: *Refer to the appropriate "alternate cover construction" on the exploded view to determine the end cover construction being serviced.*



1. Special Bolts
2. End Cover
3. Seal Ring-Commutator
4. Seal Ring
5. Commutator Ring
6. Commutator Ring
7. Manifold
8. Rotor Set
8A. Rotor
8B. Stator or Stator Vane
8C. Vane
8D. Stator Half
9. Wear Plate
10. Drive Link
12. Coupling Shaft
13. Bearing/Bushing, Inner
14. Thrust Washer
15. Thrust Bearing
16. Seal
17. Backup Washer
18. Housing
18A. O-Ring
19. Bearing/Bushing, Outer
20. Dirt & Water Seal
21. Plug

Figure 3-72. Swing Drive Motor (SN 0300066417 through 0300134351)

5. If the end cover (2) is equipped with shuttle valve components, remove the two previously loosened plugs (21).

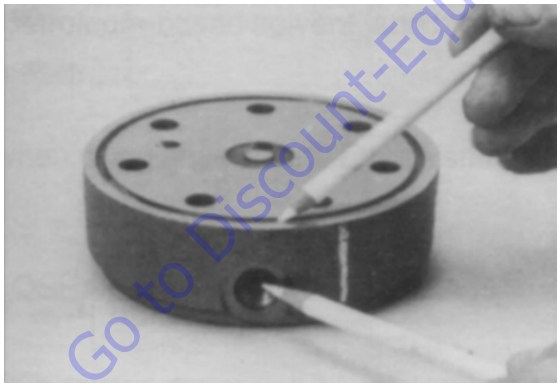


NOTICE

BE READY TO CATCH THE SHUTTLE VALVE OR RELIEF VALVE COMPONENTS THAT WILL FALL OUT OF THE END COVER VALVE CAVITY WHEN THE PLUGS ARE REMOVED.

NOTE: *The insert and if included the orifice plug in the end cover (2) must not be removed as they are serviced as an integral part of the end cover.*

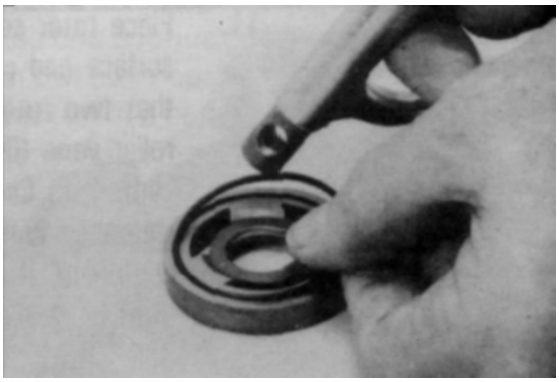
6. Thoroughly wash end cover (2) in proper solvent and blow dry. Be sure the end cover valve apertures, including the internal orifice plug, are free of contamination. Inspect end cover for cracks and the bolt head recesses for good bolt head sealing surfaces. Replace end cover as necessary.



NOTE: *A polished pattern (not scratches) on the cover from rotation of the commutator (5) is normal. Discoloration would indicate excess fluid temperature, thermal shock, or excess speed and require system investigation for cause and close inspection of end cover, commutator, manifold, and rotor set.*

7. Remove commutator ring (6). Inspect commutator ring for cracks, or burrs.

8. Remove commutator (5) and seal ring (3) Remove seal ring from commutator, using an air hose to blow air into ring groove until seal ring is lifted out and discard seal ring. Inspect commutator for cracks or burrs, wear, scoring, spalling or brinelling. If any of these conditions exist, replace commutator and commutator ring as a matched set.

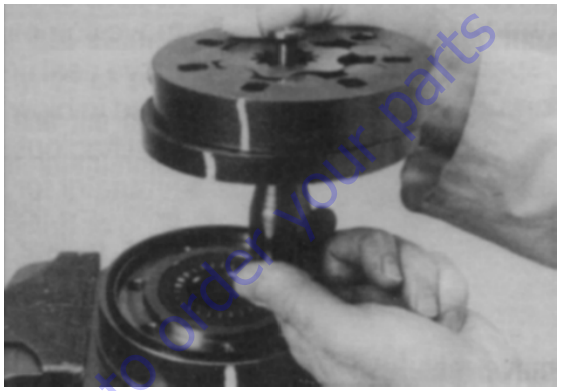


9. Remove manifold (7) and inspect for cracks surface scoring, brinelling or spalling. Replace manifold if any of these conditions exist. A polished pattern on the ground surface from commutator or rotor rotation is normal. Remove and discard the seal rings (4) that are on both sides of the manifold.

NOTE: *The manifold is constructed of plates bonded together to form an integral component not subject tofurtherdisassemblyforservice.Compare configuration of both sides oft hem an if old to ensure that same surface is reassembled against the rotor set.*

10. Remove rotor set (8) and warplane (9), together to retain the rotor set in its assembled form, maintaining the same rotor vane (8C) to stator (8B) contact surfaces. The drive link (10) may come away from the coupling shaft (12) with the rotor set, and wearplate.You may have to shift the rotor set on the warplane to work the drive link out of the rotor (8A) and warplane. Inspect the rotor set in its assembled form for nicks, scoring, or spalling on any surface and for broken or worn splines. If the rotor set component requires replacement, the complete rotor set must be replaced as it is a matched set. Inspect the warplane for cracks, brinelling, or scoring. Discard seal ring (4) that is between the rotor set and wearplate.

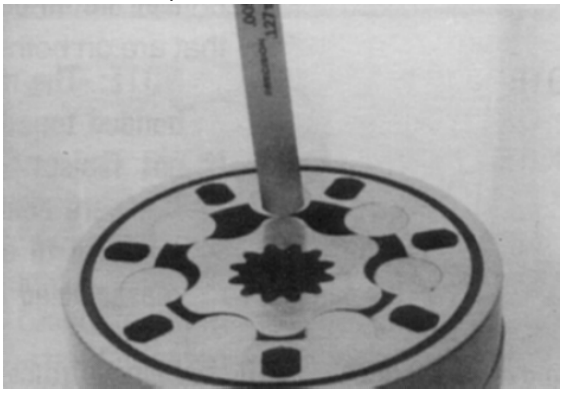
NOTE: *The rotor set (8) components may become disassembled during service procedures. Marking the surface of the rotor and stator that is facing UP, with etching ink or grease pencil before removal from Torqlink™ will ensure correct reassembly of rotor into stator and rotor set intoTorqlink™.Marking all rotor components and mating spline components for exact repositioning at assembly will ensure maximum wear life and performance of rotor set andTorqlink™.*



NOTE: *Series TG Torqlinks™ may have a rotor set with two stator halves (8B) with a seal ring (4) between them and two sets of seven vanes (8C). Discard seal ring only if stator halves become disassembled during the service procedures.*

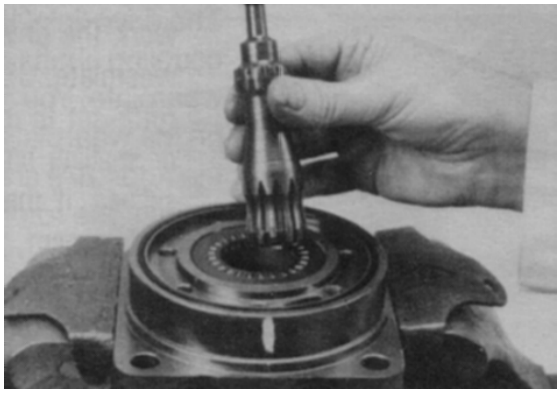
NOTE: *A polished pattern on the wear plate from rotor rotation is normal.*

11. Place rotor set (8) and wear plate (9) on a flat surface and center rotor (8A) in stator (8B) such that two rotor lobes (180 degrees apart) and a roller vane (8C) centerline are on the same stator centerline. Check the rotor lobe to roller vane clearance with a feeler gage at this common centerline. If there is more than 0.005 in. (0.13 mm) of clearance, replace rotor set.



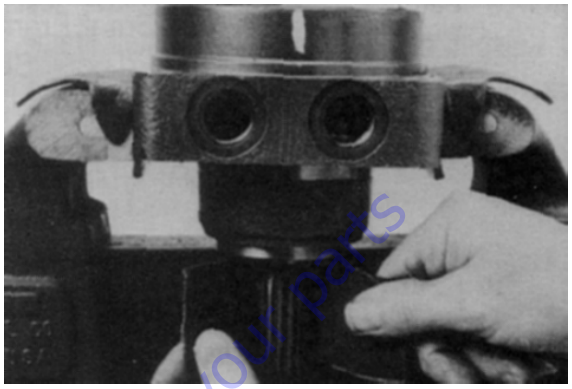
NOTE: *If rotor set (8) has two stator halves (8B & 8D) and two sets of seven vanes (8C & 8E) as shown in the alternate construction TG rotor set assembly view, check the rotor lobe to roller vane clearance at both ends of rotor.*

12. Remove drive link (10) from coupling shaft (12) if it was not removed with rotor set and wear plate. Inspect drive link for cracks and worn or damaged splines. No perceptible lash (play) should be noted between mating spline parts. Remove and discard seal ring (4) from housing (18).

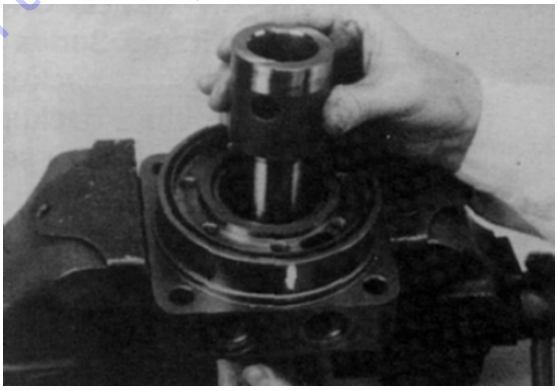


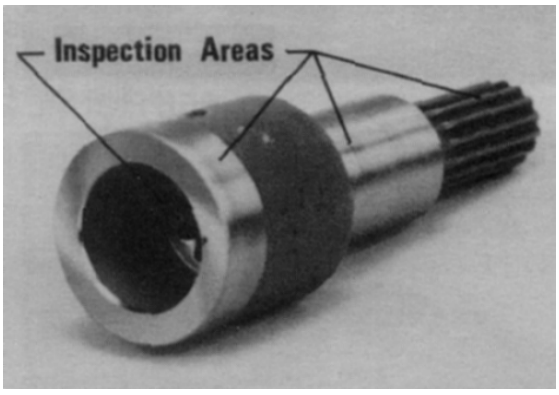
13. Remove thrust bearing (11) from top of coupling shaft (12). Inspect for wear, brinelling, corrosion and a full complement of retained rollers.

14. Check exposed portion of coupling shaft (12) to be sure you have removed all signs of rust and corrosion which might prevent its withdrawal through the seal and bearing. Crocus cloth or fine emery paper may be used.



15. Remove coupling shaft (12), by pushing on the output end of shaft. Inspect coupling shaft bearing and seal surfaces for spalling, nicks, grooves, severe wear or corrosion and discoloration. Inspect for damaged or worn internal and external splines or keyway. Replace coupling shaft if any of these conditions exist.



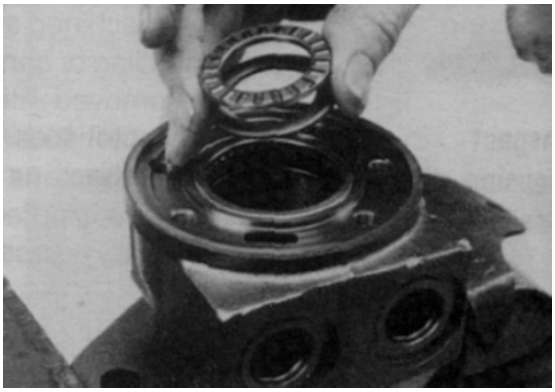


NOTE: *Minor shaft wear in seal area is permissible. If wear exceeds 0.020 in. (0.51 mm) diametrically, replace coupling shaft.*

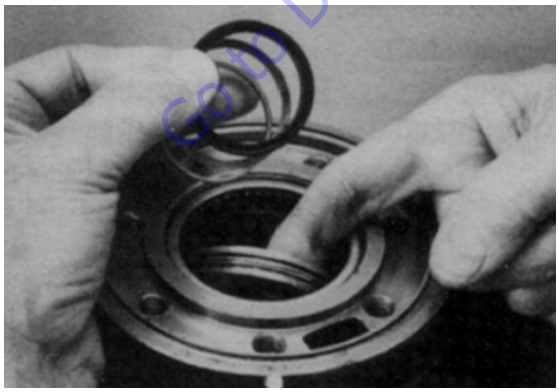
NOTE: *A slight "polish" is permissible in the shaft bearing areas. Anything more would require coupling shaft replacement.*

16. Remove and discard seal ring (4) from housing (18).

17. Remove thrust bearing (15) and thrust washer (14) Inspect for wear, brinelling, corrosion and a full complement of retained rollers.

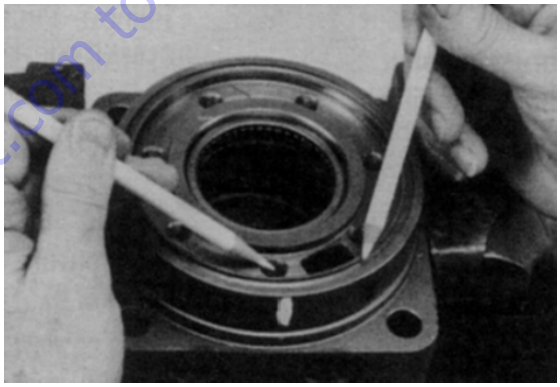


18. Remove seal (16) and backup washer (17) from Small Frame, housing (18). Discard both.

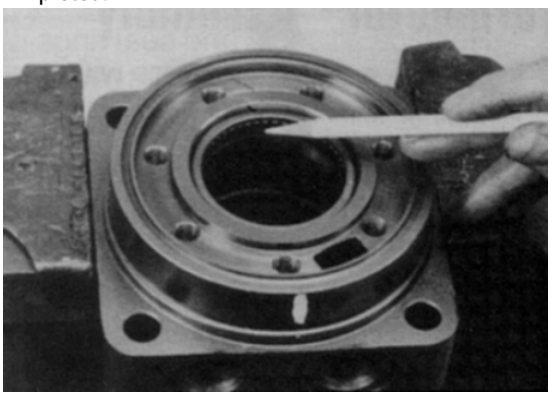


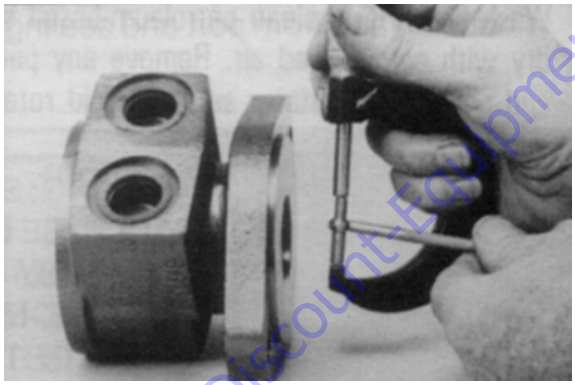
19. Remove housing (18) from vise, invert it and remove and discard seal (20). A blind hole bearing or seal puller is required.

20. Inspect housing (18) assembly for cracks, the machined surfaces for nicks, burrs, brinelling or corrosion. Remove burrs that can be removed without changing dimensional characteristics. Inspect tapped holes for thread damage. If the housing is defective in these areas, discard the housing assembly.

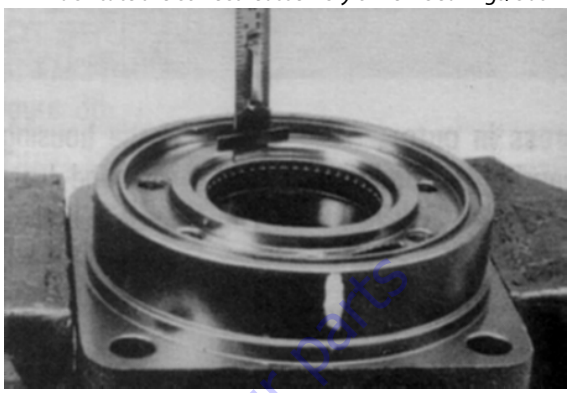


21. If the housing (18) assembly has passed inspection to this point, inspect the housing bearings/bushings (19) and (13) and if they are captured in the housing cavity the two thrust washers (14) and thrust bearing (15). The bearing rollers must be firmly retained in the bearing cages, but must rotate and orbit freely. All rollers and thrust washers must be free of brinelling and corrosion. The bushing (19) or (13) to coupling shaft diameter clearance must not exceed 0.010 in. (0.025 mm). A bearing, bushing, or thrust washer that does not pass inspection must be replaced. If the housing has passed this inspection the disassembly of the Torqlink™ is completed.

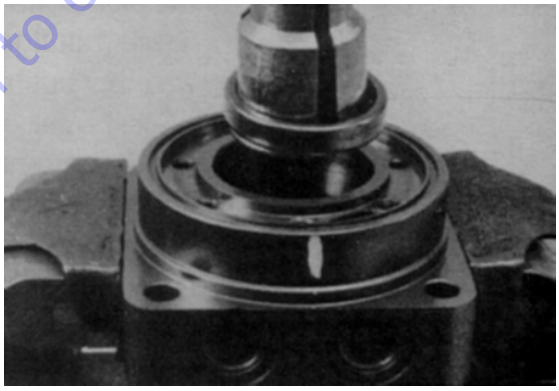


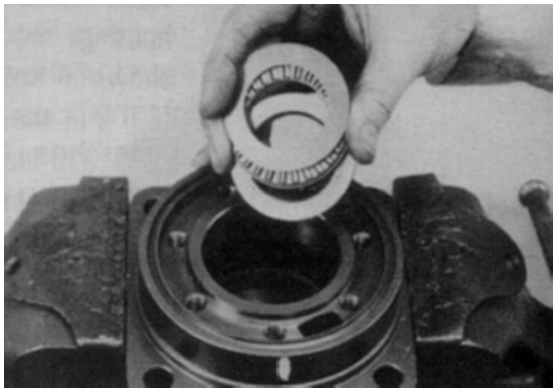


NOTE: *The depth or location of bearing/bushing (13) in relation to the housing wear plate surface and the depth or location of bearing/bushing (19) in relation to the beginning of bearing/bushing counterbore should be measured and noted before removing the bearings/ bushings. This will facilitate the correct reassembly of new bearings/bushings.*



22. If the bearings, bushing or thrust washers must be replaced use a suitable size bearing puller to remove bearing/bushings (19) and (13) from housing (18) without damaging the housing. Remove thrust washers (14) and thrust bearing (15) if they were previously retained in the housing by bearing (13).





Assembly

Replace all seals and seal rings with new ones each time you reassemble the Torqlink™ unit. Lubricate all seals and seal rings with SAE 10W40 oil or clean grease before assembly.

NOTE: *Individual seals and seal rings as well as a complete seal kit are available. The parts should be available through most OEM parts distributors or Parker approved Torqlink™ distributors. (Contact your local dealer for availability).*

NOTE: *Unless otherwise indicated, do not oil or grease parts before assembly.*

Wash all parts in clean petroleum-based solvents before assembly. Blow them dry with compressed air. Remove any paint chips from mating surfaces of the end cover, commutator set, manifold rotor set, wear plate and housing and from port and sealing areas.

⚠ WARNING

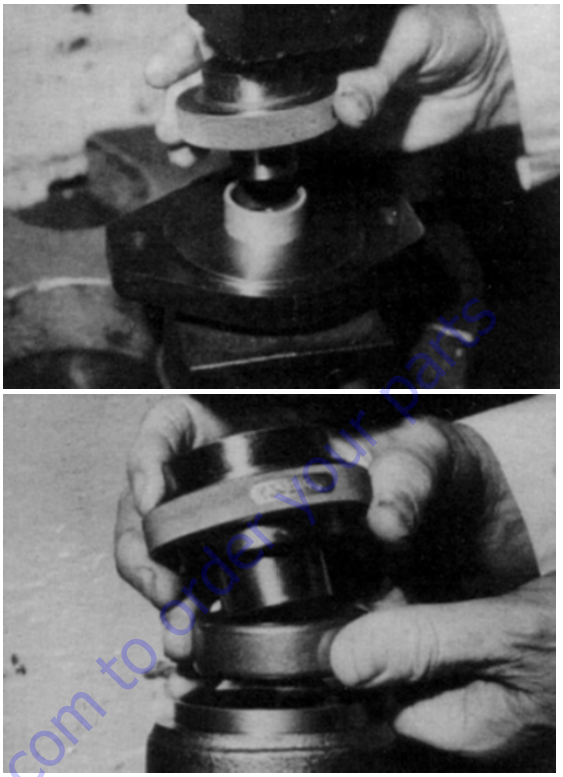
SINCE THEY ARE FLAMMABLE, BE EXTREMELY CAREFUL WHEN USING ANY SOLVENT. EVEN A SMALL EXPLOSION OR FIRE COULD CAUSE INJURY OR DEATH.

⚠ CAUTION

WEAR EYE PROTECTION AND BE SURE TO COMPLY WITH OSHA OR OTHER MAXIMUM AIR PRESSURE REQUIREMENTS.

1. If the housing (18) bearing components were removed for replacement, thoroughly coat and pack a **new** outer bearing/bushing (19) with clean corrosion resistant grease recommended in the material section. Press the new bearing/bushing into the counterbore at the mounting flange end of the housing, using the appropriate sized bearing mandrel, which will control the bearing/ bushing depth.

   Torqlink™ housings require the use of bearing mandrel to press bearing/ bushing (19) into the housing to a required depth of 0.151/0.161 in. (3.84/4.09 mm) from the end of the bearing counterbore.



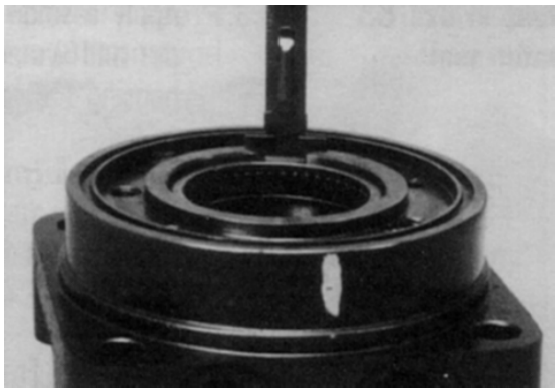
NOTE: *Bearing mandrel must be pressed against the lettered end of bearing shell. Take care that the housing bore is square with the press base and the bearing/bushing is not cocked when pressing a bearing/bushing into the housing.*

NOTICE

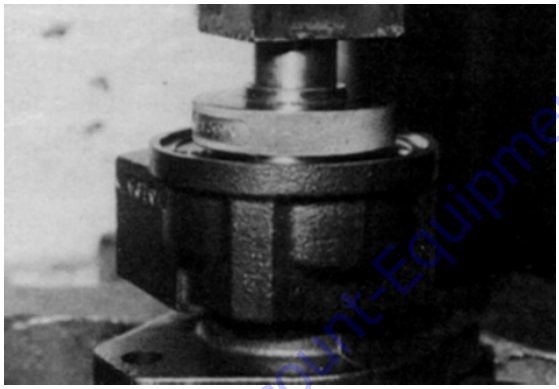
IF THE BEARING MANDREL SPECIFIED IN THE "TOOLS AND MATERIALS REQUIRED FOR SERVICING" SECTION IS NOT AVAILABLE AND ALTERNATE METHODS ARE USED TO PRESS IN BEARING/BUSHING (13) AND (19) THE BEARING/BUSHING DEPTHS SPECIFIED MUST BE ACHIEVED TO INSURE ADEQUATE BEARING SUPPORT AND CORRECT RELATIONSHIP TO ADJACENT COMPONENTS WHEN ASSEMBLED.

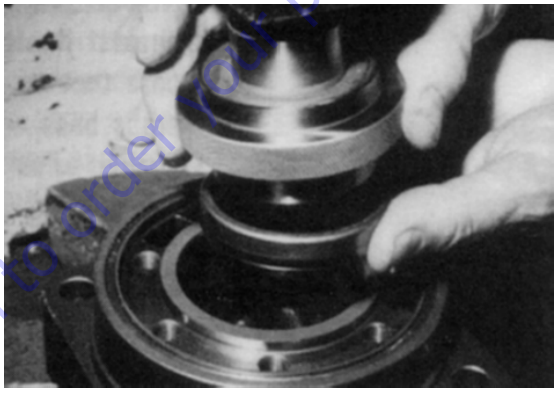
NOTICE

BECAUSE THE BEARING/BUSHINGS (13) AND (19) HAVE A PRESS FIT INTO THE HOUSING THEY MUST BE DISCARDED WHEN REMOVED. THEY MUST NOT BE REUSED.



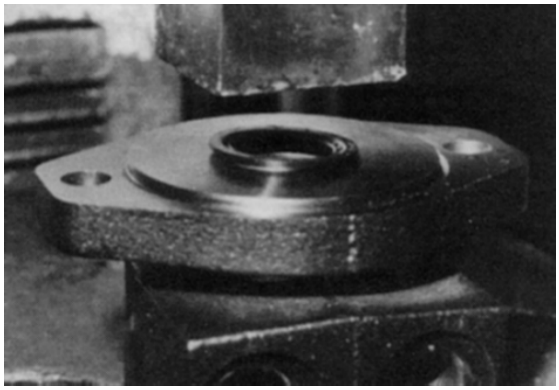
2. The Torqlink™ inner housing bearing/bushing (13) can now be pressed into its counterbore in housing (18) flush to 0.03 in. (.76 mm) below the housing wear plate contact face. Use the opposite end of the bearing mandrel that was used to press in the outer bearing/bushing (19).

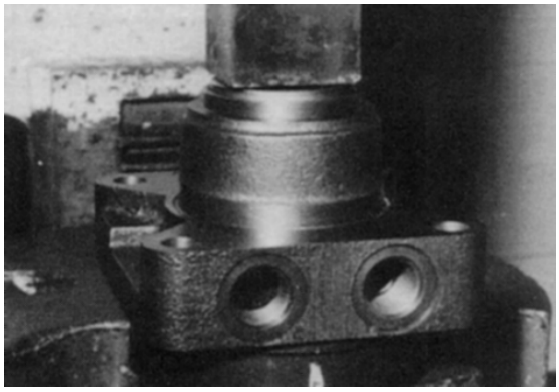




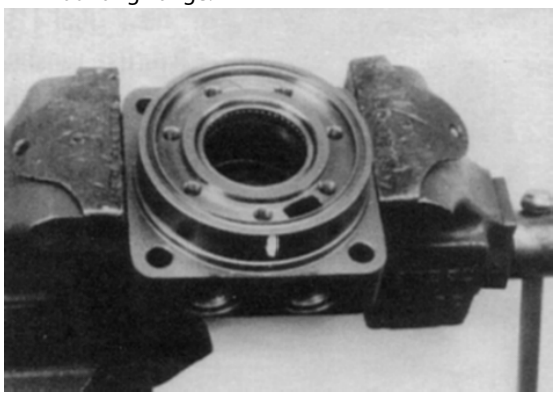
3. Press a new dirt and water seal (20) into the housing (18) outer bearing counterbore.

   The Torqlink™ dirt and water seal (20) must be pressed in until its' flange is flush against the housing.

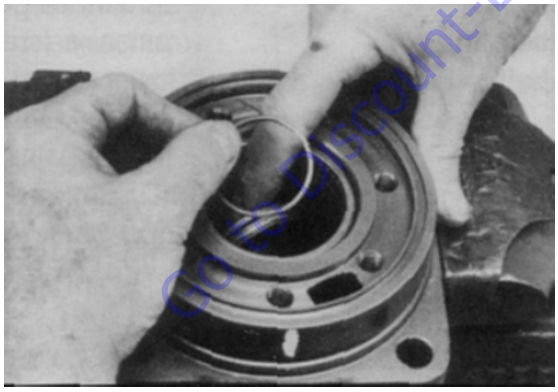




4. Place housing (18) assembly into a soft jawed vise with the coupling shaft bore down, clamping against the mounting flange.



5. On the Torqlinks™ assemble a new backup washer (17) and new seal (16) with the seal lip facing toward the inside of Torqlink™, into their respective counterbores in housing (18) if they were not assembled in procedure 2.



NOTICE

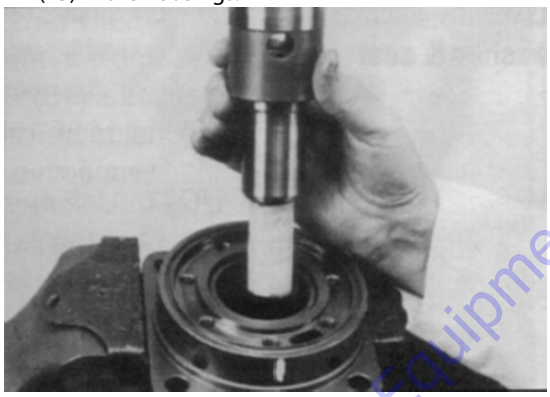
ORIGINAL DESIGN LARGE FRAME, TF & TG TORQLINKS™ THAT DO NOT HAVE BACKUP WASHER (25) WHEN DISASSEMBLED MUST BE ASSEMBLED WITH A NEW BACKUP WASHER (17), NEW BACKUP WASHER (25), AND NEW SEAL (16).

6. Assemble thrust washer (14) then thrust bearing (15) that was removed from the Torqlink™.

NOTE: *Torqlinks™ require one thrust washer (14) with thrust bearing (15).The coupling shaft will be seated directly against the thrust washer.*

7. Apply masking tape around splines or keyway on shaft (12) to prevent damage to seal.

8. Be sure that a generous amount of clean corrosion resistant grease has been applied to the lower (outer) housing bearing/bushing (19). Install the coupling shaft (12) into housing (18), seating it against the thrust bearing (15) in the housings.



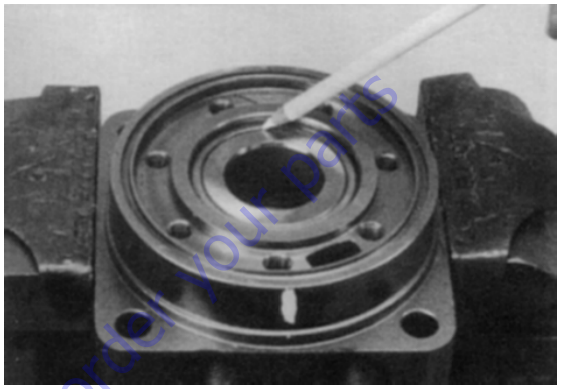
NOTICE

THE OUTER BEARING (19) IS NOT LUBRICATED BY THE SYSTEM'S HYDRAULIC FLUID. BE SURE IT IS THOROUGHLY PACKED WITH THE RECOMMENDED GREASE, PARKER GEAR GREASE SPECIFICATION #045236, E/M LUBRICANT #K-70M.

NOTE: *Mobil Mobilith SHC ® 460*

NOTE: *A 102Tube (P/N 406010) is included in each seal kit.*

NOTE: *The coupling shaft (12) will be flush or just below the housing wear plate surface on Torqlinks™ when properly seated. The coupling shaft must rotate smoothly on the thrust bearing package.*



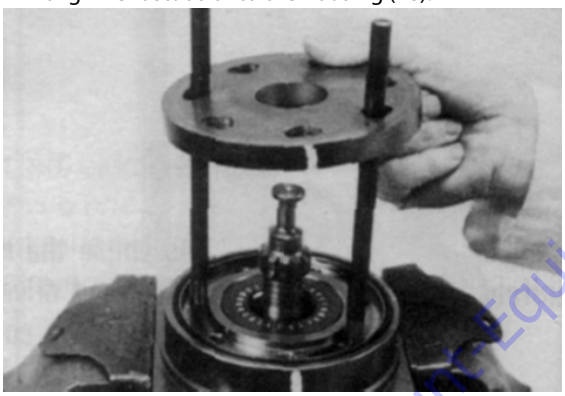
9. Apply a small amount of clean grease to a new seal ring (4) and insert it into the housing (18) seal ring groove.

NOTE: *One or two alignment studs screwed finger tight into housing (18) bolt holes, approximately 180 degrees apart, will facilitate the assembly and alignment of components as required in the following procedures.The studs can be made by cutting off the heads of either 3/8-24 UNF 2A or 5/16-24 UNF 2A bolts as required that are over 0.5 in. (12.7 mm) longer than the bolts (1) used in the Torqlink™.*

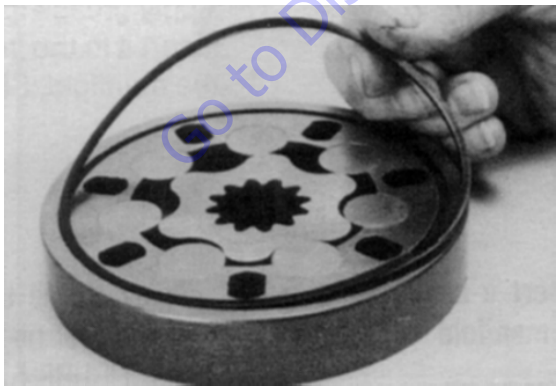
10. Install drive link (10) the long splined end down into the coupling shaft (12) and engage the drive link splines into mesh with the coupling shaft splines.

NOTE: *Use any alignment marks put on the coupling shaft and drive link before disassembly to assemble the drive link splines in their original position in the mating coupling shaft splines.*

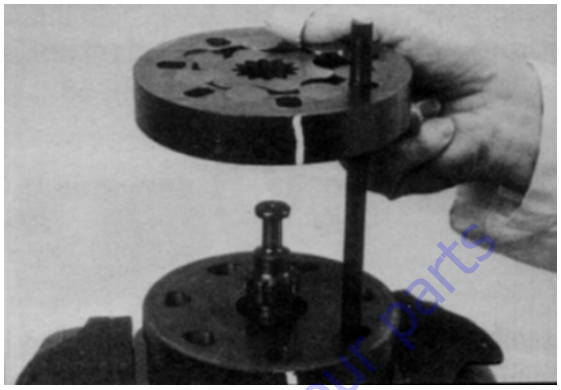
11. Assemble wear plate (9) over the drive link (10) and alignment studs onto the housing (18).



12. Apply a small amount of clean grease to a new seal ring (4) and assemble it into the seal ring groove on the wear plate side of the rotor set stator (8B).



13. Install the assembled rotor set (8) onto wear plate (9) with rotor (8A) counterbore and seal ring side down and the splines into mesh with the drive link splines.

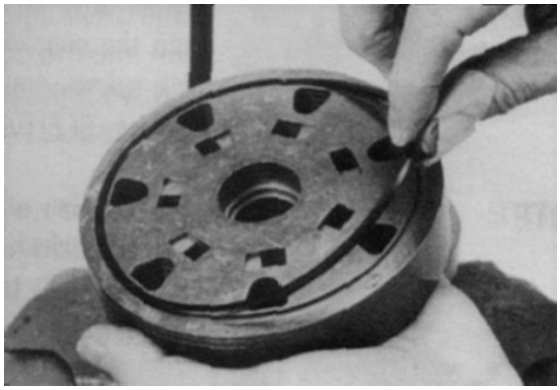


NOTE: *It may be necessary to turn one alignment stud out of the housing (18) temporarily to assemble rotor set (8) or manifold (7) over the drive link.*

NOTE: *If necessary, go to the appropriate, "Rotor Set Component Assembly Procedure."*

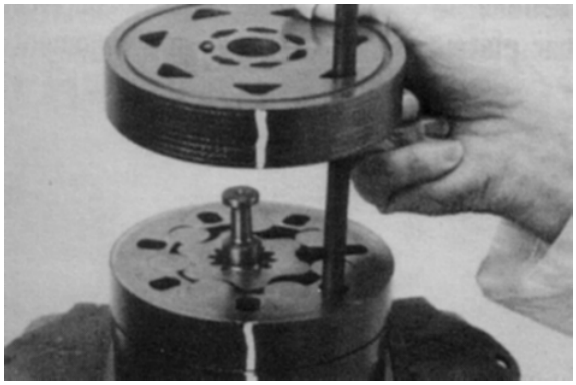
NOTE: *The rotor set rotor counterbore side must be down against wear plate for drive link clearance and to maintain the original rotor-drive link spline contact. A rotor set without a counterbore and that was not etched before disassembly can be reinstalled using the drive link spline pattern on the rotor splines if apparent, to determine which side was down.The rotor set seal ring groove faces toward the wear plate (9).*

14. Apply clean grease to a new seal ring (4) and assemble it in the seal ring groove in the rotor set contact side of manifold (7).

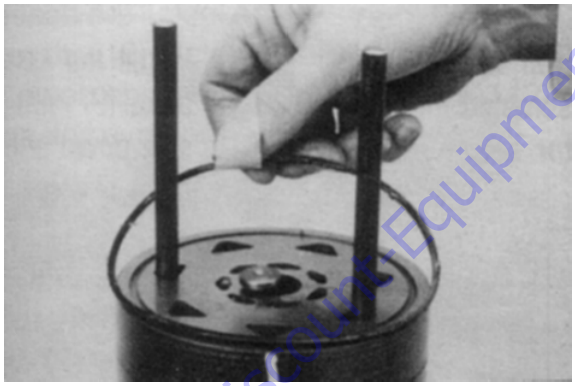


NOTE: *The manifold (7) is made up of several plates bonded together permanently to form an integral component.The manifold surface that must contact the rotor set has it's series of irregular shaped cavities on the largest circumference or circle around the inside diameter.The polished impression left on the manifold by the rotor set is another indication of which surface must contact the rotor set.*

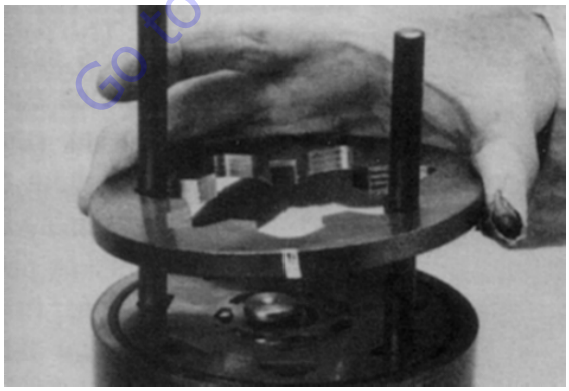
15. Assemble the manifold (7) over the alignment studs and drive link (10) and onto the rotor set. Be sure the correct manifold surface is against the rotor set.



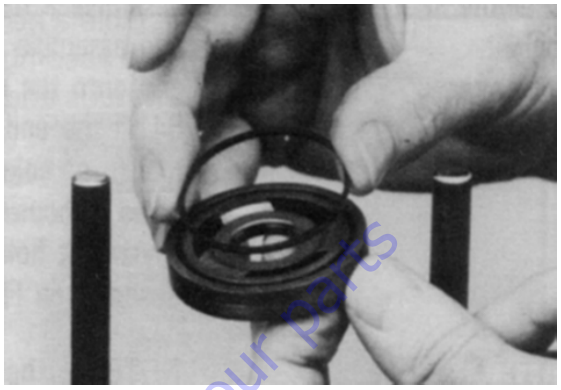
16. Apply grease to a new seal ring (4) and insert it in the seal ring groove exposed on the manifold.

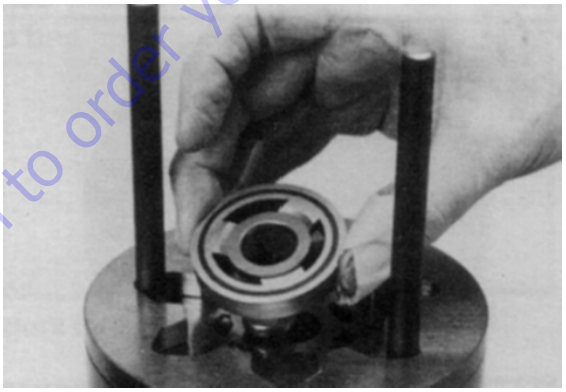


17. Assemble the commutator ring (6) over alignment studs onto the manifold.



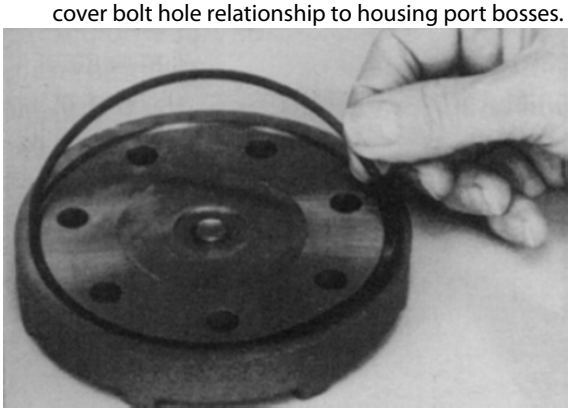
18. Assemble a new seal ring (3) flat side up, into commutator (5) and assemble commutator over the end of drive link (10) onto manifold (7) with seal ring side up.

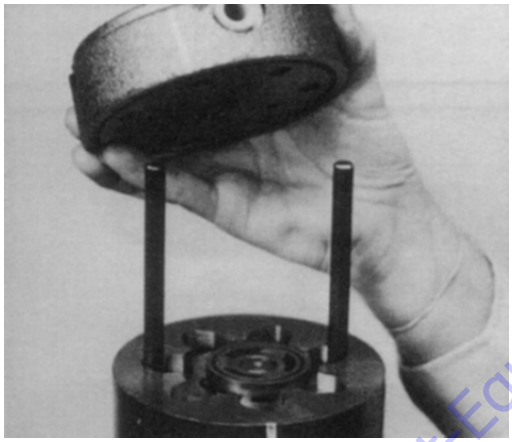


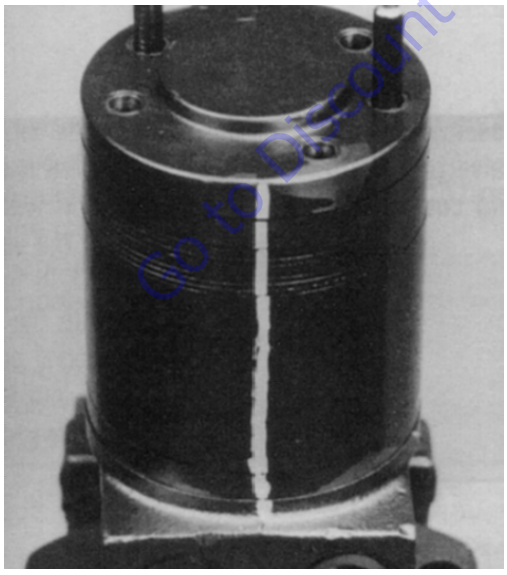


19. If shuttle valve components items #21, were removed from the end cover (2) turn a plug (21), loosely into one end of the valve cavity in the end cover. A 3/16 in. Allen wrench is required.

20. Assemble a new seal ring (4) into end cover (2) and assemble end cover over the alignment studs and onto the commutator set. If the end cover has only 5 bolt holes be sure the cover holes are aligned with the 5 threaded holes in housing (18). The correct 5 bolt end cover bolt hole relationship to housing port bosses.

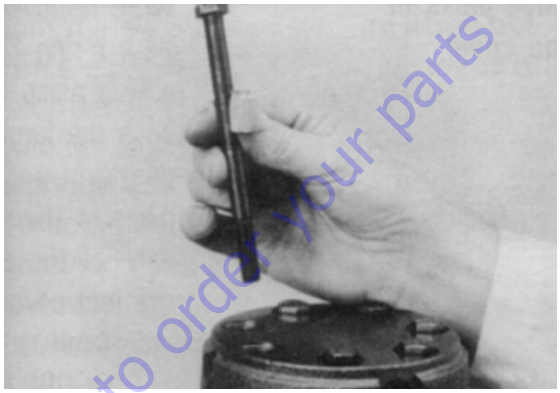


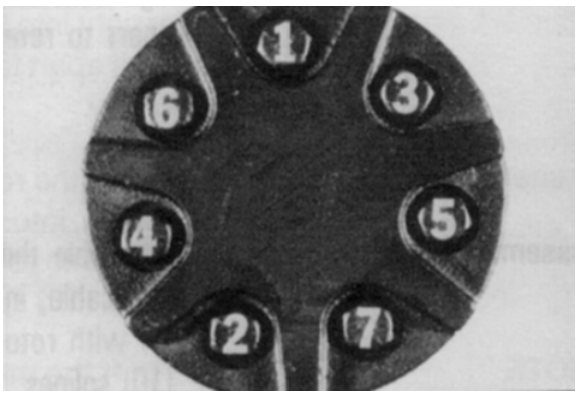




NOTE: *If the end cover has a valve (24) or has five bolt holes, use the line you previously scribed on the cover to radially align the end cover into its original position.*

21. Assemble the 5 or 7 special bolts (1) and screw in finger tight. Remove and replace the two alignment studs with bolts after the other bolts are in place. Alternately and progressively tighten the bolts to pull the end cover and other components into place with a final torque of 45-55 ft. lbs. (61-75 Nm) for the seven 3/8-24 threaded bolts.

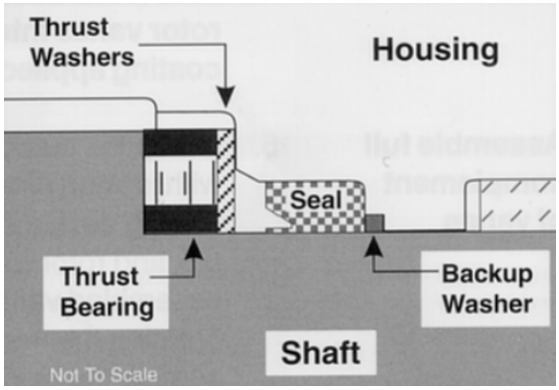




NOTE: *The special bolts required for use with the relief or shuttle valve (24) end cover assembly (2) are longer than the bolts required with standard and cover assembly. Refer to the individual service parts lists or parts list charts for correct service part number if replacement is required.*

22. Torque the two shuttle valve plug assemblies (21) in end cover assembly to 9-12 ft. lbs. (12-16 Nm) if cover is so equipped.

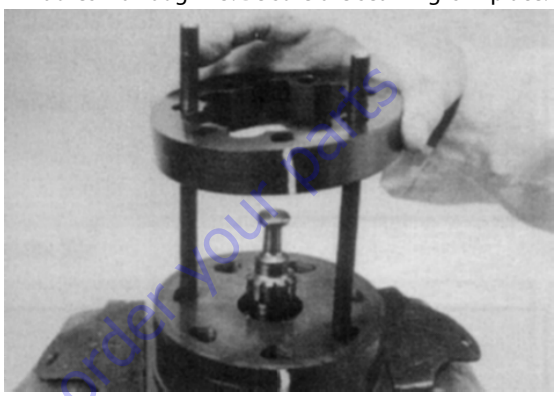
Torque the two relief valve plug assemblies (21) in end cover assembly to 45-55 ft. lbs. (61-75 Nm) if cover is so equipped.



One Piece Stator Construction

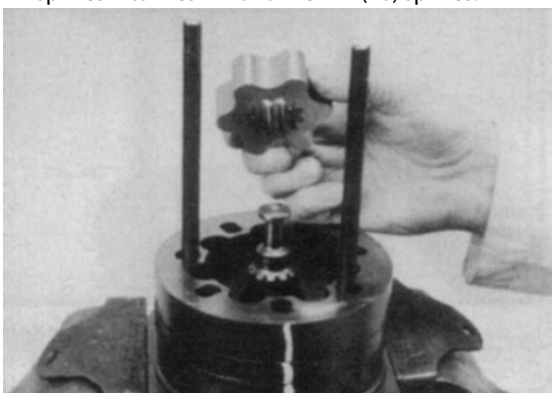
A disassembled rotor (8A) stator (8B) and vanes (8C) that cannot be readily assembled by hand can be assembled by the following procedures.

1. Place stator (8B) onto wear plate (9) with seal ring (4) side down, after following Torqlink™ assembly procedures 1 through 13. Be sure the seal ring is in place.



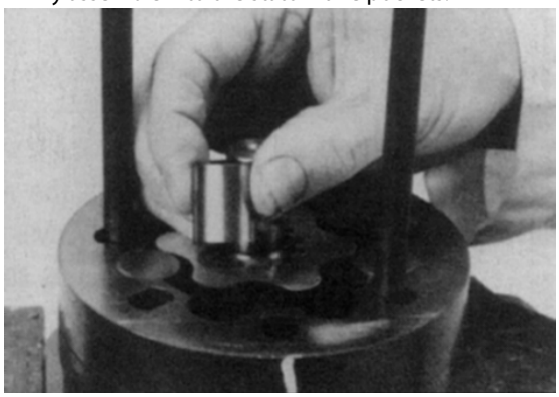
2. If assembly alignment studs are not being utilized, align stator bolt holes with wear plate and housing bolt holes and turn two bolts (1) finger tight into bolt holes approximately 180 degrees apart to retain stator and wear plate stationary.

3. Assemble the rotor (8A), counterbore down if applicable, into stator (8B), and onto wear plate (9) with rotor splines into mesh with drive link (10) splines.



NOTE: *If the manifold side of the rotor was etched during Torqlink disassembly, this side should be up. If the rotor is not etched and does not have a counterbore, use the drive link spline contact pattern apparent on the rotor splines to determine the rotor side that must be against the wear plate.*

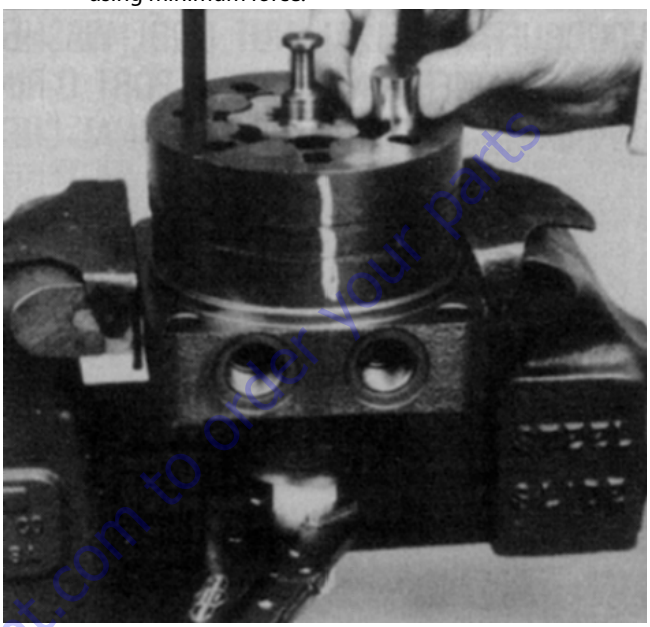
4. Assemble six vanes (8C), or as many vanes that will readily assemble into the stator vane pockets.



NOTICE

EXCESSIVE FORCE USED TO PUSH THE ROTOR VANES INTO PLACE COULD SHEAR OFF THE COATING APPLIED TO THE STATOR VANE POCKETS.

5. Grasp the output end of coupling shaft (12) with locking pliers or other appropriate turning device and rotate coupling shaft, drive link and rotor to seat the rotor and the assembled vanes (8C) into stator (8B), creating the necessary clearance to assemble the seventh or full complement of seven vanes. Assemble the seven vanes using minimum force.

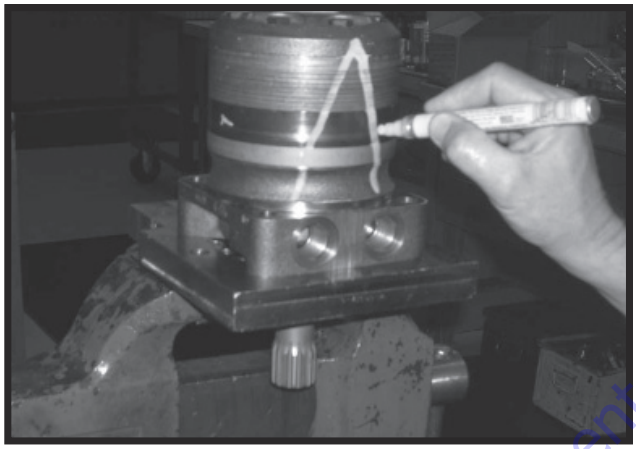


6. Remove the two assembled bolts (1) if used to retain stator and wear plate.

3.21 SWING MOTOR (SN 0300134352 THROUGH 0300182743, B300000100 THROUGH B300001091)

Disassembly

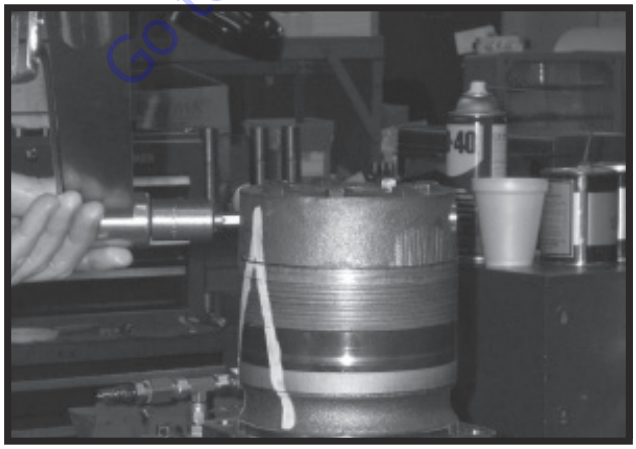
7. Place the Torqmotor™ in a soft jawed vice, with coupling shaft (12) pointed down and the vise jaws clamping firmly on the sides of the housing (18) mounting flange or port bosses. Remove manifold port o-rings (18A) if applicable.

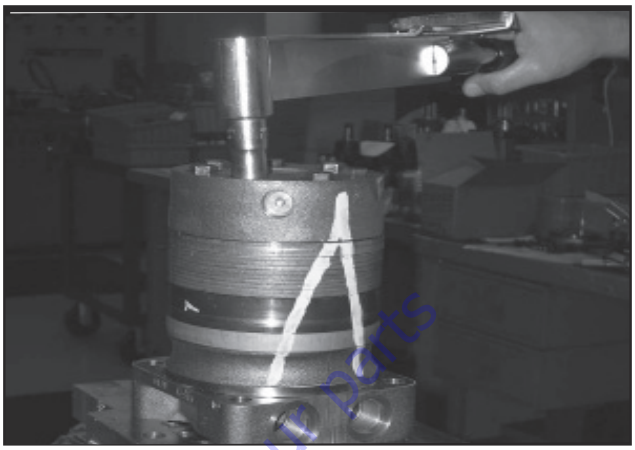


⚠ WARNING

IF THE TORQMOTOR™ IS NOT FIRMLY HELD IN THE VISE, IT COULD BE DISLODGED DURINGTHE SERVICE PROCEDURES, CAUSING INJURY.

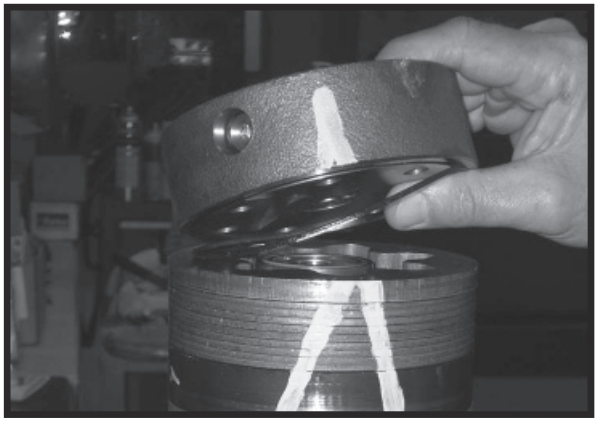
8. Scribe an alignment mark down and across the Torqmotor™ components from end cover (2) to housing (18) to facilitate reassembly orientation where required. Loosen two shuttle or relief valve plugs (21) for disassembly later if included in end cover. 3/16 or 3/8 in. Allen wrench or 1 in. hex socket required.



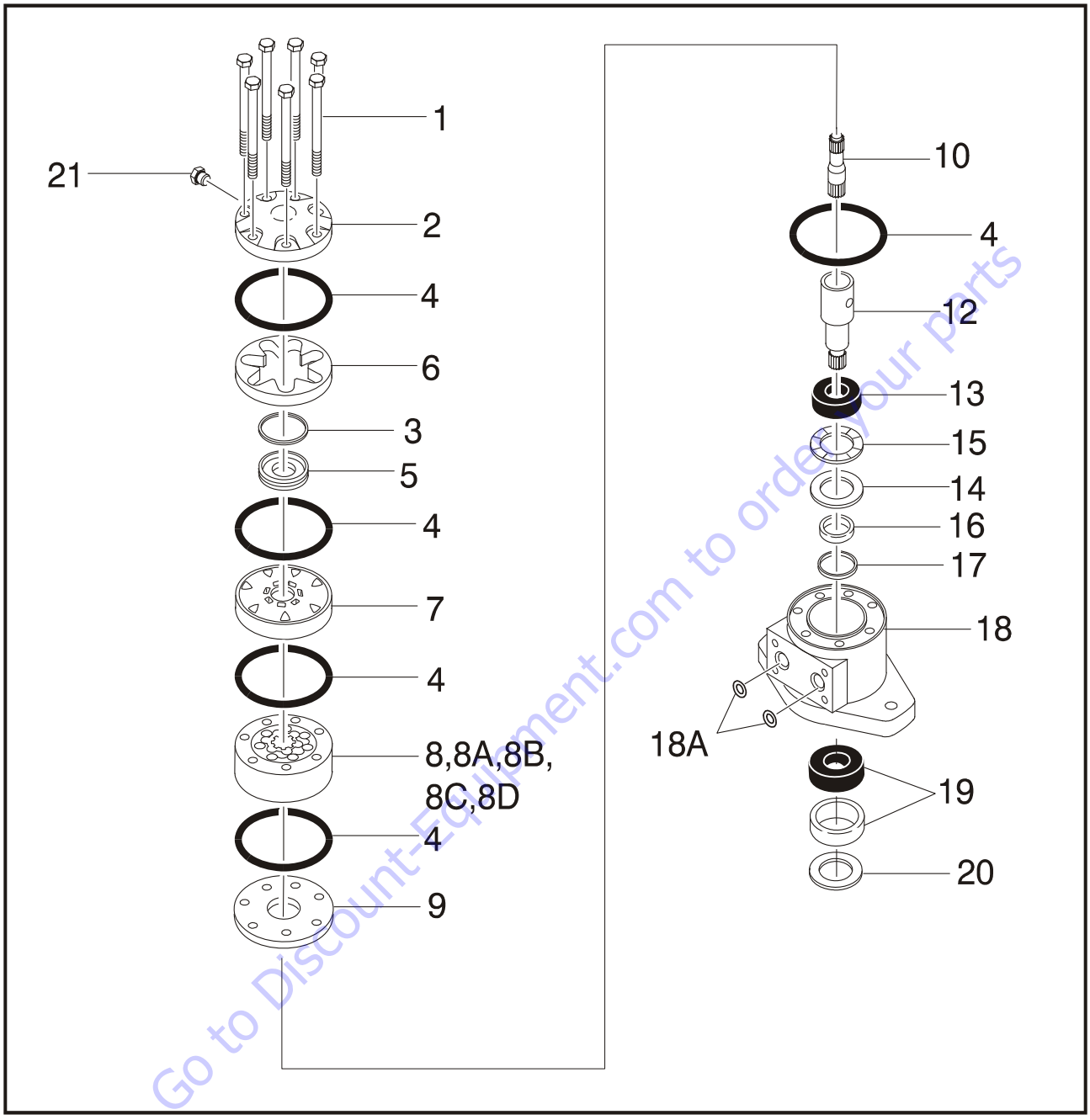


9. Remove the five, six, or seven special ring head bolts (1) using an appropriate 1/2 or 9/16 in. size socket. Inspect bolts for damaged threads, or sealing rings, under the bolt head. Replace damaged bolts.

10. Remove end cover assembly (2) and seal ring (4). Discard seal ring.



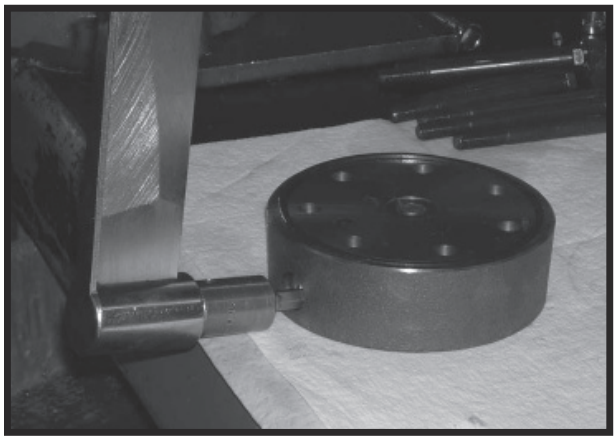
NOTE: *Refer to the appropriate "alternate cover construction" on the exploded view to determine the end cover construction being serviced.*



1. Special Bolts
2. End Cover
3. Seal Ring-Commutator
4. Seal Ring
5. Commutator Ring
6. Commutator Ring
7. Manifold
8. Rotor Set
8A. Rotor
8B. Stator or Stator Vane
8D. Stator Half
9. Wear Plate
10. Drive Link
11. Not Used
12. Coupling Shaft
13. Bearing/Bushing, Inner
14. Thrust Washer
15. Thrust Bearing
16. Seal
17. Backup Washer
18. Housing
18A. O-Ring
19. Bearing/Bushing, Outer
20. Dirt & Water Seal
21. Plug

Figure 3-73. Swing Drive Motor (SN 0300134352 through 0300182743, B300000100 through B300001091)

5. If the end cover (2) is equipped with shuttle valve components, remove the two previously loosened plugs (21).



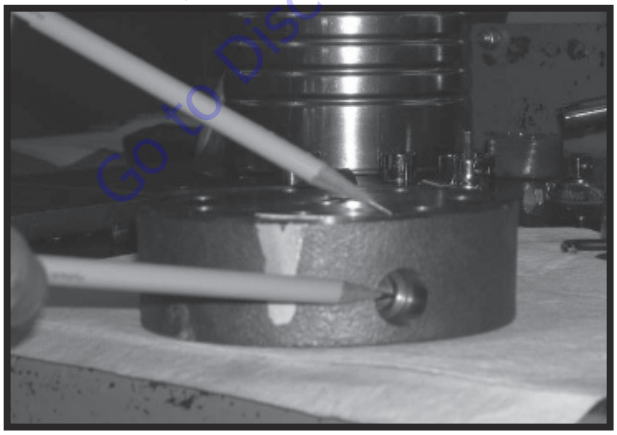
NOTICE

BE READY TO CATCH THE SHUTTLE VALVE OR RELIEF VALVE COMPONENTS THAT WILL FALL OUT OF THE END COVER VALVE CAVITY WHEN THE PLUGS ARE REMOVED.

NOTE: *O- ring is not included in seal kit but serviced separately, if required.*

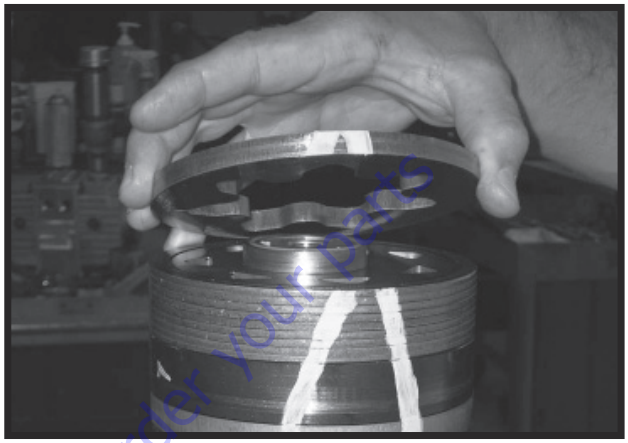
NOTE: *The insert and if included the orifice plug in the end cover (2) must not be removed as they are serviced as an integral part of the end cover.*

6. Thoroughly wash end cover (2) in proper solvent and blow dry. Be sure the end cover valve apertures, including the internal orifice plug, are free of contamination. Inspect end cover for cracks and the bolt head recesses for good bolt head sealing surfaces. Replace end cover as necessary.

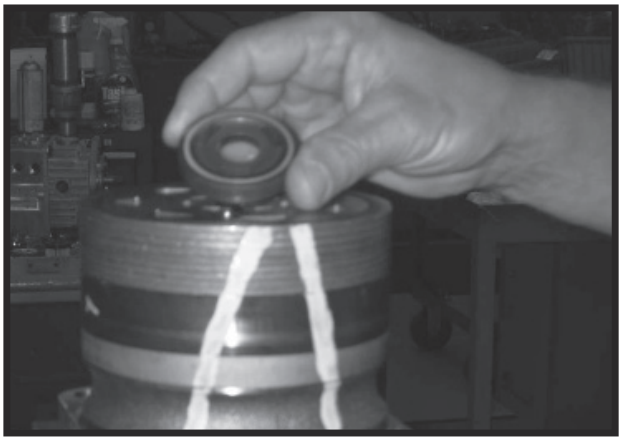


NOTE: *A polished pattern (not scratches) on the cover from rotation of the commutator (5) is normal. Discoloration would indicate excess fluid temperature, thermal shock, or excess speed and require system investigation for cause and close inspection of end cover, commutator, manifold, and rotor set.*

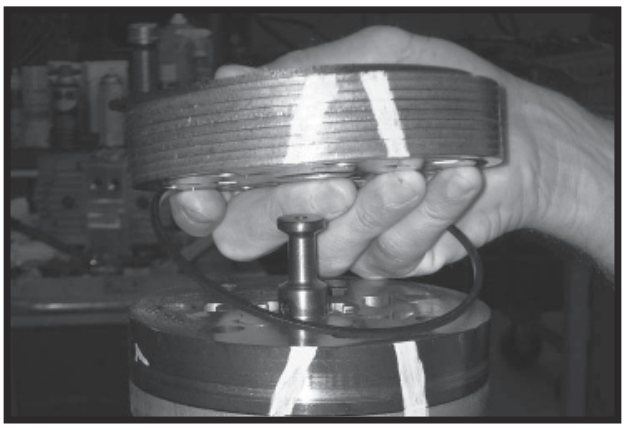
7. Remove commutator ring (6). Inspect commutator ring for cracks, or burrs.



8. Remove commutator (5) and seal ring (3) Remove seal ring from commutator, using an air hose to blow air into ring groove until seal ring is lifted out and discard seal ring. Inspect commutator for cracks or burrs, wear, scoring, spalling or brinelling. If any of these conditions exist, replace commutator and commutator ring as a matched set.

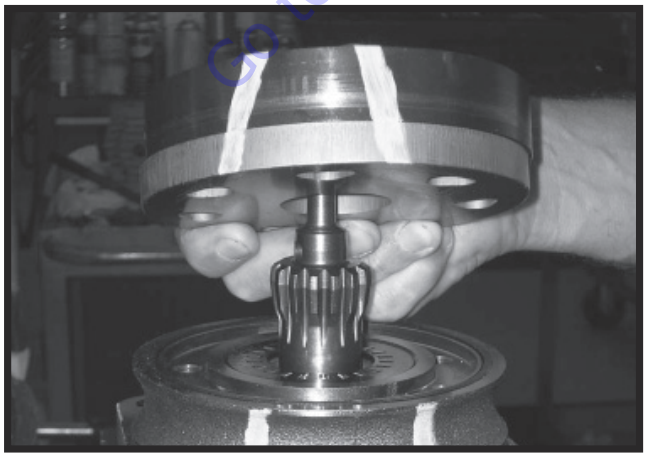


9. Remove manifold (7) and inspect for cracks surface scoring, brinelling or spalling. Replace manifold if any of these conditions exist. A polished pattern on the ground surface from commutator or rotor rotation is normal. Remove and discard the seal rings (4) that are on both sides of the manifold.



NOTE: *The manifold is constructed of plates bonded together to form an integral component not subject to further disassembly for service. Compare configuration of both sides oft hem an if old to ensure that same surface is reassembled against the rotor set.*

10. Remove rotor set (8) and wear plate (9), together to retain the rotor set in its assembled form, maintaining the same rotor vane (8C) to stator (8B) contact surfaces. The drive link (10) may come away from the coupling shaft (12) with the rotor set, and wear plate.You may have to shift the rotor set on the wear plate to work the drive link out of the rotor (8A) and wear plate. Inspect the rotor set in its assembled form for nicks, scoring, or spalling on any surface and for broken or worn splines. If the rotor set component requires replacement, the complete rotor set must be replaced as it is a matched set. Inspect the warplane for cracks, brinelling, or scoring. Discard seal ring (4) that is between the rotor set and wear plate.

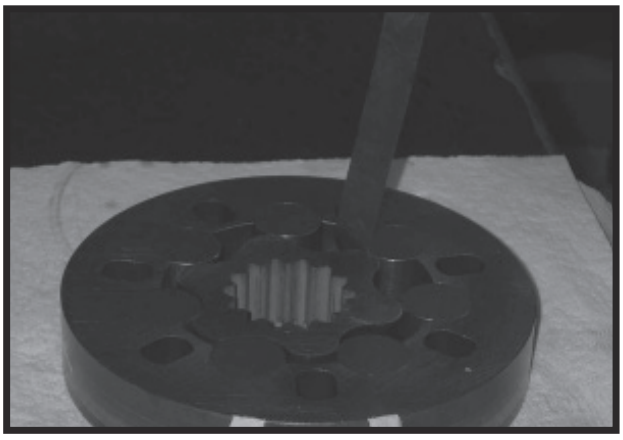


NOTE: *The rotor set (8) components may become disassembled during service procedures. Marking the surface of the rotor and stator that is facing UP, with etching ink or grease pencil before removal from Torqmotor™ will ensure correct reassembly of rotor into stator and rotor set intoTorqmotor™.Marking all rotor components and mating spline components for exact repositioning at assembly will ensure maximum wear life and performance of rotor set and Torqmotor™.*

NOTE: *Series TG and TH may have a rotor set with two stator halves (8B & 8D) with a seal ring (4) between them and two sets of seven vanes (8C & 8E). Discard seal ring only if stator halves become disassembled during the service procedures.*

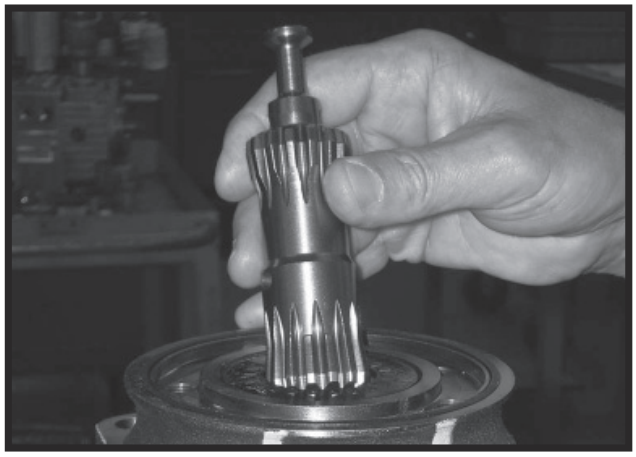
NOTE: *A polished pattern on the wear plate from rotor rotation is normal.*

11. Place rotor set (8) and wear plate (9) on a flat surface and center rotor (8A) in stator (8B) such that two rotor lobes (180 degrees apart) and a roller vane (8C) centerline are on the same stator centerline. Check the rotor lobe to roller vane clearance with a feeler gage at this common centerline. If there is more than 0.005 in. (0.13 mm) of clearance, replace rotor set.

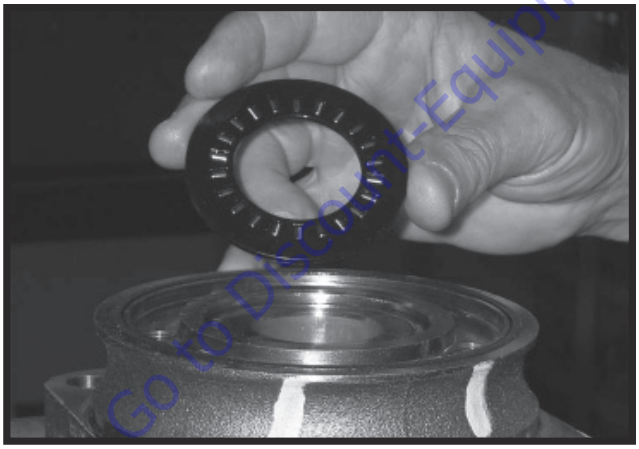


NOTE: *If rotor set (8) has two stator halves (8B & 8D) and two sets of seven vanes (8C & 8E) as shown in the alternate construction TG rotor set assembly view, check the rotor lobe to roller vane clearance at both ends of rotor.*

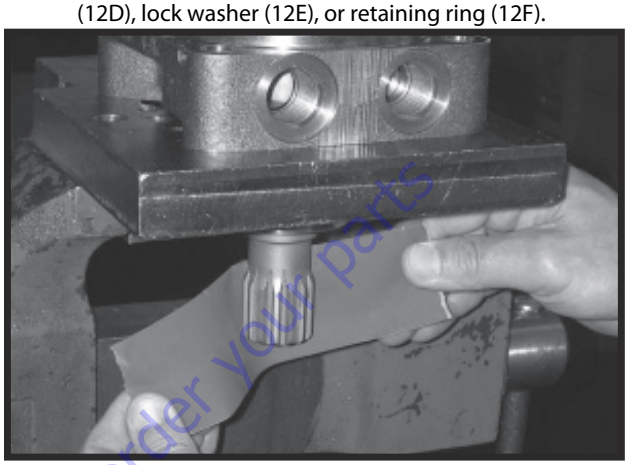
12. Remove drive link (10) from coupling shaft (12) if it was not removed with rotor set and wear plate. Inspect drive link for cracks and worn or damaged splines. No perceptible lash (play) should be noted between mating spline parts. Remove and discard seal ring (4) from housing (18).



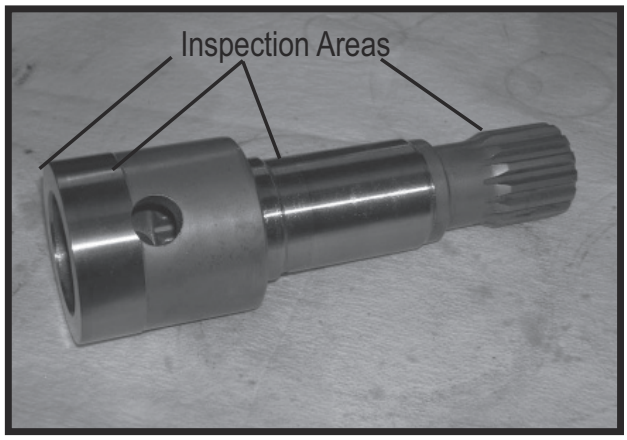
13. Remove thrust bearing (11) from top of coupling shaft (12). Inspect for wear, brinelling, corrosion and a full complement of retained rollers.



14. Check exposed portion of coupling shaft (12) to be sure you have removed all signs of rust and corrosion which might prevent its withdrawal through the seal and bearing. Crocus cloth or fine emery paper may be used. Remove any key (12A), nut (12B), washer (12C), bolt (12D), lock washer (12E), or retaining ring (12F).



15. Remove coupling shaft (12), by pushing on the output end of shaft. Inspect coupling shaft bearing and seal surfaces for spalling, nicks, grooves, severe wear or corrosion and discoloration. Inspect for damaged or worn internal and external splines or keyway. Replace coupling shaft if any of these conditions exist.



NOTE: *Minor shaft wear in seal area is permissible. If wear exceeds 0.020 in. (0.51 mm) diametrically, replace coupling shaft.*

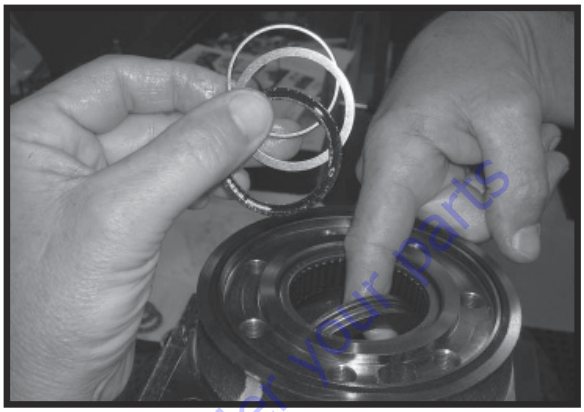
NOTE: *A slight "polish" is permissible in the shaft bearing areas. Anything more would require coupling shaft replacement.*

16. Remove and discard seal ring (4) from housing (18).

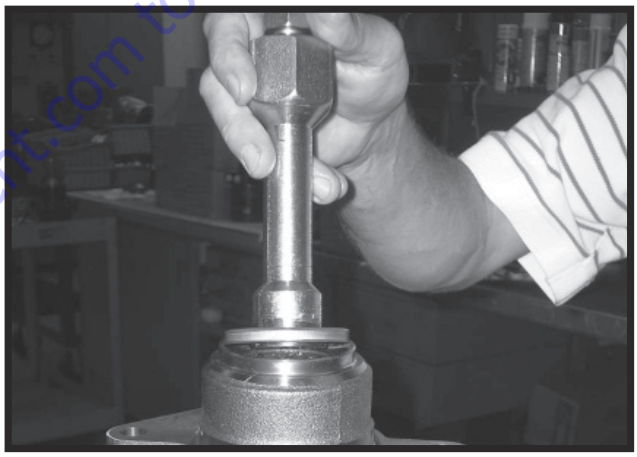
17. Remove thrust bearing (15) and thrust washer (14) Inspect for wear, brinelling, corrosion and a full complement of retained rollers.

18. Remove seal (16) and backup ring (17) from Small Frame, housing (18) and backup washer (25). Discard both.

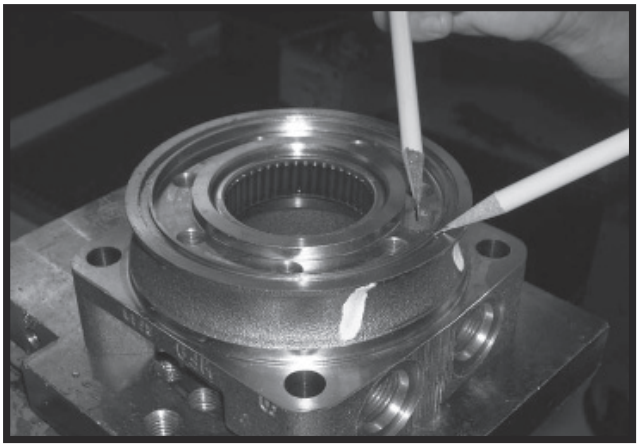
19. Remove seal (16), backup ring (17) and backup washer (25) from large frame, housing by working them around unseated thrust washers (14) and thrust bearing (15) and out of the housing. Discard seal and washers.



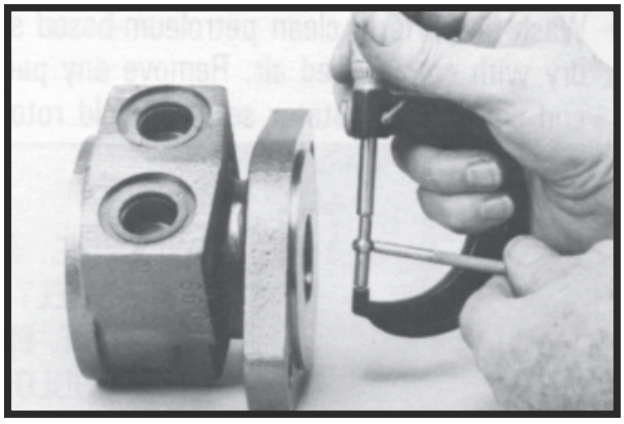
20. Remove housing (18) from vise, invert it and remove and discard seal. A blind hole bearing or seal puller is required.



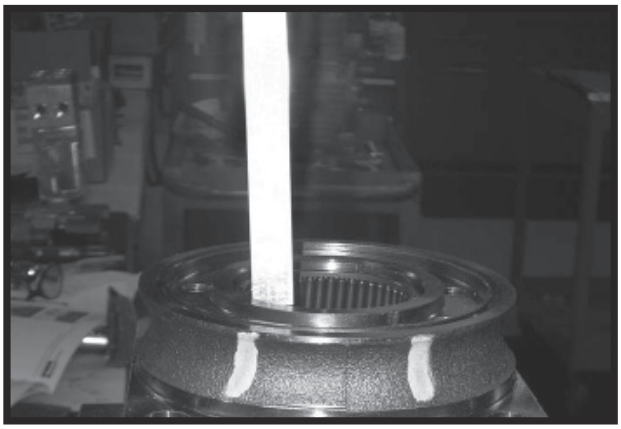
21. Inspect housing (18) assembly for cracks, the machined surfaces for nicks, burrs, brinelling or corrosion. Remove burrs that can be removed without changing dimensional characteristics. Inspect tapped holes for thread damage. If the housing is defective in these areas, discard the housing assembly.



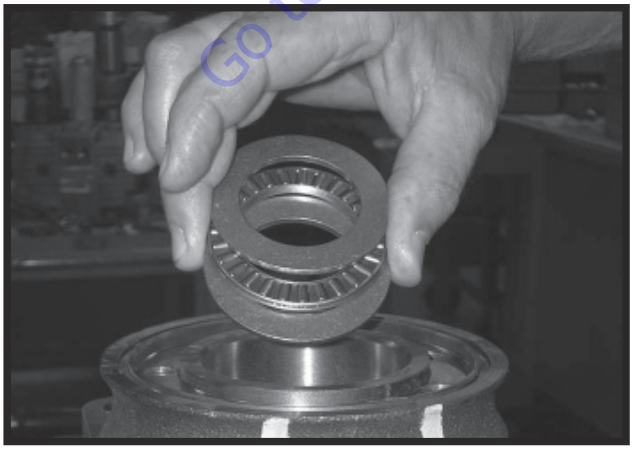
22. If the housing (18) assembly has passed inspection to this point, inspect the housing bearings/bushings (19) and (13) and if they are captured in the housing cavity the two thrust washers (14) and thrust bearing (15). The bearing rollers must be firmly retained in the bearing cages, but must rotate and orbit freely. All rollers and thrust washers must be free of brinelling and corrosion. The bushing (19) or (13) to coupling shaft diameter clearance must not exceed 0.010 in. (0.025 mm). A bearing, bushing, or thrust washer that does not pass inspection must be replaced. If the housing has passed this inspection the disassembly of the Torqmotor™ is completed.



NOTE: *The depth or location of bearing/bushing (13) in relation to the housing wear plate surface and the depth or location of bearing/bushing (19) in relation to the beginning of bearing/bushing counterbore should be measured and noted before removing the bearings/ bushings. This will facilitate the correct reassembly of new bearings/bushings.*



23. If the bearings, bushing or thrust washers must be replaced use a suitable size bearing puller to remove bearing/bushings (19) and (13) from housing (18) without damaging the housing. Remove thrust washers (14) and thrust bearing (15) if they were previously retained in the housing by bearing (13).



Assembly

Replace all seals and seal rings with new ones each time you reassemble the Torqmotor™ unit. Lubricate all seals and seal rings with SAE 10W40 oil or clean grease before assembly.

NOTE: *Individual seals and seal rings as well as a complete seal kit are available. The parts should be available through most OEM parts distributors or Parker approved Torqmotor™ distributors. (Contact your local dealer for availability).*

NOTE: *Unless otherwise indicated, do not oil or grease parts before assembly.*

Wash all parts in clean petroleum-based solvents before assembly. Blow them dry with compressed air. Remove any paint chips from mating surfaces of the end cover, commutator set, manifold rotor set, wear plate and housing and from port and sealing areas.

⚠ DANGER

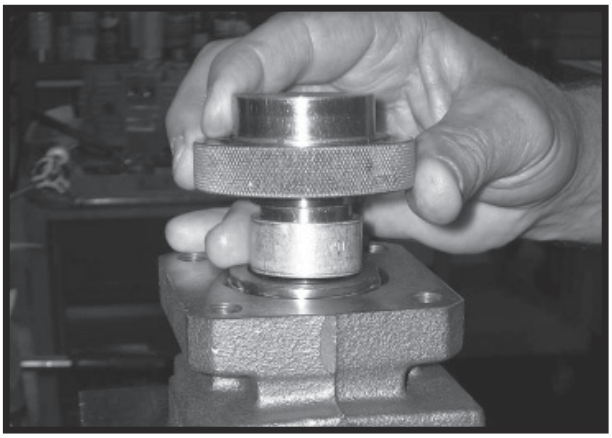
SINCE THEY ARE FLAMMABLE, BE EXTREMELY CAREFUL WHEN USING ANY SOLVENT. EVEN A SMALL EXPLOSION OR FIRE COULD CAUSE INJURY OR DEATH.

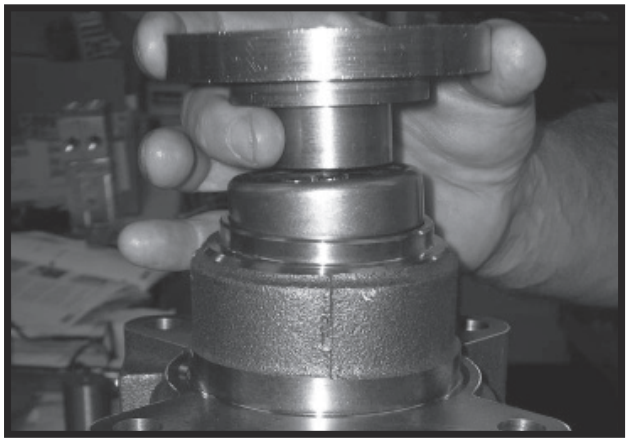
⚠ WARNING

WEAR EYE PROTECTION AND BE SURE TO COMPLY WITH OSHA OR OTHER MAXIMUM AIR PRESSURE REQUIREMENTS.

1. If the housing (18) bearing components were removed for replacement, thoroughly coat and pack a new outer bearing/bushing (19) with clean corrosion resistant grease recommended in the material section. Press the new bearing/bushing into the counterbore at the mounting flange end of the housing, using the appropriate sized bearing mandrel, which will control the bearing/ bushing depth.

Torqmotor™ housings require the use of bearing mandrel to press bearing/ bushing (19) into the housing to a required depth of 0.151/0.161 in. (3.84/4.09 mm) from the end of the bearing counterbore.





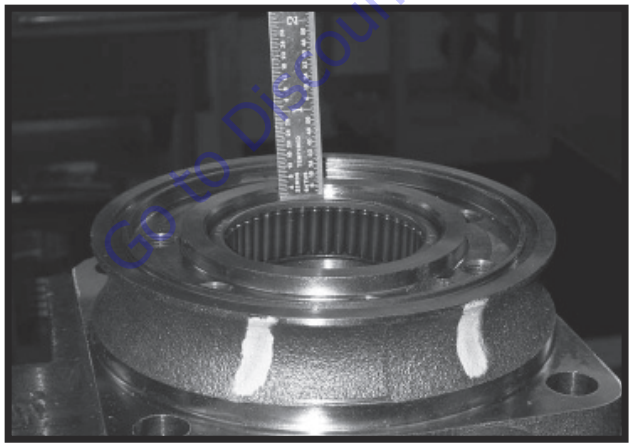
NOTE: *Bearing mandrel must be pressed against the lettered end of bearing shell. Take care that the housing bore is square with the press base and the bearing/bushing is not cocked when pressing a bearing/bushing into the housing.*

NOTICE

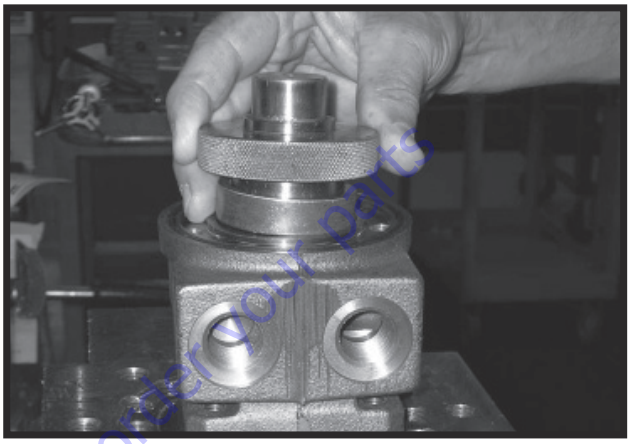
IF THE BEARING MANDREL SPECIFIED IN THE "TOOLS AND MATERIALS REQUIRED FOR SERVICING" SECTION IS NOT AVAILABLE AND ALTERNATE METHODS ARE USED TO PRESS IN BEARING/BUSHING (13) AND (19) THE BEARING/BUSHING DEPTHS SPECIFIED MUST BE ACHIEVED TO INSURE ADEQUATE BEARING SUPPORT AND CORRECT RELATIONSHIP TO ADJACENT COMPONENTS WHEN ASSEMBLED.

NOTICE

BECAUSE THE BEARING/BUSHINGS (13) AND (19) HAVE A PRESS FIT INTO THE HOUSING THEY MUST BE DISCARDED WHEN REMOVED. THEY MUST NOT BE REUSED.

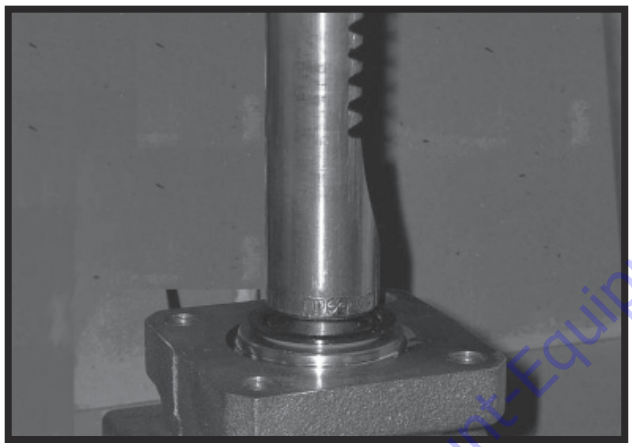


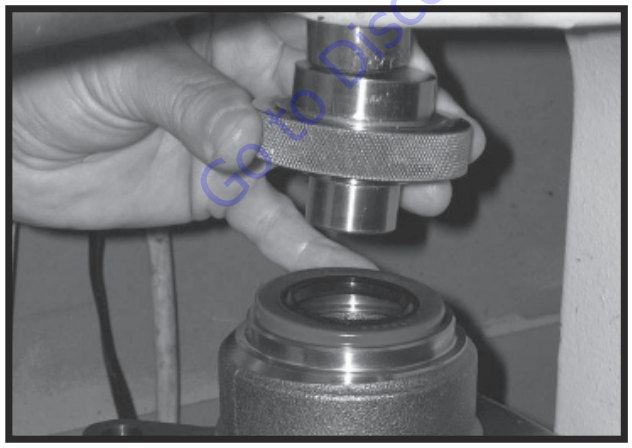
2. The Torqmotor™ inner housing bearing/bushing (13) can now be pressed into its counterbore in housing (18) flush to 0.03 in. (.76 mm) below the housing wear plate contact face. Use the opposite end of the bearing mandrel that was used to press in the outer bearing/ bushing (19).



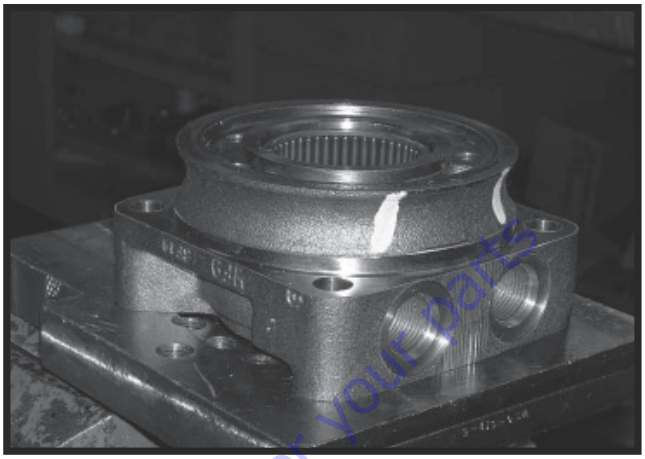
3. Press a new dirt and water seal (20) into the housing (18) outer bearing counterbore.

   The Torqmotor™ dirt and water seal (20) must be pressed in until its flange is flush against the housing.

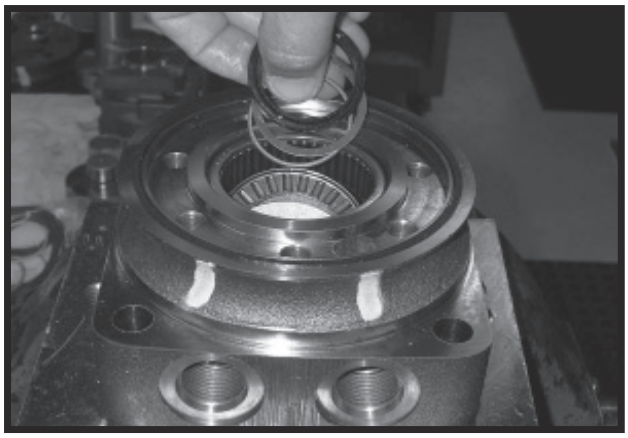




4. Place housing (18) assembly into a soft jawed vise with the coupling shaft bore down, clamping against the mounting flange.



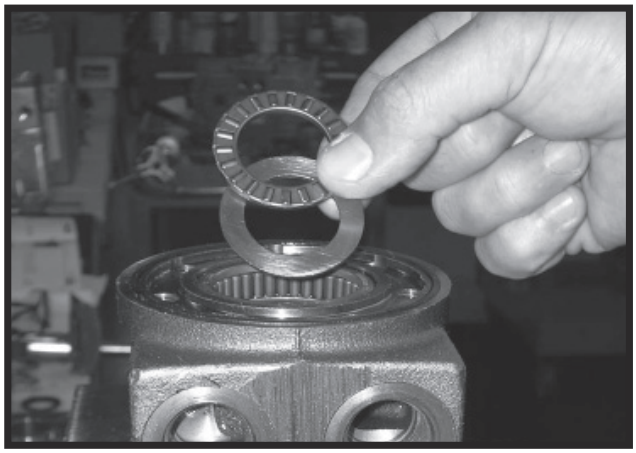
5. On the Torqmotor™ assemble a new backup washer (17) and new seal (16) with the seal lip facing toward the inside of Torqmotor™, into their respective counterbores in housing (18) if they were not assembled in procedure 2.



NOTICE

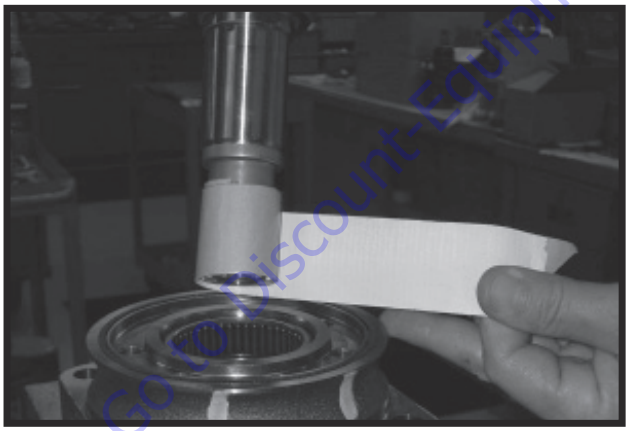
ORIGINAL DESIGN LARGE FRAME, TF & TG TORQMOTORS™ THAT DO NOT HAVE BACKUP WASHER (25) WHEN DISASSEMBLED MUST BE ASSEMBLED WITH A NEW BACKUP WASHER (17), NEW BACKUP WASHER (25), AND NEW SEAL (16).

6. Assemble thrust washer (14) then thrust bearing (15) that was removed from the Torqmotor™.

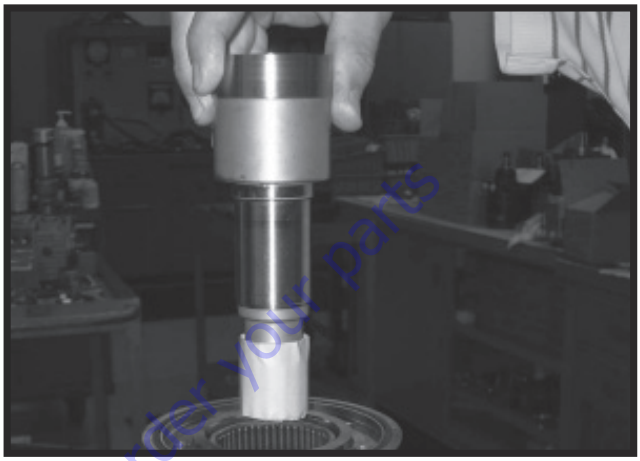


NOTE: *Torqmotors™ require one thrust washer (14) with thrust bearing (15).The coupling shaft will be seated directly against the thrust.*

7. Apply masking tape around splines or keyway on shaft (12) to prevent damage to seal.



8. Be sure that a generous amount of clean corrosion resistant grease has been applied to the lower (outer) housing bearing/bushing (19). Install the coupling shaft (12) into housing (18), seating it against the thrust bearing (15) in the housings.



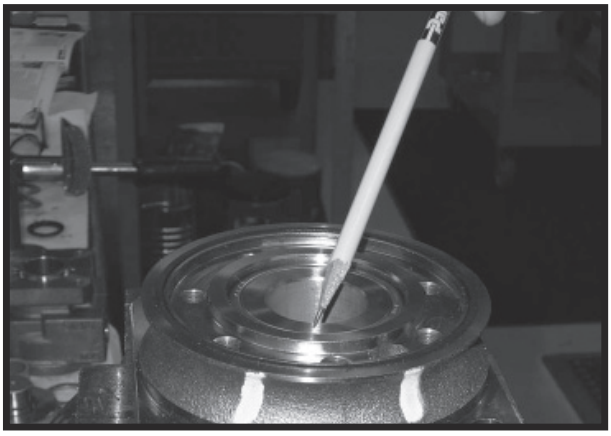
NOTICE

THE OUTER BEARING (19) IS NOT LUBRICATED BY THE SYSTEM'S HYDRAULIC FLUID. BE SURE IT IS THOROUGHLY PACKED WITH THE RECOMMENDED GREASE, PARKER GEAR GREASE SPECIFICATION #045236, E/M LUBRICANT #K-70M.

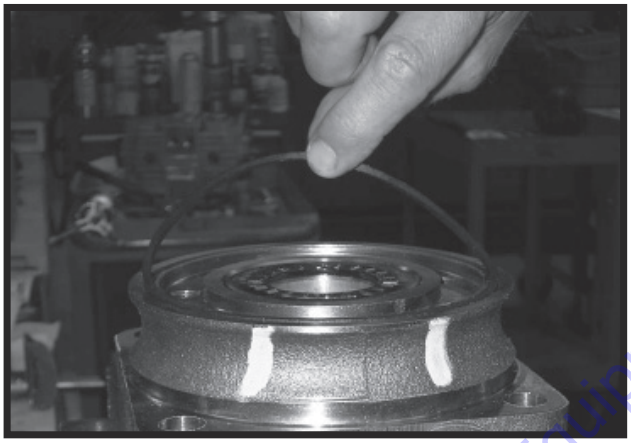
NOTE: *Mobil Mobilith SHC ® 460*

NOTE: *A 102Tube (P/N 406010) is included in each seal kit.*

NOTE: *The coupling shaft (12) will be flush or just below the housing wear plate surface on Torqmotors™ when properly seated. The coupling shaft must rotate smoothly on the thrust bearing package.*

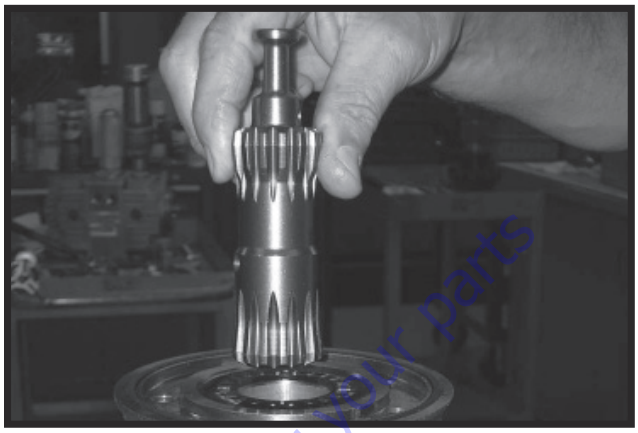


9. Apply a small amount of clean grease to a new seal ring (4) and insert it into the housing (18) seal ring groove.



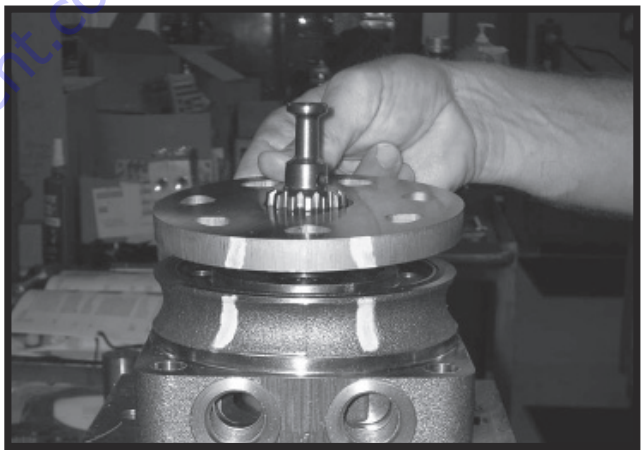
NOTE: *One or two alignment studs screwed finger tight into housing (18) bolt holes, approximately 180 degrees apart, will facilitate the assembly and alignment of components as required in the following procedures.The studs can be made by cutting off the heads of either 3/8-24 UNF 2A or 5/16-24 UNF 2A bolts as required that are over 0.5 in. (12.7 mm) longer than the bolts (1) used in the Torqmotor™.*

10. Install drive link (10) the long splined end down into the coupling shaft (12) and engage the drive link splines into mesh with the coupling shaft splines.

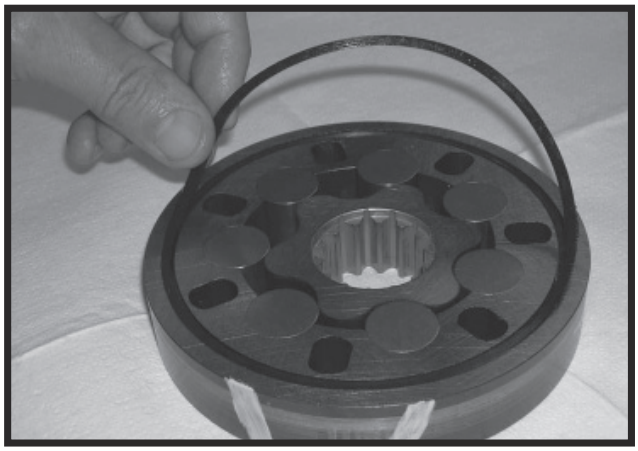


NOTE: *Use any alignment marks put on the coupling shaft and drive link before disassembly to assemble the drive link splines in their original position in the mating coupling shaft splines.*

11. Assemble wear plate (9) over the drive link (10) and alignment studs onto the housing (18).



12. Apply a small amount of clean grease to a new seal ring (4) and assemble it into the seal ring groove on the wear plate side of the rotor set stator (8B).



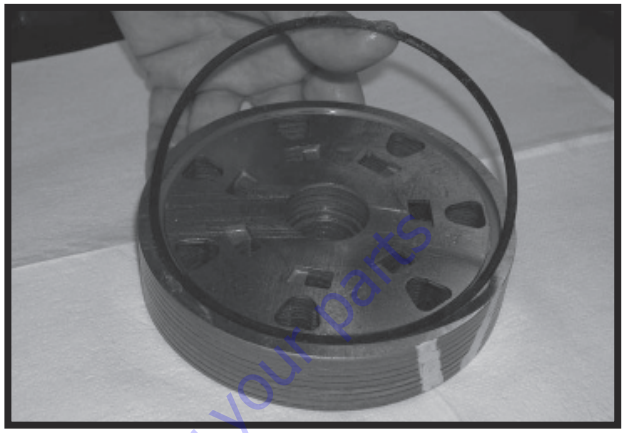
13. Install the assembled rotor set (8) onto wear plate (9) with rotor (8A) counterbore and seal ring side down and the splines into mesh with the drive link splines.

NOTE: *It may be necessary to turn one alignment stud out of the housing (18) temporarily to assemble rotor set (8) or manifold (7) over the drive link.*

NOTE: *If necessary, go to the appropriate, "Rotor Set Component Assembly Procedure."*

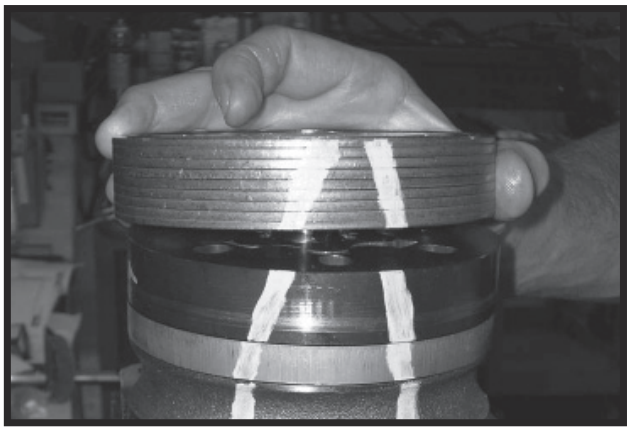
NOTE: *The rotor set rotor counterbore side must be down against wear plate for drive link clearance and to maintain the original rotor-drive link spline contact. A rotor set without a counterbore and that was not etched before disassembly can be reinstalled using the drive link spline pattern on the rotor splines if apparent, to determine which side was down.The rotor set seal ring groove faces toward the wear plate (9).*

14. Apply clean grease to a new seal ring (4) and assemble it in the seal ring groove in the rotor set contact side of manifold (7).

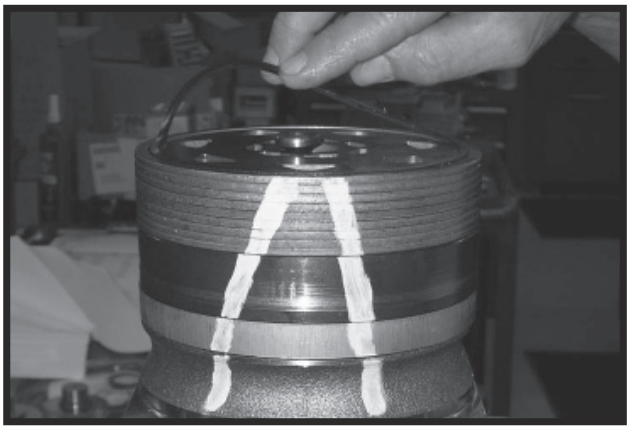


NOTE: *The manifold (7) is made up of several plates bonded together permanently to form an integral component. The manifold surface that must contact the rotor set has it's series of irregular shaped cavities on the largest circumference or circle around the inside diameter. The polished impression left on the manifold by the rotor set is another indication of which surface must contact the rotor set.*

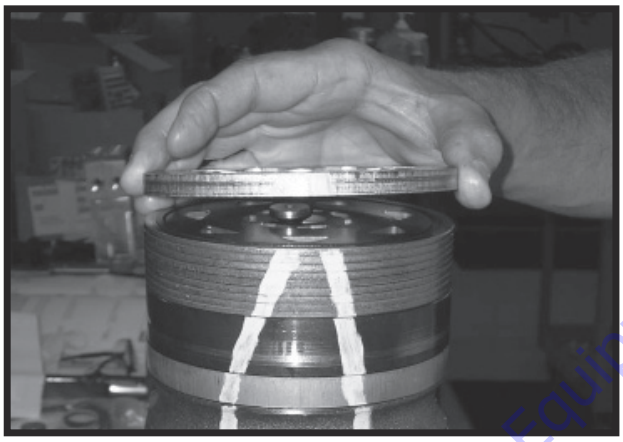
15. Assemble the manifold (7) over the alignment studs and drive link (10) and onto the rotor set. Be sure the correct manifold surface is against the rotor set.



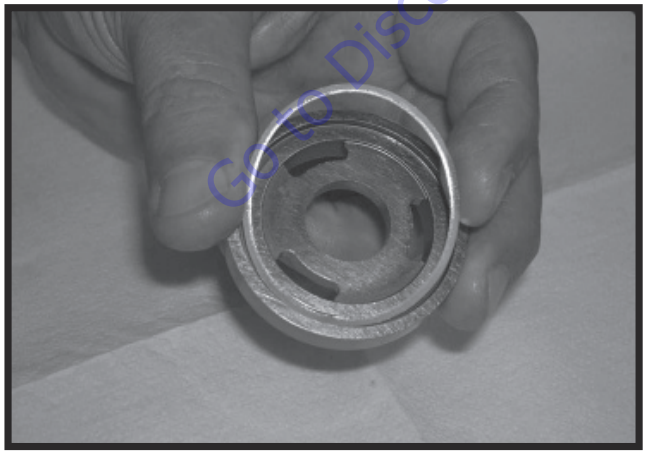
16. Apply grease to a new seal ring (4) and insert it in the seal ring groove exposed on the manifold.

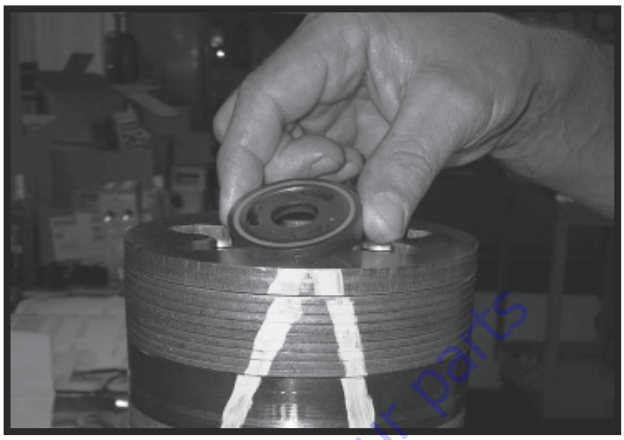


17. Assemble the commutator ring (6) over alignment studs onto the manifold.

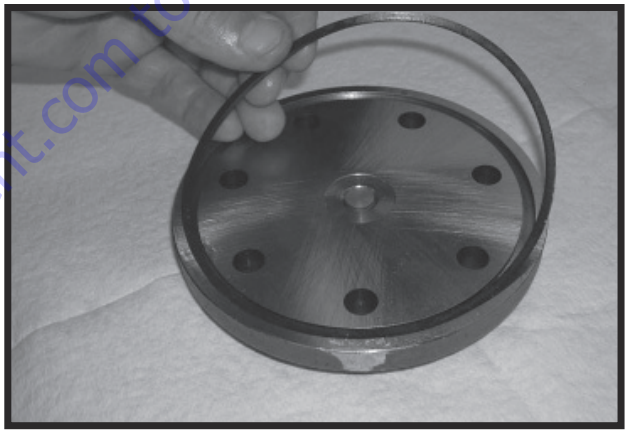


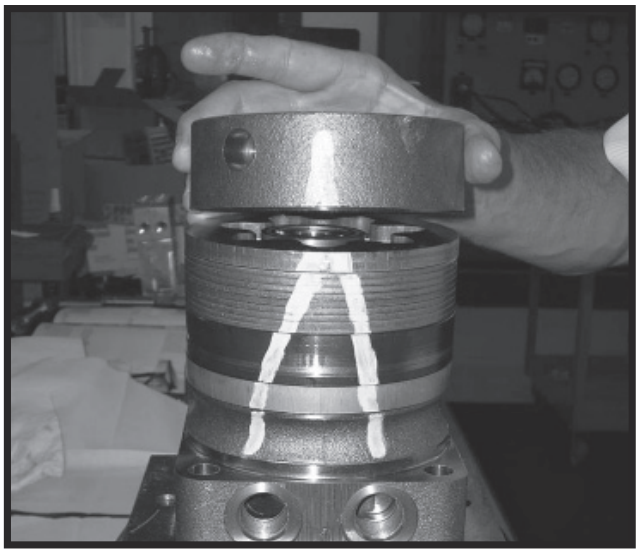
18. Assemble a new seal ring (3) flat side up, into commutator (5) and assemble commutator over the end of drive link (10) onto manifold (7) with seal ring side up.

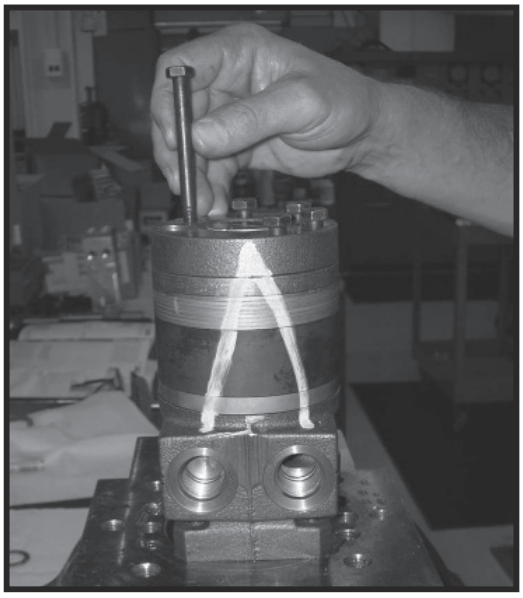


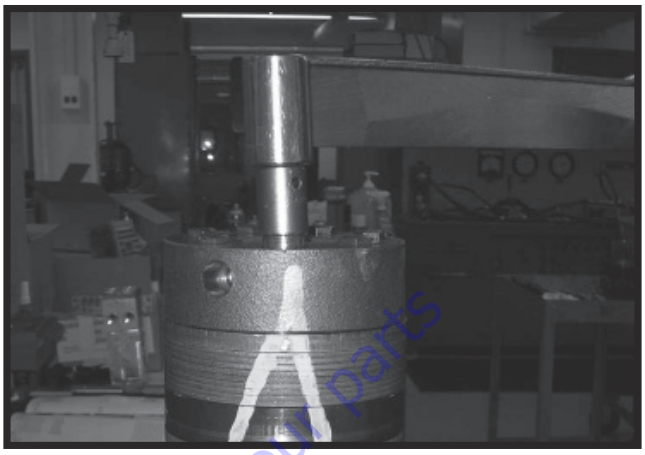


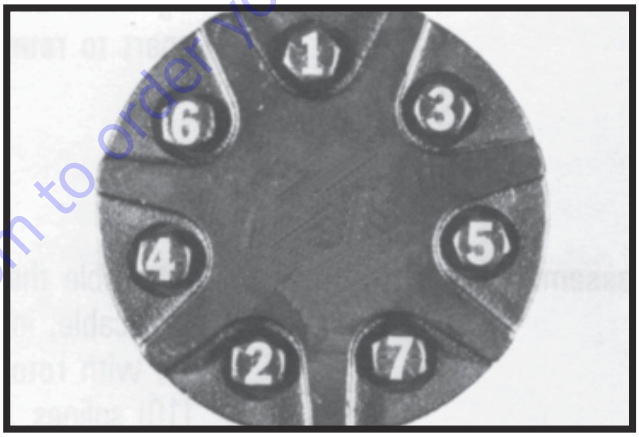
19. Assemble a new seal ring (4) into end cover (2) and assemble end cover over the alignment studs and onto the commutator set. If the end cover has only 5 bolt holes be sure the cover holes are aligned with the 5 threaded holes in housing (18).The correct 5 bolt end cover bolt hole relationship to housing port bosses.



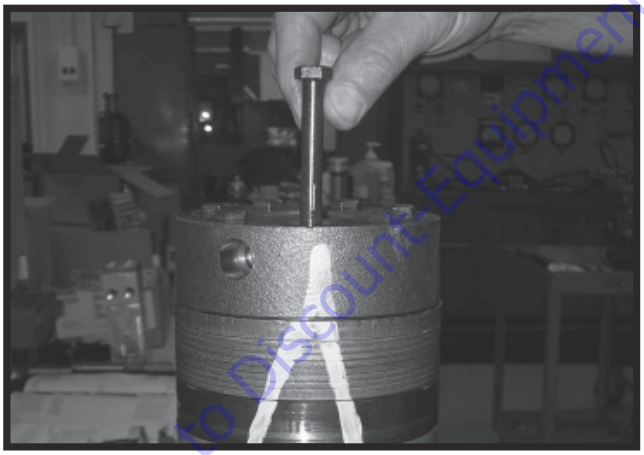








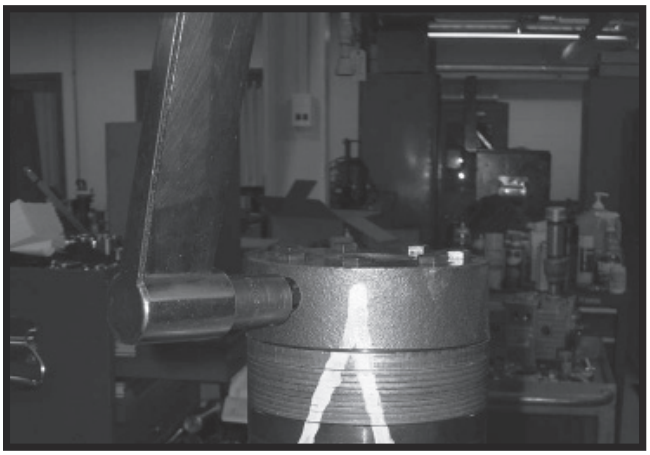
20. Assemble the 5 or 7 special bolts (1) and screw in finger tight. Remove and replace the two alignment studs with bolts after the other bolts are in place. Alternately and progressively tighten the bolts to pull the end cover and other components into place with a final torque of 50-55 ft. lbs. (68-75 Nm) for the seven 3/8-24 threaded bolts.

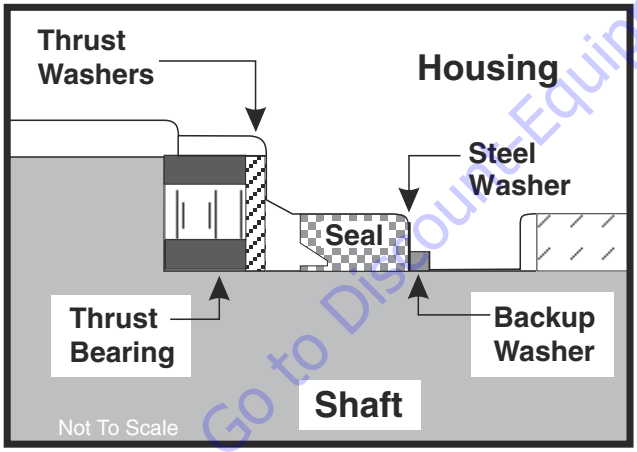


NOTE: *The special bolts required for use with the relief or shuttle valve (24) end cover assembly (2) are longer than the bolts required with standard and cover assembly. Refer to the individual service parts lists or parts list charts for correct service part number if replacement is required.*

21. Torque the two shuttle valve plug assemblies (21) in end cover assembly to 9-12 ft. lbs. (12-16 Nm) if cover is so equipped.

Torque the two relief valve plug assemblies (21) in end cover assembly to 45-55 ft. lbs. (61-75 Nm) if cover is so equipped.





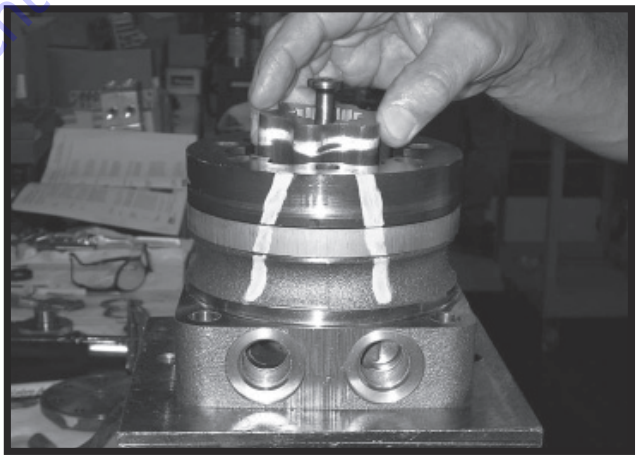
One Piece Stator Construction

A disassembled rotor (8A) stator (8B) and vanes (8C) that cannot be readily assembled by hand can be assembled by the following procedures.

1. Place stator (8B) onto wear plate (9) with seal ring (4) side down, after following Torqmotor™ assembly procedures 1 through 13. Be sure the seal ring is in place.

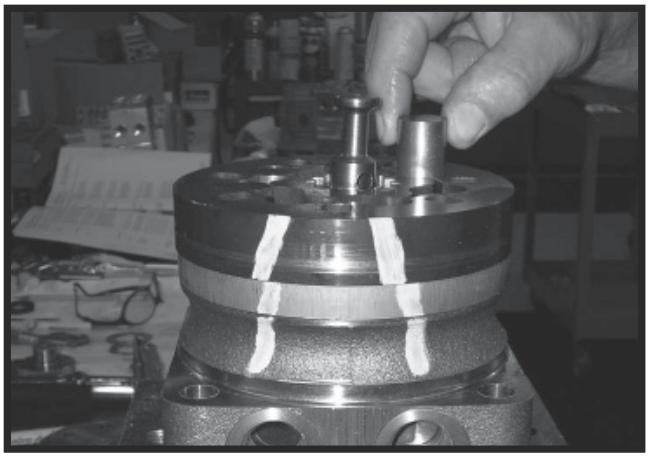
2. If assembly alignment studs are not being utilized, align stator bolt holes with wear plate and housing bolt holes and turn two bolts (1) finger tight into bolt holes approximately 180 degrees apart to retain stator and wear plate stationary.

3. Assemble the rotor (8A), counterbore down if applicable, into stator (8B), and onto wear plate (9) with rotor splines into mesh with drive link (10) splines.



NOTE: *If the manifold side of the rotor was etched during Torqmotor disassembly, this side should be up. If the rotor is not etched and does not have a counterbore, use the drive link spline contact pattern apparent on the rotor splines to determine the rotor side that must be against the wear plate.*

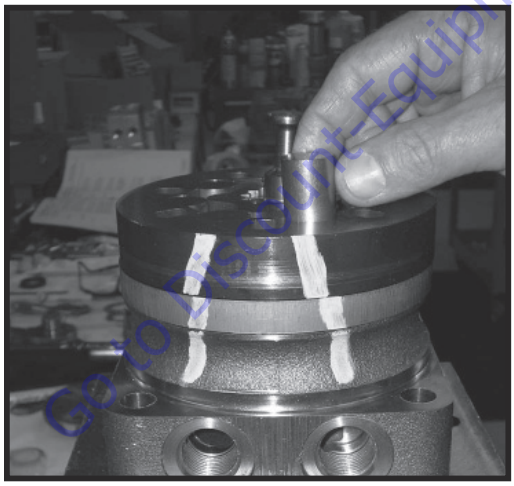
4. Assemble six vanes (8C), or as many vanes that will readily assemble into the stator vane pockets.



NOTICE

EXCESSIVE FORCE USED TO PUSH THE ROTOR VANES INTO PLACE COULD SHEAR OFF THE COATING APPLIED TO THE STATOR VANE POCKETS.

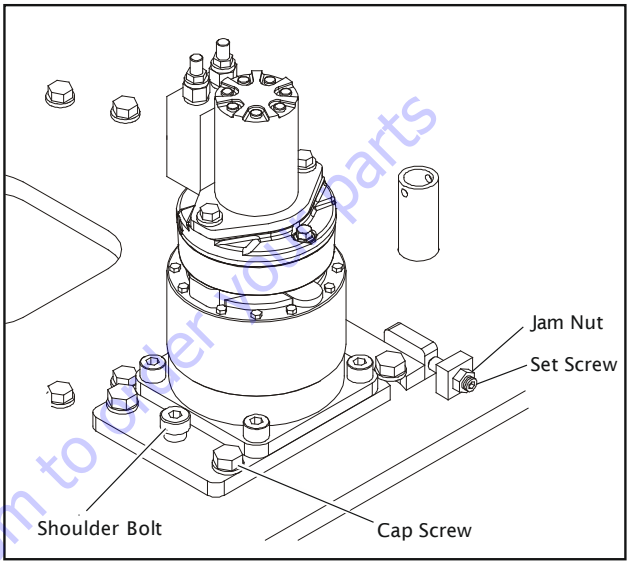
5. Grasp the output end of coupling shaft (12) with locking pliers or other appropriate turning device and rotate coupling shaft, drive link and rotor to seat the rotor and the assembled vanes (8C) into stator (8B), creating the necessary clearance to assemble the seventh or full complement of seven vanes. Assemble the seven vanes using minimum force.



6. Remove the two assembled bolts (1) if used to retain stator and wear plate.

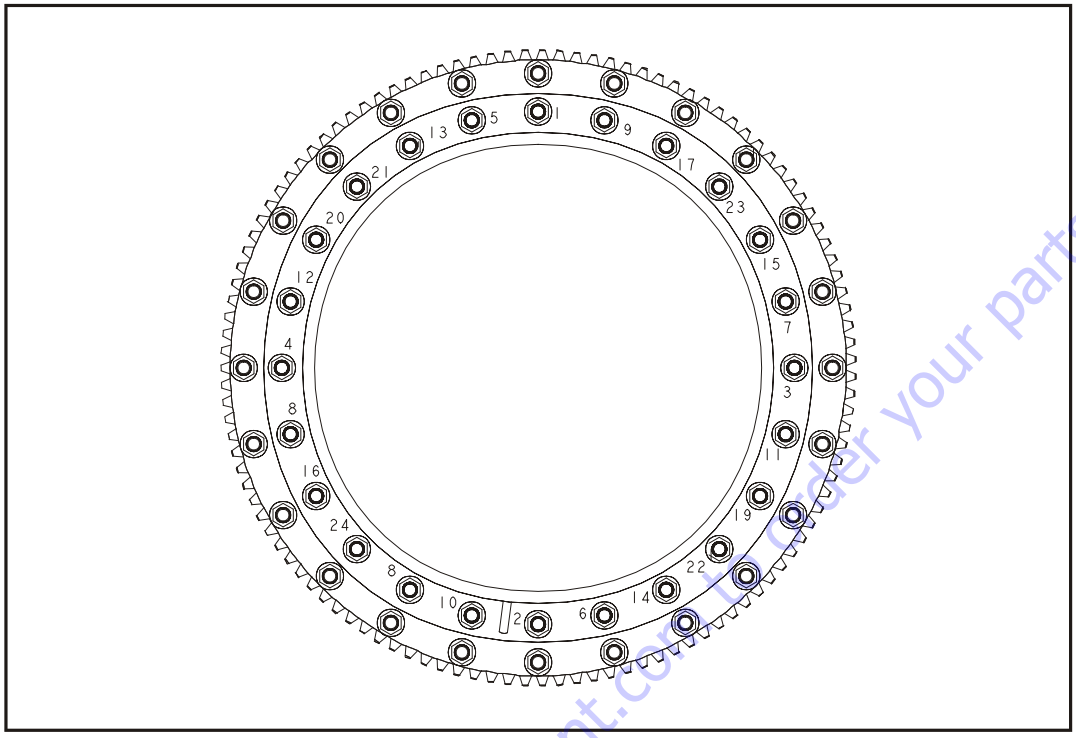
3.22 SWING HUB REMOVAL

1. Disconnect all wiring harness terminals connected to the swing motor.
2. Gently loosen the set screw. Do not remove.
3. Remove the shoulder bolt using Allen Wrench.



4. Remove the cap bolts securing swing drive hub to the turntable.
5. Using the suitable lifting device, remove the swing drive hub from mounting plate without damaging the swing gear.
6. Place swing drive hub in the clean area.
7. Refer to Swing Drive Section for swing drive maintenance.

3.23 SWING BEARING



NOTE: *Swing Bearing Torque Sequence is typical for both inner and outer races.*

Figure 3-74. Swing Bearing Torque Sequence

Turntable Bearing Mounting Bolt Condition Check

NOTE: *This check is designed to replace the existing bearing bolt torque checks on JLG Lifts in service. This check must be performed after the first 50 hours of machine operation and every 600 hours of machine operation thereafter. If during this check any bolts are found to be missing or loose, replace missing or loose bolts with new bolts and torque to the value specified in the torque chart, after lubricating the bolt threads with JLG Threadlocker P/N 0100019. After replacing and retorquing bolt or bolts recheck all existing bolts for looseness.*

1. Check the frame to bearing attach bolts as follows:
   - **a.** Elevate the fully extended main boom to horizontal. (See Figure 3-75.)
   - **b.** At the positions indicated on Figure 3-75., try to insert a 0.0015 in. feeler gauge between the bolt and hardened washer at the arrow indicated position.
   - **c.** Ensure that the 0.0015" feeler gauge will not penetrate under the bolt head to the bolt shank.
   - **d.** Swing the turntable 90 degrees, and check some selected bolts at the new position.
   - **e.** Continue rotating the turntable at 90 degrees intervals until a sampling of bolts have been checked in all quadrants.
2. Check the turntable to bearing Attach bolts as follows:
   - **a.** Elevate the fully retracted main boom to full elevation.
   - **b.** At the position indicated on Figure 3-77., try to insert the 0.0015" feeler gauge between the bolt head and hardened washer at the arrow indicated position.
   - **c.** Lower the boom to horizontal and fully extend the boom.
   - **d.** At the position indicated on Figure 3-76., try and insert the 0.0015" feeler gauge between the bolt head and hardened washer at the arrow indicated position.

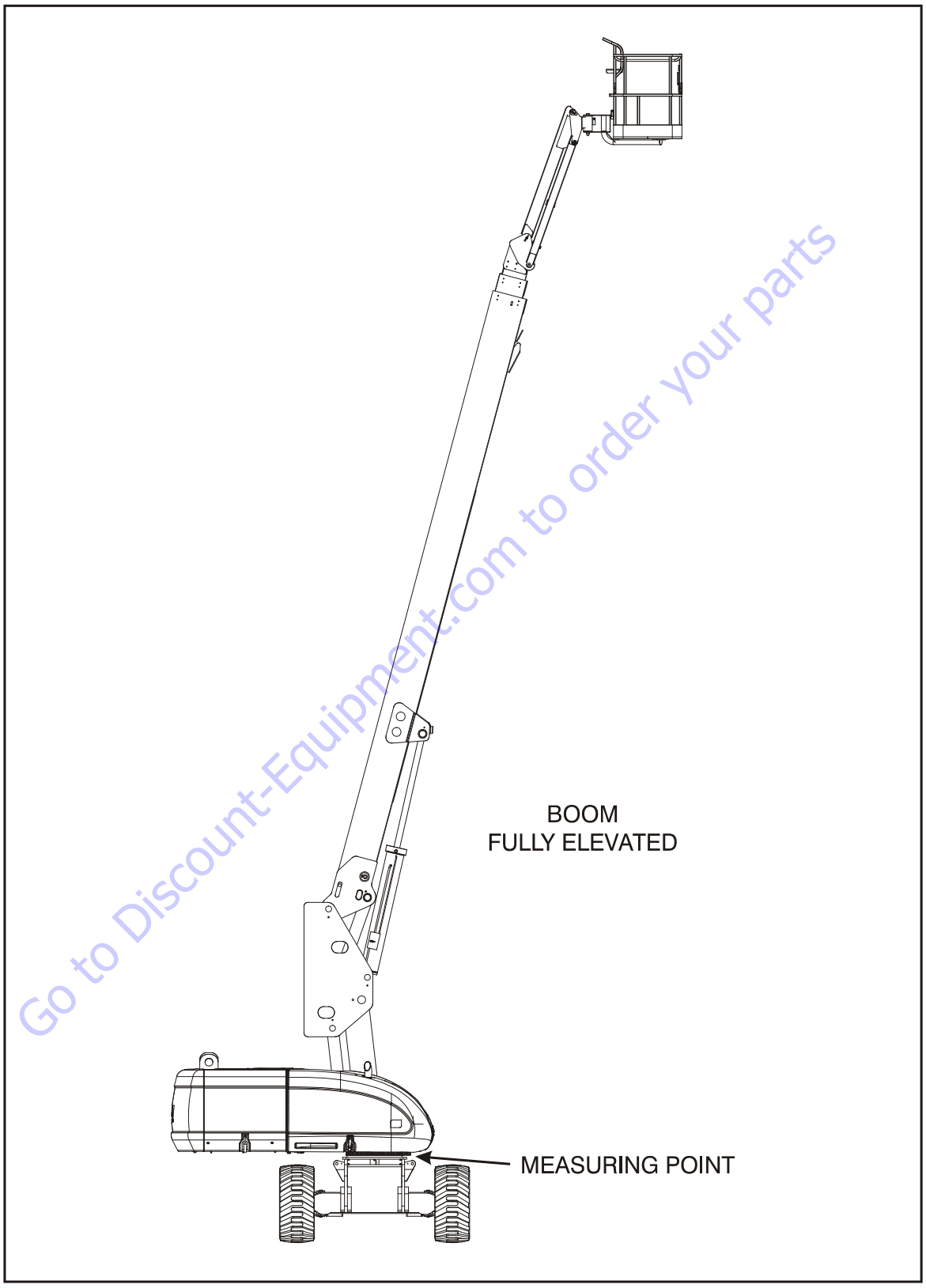


Figure 3-75. Swing Bearing Tolerance Boom Placement. (Sheet 1 of 2)

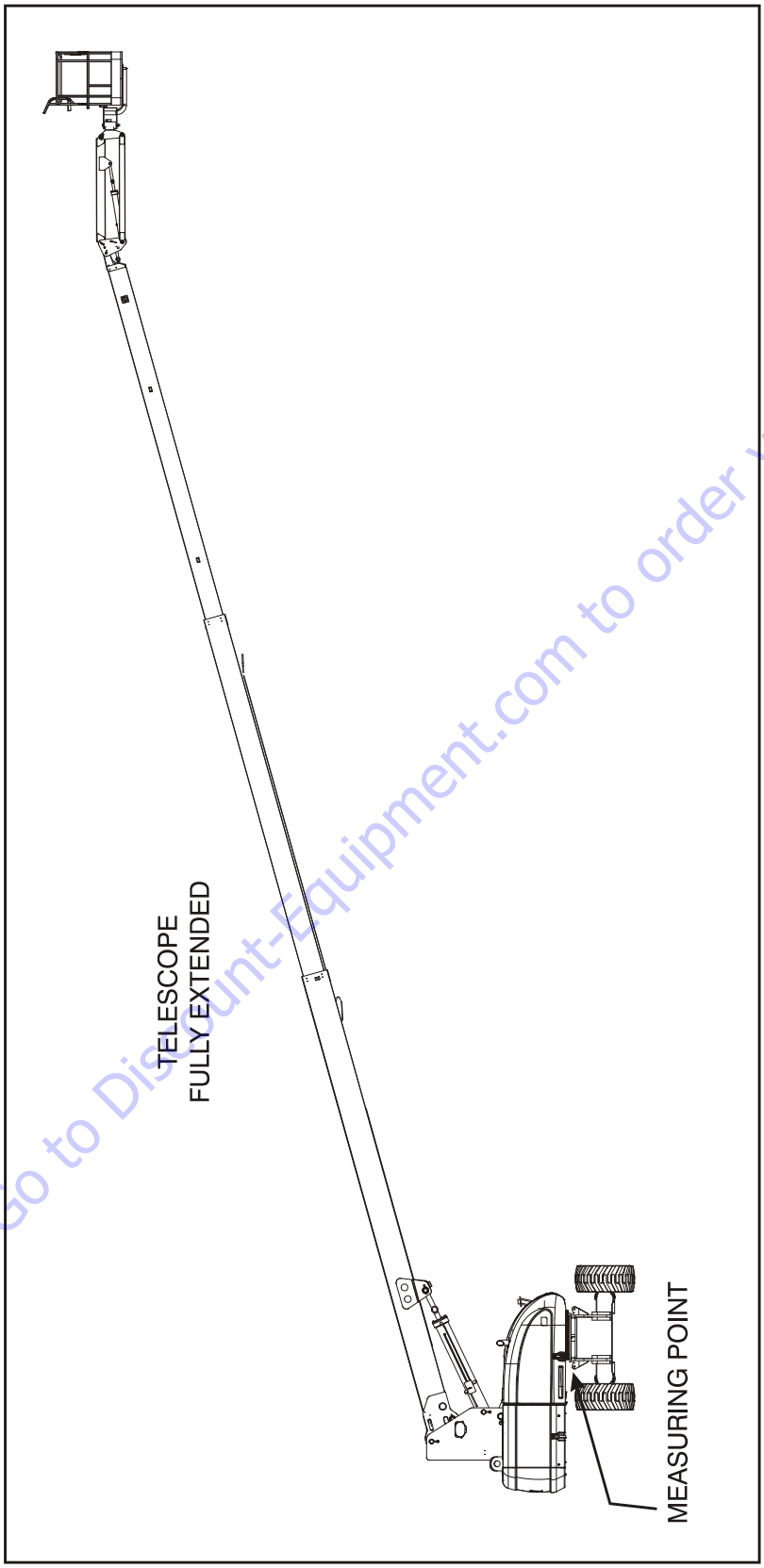


Figure 3-76. Swing Bearing Tolerance Boom Placement.(Sheet 2 of 2)

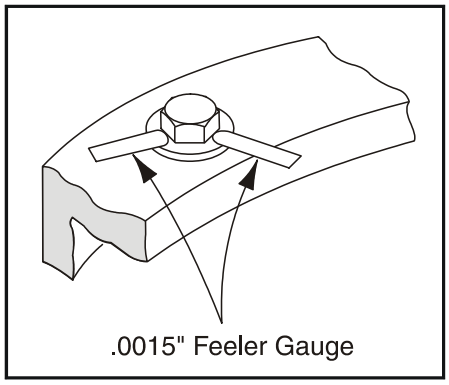


Figure 3-77. Swing Bolt Feeler Gauge Check.

Wear Tolerance

1. From the underside of the machine, at rear center, with the main boom fully elevated and fully retracted, and tower boom stowed, as shown in Figure 3-75., Swing Bearing Tolerance Boom Placement. (Sheet 1 of 2), using a magnetic base dial indicator, measure and record the distance between the swing bearing and turntable. See Figure 3-78., Swing Bearing Tolerance Measuring Point.
2. At the same point, with the main boom at horizontal and fully extended, and the tower boom fully elevated and fully retracted as shown in Figure 3-76., Swing Bearing Tolerance Boom Placement.(Sheet 2 of 2). Using a magnetic base dial indicator, measure and record the distance between the swing bearing and turntable. See Figure 3-78., Swing Bearing Tolerance Measuring Point.
3. If a difference greater than 0.079 in. (2.00 mm) is determined, the swing bearing should be replaced.
4. If a difference less than 0.079 in. (2.00 mm) is determined, and any of the following conditions exist, the bearing should be removed, disassembled, and inspected for the following:
   - **a.** Metal particles in the grease.
   - **b.** Increased drive power required.
   - **c.** Noise.
   - **d.** Rough rotation.
5. If bearing inspection shows no defects, reassemble and return to service.

NOTICE

THE SWING BEARING IS ONE OF THE MOST CRITICAL POINTS ON AN AERIAL LIFT. IT IS HERE THAT THE STRESSES OF LIFTING ARE CONCENTRATED, AT THE CENTER OF ROTATION. BECAUSE OF THIS, PROPER MAINTENANCE OF THE SWING BEARING BOLTS IS A MUST FOR SAFE OPERATION.

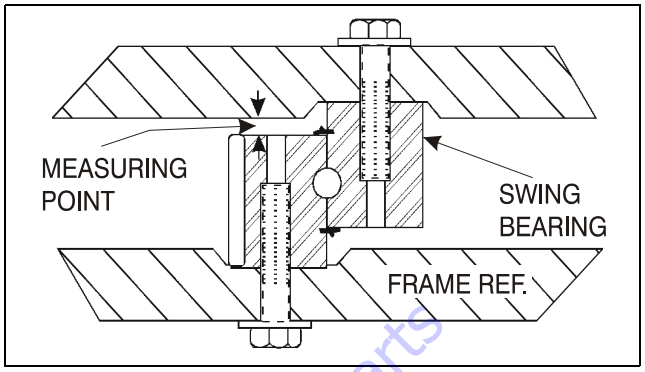


Figure 3-78. Swing Bearing Tolerance Measuring Point.

Swing Bearing Removal

1. From Ground Control station, operate the boom adequately to provide access to frame opening to rotary coupling.

⚠ WARNING

NEVER WORK BENEATH THE BOOM WITHOUT FIRST ENGAGING BOOM SAFETY PROP OR PROVIDING ADEQUATE OVERHEAD SLING SUPPORT AND/OR BLOCKING.

2. Attach an adequate support sling to the boom and draw all slack from sling. Prop or block the boom if feasible.
3. From inside turntable, remove mounting hardware which attach rotary coupling retaining yoke brackets to turntable.

NOTICE

HYDRAULIC LINES AND PORTS SHOULD BE CAPPED IMMEDIATELY AFTER DISCONNECTING LINES TO AVOID THE ENTRY OF CONTAMINANTS INTO THE SYSTEM.

4. Tag and disconnect the hydraulic lines from the fittings on the top of the rotary coupling. Use a suitable container to retain any residual hydraulic fluid. Immediately cap lines and ports.
5. Attach suitable overhead lifting equipment to the base of the turntable weldment.
6. Use a suitable tool to scribe a line on the inner race of the swing bearing and on the underside of the turntable. This will aid in aligning the bearing upon installation. Remove the bolts and washers which attach the turntable to the bearing inner race. Discard the bolts.
7. Use the lifting equipment to carefully lift the complete turntable assembly from the bearing. Ensure that no damage occurs to the turntable, bearing or frame-mounted components.

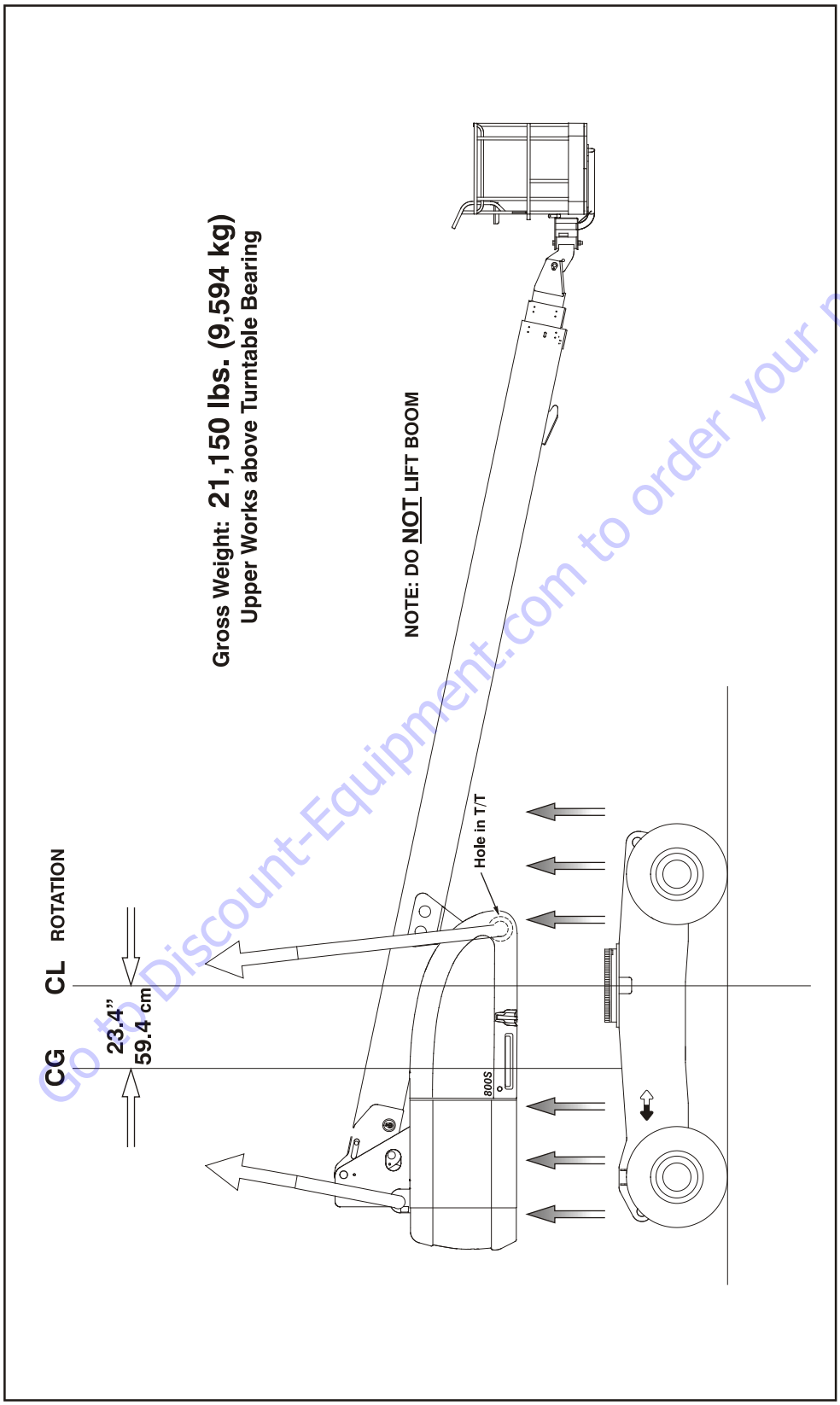


Figure 3-79. Swing Bearing Removal - 800S

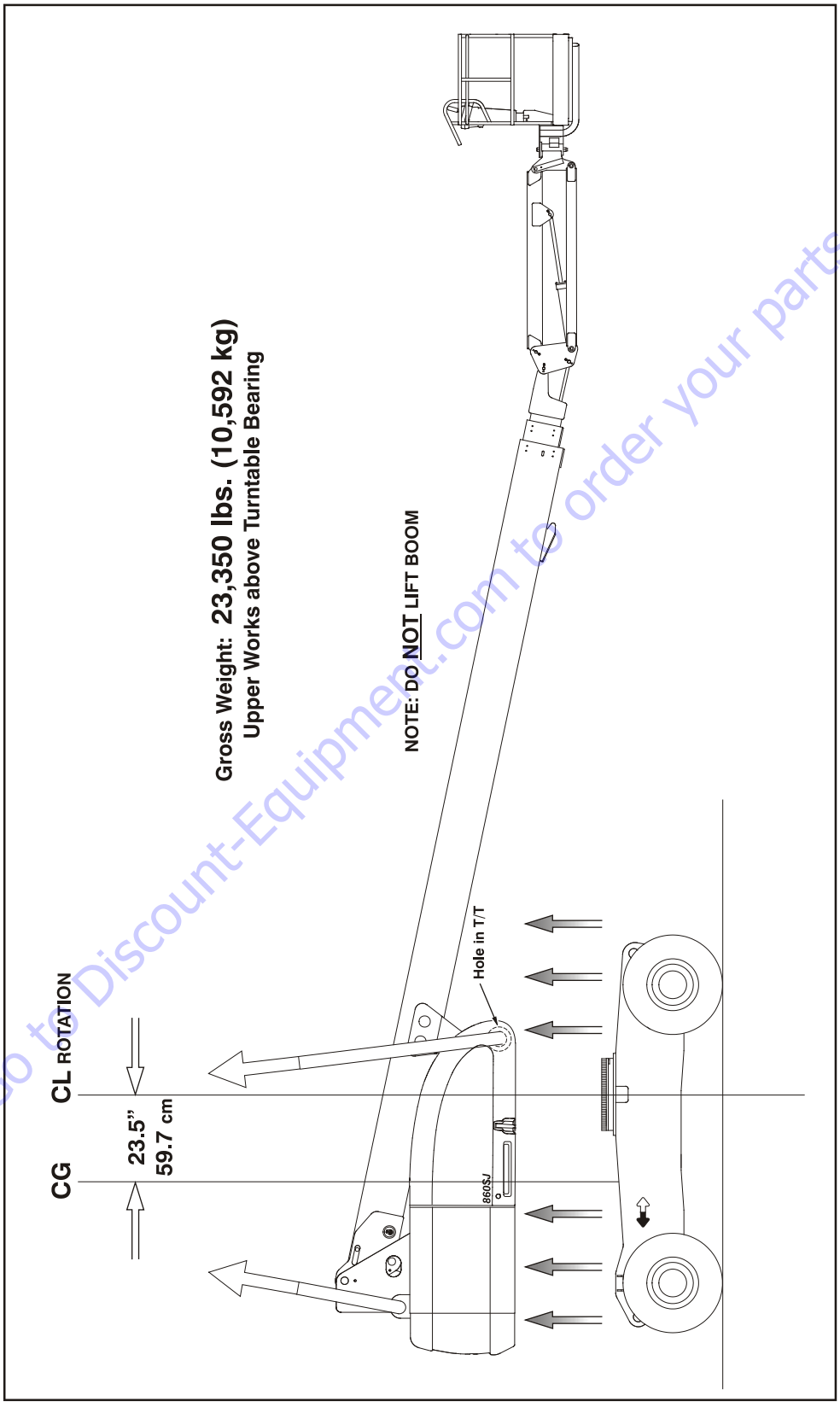


Figure 3-80. Swing Bearing Removal - 860SJ

8. Carefully place the turntable on a suitably supported trestle.
9. Use a suitable tool to scribe a line on the outer race of the swing bearing and the frame. This line will aid in aligning the bearing upon installation. Remove the bolts and washers which attach the outer race of the bearing to the frame. Discard the bolts. Use suitable lifting equipment to remove the bearing from the frame, then move the bearing to a clean, suitably supported work area.

Swing Bearing Installation

1. Using suitable lifting equipment, carefully lower the swing bearing into position on the frame. Ensure the scribed line of the outer race of the bearing aligns with the scribed line on the frame. If a new swing bearing is used, ensure that the spot with minimum gear backlash (marked with yellow paint) is towards the centerline of the swing drive (as close as the bolt pattern will allow).

⚠ CAUTION

JLG INDUSTRIES RECOMMENDS THAT ALL REMOVED BEARING BOLTS BE DISCARDED AND REPLACED WITH NEW BOLTS. SINCE THE SWING BEARING IS THE ONLY STRUCTURAL LINK BETWEEN THE FRAME AND TURNTABLE, IT IS IMPERATIVE THAT SUCH REPLACEMENT HARDWARE MEETS JLG SPECIFICATIONS. USE OF GENUINE JLG HARDWARE IS HIGHLY RECOMMENDED.

2. Apply a light coating of JLG Threadlocker P/N 0100019 to the new bearing bolts, and loosely install the bolts and washers through the frame and outer race of bearing.

NOTICE

IF COMPRESSED AIR OR ELECTRICALLY OPERATED IMPACT WRENCH IS USED FOR TIGHTENING THE BEARING ATTACHMENT BOLTS, THE TORQUE SETTING ACCURACY OF THE TOOL SHOULD BE CHECKED PRIOR TO USE.

3. Refer to the Torque Sequence diagram as shown in Figure 3-74., Swing Bearing Torque Sequence. Spray a light coat of Safety Solvent 13 on the new bearing bolts. Then apply a light coating of JLG Threadlocker P/N 0100019 to the new bearing bolts, and install the bolts and washers through the frame and outer race of the bearing. Tighten the bolts to a torque of 190 ft. lbs. (258 Nm) w/ Loctite.
4. Remove the lifting equipment from the bearing.
5. Using suitable lifting equipment, carefully position the turntable assembly above the machine frame.
6. Carefully lower the turntable onto the swing bearing, ensuring that the scribed line of the inner race of the bearing aligns with scribed line on the turntable. If a new swing bearing is used, ensure that the filler plug fitting is at 90 degrees from the fore and aft center line of the turntable.
7. Spray a light coat of Safety Solvent 13 on the new bearing bolts. Then apply a light coating of JLG Threadlocker P/N 0100019 to the new bearing bolts, and install the bolts and washers through the turntable and inner race of the bearing.
8. Following the Torque Sequence diagram shown in Figure 3-74., Swing Bearing Torque Sequence, tighten the bolts to a torque of 190 ft. lbs. (258 Nm) w/Loctite.
9. Remove the lifting equipment.
10. Install the rotary coupling retaining yoke brackets, apply a light coating of JLG Threadlocker P/N 0100011 to the attaching bolts and secure the yoke to the turntable with the mounting hardware.
11. Connect the hydraulic lines to the rotary coupling as tagged prior to removal.
12. At ground control station, use boom lift control to lower boom to stowed position.
13. Using all applicable safety precautions, activate the hydraulic system and check the swing system for proper and safe operation.

Swing Bearing Torque Values

1. Outer Race - 190 ft. lbs. (258 Nm) w/Loctite.
2. Inner Race - 190 ft. lbs. (258 Nm) w/Loctite.
3. See Swing Bearing Torquing Sequence.

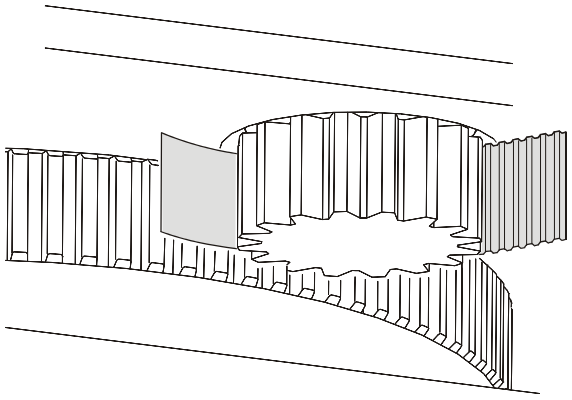
⚠ WARNING

CHECK THE INNER AND OUTER SWING BEARING BOLTS FOR MISSING OR LOOSENESS AFTER FIRST 50 HOURS OF OPERATION, AND EVERY 600 HOURS THEREAFTER.

3.24 PROCEDURE FOR SETTING GEAR BACKLASH

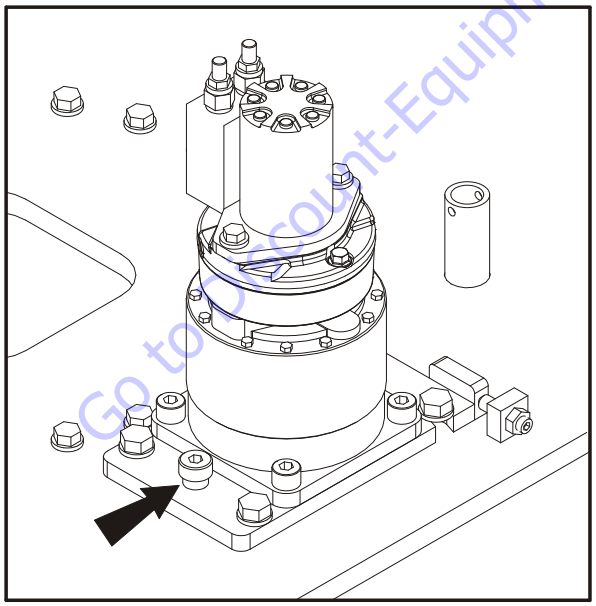
Ensure mounting plate and mounting location of the base plate are clean and painted with a uniform coating of minimum thickness (no runs, drips, etc.).

1. Set backlash to 0.008 to 0.012 in. (0.203 to 0.304 mm) using the following procedure.
2. Place shim between pinion and bearing on the bearing high spot.

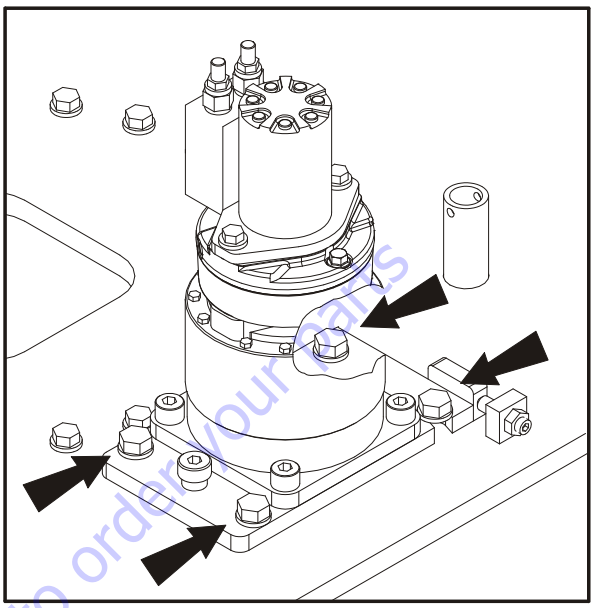


3. Apply JLG Threadlocker P/N 0100019 to the shoulder screw (shown below) and torque to 205 ft. lbs. (278 Nm).

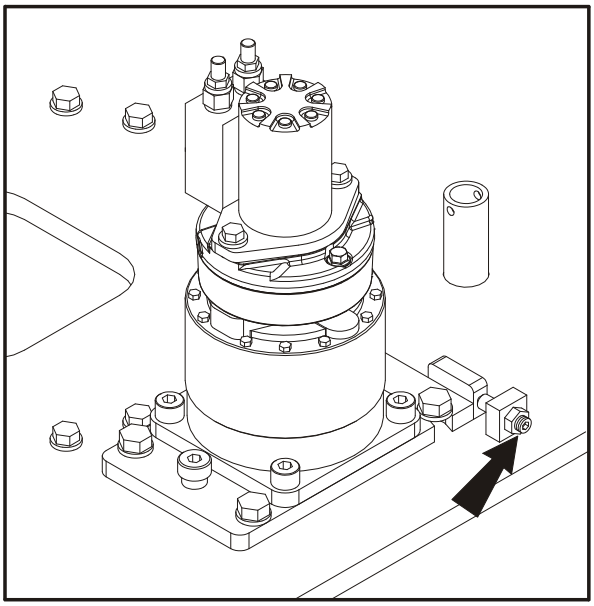
NOTE: *Torque shoulder bolt against turntable baseplate. Shoulder bolt will not tighten against the swing drive mounting plates.*



4. Remove the turntable lock pin.
5. Apply JLG Threadlocker P/N 0100019 to the capscrews (shown below) and pre-torque to 30 ft. lbs. (42 Nm).

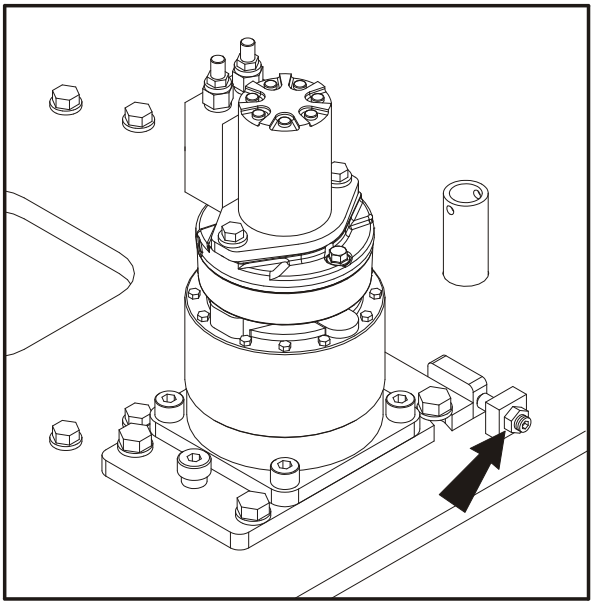


6. Tighten the setscrew (shown below) until the pinion is completely snug against the shim and bearing and then back off the setscrew.

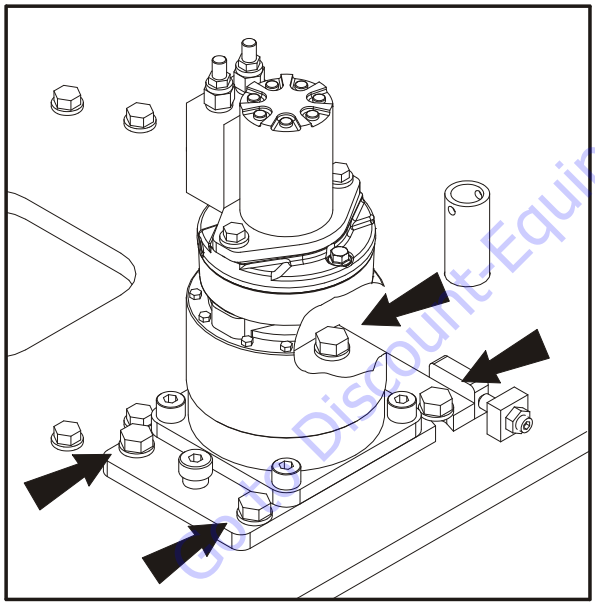


7. Apply JLG Threadlocker P/N 0100019 to the setscrew and torque to 50 ft.lbs. (68 Nm).

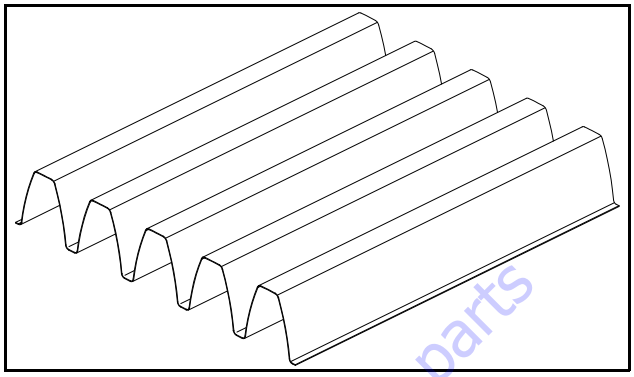
8. Apply JLG Threadlocker P/N 0100019 to the jam nut (shown below) and tighten.



9. Torque the capscrews shown in step 5 to 340 foot-pounds (569 Nm).

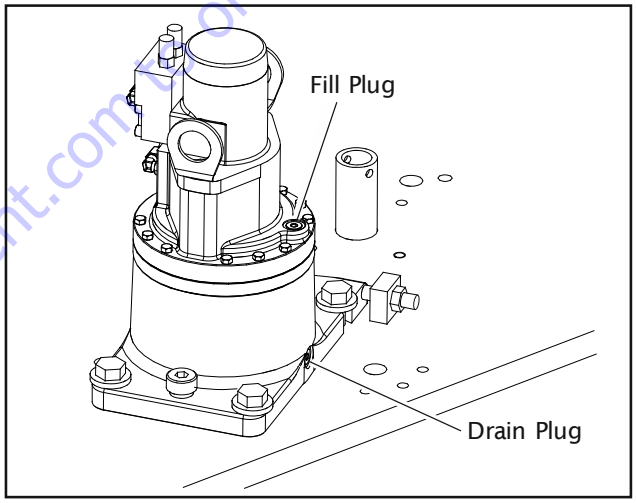


10. Remove shim and discard.



Swing Drive Lubrication

Fill Swing Drive Gearbox with 43 oz (1.27 L) 90w80gear oil with EP additives. Oil should cover the ring gear. Torque pipe plug to 23-25 ft. lbs. (31- 33 Nm).



3.25 ROTARY COUPLING (PRIOR TO SN 0300083331)

Use the following procedure to install the seal kit.

1. If not already removed, remove the axle oscillation valve from the cylinder barrel. The spool of the valve protrudes into the barrel and will damage the spool and seals if left in place.
2. Remove snap ring (7) from end.
3. Remove thrust ring (6) from the same end.
4. Remove center body (1) from housing (3).
5. Cut off old seals (2,4,5).
6. Assemble lip seals (2) in direction shown in Figure 3-81., Rotary Coupling Seal Installation (Prior to SN 0300083331).
7. Reassemble o-ring (4).
8. Heat cap seals (5) in hydraulic oil for 5 minutes at 300° F (149° C).
9. Assemble cap seals over o-rings.
10. Reinsert center body into housing (lube with hydraulic oil).

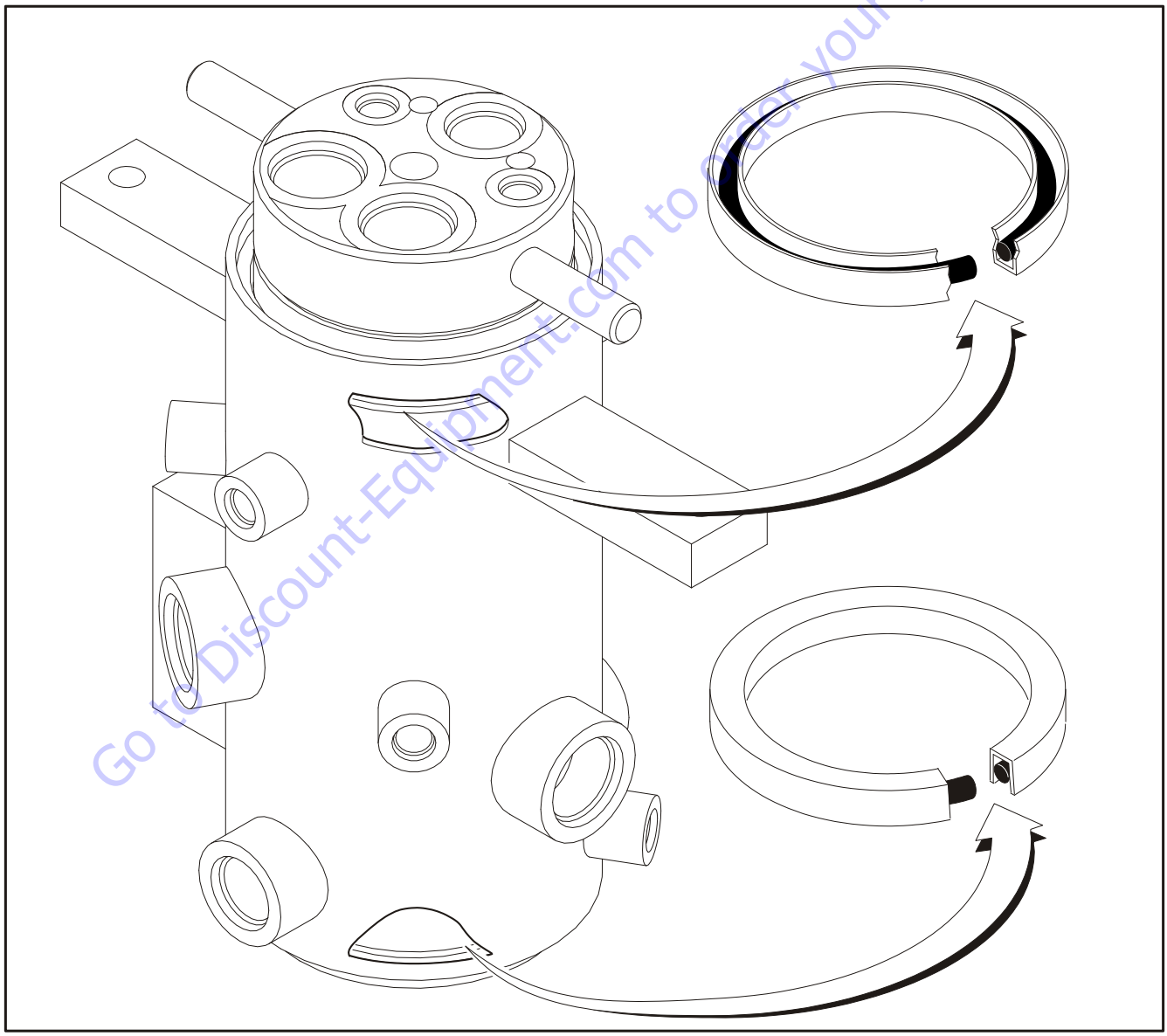
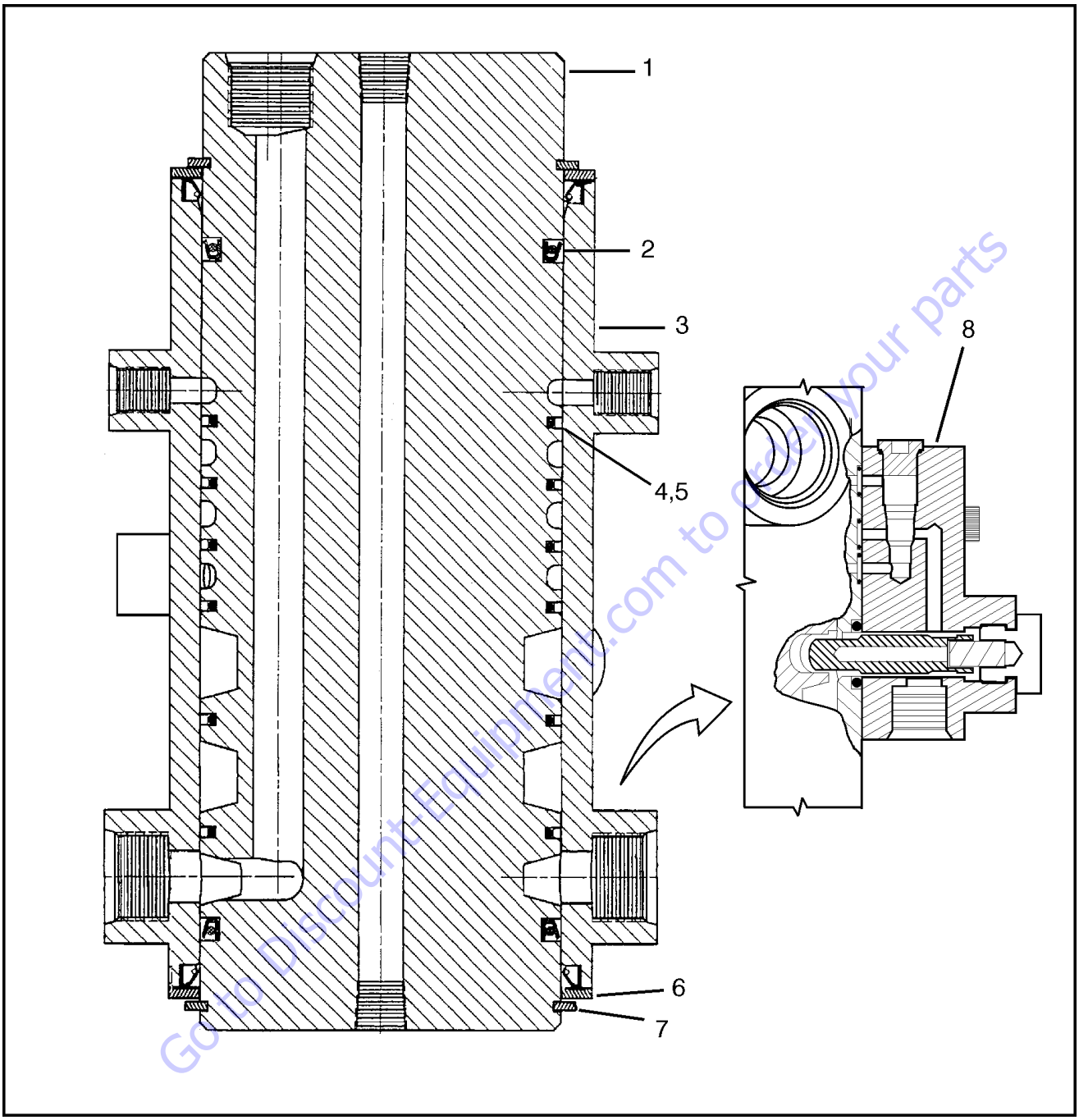


Figure 3-81. Rotary Coupling Seal Installation (Prior to SN 0300083331)



1. Center Body
2. Seal
3. Housing
4. O-ring
5. Seal
6. Thrust Ring
7. Snap Ring
8. Valve Block (Axle Oscillation)

Figure 3-82. Rotary Coupling Cutaway (Prior to SN 0300083331)

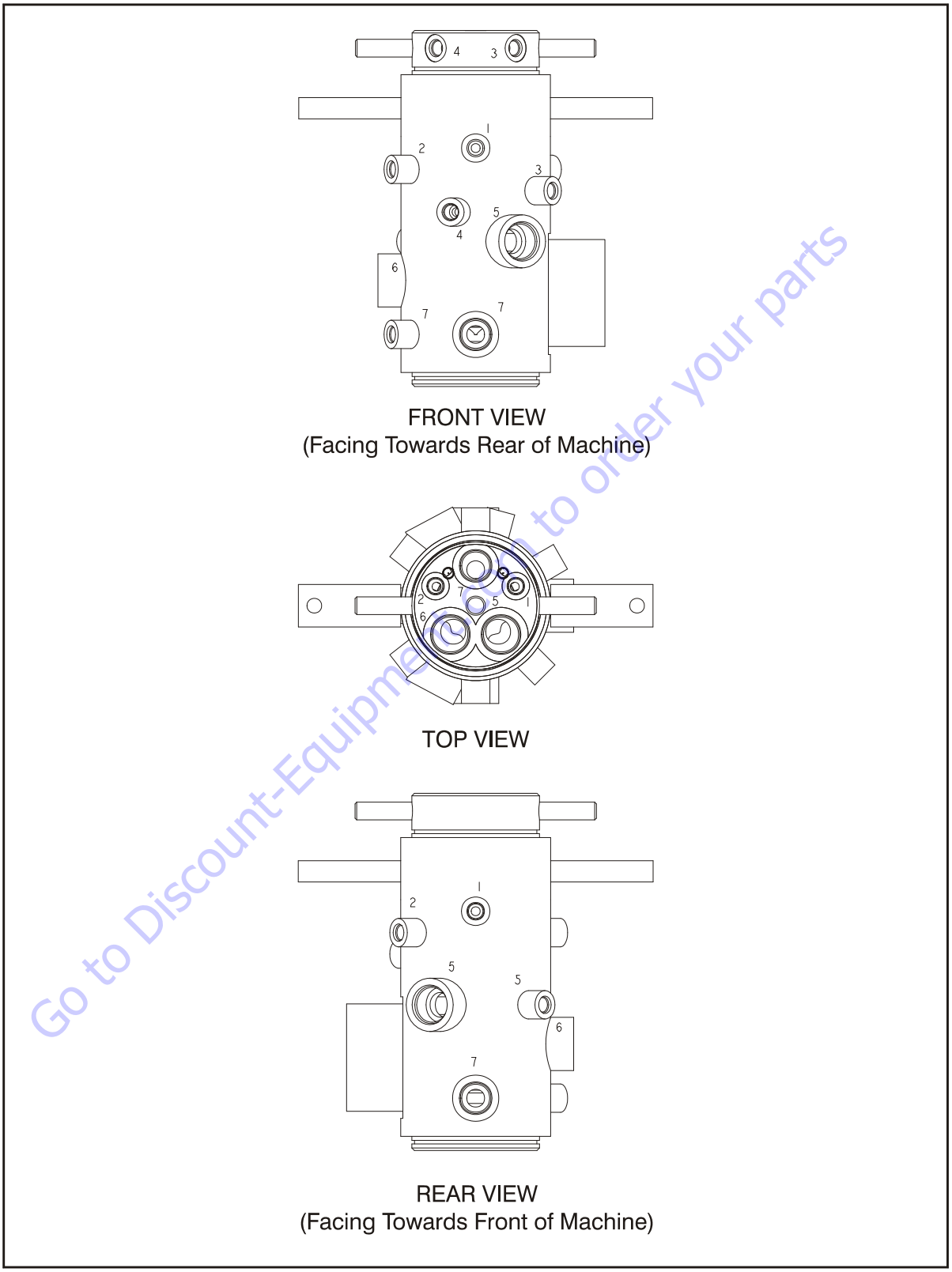
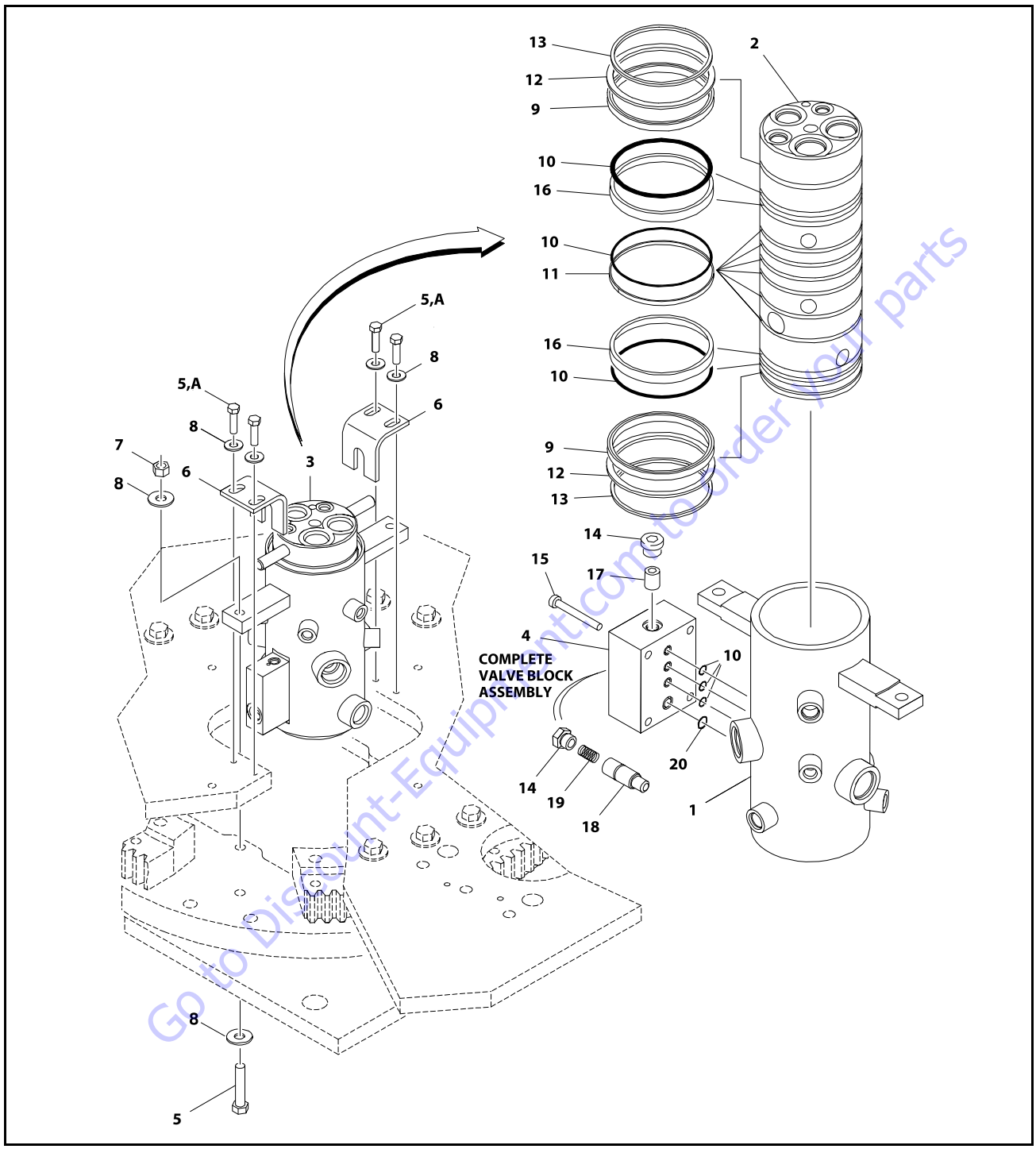


Figure 3-83. Rotary Coupling Port Location (7 Port) (Prior to SN 0300083331)



1. Housing
2. Body
3. Rotary Coupling
4. Block Valve Assembly
5. Bolt
6. Bracket
7. Locknut
8. Washer
9. Seal
10. O-ring
11. Cap Seal
12. Ring
13. Retaining Ring
14. Plug
15. Capscrew
16. Bearing
17. Check Valve
18. Plunger Valve
19. Spring
20. O-ring

A. JLG Threadlocker

Figure 3-84. Rotary Coupling Installation (Prior to SN 0300083331)

3.26 ROTARY COUPLING (SN 0300083331 THROUGH 0300182743, B300000100 THROUGH B300001091)

Use the following procedure to install the seal kit.

1. If not already removed, remove the axle oscillation valve from the cylinder barrel. The spool of the valve protrudes into the barrel and will damage the spool and seals if left in place.
2. Remove snap ring (7) from end.
3. Remove thrust ring (6) from the same end.
4. Remove center body (1) from housing (3).
5. Cut off old seals (2, 4, 5).
6. Remove proximity switch.
7. Assemble lip seals (2) in direction shown in Figure 3-81., Rotary Coupling Seal Installation (Prior to SN 0300083331).
8. Reassemble o-ring (4).
9. Heat cap seals (5) in hydraulic oil for 5 minutes at 300° F (149° C).
10. Assemble cap seals over o-rings.
11. Reinsert center body into housing (lube with hydraulic oil).
12. Replace thrust ring and snap ring.
13. Install proximity switch as shown in Figure 3-88.

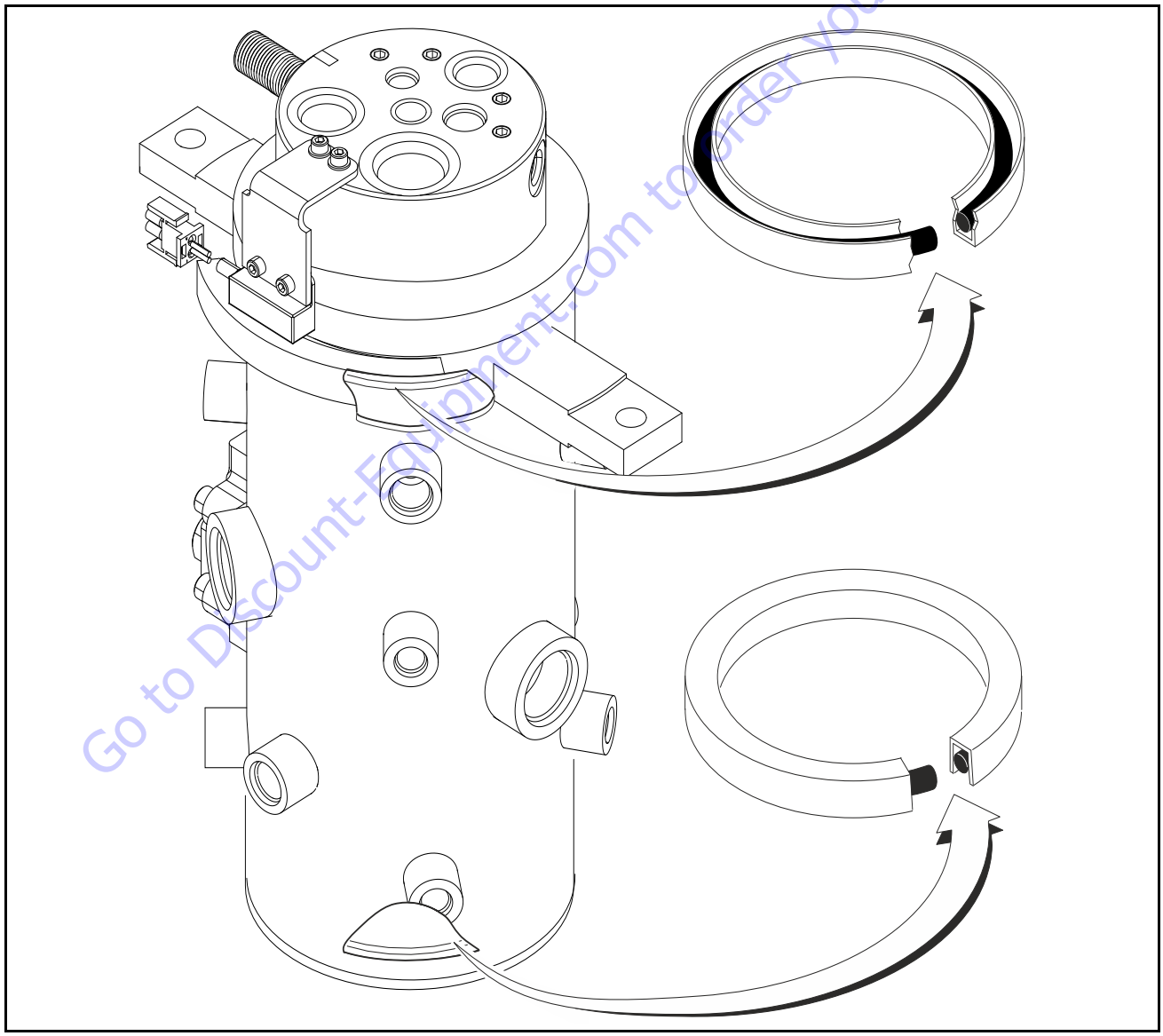
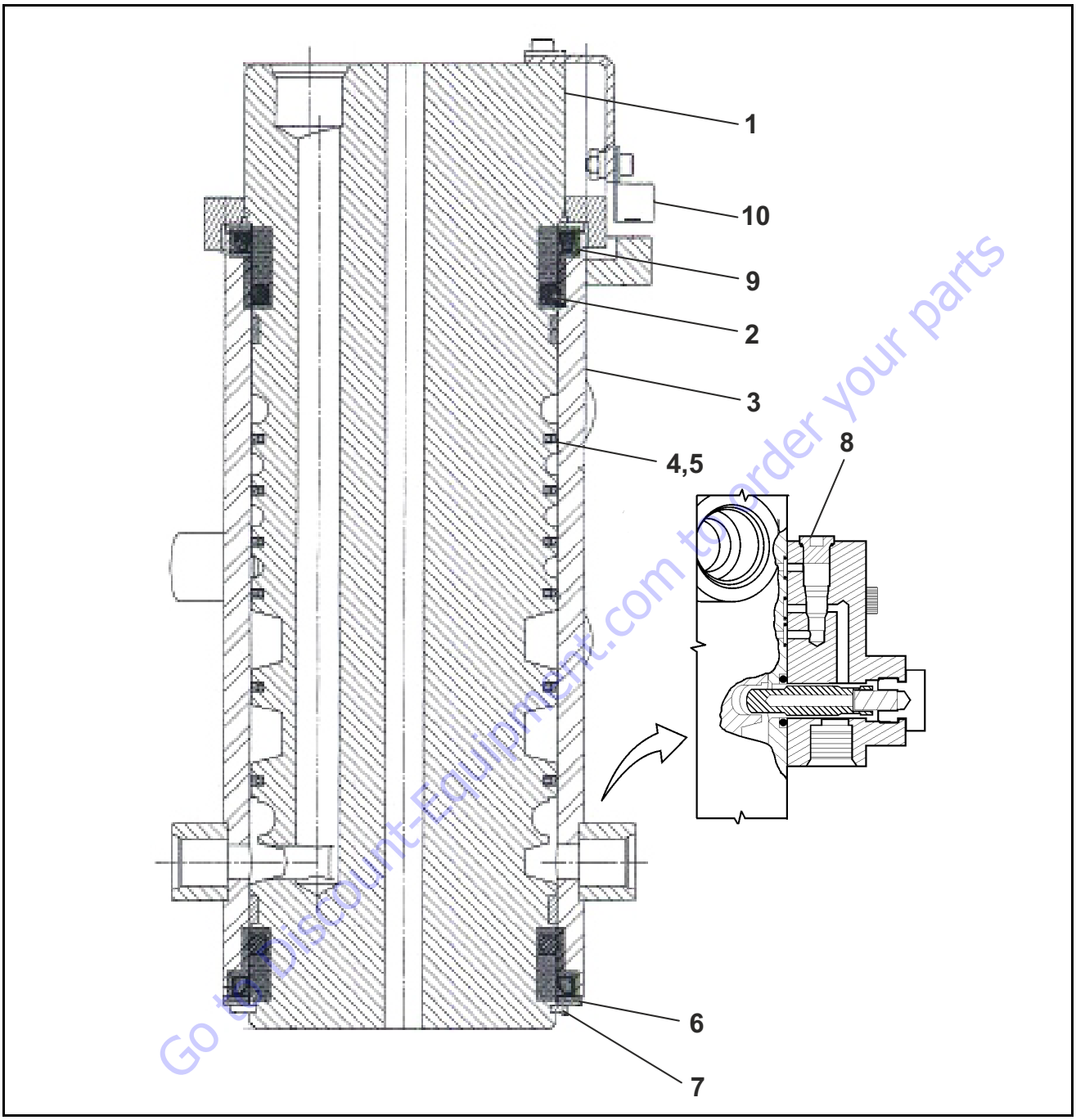


Figure 3-85. Rotary Coupling Seal Installation (SN 0300083331 through 0300182743, B300000100 through B300001091)



1. Center Body
2. Seal
3. Housing
4. O-ring
5. Seal
6. Thrust Ring
7. Snap Ring
8. Valve Block (Axle Oscillation)
9. O-ring
10. Proximity Switch

Figure 3-86. Rotary Coupling Cutaway (SN 0300083331 through 0300182743, B300000100 through B300001091)

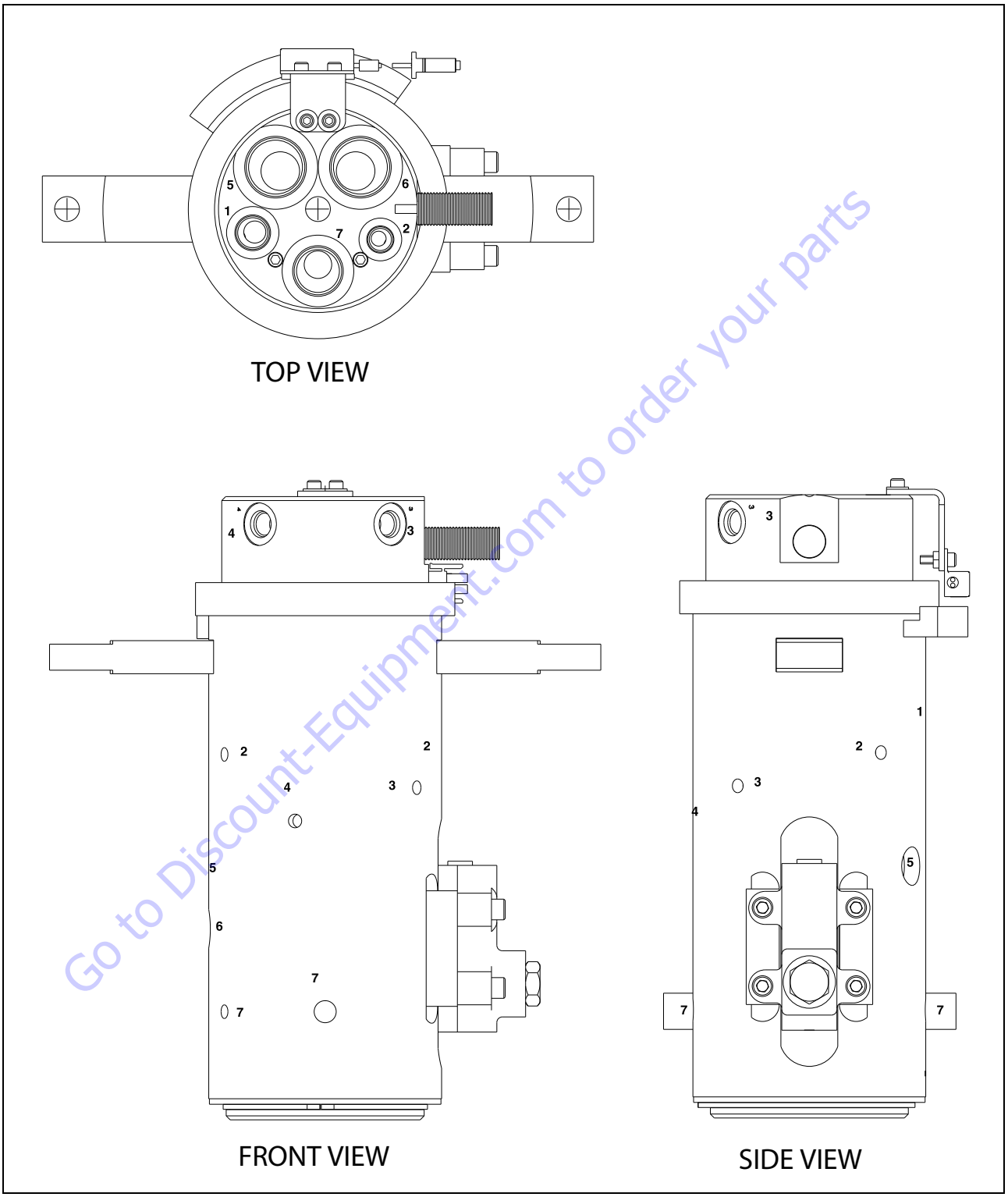
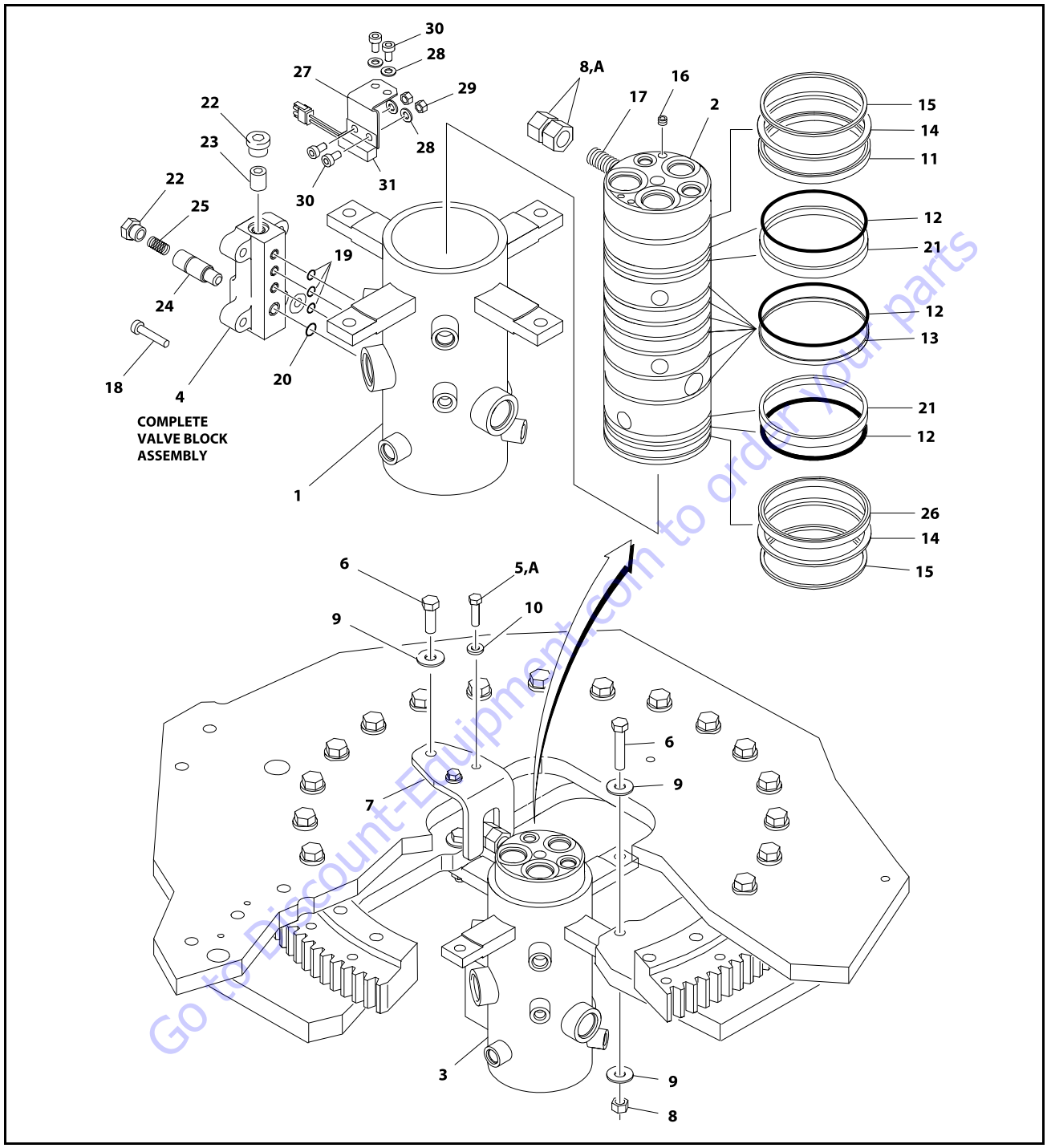


Figure 3-87. Rotary Coupling Port Location (7 Port) (SN 0300083331 through 0300182743, B300000100 through B300001091)



1. Housing
2. Body
3. Rotary Coupling
4. Block Valve Assembly
5. Bolt
6. Bolt
7. Bracket
8. Locknut
9. Washer
10. Washer
11. Seal
12. O-ring
13. Cap Seal
14. Thrust Ring
15. Retaining Ring
16. Plug
17. Torque Lug
18. Capscrew
19. O-ring
20. O-ring
21. Bearing
22. Plug
23. Check Valve
24. Plunger Valve
25. Spring
26. Seal
27. Bracket
28. Washer
29. Locknut
30. Capscrew
31. Proximity Switch

Figure 3-88. Rotary Coupling Installation (SN 0300083331 through 0300182743, B300000100 through B300001091)

Table 3-10. Coupling Port Information Table (Prior to SN 0300083331)

Port No.	Outlets	Port Size	Description	Operating Pressure PSI (Bar)	Proof Pressure PSI (Bar)
1	2	-6	Brake	400(28)	600 (41)
2	2	-6	2 Speed	4500 (310)	6750 (465)
3	1	-6	Steer	2000 (138)	3000 (207)
4	1	-6	Steer	2000 (138)	3000 (207)
5	3	2-16, 1-6	Drive Reverse	4500 (310)	6750 (465)
6	1	-16	Drive Forward	4500 (310)	6750 (465)
7	3	2-12, 1-6	Drain	250 (17)	375 (26)
P	1	4	Port	4500 (310)	6750 (465)

Table 3-11. Coupling Port Information Table (SN 0300083331 through 0300182743, B300000100 through B300001091)

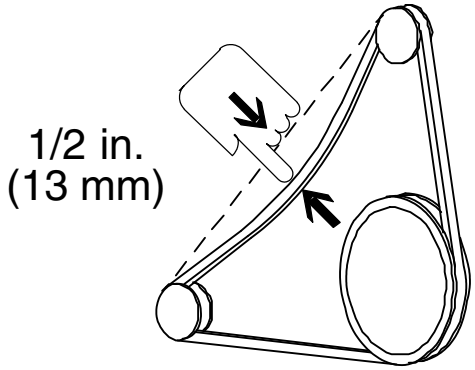
Port No.	Outlets	Port Size	Description	Operating Pressure PSI (Bar)	Proof Pressure PSI (Bar)
1	1	-8	Brake	450 (31)	675 (46)
2	2	-6	2 Speed	4500 (310)	6750 (465)
3	1	-6	Steer	2500 (172)	3750 (258)
4	1	-6	Steer	2500 (172)	3750 (258)
5	2	1-6, 1-16	Drive Reverse	4500(310)	6750(465)
6	1	-16	Drive Forward	4500 (310)	6750 (465)
7	3	2-8, 1-6	Drain	250 (17)	375 (26)

3.27 GENERATOR

Maintenance Schedule

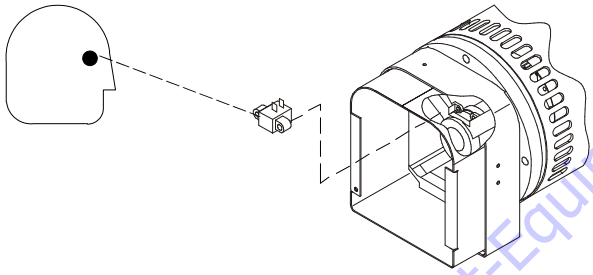
EVERY 250 HOURS

Every 250 hours of operation, check the drive belt for proper tension.

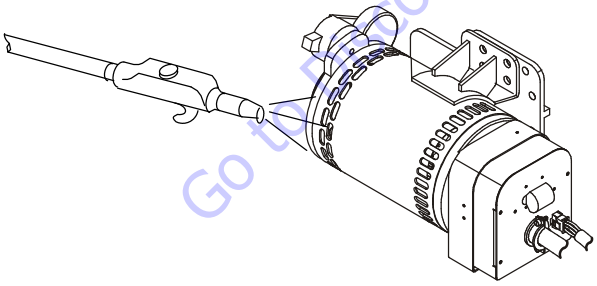


EVERY 500 HOURS

Every 500 hours of operation, service the generator brushes and slip rings. Hostile environments may require more frequent service.



Every 500 hours of service, blow out the inside of the generator. If operating in a hostile environment, clean monthly.

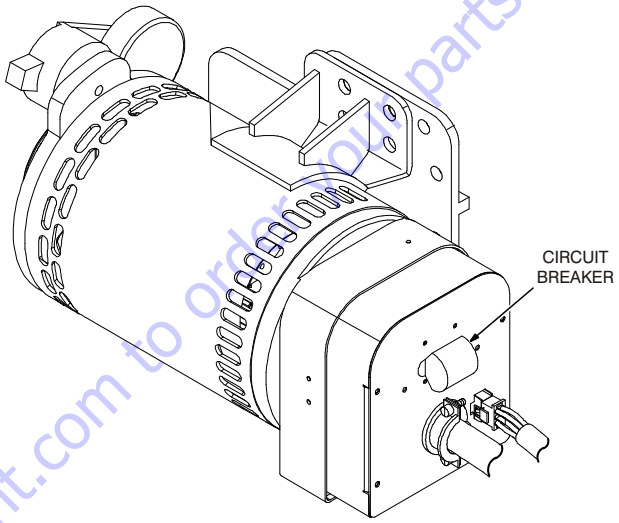


Overload Protection

⚠ CAUTION

STOP THE ENGINE WHENEVER CHECKING OR INSPECTING THE CIRCUIT BREAKER.

The circuit breaker protects the generator windings from overload. If the circuit breaker opens, generator output stops. If the circuit breaker continues to open, check for faulty equipment connected to the platform receptacles.



Inspecting Brushes, Replacing Brushes, and Cleaning Slip Rings

Refer to Figure 3-89., Inspecting Generator Brushes, Replacing Brushes, and Cleaning Slip Rings.

INSPECTING BRUSH POSITION

Inspect brush alignment with slip rings. View alignment through the air vents in the stator barrel. The brushes must ride completely on the slip rings.

INSPECTING BRUSHES

Remove the end panel. Inspect the wires. Remove the brush holder assembly. Pull the brushes from the holders.

Replace the brushes if damaged, or if the brush is at or near minimum length.

CLEANING SLIP RINGS

Visually inspect the slip rings. Under normal use, the rings turn dark brown.

If the slip rings are corroded or their surface is uneven, remove the belt to turn the shaft by hand for cleaning.

Clean the rings with 220 grit emery paper. Remove as little material as possible. If the rings are deeply pitted and do not clean up, consult generator factory service.

Reinstall the belt, brush holder assembly, and end panel.

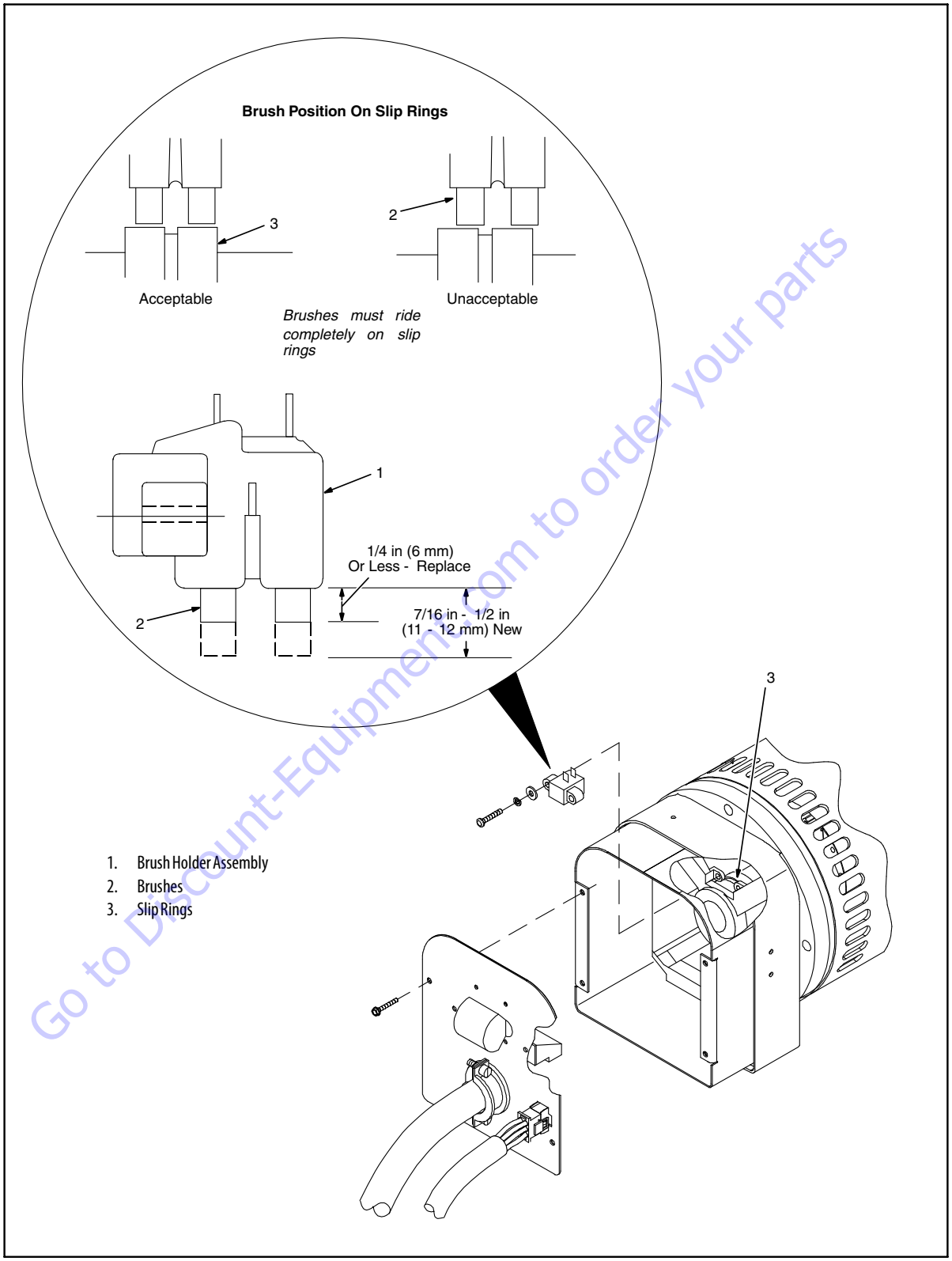


Figure 3-89. Inspecting Generator Brushes, Replacing Brushes, and Cleaning Slip Rings

Troubleshooting

Table 3-12. Troubleshooting

Trouble	Remedy
No generator output at platform AC receptacles.	Be sure generator control switch is turned on at platform.
	Check and secure electrical connections at platform, generator, and control box.
	Be sure all equipment is turned off when starting unit.
	Reset circuit breaker CB1.
	Check plug PLG3 connection and/or connections at receptacles RC3 and RC5.
	Be sure + 12 volts DC input voltage is being supplied to control box.
	Check slip rings, wiring to brushes, and brush position on slip rings. Install new brushes if necessary.
	Disconnect leads 12 and 13 from brushes, and check continuity across slip rings (nominal reading is 26 ohms). Replace generator if rotor is open.
	Disconnect stator weld leads 1, 2, and 3 from circuit breaker CB1 , and check continuity between leads. Replace generator if necessary.
	Disconnect plug PLG4 and check continuity between exciter leads 5 and 6. Replace generator if necessary.
	Check power board PC1 and connections, and replace if necessary.
	Check control board PC2 and connections, and replace if necessary.
Low generator output at platform AC receptacles.	Verify generator is running at 3600 rpm (60 Hz) or 3000 rpm (50 Hz).
	Check slip rings, wiring to brushes, and brush position on slip rings. Install new brushes if necessary.
	Disconnect leads 12 and 13 from brushes, and check continuity across slip rings nominal reading is 26 ohms). Replace generator if rotor is open.
	Disconnect stator weld leads 1, 2, and 3 from circuit breaker CB1, and check continuity between leads. Replace generator if necessary.
	Disconnect plug PLG4 and check continuity between exciter leads 5 and 6. Replace generator if necessary.
	Check power board PC1 and connections, and replace if necessary.
	Check control board PC2 and connections, and replace if necessary.
High generator output at platform AC receptacles.	Verify generator is running at 3600 rpm (60 Hz) or 3000 rpm (50 Hz).
	Check slip rings, wiring to brushes, and brush position on slip rings. Install new brushes if necessary.
	Check power board PC1 and connections, and replace if necessary.
	Check control board PC2 and connections, and replace if necessary.
Erratic generator output at platform AC receptacles.	Check and secure electrical connections at platform, generator, and control box.
	Verify generator is running at 3600 rpm (60 Hz) or 3000 rpm (50 Hz).
	Check slip rings, wiring to brushes, and brush position on slip rings. Install new brushes necessary.
	Disconnect leads 12 and 13 from brushes, and check continuity across slip rings nominal reading is 26 ohms). Replace generator if rotor is open.
	Check power board PC1 and connections, and replace if necessary.
	Check control board PC2 and connections, and replace if necessary.

3.28 FORD EFI ENGINE

Performing Diagnostics

1. Verify the complaint and determine if it is a deviation from normal operation.
2. Once the complaint has been verified, preliminary checks can be done. Conduct a thorough visual inspection, be alert for unusual sounds or odors, and gather diagnostic trouble code information.
3. Perform a system check that will verify the proper operation of the system in question and check for recent information updates.
4. If a diagnostic trouble code (DTC) is stored, contact a JLG distributor to make an effective repair.
5. If no DTC is stored, select the symptom from the symptom tables and follow the diagnostic path or suggestions to complete the repair.
6. After the repair has been made and validated for proper operation, the old part should be momentarily reinstalled to verify that it was indeed the source of the problem.

If no matching symptom is available, analyze the complaint and develop a plan for diagnostics utilizing the wiring diagrams, technical assistance, and repair history.

Intermittent conditions may be resolved by using a check sheet to pinpoint the circuit or electrical system component. Some diagnostic charts contain Diagnostic Aids which give additional information about a system. Be sure to use all of the information that is available to you.

VISUAL/PHYSICAL ENGINE INSPECTION CHECK

Perform a careful visual and physical engine inspection before performing any diagnostic procedure. Perform all necessary repairs before proceeding with additional diagnosis, this can often lead to repairing a problem without performing unnecessary steps. Use the following guidelines when performing a visual/physical inspection check:

- Inspect engine for modifications or aftermarket equipment that can contribute to the symptom; verify that all electrical and mechanical loads or accessory equipment is "OFF" or disconnected before performing diagnosis.
- Inspect engine fluids for correct levels and evidence of leaks.
- Inspect vacuum hoses for damage, leaks, cracks, kinks and improper routing, inspect intake manifold sealing surface for a possible vacuum leak.
- Inspect PCV valve for proper installation and operation.
- Inspect all wires and harnesses for proper connections and routing; bent or broken connector pins; burned, chafed, or pinched wires; and corrosion. Verify that harness grounds are clean and tight.
- Inspect engine control module (ECM), sensors, and actuators for physical damage.
- Inspect ECM grounds for cleanliness, tightness, and proper location.
- Inspect fuel system for adequate fuel level, and fuel quality (concerns such as proper octane, contamination, winter/summer blend).
- Inspect intake air system and air filter for restrictions.
- Inspect battery condition and starter current draw.

If no evidence of a problem is found after visual/physical engine check has been performed, proceed to MIL DTC retrieval procedure.

EFI Diagnostics

The EFI diagnostics are designed to assist in locating a faulty circuit or component. When a malfunction is detected by the Engine Control Module (ECM), a diagnostic trouble code (DTC) is set and will be displayed on the JLG Control System Analyzer. Refer to Section 6 - JLG Control System.

CLEARING TROUBLE CODES

To clear the trouble codes from the ECM, the electrical current running to the ECM must be shut off. To do this, disconnect the negative terminal from the battery for a period of approximately 15 minutes.

ECM and Sensors

CRANKSHAFT POSITION (CKP) SENSOR

The crankshaft position (CKP) sensor provides a signal used by the engine control module (ECM) to calculate the ignition sequence. The CKP sensor initiates the reference pulses which the ECM uses to calculate RPM and crankshaft position.

CAMSHAFT POSITION (CMP) SENSOR AND SIGNAL

The camshaft position (CMP) sensor sends a CMP signal to the ECM. The ECM uses this signal as a "sync pulse" to trigger the injectors in the proper sequence. The ECM uses the CMP signal to indicate the position of the #1 piston during its power stroke. The CMP uses a Hall Effect sensor to measure piston position. This allows the ECM to calculate true sequential fuel injection (SFI) mode of operation. If the ECM detects an incorrect CMP signal while the engine is running, DTC 53 will set. If the CMP signal is lost while the engine is running, the fuel injection system will shift to a calculated sequential fuel injection mode based on the last fuel injection pulse, and the engine will continue to nun. As long as the fault is present, the engine can be restarted. It will run in the previously established injection sequence.

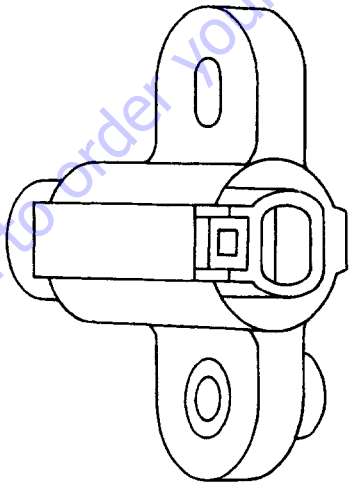


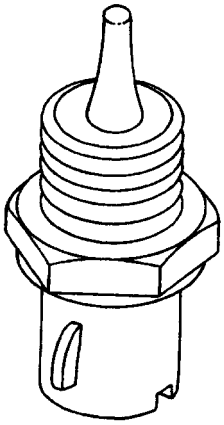
Table 3-13. ECM Diagnostic Trouble Codes

Diagnostic Trouble Code	Description
11	All Systems OK
12	Throttle Position (TP) Sensor Low Voltage
14	Manifold Absolute Pressure (MAP) Low Voltage
15	Under Minimum Map Sensor Temperature
21	Overspeed
22	Throttle Position (TP) Sensor High Voltage
23	Over maximum throttle
24	Manifold Absolute Pressure (MAP) High Voltage
25	Over Maximum Map Sensor Temperature
26	Over maximum initial Throttle Position Sensor Voltage
31	Fuel Pump Low Voltage
32	Heated Oxygen Sensor (HO2S) Low Voltage
33	Engine Coolant Temperature (ECT) Sensor High Voltage
35	Intake Air Temperature (IAT) Sensor High Voltage
41	Fuel Pump High Voltage
42	Heated Oxygen Sensor (HO2S) High Voltage
43	Engine Coolant Temperature (ECT) Sensor Low Voltage
45	Intake Air Temperature (IAT) Sensor Low Voltage
51	Low Oil Pressure
52	Crankshaft Position (CKP) Sensor Extra/Missing Pulses
53	Camshaft Position Sensor (CMP) Sensor Illegal Pattern
54	Engine Control Module (ECM) Fault Illegal Operation
55	Engine Control Module (ECM) Fault Illegal Interruption
56	Engine Control Module (ECM) Fault COP (Computer Operating Properly) Failure
61	System Voltage Low
62	System Voltage High

ENGINE COOLANT TEMPERATURE (ECT) SENSOR

The engine coolant temperature (ECT) sensor is a g thermistor (a resistor which changes value based on temperature) mounted in the engine coolant stream. Low coolant temperature produces a high resistance of 100,000 ohms at -40°C (-40°F). High temperature causes a low resistance of 70 ohms at 130°C (266°F). The ECM supplies a 5-volt signal to the ECT sensor through resistors in the ECM and measures the voltage. The signal voltage will be high when the engine is cold and low when the engine is hot. By measuring the voltage, the ECM calculates the engine coolant temperature. Engine coolant temperature affects most of the systems that the ECM controls.

After engine start-up, the temperature should rise steadily to about 85°C (185°F). it then stabilizes when the thermostat opens. If the engine has not been run for several hours (overnight), the engine coolant temperature and intake air temperature displays should be close to each other. A fault in the engine coolant sensor circuit will set DTC 33 or DTC 43.



ELECTRICALLY ERASABLE PROGRAMMABLE READ ONLY MEMORY (EEPROM)

The electrically erasable programmable read only memory (EEPROM) is a permanent memory chip that is located within the ECM. The EEPROM contains the pro-gram and the calibration information that the ECM needs to control engine operations.

If the ECM is replaced, the new ECM will need to be programmed. An IBM-compatible computer and software containing the correct program and calibration for the application are required to program the ECM.

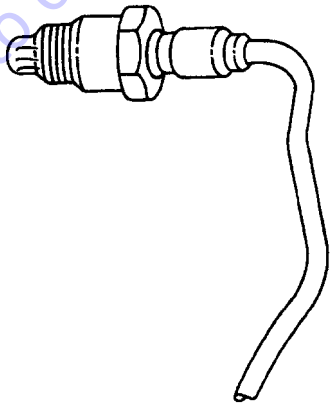
HEATED OXYGEN SENSOR

The heated oxygen sensor is mounted in the exhaust stream where it can monitor the oxygen content of the exhaust gas. The oxygen present in the exhaust gas reacts with the sensor to produce a voltage output. This voltage should constantly fluctuate from approximately 100 mV to 900 mV. The heated oxygen sensor voltage can be monitored on an IBM PC-compatible computer with diagnostic software. By monitoring the voltage out-put of the oxygen sensor, the ECM calculates the pulse width command for the injectors to produce the proper combustion chamber mixture.

Low HO2S voltage indicates a lean mixture which will result in a rich command to compensate.

High HO2S voltage indicates a rich mixture which will result in a lean command to compensate.

A constant voltage below 200 mV for 10 consecutive seconds will set OTC 32. A constant voltage above 650 mV for 10 consecutive seconds will set OTC 42.



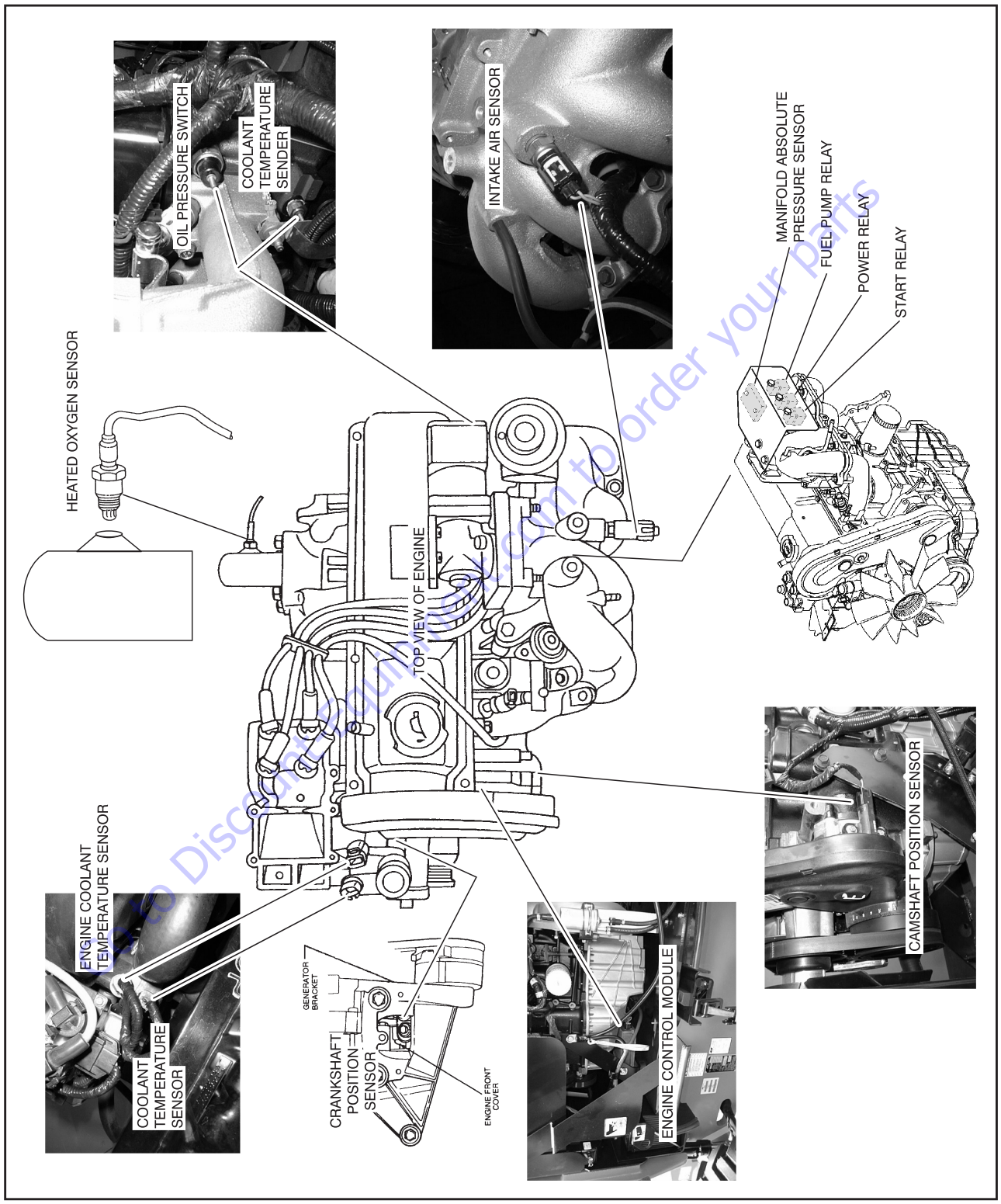
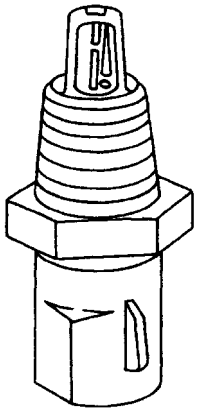


Figure 3-90. EFI Component Location

INTAKE AIR TEMPERATURE (IAT) SENSOR

The intake air temperature (IAT) sensor is a thermistor which changes its resistance based on the temperature of air entering the engine. Low temperature produces a high resistance of 100,000 ohms at -40°C (-40°F). High temperature causes a low resistance of 70 ohms at 130°C (266°F). The ECM supplies a 5-volt signal to the sensor through a resistor in the ECM and monitors the signal voltage. The signal voltage will be high when the incoming air is cold and low when the incoming air is hot. By measuring the voltage, the ECM calculates the incoming air temperature. The IAT sensor signal is used to adjust spark timing according to the incoming air density. An IBM PC-compatible computer with diagnostic soft-ware can be used to display the temperature of the air entering the engine. The temperature should read close to the ambient air temperature when the engine is cold, and rise as engine compartment temperature increases. If the engine has not been run for several hours (overnight), the IAT sensor temperature and engine coolant temperature should read close to each other. A failure in the IAT sensor circuit will set DTC 35 or DTC 45.



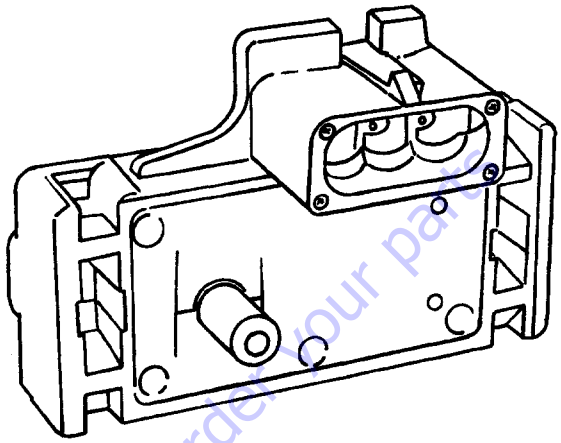
MANIFOLD ABSOLUTE PRESSURE (MAP) SENSOR

The manifold absolute pressure (MAP) sensor responds to changes in intake manifold pressure (vacuum). The MAP sensor signal voltage to the ECM varies from below 2 volts at idle (high vacuum) to above 4 volts with the ignition ON, engine not running or at wide-open throttle (low vacuum).

The MAP sensor is used to determine the following:

- Engine vacuum level for engine control purposes.
- Barometric pressure (BARO)

If the ECM detects a voltage that is significantly lower than the estimated MAP value for 2 or more consecutive seconds, DTC 14 will be set. A signal voltage significantly higher than the estimated MAP value for 2 or more consecutive seconds will set DTC 24.



ENGINE CONTROL MODULE (ECM)

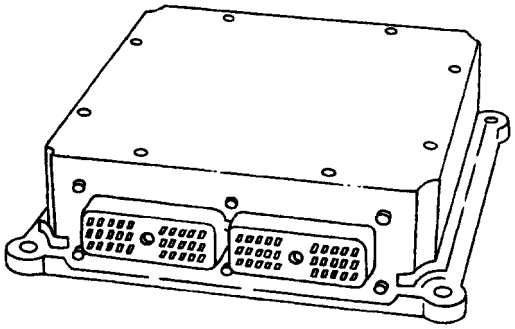
The ECM controls the following:

- Fuel metering system
- Ignition timing
- On-board diagnostics for engine functions

The ECM constantly observes the information from various sensors. The ECM controls the systems that affect engine performance. The ECM performs the diagnostic function of the system. It can recognize operational problems, alert the operator through the Malfunction Indicator Lamp (MIL), and store diagnostic trouble codes (DTCs). DTCs identify the problem areas to aid the technician in making repairs.

The ECM supplies either 5 or 12 volts to power various sensors or switches. The power is supplied through resistances in the ECM which are so huh in value that a test light will not light when connected to the circuit. In some cases, even an ordinary shop voltmeter will not give an accurate reading because its resistance is too low. Therefore, a digital voltmeter with at least 10 meg ohms input impedance is required to ensure accurate voltage readings. The ECM controls output circuits such as the fuel injectors, electronic governor, etc., by control ling the ground or the power feed circuit through transistors or other solid state devices.

The ECM is designed to maintain exhaust emission levels to government mandated standards while providing excellent operation and fuel efficiency. The ECM monitors numerous engine functions via electronic sensors such as the throttle position (TP) sensor and the heated oxygen sensor (HO2S).



ECM INPUTS/OUTPUTS

Inputs—Operating Conditions

- Engine Coolant Temperature
- Crankshaft Position
- Exhaust Oxygen Content
- Manifold Absolute Pressure
- Battery Voltage
- Throttle Position
- Fuel Pump Voltage
- Intake Air Temperature
- Camshaft Position

Outputs - System Controlled

- Fuel Control
- Idle Air Control
- Electric Fuel Pump
- Diagnostics:
  - Malfunction Indicator Lamp
  - Data Link Connector (DLC)

ECM SERVICE PRECAUTIONS

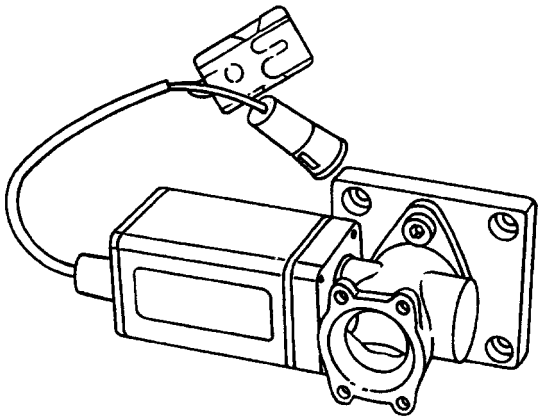
The ECM is designed to withstand normal current draws associated with engine operation. When servicing the ECM, observe the following guidelines:

- Do not overload any circuit.
- Do not probe wires for testing. This can cause a voltage drop that would be critical to the operation of the ECM.
- When testing for opens and shorts, do not ground or apply voltage to any of the ECM's circuits unless instructed to do so.
- When measuring voltages, use only a digital voltmeter with an input impedance of at least 10 megohms.
- Do not jump start with more than 12 volts. This could cause damage to the electronic components.
- Do not employ any non-standard practices such as charging the battery with an arc welder.
- Take proper precautions to avoid static damage to the ECM. Refer to "Electrostatic Discharge Damage" for more information.

THROTTLE POSITION (TP) SENSOR

The throttle position (TP) sensor is a potentiometer connected to the throttle shaft on the throttle body which is built into the electronic governor. The ECM monitors the voltage on the signal line and calculates throttle position. As the throttle valve angle is changed, the TP sensor signal also changes. At a closed throttle position, the output of the TP sensor is low. As the throttle valve opens, the output increases so that at wide open throttle (WOT), the output voltage should be above 4 volts.

The ECM calculates fuel delivery based on throttle valve angle (operator demand). A broken or loose TP sensor may cause intermittent bursts of fuel from an injector and unstable idle because the ECM thinks the throttle is moving. A hard failure in the TP sensor 5-Volt reference or signal circuits for greater than 2 consecutive seconds will set either a DTC 12 or DTC 22. A hard failure with the TP sensor ground circuit for more than two consecutive seconds may set DTC 22. If either DTC 12 or DTC 22 are set, the throttle will be forced to a 6% (idle) position.



USE OF CIRCUIT TESTING TOOLS

Do not use a test light to diagnose the engine electrical systems unless specifically instructed by the diagnostic procedures. A test light can put an excessive load on an ECM circuit and result in component damage. For volt-age measurements, use only a digital voltmeter with an input impedance of at least 10 megohms.

ELECTROSTATIC DISCHARGE DAMAGE

Electronic components used in the ECM are often designed to carry very low voltage. Electronic components are susceptible to damage caused by electrostatic discharge. Less than 100 volts of static electricity can cause damage to some electronic components. By comparison, It takes as much as 4000 volts for a person to feel the spark of a static discharge.

There are several ways for a person to become statically charged. The most common methods of charging are by friction and induction.

An example of charging by friction is a person sliding across a seat.

Charge by induction occurs when a person with well-insulated shoes stands near a highly charged object and momentarily touches ground. Charges of the same polarity are drained off, leaving the person highly charged with the opposite polarity. Static charges can cause damage, therefore it is important to-use care when handling and testing electronic components.

To prevent possible electrostatic discharge damage, follow these guidelines:

- Do not touch the ECM connector pins or soldered components on the ECM board.
- Do not open the replacement part package until the part is ready to be installed.
- Before removing the part from the package, ground the package to a known good ground on the equipment.
- If the part has been handled while sliding across a seat, while sitting down from a standing position, or while walking a distance, touch a known good ground before installing the part.

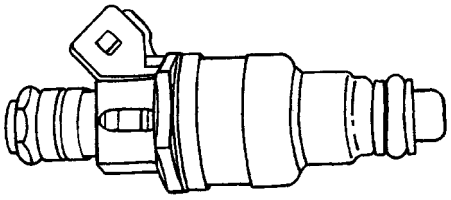
Fuel System

FUEL INJECTOR

The Electronic Fuel Injection (EFI) fuel injector is a solenoid-operated device controlled by the ECM. The ECM energizes the solenoid, which opens a valve to allow fuel delivery.

The fuel is injected under pressure in a conical spray pattern at the opening of the intake valve. Excess fuel not used by the injectors passes through the fuel pressure regulator before being returned to the fuel tank.

A fuel injector which is stuck partly open will cause a loss of fuel pressure after the engine is shut down, causing long crank times.



FUEL METERING SYSTEM COMPONENTS

The fuel metering system is made up of the following parts:

- The fuel injectors
- The fuel rail
- The fuel pressure regulator/filter assembly
- The electronic governor
- The ECM
- The crankshaft position (CKP) sensor
- The camshaft position (CMP) sensor
- The fuel pump
- The fuel pump relay

BASIC SYSTEM OPERATION

The fuel metering system starts with the fuel in the fuel tank. The fuel is drawn up to the fuel pump through a pre-filter. The electric fuel pump then delivers the fuel to the fuel rail through an inane fuel filter. The pump is designed to provide fuel at a pressure above the pressure needed by the injectors. A fuel pressure regulator in the fuel filter assembly keeps fuel available to the fuel injectors at a constant pressure. A return line delivers unused fuel back to the tank.

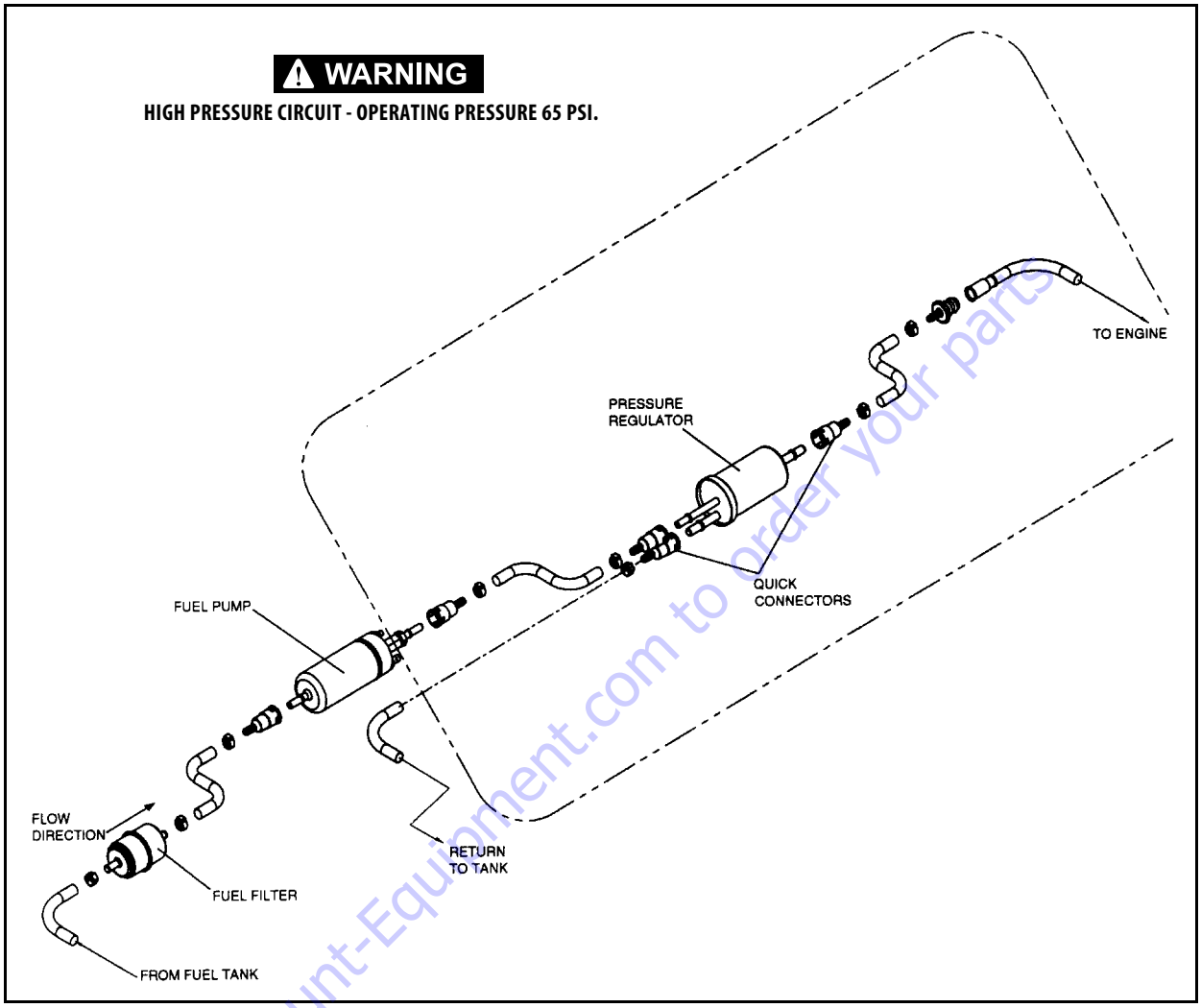


Figure 3-91. Typical Fuel System

FUEL METERING SYSTEM PURPOSE

The basic function of the air/fuel metering system is to control the air/fuel delivery to the engine. Fuel is delivered to the engine by individual fuel injectors mounted in the intake manifold near each intake valve.

The main control sensor is the heated oxygen sensor (H02S) located in the exhaust system. The H02S tells the ECM how much oxygen is in the exhaust gas. The ECM changes the air/fuel ratio to the engine by control-ling the amount of time that the fuel injector is "ON." The best mixture to minimize exhaust emissions is 14.7 parts of air to 1 part of gasoline by weight, which provides the most efficient combustion. Because of the constant measuring and adjusting of the air/fuel ratio, the fuel injection system is called a "closed loop" system.

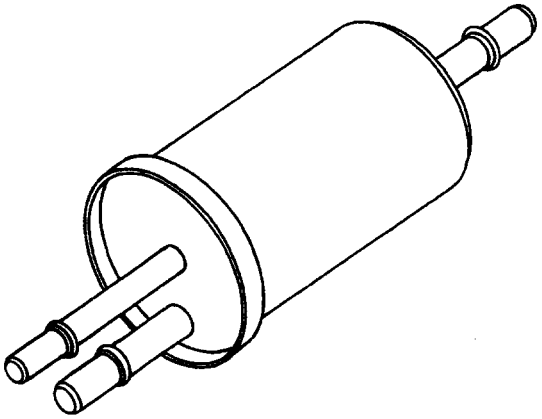
The ECM monitors signals from several sensors in order to determine the fuel needs of the engine. Fuel is delivered under one of several conditions called "modes." All modes are controlled by the ECM. Refer to "Open Loop and Closed Loop Operation" for more information.

FUEL PRESSURE REGULATOR

The fuel pressure regulator is a relief valve mounted in the fuel filter. It provides a constant fuel pressure of 441 kPa (64 psi).

If the pressure is too low, poor performance and a DTC 32 will set. If the pressure is too high, excessive odor and/or a DTC 42 will result.

When replacing the fuel filter, be sure to use an identical filter/regulator assembly. A standard fuel filter does not regulate pressure and could cause engine problems or component damage.



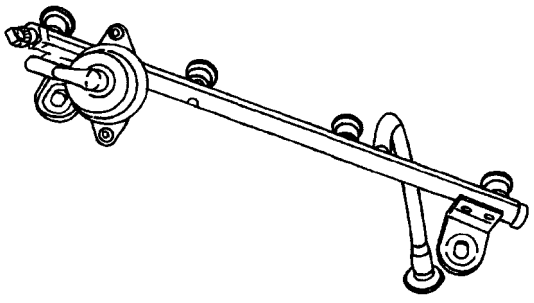
FUEL PUMP ELECTRICAL CIRCUIT

When the key is first turned "ON," the ECM energizes the fuel pump relay for two seconds to build up the fuel pressure quickly. If the engine is not started within two seconds, the ECM shuts the fuel pump off and waits until the engine is cranked. When the engine is cranked and crankshaft position signal has been detected by the SECM, the ECM supplies 12 volts to the fuel pump relay to energize the electric fuel pump.

An inoperative fuel pump will cause a "no-start" condition. A fuel pump which does not provide enough pressure will result in poor performance.

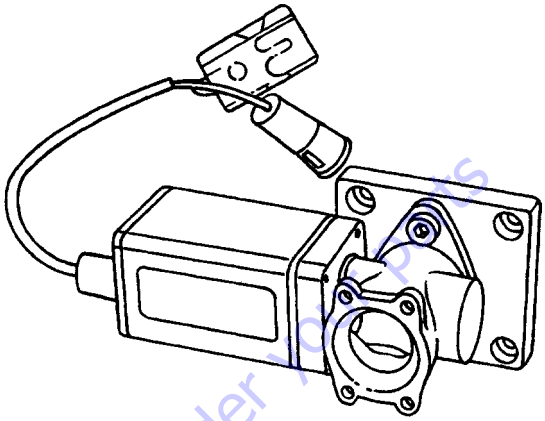
FUEL RAIL

The fuel rail is mounted to the top of the engine and distributes fuel to the individual injectors. Fuel is delivered to the fuel inlet tube of the fuel rail by the fuel lines.



ELECTRONIC GOVERNOR AND THROTTLE BODY

In the 2.5L EFI industrial engine, throttle control is achieved by using an electronic governor which is controlled by the engine control module (ECM).



The electronic governor consists of a throttle body, an electronically-actuated throttle plate, and a built-in throttle position (TP) sensor. There are two pigtails that exit the governor body. The 3-wire pigtail connects the TP sensor to the ECM. Refer to "Throttle Position (TP) Sensor" for more information.

The 2-wire pigtail carries the throttle signal from the ECM to the governor. Desired engine speeds are stored in the configuration program for each specific application, and can be changed with the ECM calibration software. When an engine speed is selected with the toggle switch, the ECM sends the appropriate signal to the governor. This is a pulse-width modulated (PWM) signal which cannot be read with conventional diagnostic tools such as a voltmeter. A 12-volt signal is pulsed on and off at a high rate of speed. The width of the "on" pulse determines the amount of throttle opening. The ECM sends a signal with the appropriate pulse width to the governor based on the operator's choice of switch settings.

The electronic governor also acts as an idle air control (IAC) valve. Changes in engine load are detected by the ECM by comparing manifold absolute pressure (MAP) with throttle position. When the ECM detects a change in engine load, it can adjust idle speed by changing the PWM signal to the governor.

OPEN LOOP AND CLOSED LOOP OPERATION

The ECM will operate in the following two modes:

- Open loop
- Closed loop

When the engine is first started, the system is in "open loop" operation. In open loop, the ECM ignores the signal from the heated oxygen sensor (HO2S). it uses a pre-programmed routine to calculate the air/fuel ratio based on inputs from the TP, ECT, and MAP sensors.

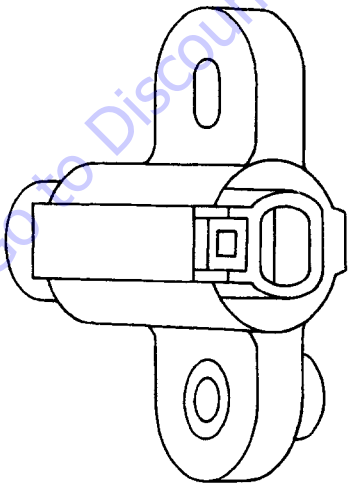
The system remains in open loop until the following conditions are met:

- The HO2S has a varying voltage output showing that it is hot enough to operate properly (this depends on temperature).
- The ECT has reached 160°F (71°C).
- Seven minutes has elapsed since starting the engine.

After these conditions are met, the engine is said to be operating in "closed loop." In closed loop, The ECM continuously adjusts the air/fuel ratio by responding to signals from the HO2S (except at wide-open throttle). When the HO2S reports a lean condition (low sensor signal voltage), the ECM responds by increasing the "on" time of the fuel injectors, thus enriching the mixture. When the HO2S reports a rich condition (high sensor signal Voltages the ECM responds by reducing the "on" time of the fuel injectors, thus leaning out the mixture.

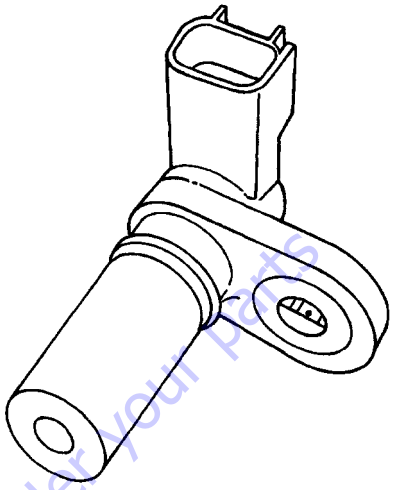
CAMSHAFT POSITION (CMP) SENSOR

The CMP sensor uses a variable reactor sensor to detect camshaft position. The CMP signal is created as piston #1 is a predetermined number of degrees after top dead center on the power stroke.



CRANKSHAFT POSITION (CKP) SENSOR

The crankshaft position (CKP) sensor provides a signal used by the engine control module (ECM) to calculate the ignition sequence. The sensor initiates the reference pulses which the ECM uses to calculate RPM and crank-shaft position.



ELECTRONIC IGNITION

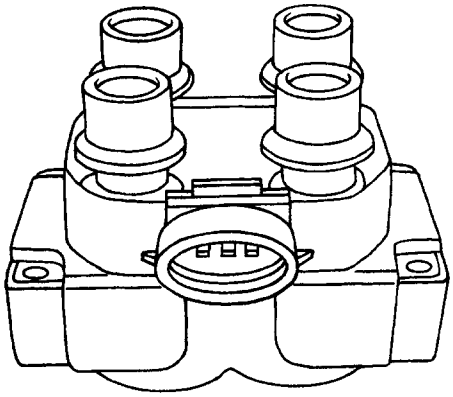
The electronic ignition system controls fuel combustion by providing a spark to ignite the compressed air/fuel w mixture at the correct time. To provide optimum engine performance, fuel economy, and control of exhaust emissions, the ECM controls the spark advance of the ignition system. Electronic ignition has the following advantages over a mechanical distributor system:

- No moving parts
- Less maintenance
- Remote mounting capability
- No mechanical load on the engine
- More coil cooldown time between firing events
- Elimination of mechanical timing adjustments
- Increased available ignition coil saturation time

IGNITION COIL

The electronic ignition system uses a coil pack with one ignition coil for each two cylinders in the engine. Each cylinder is paired with its opposing cylinder in the firing order, so that one cylinder on compression fires simultaneously with the opposing cylinder on exhaust. The spark that occurs in the cylinder on the exhaust stroke is referred to as a "waste spark."

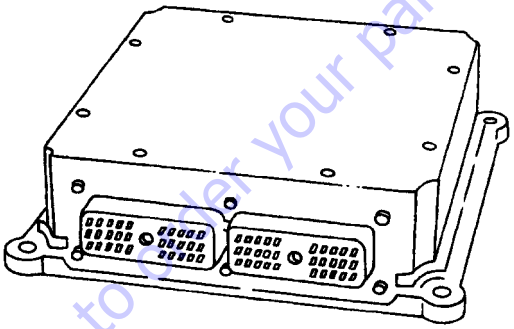
The primary coils in the coil pack are triggered by the "Ignition Coil Feed #1" and "Ignition Coil Feed #2" Signals from the ECM.



ENGINE CONTROL MODULE (ECM)

The ECM is responsible for maintaining proper spark and fuel injection timing for all operating conditions. To provide optimum operation and emissions, the ECM monitors the input signals from the following components in order to calculate spark timing:

- Engine coolant temperature (ECT) sensor
- Intake air temperature (IAT) sensor
- Throttle position sensor
- Crankshaft position sensor



3.29 DEUTZ EMR 2

The EMR2 consists of the sensors, the control unit and the actuator. Engine-side controls as well as the JLG Control System are connected by means of separate cable harnesses to the EMR control unit.

The sensors attached to the engine provide the electronics in the control unit with all the relevant physical parameters In accordance with the information of the current condition of the engine and the preconditions (throttle position etc.), the EMR2 controls an actuator that operates the control rod of the injection pump and thus doses the fuel quantity in accordance with the performance requirements.

The exact position of the regulating rod is reported back and, if necessary, is corrected, by means of the control rod travel sensor, situated together with the rotation magnets in a housing of the actuator.

The EMR2 is equipped with safety devices and measures in the hardware and software in order to ensure emergency running (Limp home) functions.

In order to switch the engine off, the EMR2 is switched in a de-energized fashion over the ignition switch. A strong spring in the actuator presses the control rod in the de-energized condition into the zero position. As a redundancy measure, an additional solenoid serves for switching off and this, independently of the actuator, also moves the control rod in the de-energized condition into the zero position.

After the programming, that is carried out over the ISO9141 interface, the EMR2 possesses a motor-specific data set and this is then fixedly assigned to the engine. Included in this are the various application cases as well as the customer's wishes regarding a particular scope of function.

Each EMR2 module is matched by serial number to the engine. Modules cannot be swapped between engines.

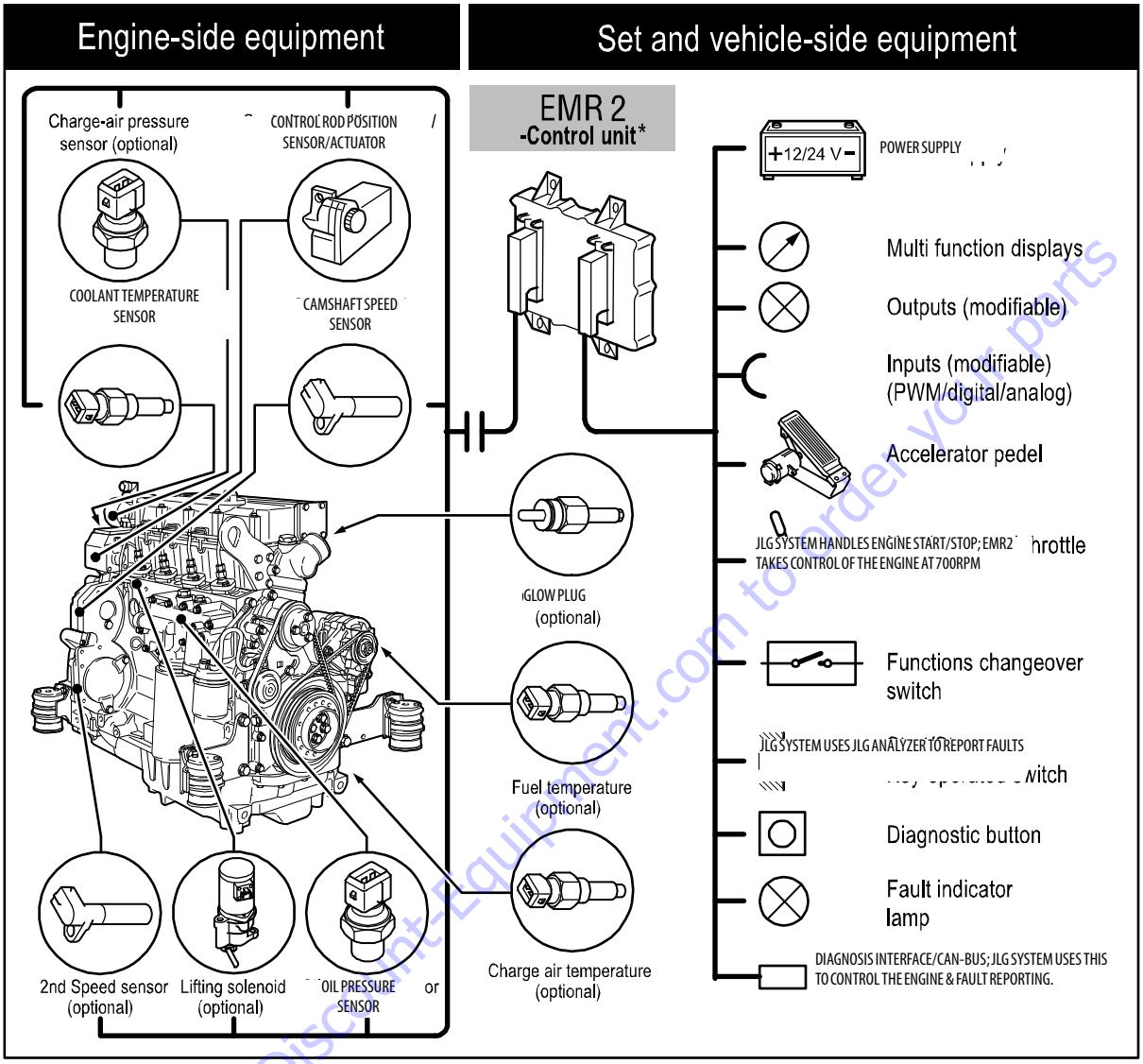


Figure 3-92. EMR 2 Engine Side Equipment

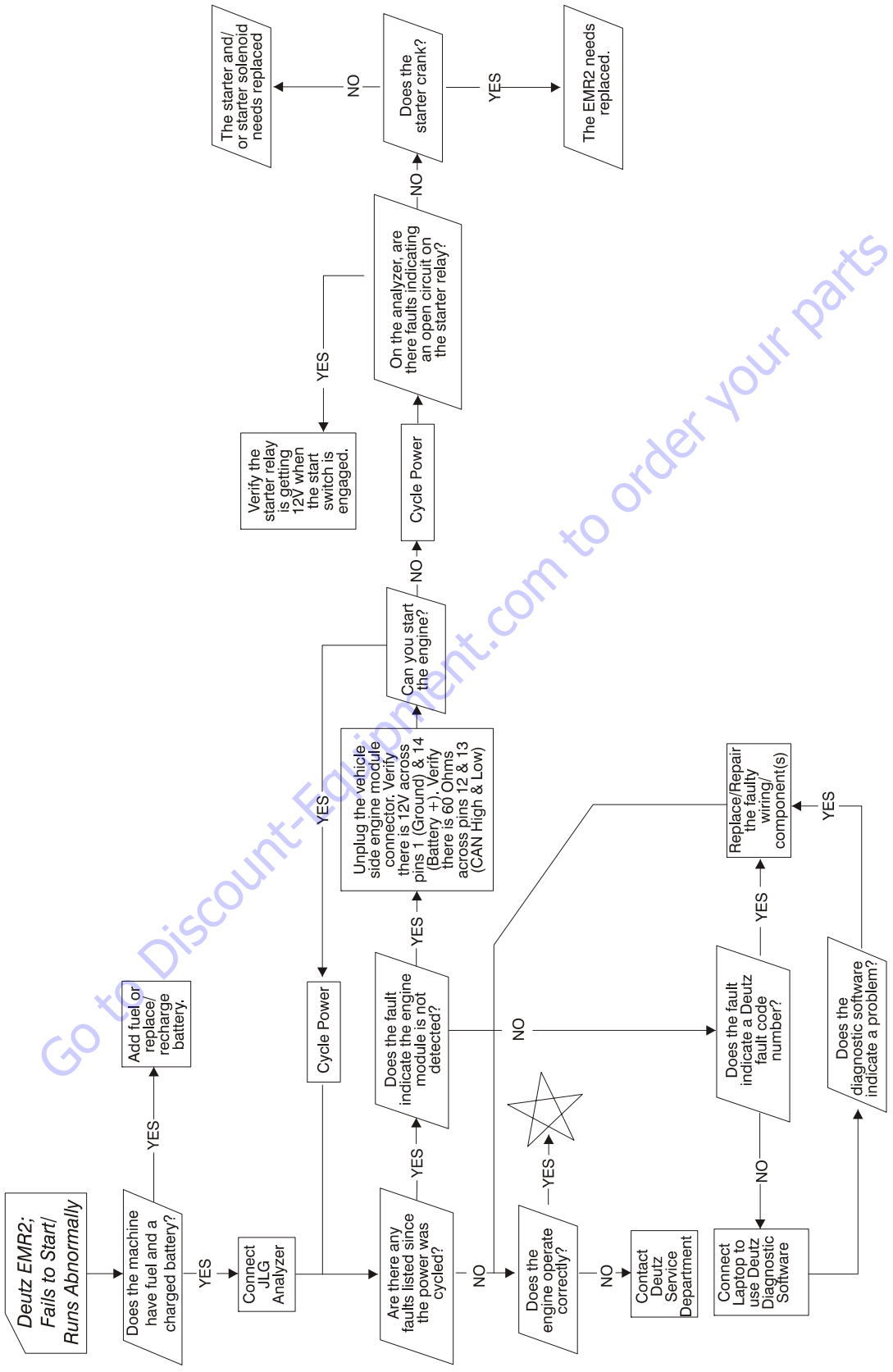


Figure 3-93. Deutz EMR 2 Troubleshooting Flow Chart

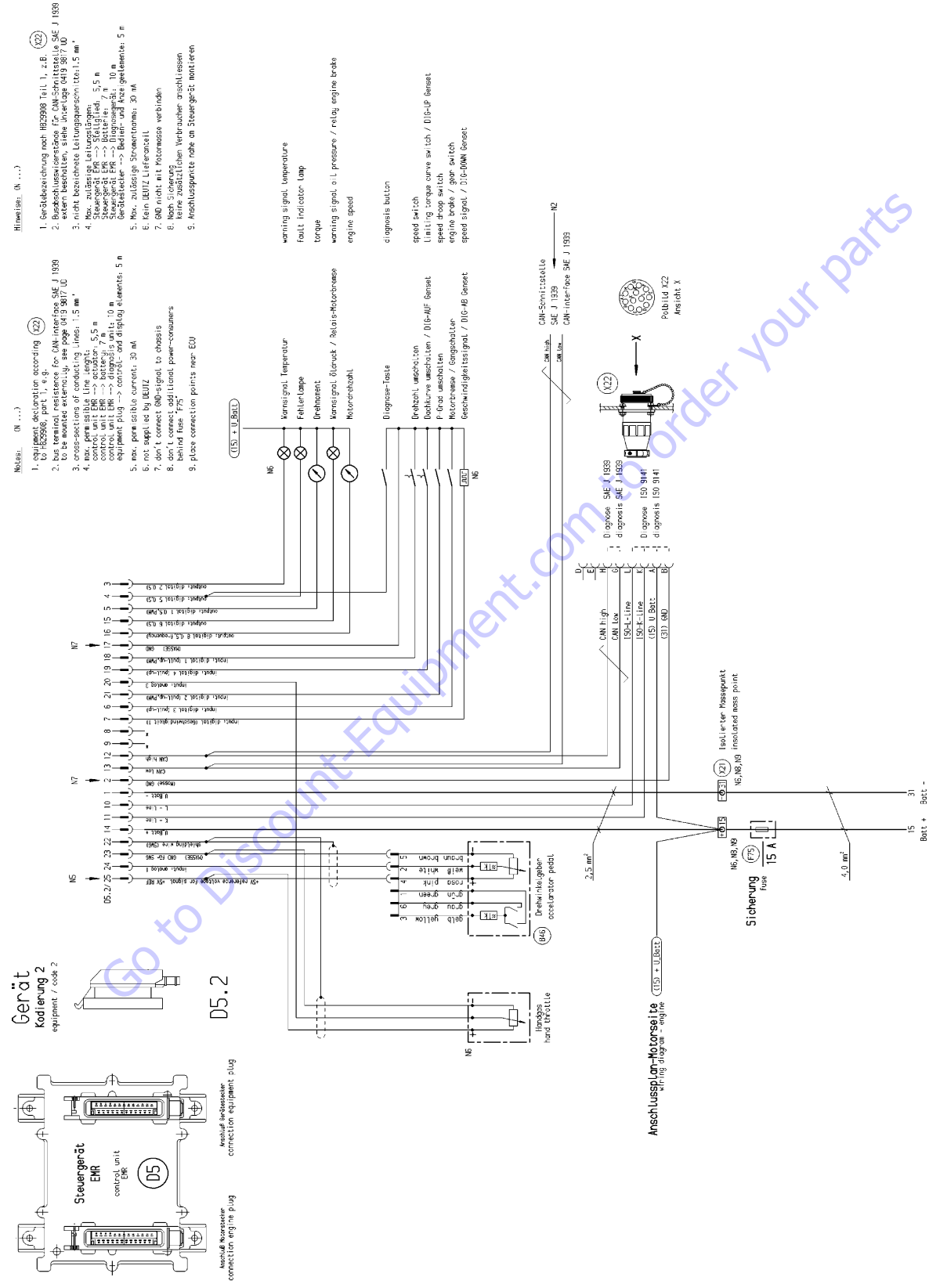


Figure 3-94. Deutz EMR 2 Vehicle Side Connection Diagram

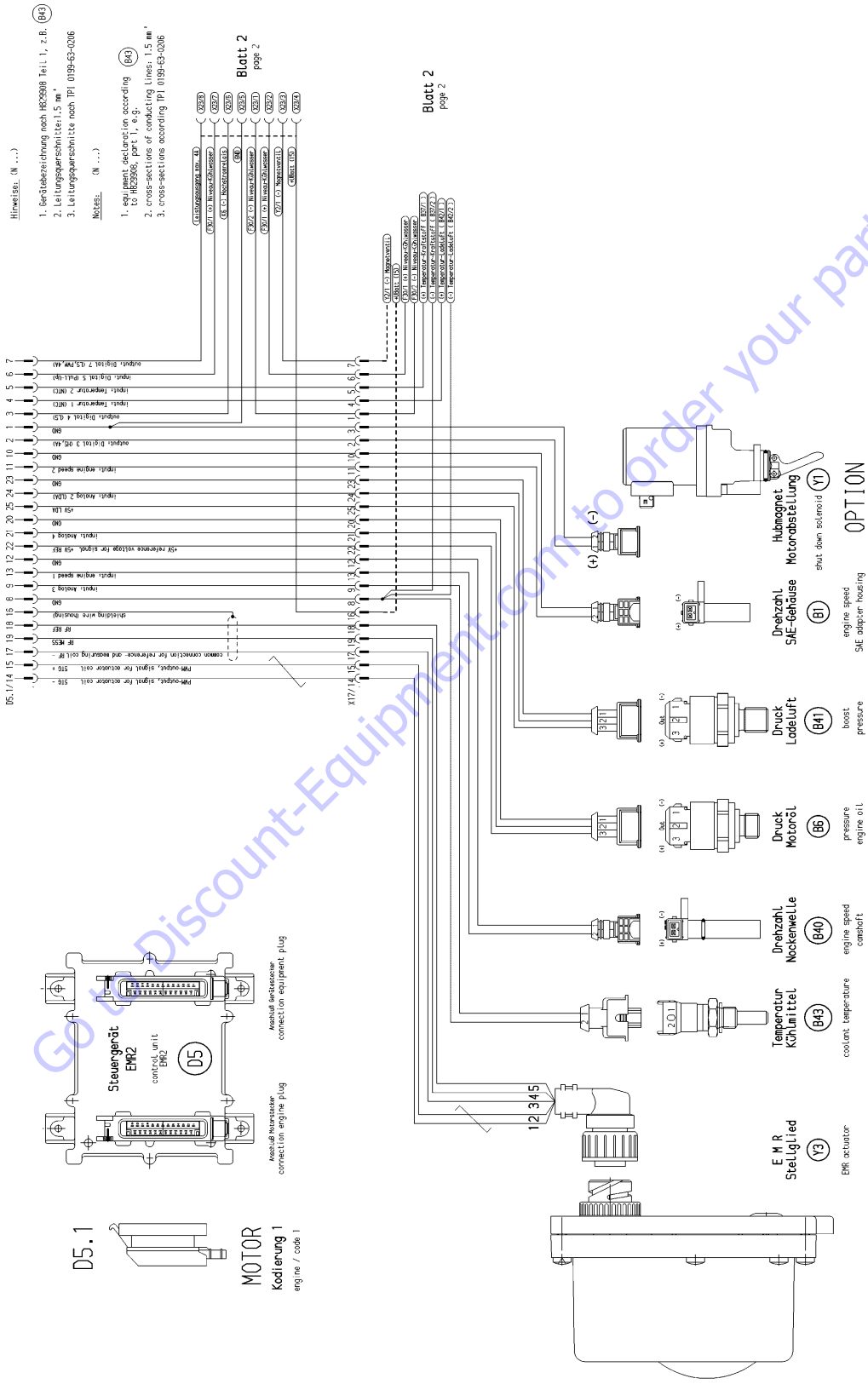


Figure 3-95. Deutz EMR 2 Engine Side Connection Diagram - Sheet 1 of 2

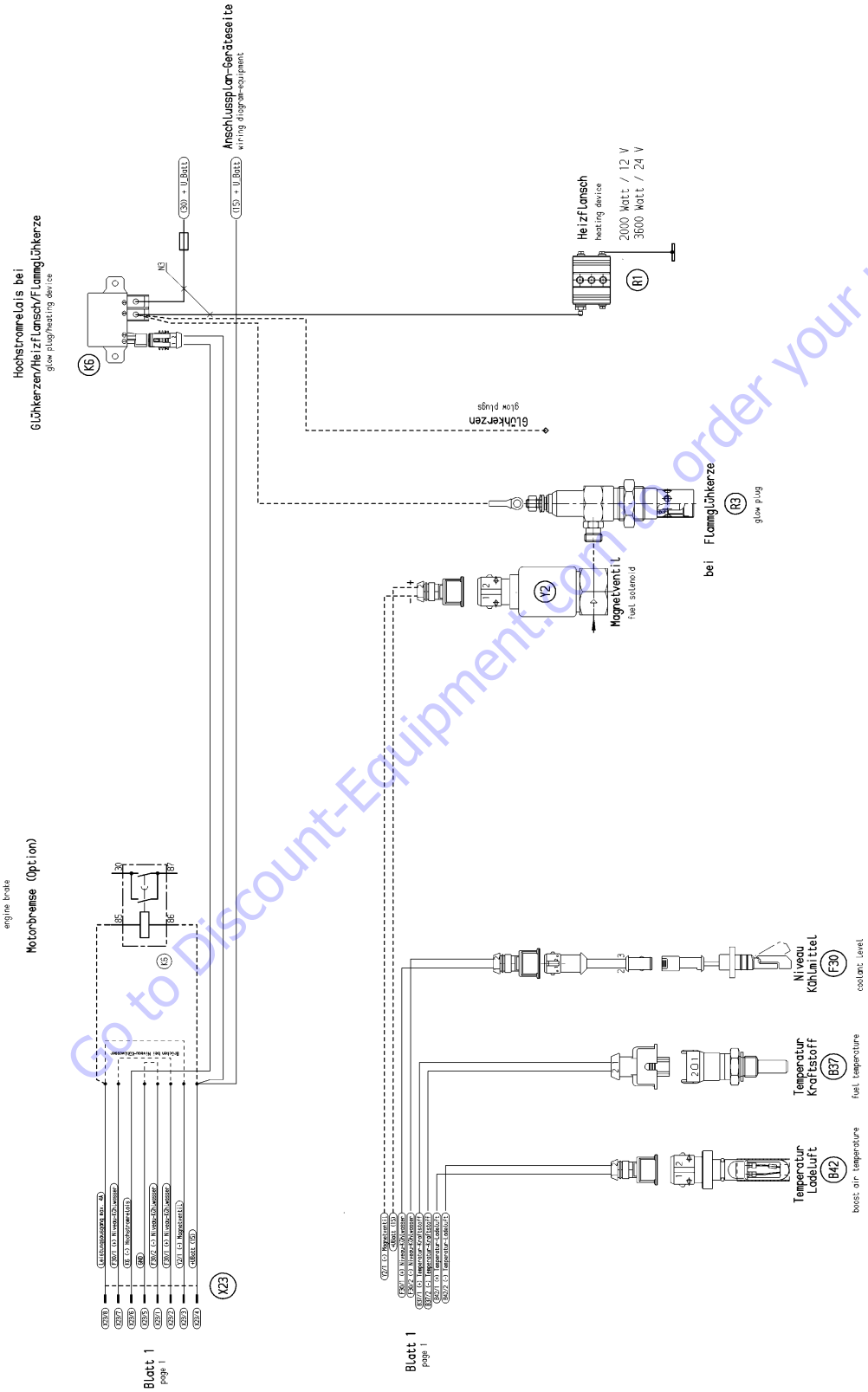
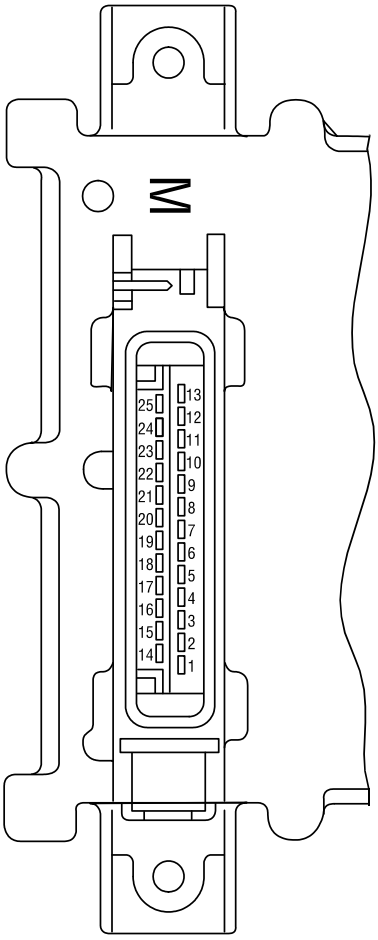


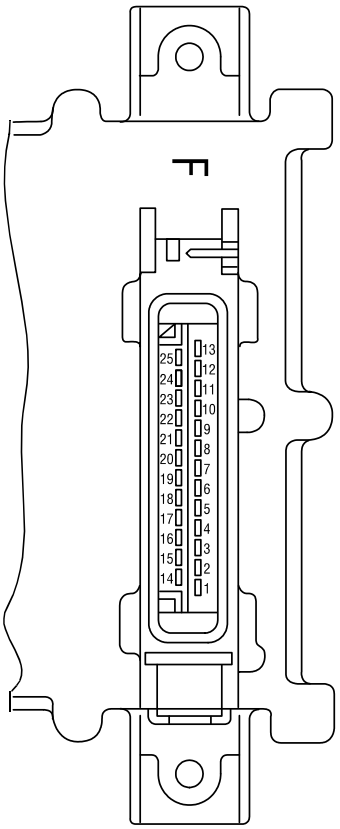
Figure 3-96. Deutz EMR 2 Engine Side Connection Diagram - Sheet 2 of 2



Pin No.	Designation	Description
1	Reserve	Reserve
2	Output: digital 3	Digital output for solenoid [1)]
3	Output: digital 4	For heating flange (optional)/ glow plug (optional)
4	Input (optional) Temp 1	Fuel temperature [2)]
5	Input (optional) Temp 2	Charge air temperature
6	Input (optional) DigIn 5	Coolant level / oil level
7	Output: PWM2/digital 6	
8	GND	Reference potential for analog signal at pin 9
9	Input: analog 7	Analog input for Coolant temperature sensor (NTC)
10	GND	Reference potential for analog signal at pin 11
11	Multi-function input: speed 2/DigIn 2	Digital input second engine speed (crankshaft) (optional) and speed signal (optional)
12	GND	Reference potential for analog signal at pin 13
13	Input: speed 1	Digital input first engine speed (camshaft)
14	STG -	PWM output, signal for actuator coil
15	STG +	PWM output, signal for actuator coil
16	Screen	Screening regulating rod travel sensor (for lines 17, 18, 19)
17	RF -	General connection for reference and measuring coil
18	RF REF	Analog input, reference signal of the reference coil
19	RF MESS	Analog input, measuring signal of the measuring coil
20	GND	Reference potential for signal at pin 21
21	Input: analog 4/digital 9	Analog input 4 (sensor signal oil pressure sensor) or digital input 9
22	+5 V REF	+5 V Reference voltage for signal at pin 21 (max. 15 mA)
23	GND	Reference potential for signal at pin 24
24	Input: analog 2/digital 7	Analog input 2 (sensor signal charge air) or digital input 7
25	+5 V LDA	+5 V Reference potential for signal at pin 24 (max. 15 mA)

1) For continuous power: < 4 A
2) Corresponds to special function”fuel temperature compensation at the EMR (0211 2571)

Figure 3-97. EMR 2 Engine Plug Pin Identification



Pin-No.	Designation	Description
1	U Batt -	Negative pole at battery (clamp 31)
2	GND	Reference potential for signal
3	Output: digital 2	PWM or digital output, various functions
4	Input / output: DigInOut	Fault lamp and diagnostic button
5	Output: PWM 1/Dig 1	PWM or digital output, various functions
6	Multi-function input: DigIn 3	Genset applications/gear shift/motor brake
7	Input: digital 10/velocity	Speed signal (tacho input)
8	NC	Not occupied
9	NC	Not occupied
10	L-line	Serial ISO 9141 interface
11	K-line	Serial ISO 9141 interface
12	CAN high	Interface for CAN-Bus
13	CAN low	Interface for CAN-Bus
14	U Batt +	Positive pole for battery (clamp 15)
15	Output: digital 5	Digital output, various functions
16	Output: digital 7/Frequency	Frequency, PWM or digital output, various functions
17	Ground	Reference potential for signal at pins 18, 19 and 21
18	Input: digital 1 / PWM 1	PWM 1 or digital input 1, various functions
19	Multi-function input: DigIn 4	Performance curve switching/genset applications
20	Multi-function input: digital 8 / analog 3	Hand hand throttle/genset applications, Digital (8) or analog input (3)
21	Input: digital 2 / PWM 2	PWM 2 or digital input 2, various functions
22	Screen	Screening (e.g. for lines hand throttle or PWG)
23	GND	Reference potential for signal at pin 24
24	Input: analog 1 / digital 6	Analog input 1 (pedal value sensor, PWG) or digital input 6
25	+5 V REF	+5 V Reference voltage for signal at pin 24

Figure 3-98. EMR 2 Vehicle Plug Pin Identification

Fault group	Fault no. (in SERDIA)	Fault locality/ Fault description	SPN	FMI	Cause	Remarks	Help
Zero error display	-	No faults	524287	31	No **active** faults present		
Revolutions / speed acquisition	01	Speed sensor 1	190	8	Sensor failure. Distance from gear too far. Additional fault impulses. Cable joint interrupted.	Governor in emergency operation (if sensor 2 available). Emergency switch-off (if sensor 2 not available or failed).	Check distance. Check cable connection. Check sensor and replace if required.
						Governor in emergency operation (with sensor 1) Emergency switch-off (if sensor 1 not available or failed).	
	03	Speed sensor	84	8	Tacho failed. Additional fault impulses. Cable connection interrupted.	Governor in emergency operation.	Check cable connection and Tacho. Replace if required.
	04	Excess speed switch-off	190	0	Speed was/is in excess of limit.e.	Engine stop.	Check parameter (21). Check speed settings.
					Check PID setting. Check rods. Check actuator and replace if required. Check cable to actuator (impulse on incorrect speed). Check No. of teeth. For vehicles check for possible thrust mode.		
Sensors	07	Charge air pressure	102	2	Fault at corresponding sensor entry (e.g. short circuit or cable break).	With failure of the sensor, the associated monitoring function is de-activated.	Check sensor cable. Check sensor and replace if required. Check fault limits for sensor.
	08	Oil pressure	100	2			
	09	Coolant temperature	110	2			
	10	Charge air temperature	105	2			
	11	Fuel temperature	174	2			

NOTE: SID is equal to 512. To get SPN #, add 512 + number. For example, SID 254 would be 512+254 or an SPN of 766.

Figure 3-99. EMR2 Fault Codes - Sheet 1 of 5

Fault group	Fault no. (in SERDIA)	Fault locality/ Fault description	SPN	FMI	Cause	Remarks	Help
Functional fault warning	30	Oil pressure warning	100	1	Oil pressure below speed-dependent warning line characteristic	Fault message (disappears when oil pressure is again above recovery limit). After a delay time - fill limitation.	Check engine (oil level, oil pump). Check oil pressure sensor and cable. Check oil pressure warning line characteristic.
	31	Coolant temperature warning	110	0	Coolant temperature has exceeded warning level.	Fault message (disappears when coolant temperature again drops below recovery level). After a delay time - fill limitation.	Check coolant. Check coolant temperature sensor and cable.
	32	Charge air temperature warning	105	0	Charge air temperature has exceeded warning level.	Fault message (disappears when charge air temperature gain drops below recovery level). After a delay time - fill limitation.	Check charge air. Check charge air-temperature sensor and cable.
	34	Coolant level warning	111	1	Switch input “Low coolant level” is active.	Fault message.	Check coolant level. Check coolant level sensor and cable.
	35	Speed warning (with thrust mode operation).	SID 190	14	revolutions was/is above (top) revolution speed limit. “Thrust mode” function is active.		Check parameters. Check speed settings.
					Check PID setting. Check rods. Check actuator and replace if required. Check cable to actuator. Check speed sensor (impulses on incorrect speed). Check No. of teeth. For vehicles check for possible thrust mode.		
	36	Fuel temperature warning	174	0	Fuel-temperature has exceeded warning level.	Fault message (disappears when fuel temperature again drops below recovery level).	Check fuel. Check fuel temperature sensor and cable.

NOTE: SID is equal to 512. To get SPN #, add 512 + number. For example, SID 254 would be 512+254 or an SPN of 766.

Figure 3-100. EMR2 Fault Codes - Sheet 2 of 5

Fault group	Fault no. (in SERDIA)	Fault locality/ Fault description	SPN	FMI	Cause	Remarks	Help
Functional fault, switch-off	42	Charge air temperature switch-off	105	0	Charge air temperature has exceeded switch-off limit.	Emergency stop	Check charge air. Check charge air-temperature sensor and cable. Check switch-off limit.
	44	Coolant level switch-off	111	1	Switch input “Low coolant level” is active.	Emergency stop. Start lock.	Check coolant level. Check coolant level sensor and cable.
Actuator	50	Feedback	SID 24	12	Actuator not connected. Fault in actuator confirmation.	Emergency switch-off. Actuator cannot be operated.	Check actuator, replace if required. Check cable, check fault limits for “Confirmation”.
	52	Reference feedback	SID 24	13			Check actuator, replace if required. Check cable, check fault limits for “Rifeness confirmation”.
	53	Control travel difference	SID 23	7	Injection pump/actuator jammed or not connected. Difference between nominal/actual control travel is > 10 % of the overall control path.	Fault message (disappears when difference is < 10 %).	Check actuator/actuator rods / injection pump, replace if required. Check actuator cable.
	59	Auto calibration BOSCH-EDC pumps faulty operation	SID 23	13	No automatic actuator equalization possible. Incorrect input of the actuator reference values.	Engine stop / start lock. Governor cannot be taken into use. EDC actuator calibration required.	Check actuator and replaced if required. Check feedback cable. Check fault limits and reference values of the feedback. Program the fault limits for feedback, save values. Switch ignition off and on again.Check again. If faulty, inform DEUTZ-Service and carry out automatic equalization again. Set fault limits again.

NOTE: SID is equal to 512. To get SPN #, add 512 + number. For example, SID 254 would be 512+254 or an SPN of 766.

Figure 3-101. EMR2 Fault Codes - Sheet 3 of 5

Fault group	Fault no. (in SERDIA)	Fault locality/ Fault description	SPN	FMI	Cause	Remarks	Help
Hardware inputs/ outputs	60	Digital output 3 (Switch-off solenoid, pin M 2)	SID 51	2	Fault (short circuit / cable break) at digital output.	Driver level is switched off.	Check cable of digital output (cable break or short circuit).
	62	Digital output 6, pin M 7	SID 60	2		Fault message.	
	63	Excess voltage switch-off solenoid	SID 51	6			
	67	Error Hand Setp1	91	11			
	68	Error CAN Setp1	898	2			
Communi-cation	70	CAN-Bus controller	SID 231	12	CAN-controller for CAN-bus is faulty. Fault removal despite re-initialising continuously not possible	Application-dependent.	Check CAN connection, terminating resistor (see Chapter 12.4), Check control unit.
	71	CAN interface SAE J 1939	SID 231	9	Overflow in input buffer or a transmission cannot be placed on the bus.		
	74	Cable break, short circuit or bus-error	SID 231	14			Check CAN connection, cable connection. Check sensor and replace if required.
Memory	76	Parameter programming (write EEPROM)	SID 253	12	Fault in parameter programming in the governor fixed value memory.	Emergency switch-off. engine cannot be started.	Switch ignition off and on again. Check again. If faulty inform DEUTZ Service
	77	Cyclic program test	SID 240	12	Constant monitoring of program memory shows error (so-called “Flash-test”).		
	78	Cyclic RAM test	SID 254	2	Constant monitoring of working memory shows error.		Note values of parameters (3895 and 3896). Switch ignition off and on again. Check again. If faulty inform DEUTZ Service.

NOTE: SID is equal to 512. To get SPN #, add 512 + number. For example, SID 254 would be 512+254 or an SPN of 766.

Figure 3-102. EMR2 Fault Codes - Sheet 4 of 5

Fault group	Fault no. (in SERDIA)	Fault locality/ Fault description	SPN	FMI	Cause	Remarks	Help
Control unit hardware	80	Power supply (Actuator)	SID 254	2	Power supply for actuator not in the permissible range.	Fault message (disappears when power again in the normal range).	Switch ignition off and on again. Check again. If faulty inform DEUTZ Service.
	83	Reference voltage 1	SID 254	2	Reference voltage for actuator not in the permissible range.	Fault message (disappears when power again in the normal range). Auxiliary value 5 V	Check voltage supply. Switch ignition off and on again. Check again. If faulty inform DEUTZ Service.
	84	Reference voltage 2	SID 254	2			
	85	Reference voltage 4	SID 254	2			
	86	Internal temperature	171	12	Internal temperature for control unit not in permissible range.	Fault message (disappears when power again in the normal range).	Switch ignition off and on again. Check again. If faulty inform DEUTZ Service.
	87	Atmospheric pressure	108	12	Atmospheric pressure not in permissible range.	Fault message (disappears when power again in normal range). Atmospheric pressure monitoring function de-activated.	
Program logic	90	Parameter fault (EEPROM retrieval or checksum faulty).	SID 253	2	No data found or checksum of data is faulty (note: fault only occurs during setting of parameter / saving or reset.).	Engine cannot be started.	Check data for correct settings. Save parameters. Switch ignition off and on again. Check again. If faulty inform DEUTZ Service.
	93	Stack overflow	SID 240	2	Internal calculation fault (so-called “Stack overflow” fault).	Emergency switch-off. Engine cannot be started.	Note parameters (3897 and 3898). Switch ignition off and on again. Check again. If faulty inform DEUTZ Service.
	94	Internal fault	SID 254	2			

NOTE: SID is equal to 512. To get SPN #, add 512 + number. For example, SID 254 would be 512+254 or an SPN of 766.

Figure 3-103. EMR2 Fault Codes - Sheet 5 of 5

3.30 GM ENGINE GENERAL MAINTENANCE

Maintenance of the Drive Belt

The serpentine drive belt utilizes a spring loaded tensioner which keeps the belt properly adjusted. The drive belt is an integral part of the cooling and charging systems and should be inspected frequently.

When inspecting the belts check for:

- Cracks or breaks
- Chunking of the belt
- Splits
- Material hanging from the belt
- Glazing and hardening
- Damaged or improperly aligned pulleys
- Improperly performing tensioner

Check the belt tensioner by pressing down on the midway point of the longest stretch between pulleys. The belt should not depress beyond 1/2 in. (13mm). If the depression is more than allowable adjust the tension.

NOTICE

THE ENGINE MANUFACTURER DOES NOT RECOMMEND THE USE OF "BELT DRESSING" OR "ANTI SLIPPING AGENTS" ON THE DRIVE BELT.

Engine Electrical System Maintenance

The engine electrical system incorporates computers and microprocessors to control the engine ignition, fuel control, and emissions. Due to the sensitivity of the computers to good electrical connections periodic inspection of the electrical wiring is necessary. When inspecting the electrical system use the following:

- Check and clean the battery terminal connections and insure the connections are tight
- Check the battery for any cracks or damage to the case
- Check the Positive and Negative battery cables for any corrosion build up, rubbing or chafing, check connection on the chassis to insure they are tight
- Check the entire engine wire harness for rubbing chafing, cuts or damaged connections, repair if necessary
- Check all wire harness connectors to insure they are fully seated and locked
- Check ignition coil and spark plug cables for hardening, cracking, chafing, separation, split boot covers and proper fit
- Replace spark plugs at the proper intervals as prescribed in the engine manufacturer's manual
- Check to make sure all electrical components are fitted securely
- Check the ground and platform control stations to insure all warning indicator lights are functioning

Checking/Filling Engine Oil Level

NOTICE

AN OVERFILLED CRANKCASE (OIL LEVEL OVER THE SPECIFIED FULL MARK) CAN CAUSE AN OIL LEAK, A FLUCTUATION OR DROP IN THE OIL PRESSURE, AND ROCKER ARM "CLATTER" IN THE ENGINE.

NOTICE

CARE MUST BE TAKEN WHEN CHECKING THE ENGINE OIL LEVEL. OIL LEVEL MUST BE MAINTAINED BETWEEN THE "ADD" MARK AND "FULL" MARK ON THE DIPSTICK.

To ensure that you are not getting a false reading, make sure the following steps are taken to before check the oil level.

1. Stop the engine if in use.
2. Allow sufficient time (approximately 5 minutes) for the oil to drain back into the oil pan.
3. Remove the dipstick. Wipe with a clean cloth or paper towel and reinstall. Push the dipstick all the way into the dipstick tube.
4. Remove the dipstick and note the oil level.
5. Oil level must be between the "FULL" and "ADD" marks.

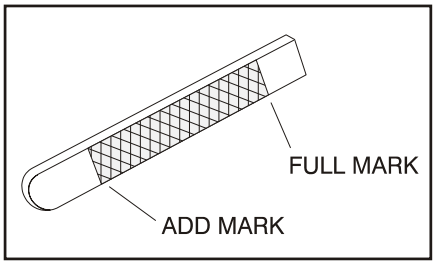


Figure 3-104. Engine Oil Dip Stick

6. If the oil level is below the "ADD" mark, proceed to Step 7 and 8 and reinstall the dipstick into the dipstick tube.
7. Remove the oil filter cap from the valve rocker arm cover.
8. Add the required amount of oil to bring the level up to but not over "FULL" mark on the dipstick.
9. Reinstall the oil fill cap to the valve rocker cover and wipe away any excess oil.

Changing The Engine Oil

NOTICE

WHEN CHANGING THE OIL, ALWAYS CHANGE THE OIL FILTER. CHANGE OIL WHEN THE ENGINE IS WARM FROM OPERATION AS THE OILS WILL FLOW FREELY AND CARRY AWAY MORE IMPURITIES.

To change the oil use the following steps:

1. Start the engine and run until it reaches normal operating temperature.
2. Stop the engine.
3. Remove the drain plug and allow the oil to drain.
4. Remove and discard the oil filter and its sealing ring.
5. Coat the sealing ring on the filter with clean engine oil and wipe the sealing surface on the filter mounting surface to remove any dust, dirt and debris. Tighten the filter securely (follow the filter manufacturers instructions). Do not over tighten.
6. Check the sealing ring on drain plug for any damage, replace if necessary, wipe the plug with a clean rag, and wipe the sealing surface on the pan and reinstall the pan plug. Do not over tighten.
7. Fill the crankcase with oil.
8. Start the engine and check for oil leaks.
9. Stop the engine and check the oil level to insure the oil level is at "FULL".
10. Dispose of the oil and filter in a safe manner.

Coolant Fill Procedure - Dual Fuel Engine

NOTICE

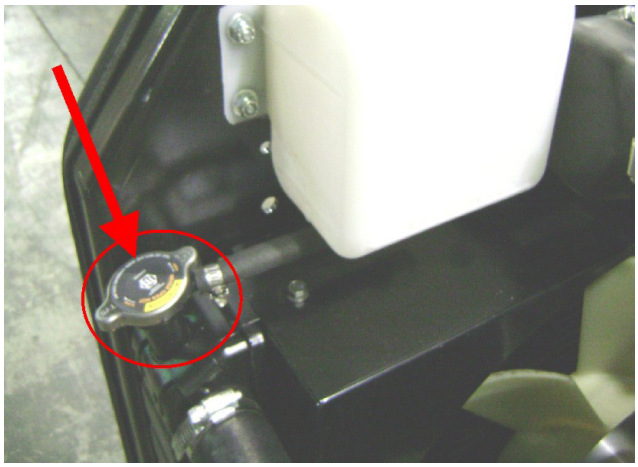
DAMAGE TO THE ENGINE COULD OCCUR IF NOT PROPERLY FILLED WITH COOLANT. LPG FUELED ENGINES ARE MOST PRONE TO CREATING AN AIR LOCK DURING A COOLANT FILL OPERATION DUE TO THE ELECTRONIC PRESSURE REGULATOR (EPR) BEING THE HIGHEST POINT IN THE COOLING SYSTEM. AN EPR THAT APPEARS TO HAVE FROST FORMING ON IT IS A SIGN THAT THE ENGINE COOLING SYSTEM CONTAINS AIR. THE APPEARANCE AND TEMPERATURE OF THE EPR SHOULD BE MONITORED DURING THE COOLANT FILL OPERATION. A WARM EPR IS AN INDICATION THAT THE COOLING SYSTEM IS PROPERLY FILLED AND FUNCTIONING.

⚠ CAUTION

MAKE SURE ENGINE IS COOL BEFORE PERFORMING ANY MAINTENANCE WORK.

1. Loosen the worm gear clamp on the coolant line running into the EPR as shown below and remove the hose from the EPR. Place a rag under the hose to prevent coolant from running onto the engine/machine.

2. Remove the radiator cap. Fill the radiator with coolant until coolant starts to appear from the previously removed hose at the EPR. Reinstall the hose back onto the EPR and continue to fill radiator with coolant.



3. With the radiator cap still removed, start the engine and run until the thermostat opens. The thermostat opens at 170° F (77° C), which can be checked using the JLG handheld analyzer.

NOTICE

WHILE ENGINE IS RUNNING, AIR AND/OR STEAM MAY BE PRESENT COMING FROM THE RADIATOR. THIS IS NORMAL.

4. After running the engine for 5 minutes after it has reached operating temperature, shut the engine off and continue to step 5.

⚠ CAUTION

WITH THE ENGINE RUNNING OR WHEN SHUTTING OFF THE ENGINE, SOME HEATED COOLANT MAY SPILL OUT DUE TO AIR "BURPING" OUT OF THE SYSTEM WITH THE RADIATOR CAP OFF.

5. Next, verify that the 2 coolant hoses on the EPR are warm. If they are not warm repeat step 3 and 4, otherwise continue to step 6.

NOTICE

A PROPERLY PURGED COOLING SYSTEM WILL YIELD A WARM UPPER RADIATOR HOSE AND A WARM EPR HOSE. IF THE UPPER RADIATOR HOSE AND/OR EPR HOSE ARE NOT WARM TO THE TOUCH AFTER THE ENGINE HAS RUN FOR 5-8 MINUTES AFTER REACHING OPERATING TEMPERATURE, THE SYSTEM MAY STILL CONTAIN AIR. IT MAY BE NECESSARY TO REPEAT THE ABOVE STEPS.

6. Fill radiator with coolant as needed and install the radiator cap. Next, remove the cap off the coolant recovery bottle and fill just below the HOT FULL line and reinstall the caps.

3.31 GM ENGINE DUAL FUEL SYSTEM

The Dual Fuel system allows the operator to operate the vehicle on either gasoline or LPG by positioning a selector switch in the operator's platform. When the operator places the selector switch in the gasoline mode the gasoline fuel pump is energized. While in the gasoline mode the LPG fuel lock-off is isolated and will not energize. In addition the gasoline injector circuit is enabled and injector pulses are provided to each injector and the ECM calibration for gasoline is also enabled. When the operator selects the LPG mode the Low Pressure LPG lock-off is energized and fuel from the LPG tank flows to the Electronic Pressure Regulator (EPR). The EPR receives an electronic signal to position the secondary lever for the start or run positions and when the engine begins to crank the mixer air valve will rise and fuel will begin flowing to engine. During this mode the gasoline fuel pump is isolated and will not be activated. The primary components of the gasoline dual fuel system are the gasoline tank, electric fuel pump and filter, fuel supply line, injector rail and injectors and the fuel pressure regulator. The primary components of the LPG dual fuel system are the LPG fuel tank, in-fuel filter, LPG Low Pressure lock-off, Electronic Pressure Regulator (EPR) and the fuel mixer module. The LPG fuel system operates at pressures which range from 14.0 in. (355.60 mm) of water column up to 312 psi (21.5 BAR).

Components which are shared by both systems include the Electronic Throttle Control and the ECM. The ECM contains a dual calibration; one controls the gasoline fuel system during gasoline operation and one controls the LPG fuel system during LPG operation.

Fuel Filter

Propane fuel like all other motor fuels is subject to contamination from outside sources. Refueling of the equipment's tank and removal of the tank from the equipment can inadvertently introduce dirt and other foreign matter into the fuel system. It is therefore necessary to filter the fuel prior to entering the fuel system components downstream of the tank. An inline fuel filter has been installed in the fuel system to remove the dirt and foreign matter from the fuel. The inline filter is replaceable as a unit only. Maintenance of the filter is critical to proper operation of the fuel system and should be replaced as Section 1. In severe operating condition more frequent replacement of the filter may be necessary.

Electric Lock Off

The Electric Lock Off device is an integrated assembly. When energized the solenoid opens the valve and allows the Propane fuel to flow through the device. The valve opens during cranking and run cycles of the engine. The lock off supply voltage is controlled by the engine control module (ECM).

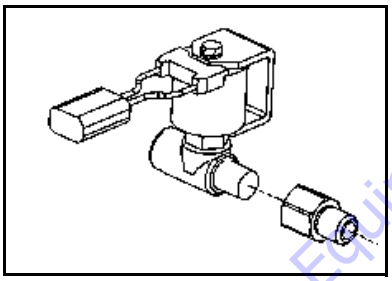
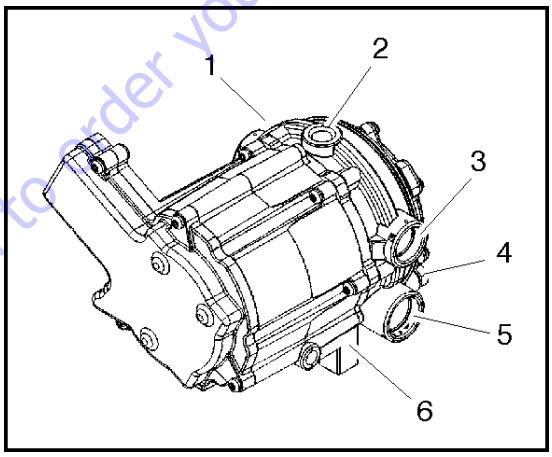


Figure 3-105. Electric Fuel Lock Off

EPR Assembly

The EPR assembly is a combination Low Pressure Regulator and a Voice Coil Assembly. The Voice coil is an electronic actuator which is controlled by an internal microprocessor. The microprocessor provides output data to the ECM and receives input data over a CAN BUS connection. The internal microprocessor receives electrical signals from the Fuel Pressure Sensor FPS and the Fuel Temperature Pressure FTP and communicates the data to the ECM. The ECM uses the FPS and FTP data to calculate the location of the secondary lever in the LPR and sends that data back to the EPR via the CAN BUS. The internal microprocessor in the EPR will then output a signal, which causes the voice coil to move and position the secondary lever to the correct location.



1. Pressure Regulator Section
2. Fuel Inlet
3. Coolant Passage
4. Primary Test Port
5. Secondary Test Port
6. Voice Coil Section

Figure 3-106. EPR Assembly

Low Pressure Regulator (LPR)

The LPR is a combination vaporizer, pressure regulating device. The LPR is a negative pressure, two stage regulator that is normally closed when the engine is not running. When the engine is cranking or running, a partial vacuum is created in the fuel line which connects the regulator to the mixer. This partial vacuum opens the regulator permitting fuel to flow to the mixer.

Propane fuel enters the primary port of the LPR and passes through the primary jet and into the primary/ exchanger chamber. As the propane passes through the heat exchanger the fuel expands and creates pressure inside the chamber. The pressure rises as the fuel expands when the pressure rises above 1.5 psi (10.34 kpa), sufficient pressure is exerted on the primary diaphragm to cause the diaphragm plate to pivot and press against the primary valve pin thus closing off the flow of fuel. This action causes the flow of fuel into the regulator to be regulated.

When the engine is cranking, sufficient vacuum will be introduced into the secondary chamber from the mixer drawing the secondary diaphragm down onto the spring loaded lever and opening the secondary valve allowing vaporized fuel to pass to the mixer. This mechanical action in conjunction with the EPR reactions causes the downward action on the secondary lever causing it to open wider allowing more fuel to flow to the mixer.

NOTICE

THE VOICE COIL SECTION OF THE EPR ASSEMBLY IS AN EMISSIONS CONTROL DEVICE AND CANNOT BE REBUILT. IF THE COIL ASSEMBLY FAILS TO OPERATE PROPERLY, REPLACE IT WITH AN OEM REPLACEMENT PART ONLY.

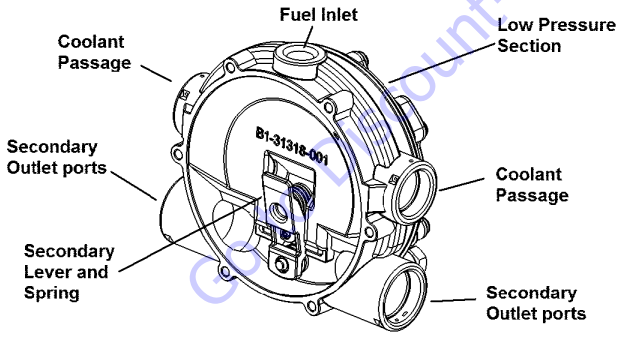


Figure 3-107. Low Pressure Regulators

Air Fuel Mixer

The air valve mixer is an air-fuel metering device and is completely self-contained. The mixer is an air valve design, utilizing a relatively constant pressure drop to draw fuel into the mixer from cranking to full load. The mixer is mounted in the air stream ahead of the throttle control device.

When the engine begins to crank, it draws in air with the air valve covering the inlet, negative pressure begins to build. This negative pressure signal is communicated to the top of the air valve chamber through 4 vacuum ports in the air valve assembly. A pressure/force imbalance begins to build across the air valve diaphragm between the air valve vacuum chamber and the atmospheric pressure below the diaphragm. The air valve vacuum spring is calibrated to generate from 4.0 in. (101.6 mm) of water column at start to as high as 14.0 in. (355.60 mm) of water column at full throttle. The vacuum being created is referred to as Air Valve Vacuum (AVV). As the air valve vacuum reaches 4.0 in. (101.6mm) of water column, the air valve begins to lift against the air valve spring. The amount of AVV generated is a direct result of the throttle position. At low engine speed the air valve vacuum is low and the air valve position is low thus creating a small venturi for the fuel to flow. As the engine speed increase the AVV increases and the air valve is lifted higher thus creating a much larger venturi. This air valve vacuum is communicated from the mixer venture to the LPR secondary chamber via the low pressure fuel supply hose. As the AVV increases in the secondary chamber the secondary diaphragm is drawn further down forcing the secondary valve lever to open wider.

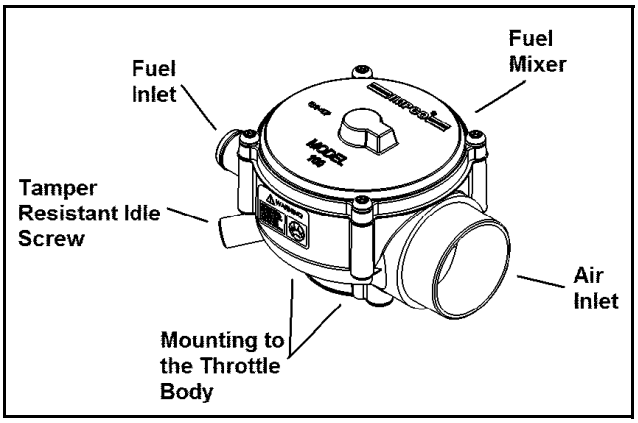


Figure 3-108. Air Fuel Mixer

Electronic Throttle Control (ETC)

Engine speed and load control is maintained by an ETC device. Speed and load control are determined by the ECM. Defaults programmed into the ECM software and throttle position sensors allow the ECM to maintain safe operating control over the engine. The Electronic Throttle Control device or "throttle body assembly" is connected to the intake manifold of the engine. The electronic throttle control device utilizes an electric motor connected to the throttle shaft. When the engine is running electrical signals are sent from the equipment controls to the engine ECM when the operator depresses an equipment function switch. The ECM then sends an electrical signal to the motor on the electronic throttle control to increase or decrease the angle of the throttle blade thus increasing or decreasing the air/fuel flow to the engine.

The electronic throttle control device also incorporates two internal Throttle Position Sensors (TPS) which provide output signals to the ECM as to the location of the throttle shaft and blade. The TPS information is used by the ECM to correct speed and load control as well as emission control.

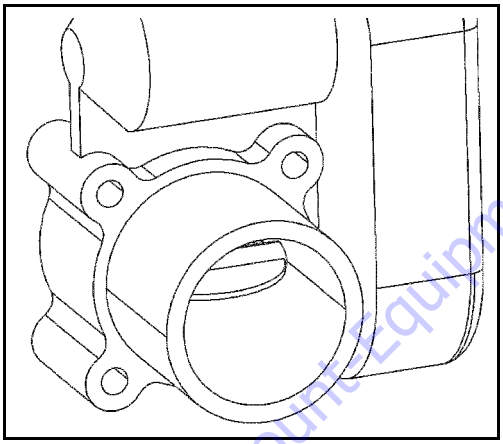


Figure 3-109. ETC throttle control device

Engine Control Module

To obtain maximum effect from the catalyst and accurate control of the air fuel ratio the emission certified engine is equipped with an onboard computer or Engine Control Unit (ECM). The ECM is a 32 bit controller which receives input data from sensors fitted to the engine and fuel system and then outputs various signals to control engine operation.

One specific function of the controller is to maintain "closed loop fuel control". Closed loop fuel control is accomplished when the exhaust gas oxygen sensor (HEGO) mounted in the exhaust system sends a voltage signal to the controller. The controller then calculates any correction that may need to be made to the air fuel ratio. The controller then outputs signals to the EPR to correct the amount of fuel being supplied to the mixer. At the same time the ECM may correct the throttle blade position to correct speed and load of the engine.

The controller also performs diagnostic functions on the fuel system and notifies the operator of malfunctions by turning on a Malfunction Indicator Light (MIL) mounted in the Ground Control Station and the Platform Control Station. Malfunctions in the system are identified by a Diagnostic Code number. In addition to notifying the operator of the malfunction in the system the controller also stores the information about the malfunction in its memory.

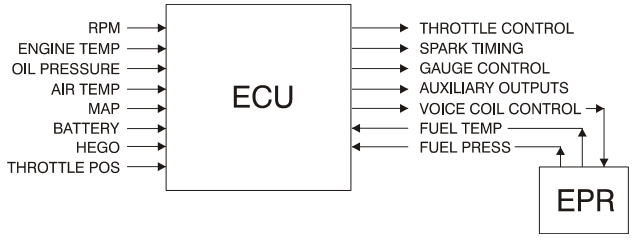


Figure 3-110. LPG Engine Control Unit (ECM)

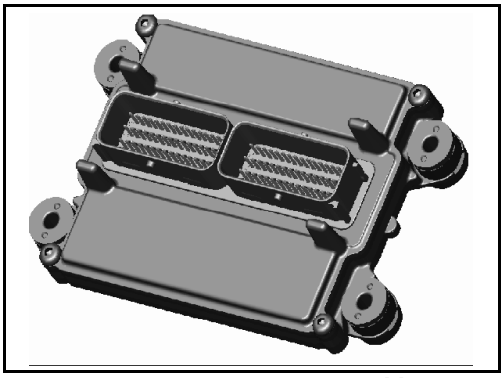


Figure 3-111. ECM Assembly

Heated Exhaust Gas Oxygen Sensor

There are two Heated Exhaust Gas Oxygen Sensors (HEGO). The first HEGO is mounted in the exhaust system downstream of the engine. It is used to measure the amount of oxygen present in the exhaust stream and communicate that to the ECM via an electrical signal. The amount of oxygen present in the exhaust stream indicates whether the fuel/air ratio is too rich or too lean. If the HEGO sensor signal indicates that the exhaust stream is too rich the ECM will decrease or lean the fuel mixture during engine operation, if the mixture is too lean the ECM will richen the mixture. The ECM continuously monitors the HEGO sensor output. If a rich or lean condition is present for an extended period of time, and the ECM cannot correct the condition, the ECM will set a diagnostic code and turn on the MIL light in control box.

The second HEGO is mounted in the exhaust system after the muffler. It measures the amount of oxygen in the exhaust system after the catalyst treatment has been completed in the muffler. If the ECM detects that the catalytic action in the muffler is not sufficient and fuel correction cannot correct the malfunction the MIL light is illuminated in the control box and a DTC code will stored in the computer.

NOTICE

THE HEATED EXHAUST GAS OXYGEN SENSOR IS AN EMISSION CONTROL DEVICE. IF THE HEGO FAILS TO OPERATE, REPLACE IT WITH AN OEM REPLACEMENT PART. THE HEGO SENSOR IS SENSITIVE TO SILICONE OR SILICONE BASED PRODUCTS AND CAN BECOME CONTAMINATED. AVOID USING SILICONE SEALERS OR HOSES TREATED WITH SILICONE LUBRICANTS IN THE AIR STREAM OR FUEL LINES.

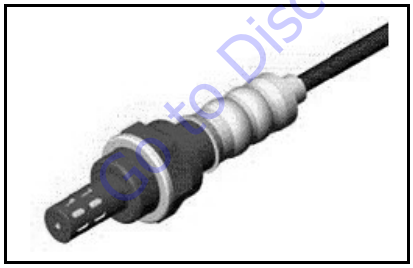


Figure 3-112. Heated Exhaust Gas Oxygen Sensor (HEGO)

Gasoline Multi Point Fuel Injection System (MPFI)

The primary components of the Gasoline Multi Point Fuel Injection (MPFI) fuel system are the fuel tank, electric fuel pump, fuel pressure and temperature sensor manifold, fuel filter and fuel rail.

Gasoline Fuel Pump

The Gasoline is stored as a liquid in the fuel tank and in drawn into the fuel system by an electric fuel pump. The fuel pump will receive a signal from the ECM to prime the fuel system for approximately 2 seconds prior to start. Priming of the fuel system provides for a quicker start, when the engine begins to crank.

Gasoline Pressure And Temperature Sensor Manifold

This engine is equipped with a fuel injector rail that does not have a pressure regulator or a return circuit to the fuel tank. Fuel pressure for this engine is regulated by the engine's ECM. The ECM receive fuel pressure and temperature feedback from the gasoline fuel sensor manifold and uses this information to control the ground side of the fuel pump. Fuel pressure is regulated by the ECM pulse width modulating (PWM) the fuel pump. The fuel pressure and temperature sensor manifold has a return or "bleed" circuit that connects back to the fuel tank. This circuit is used to bleed off any vapor that develops in the line and return a small amount of fuel to the tank. The fuel comes from the fuel tank and passes through the fuel pump. Fuel exits the fuel pump, passes through the filter and then enters the fuel pressure and temperature manifold assembly. Fuel flows through the feed circuit and is delivered to the fuel injector rail. Fuel that enters the bleed circuits through they bypass valve in the manifold is returned to the fuel tank.

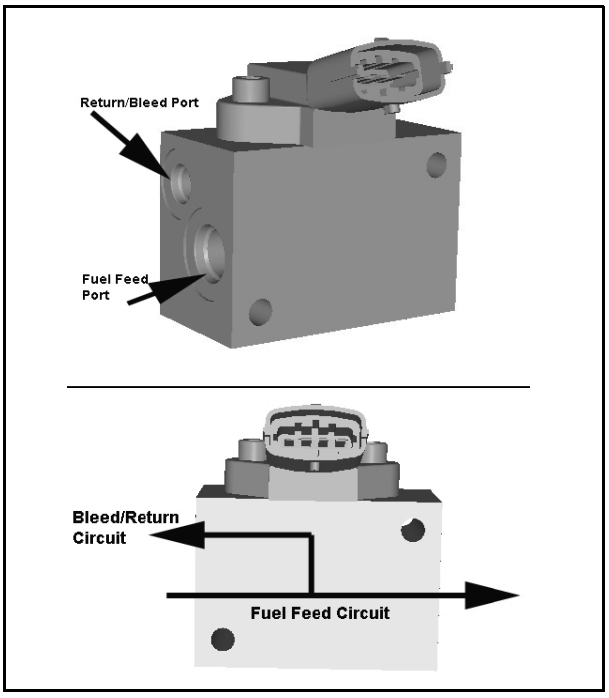


Figure 3-113. Gasoline Fuel Pressure and Temperature Manifold Assembly

Fuel Filter

After the fuel is drawn into the fuel pump, the fuel flows through the gasoline fuel filter. The fuel filter will trap small particles as the fuel passes through the filter to remove debris and prevents the fuel pressure and temperature manifold and fuel injectors from becoming damaged. Maintenance of the fuel filter is required as indicated in Section 1.

Fuel Injector Rail

Fuel flows from the fuel pressure and temperature manifold assembly to the fuel rails where the fuel is delivered to the fuel injectors. The fuel rail also contains a Schrader valve which is utilized to test the regulated pressure of the fuel system.

Fuel Injector

The fuel supply is maintained on the top of the injector from the injector rail. The injector is fed a "pulse" signal through the wire harness which causes the injector to open. During regular operating conditions the ECM controls the opening and duration of opening of the injector. During lower RPM operation the injector signals or "pulses" are less frequent then when the engine is operating at higher RPMs. The engine has been calibrated to deliver the precise amount of fuel for optimum performance and emission control.

3.32 GM ENGINE FUEL SYSTEM REPAIR

Propane Fuel System Pressure Relief

⚠ CAUTION

THE PROPANE FUEL SYSTEM OPERATES AT PRESSURES UP TO 312 PSI (21.5 BAR). TO MINIMIZE THE RISK OF FIRE AND PERSONAL INJURY, RELIEVE THE PROPANE FUEL SYSTEM PRESSURE (WHERE APPLICABLE) BEFORE SERVICING THE PROPANE FUEL SYSTEM COMPONENTS.

To relieve propane fuel system pressure:

1. Close the manual shut-off valve on the propane fuel tank.
2. Start and run the vehicle until the engine stalls.
3. Turn the ignition switch OFF.

NOTICE

RESIDUAL VAPOR PRESSURE WILL BE PRESENT IN THE FUEL SYSTEM. ENSURE THE WORK AREA IS WELL VENTILATED BEFORE DISCONNECTING ANY FUEL LINE.

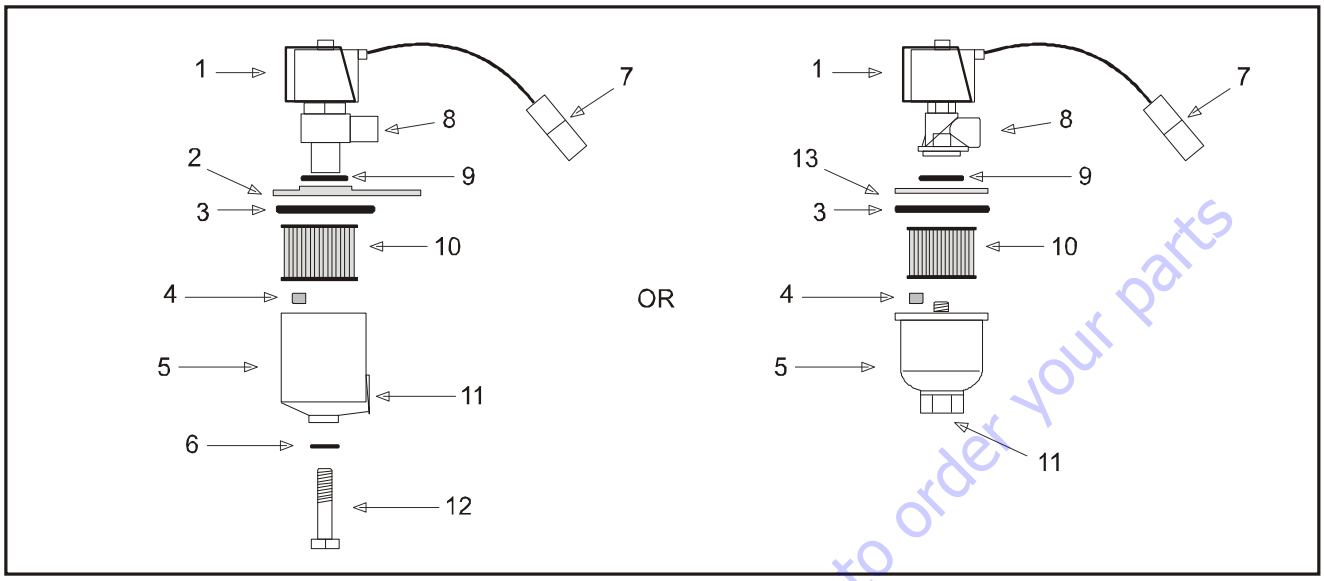
Propane Fuel System Leak Test

⚠ CAUTION

NEVER USE AN OPEN FLAME OF ANY TYPE TO CHECK FOR PROPANE FUEL SYSTEM LEAKS.

Always inspect the propane fuel system for leaks after performing service. Check for leaks at the fittings of the serviced or replaced component. Use a commercially available liquid leak detector or an electronic leak detector. When using both methods, use the electronic leak detector first to avoid contamination by the liquid leak detector.

Propane Fuel Filter Replacement



1. Electric Lock Off Solenoid
2. Mounting Plate
3. Housing Seal
4. Filter Magnet
5. Filter Housing
6. Seal
7. Electrical Connector
8. Fuel Outlet
9. O-ring
10. Filter
11. Fuel Inlet
12. Retaining Bolt
13. Ring

Figure 3-114. Filter Lock Assembly

REMOVAL

1. Relieve the propane fuel system pressure. Refer to Propane Fuel System Pressure Relief.
2. Disconnect the negative battery cable.
3. Slowly loosen the Filter housing retaining bolt and remove it.
4. Pull the filter housing from the Electric lock off assembly.
5. Locate Filter magnet and remove it.
6. Remove the filter from the housing.
7. Remove and discard the housing seal.
8. Remove and discard the retaining bolt seal.
9. Remove and discard mounting plate to lock off o-ring seal.

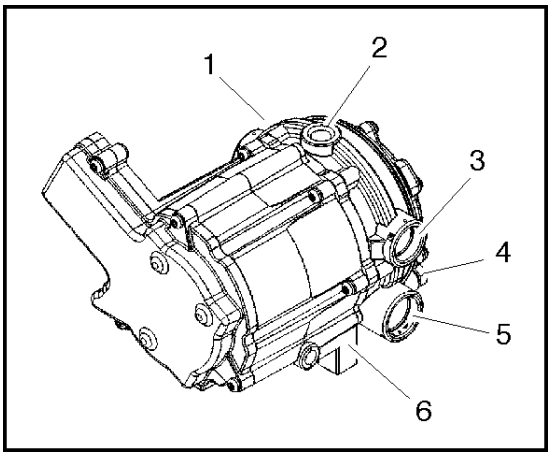
INSTALLATION

NOTICE

BE SURE TO REINSTALL THE FILTER MAGNET INTO THE HOUSING BEFORE INSTALLING NEW SEAL.

1. Install the mounting plate to lock off o-ring seal.
2. Install the retaining bolt seal.
3. Install the housing seal.
4. Drop the magnet into the bottom of the filter housing.
5. Install the filter into the housing.
6. Install the retaining bolt into the filter housing.
7. Install the filter up to the bottom of the electric lock off.
8. Tighten the filter retaining bolt to 106 in. lbs. (12 Nm).
9. Open manual shut-off valve. Start the vehicle and leak check the propane fuel system at each serviced fitting Refer to Propane Fuel System Leak Test.

Electronic Pressure Regulator (EPR) Assembly Replacement



1. Pressure Regulator Section
2. Fuel Inlet
3. Coolant Passage
4. Primary Test Port
5. Secondary Test Port
6. Voice Coil Section

Figure 3-115. EPR Assembly

The EPR assembly is a made up of two separate components. The Voice Coil Section is not serviceable and can only be replaced as an assembly. The pressure regulator section is serviceable and will be detailed in this section.

REMOVAL

1. Relieve the propane fuel system pressure. Refer to Propane Fuel System Pressure Relief.
2. Disconnect the negative battery cable.
3. Slowly remove the fuel inlet fitting at the Electric Lock Off.

NOTE: *Residual vapor pressure will be present in the fuel system.*

4. Disconnect the electrical connector to the Electric Lock off.
5. Remove the Electric Lock Off from the regulator.
6. Remove the lock pin from the vapor fitting on the regulator housing and remove the fitting and hose and retain the pin.
7. Remove the lock pin from the pressure sensor on the regulator housing and remove the Sensor and retain the pin.
8. Using a clamp pliers pinch off the hoses on the coolant lines to the regulator
9. Remove the lock pin from both the water fittings on the regulator housing and remove the fittings and hoses and retain the pin
10. Disconnect the EPR electrical connector
11. Remove the (3) three nuts from the EPR isolators and the EPR mounting bracket
12. Remove the EPR from the bracket
13. Remove the (3) three mounting isolators

INSTALLATION

NOTICE

DO NOT USE TEFLON TAPE ON ANY FUEL FITTING. USE A LIQUID PIPE THREAD SEALANT WHEN INSTALLING FITTINGS.

CHECK ALL THE O-RINGS ON THE VAPOR AND WATER FITTINGS FOR ANY DAMAGE REPLACE IF NECESSARY.

LUBE ALL THE O-RINGS WITH AN O-RING LUBE BEFORE INSTALLING.

1. Install the three (3) rubber isolators to the bottom of the EPR
2. Install the EPR assembly to the bracket and tighten the retaining nuts.

NOTE: *Do not over tighten the isolators and cause a separation of the isolators.*

3. Install the fuel temperature sensor into the regulator opening and lock in place with the locking pin, connect the electrical connector.
4. Insert the fuel vapor line and fitting into the regulator port and lock in place with the locking pin.
5. Install both the water hoses and fittings into the regulator and lock in place with the locking pin remove the clamp pliers from the hoses.
6. Install the electric lock off into the regulator inlet and tighten into proper location, connect the electrical connector.
7. Connect the fuel supply line and tighten until fully seated.
8. Connect the EPR electrical connector.
9. Open the manual valve.

10. Start the vehicle and leak check the propane fuel system at each serviced fitting Refer to Propane Fuel System Leak Test.

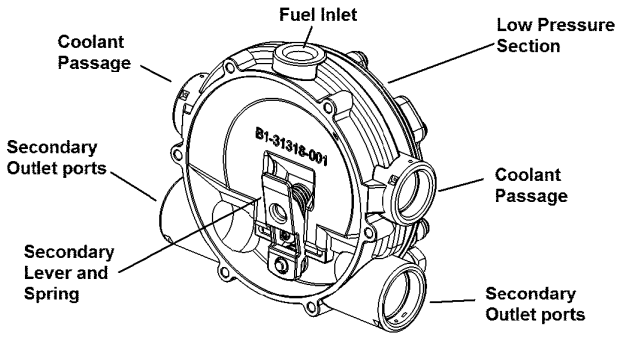


Figure 3-116. Pressure Regulator Section

PRESSURE REGULATOR SECTION REMOVAL

1. Remove the EPR refer to EPR Removal Procedure.
2. Remove the six (6) regulator to voice coil screws using the special tool and separate the regulator from the actuator.

NOTICE

DO NOT REMOVE THE SECONDARY DIAPHRAGM RETAINING PLATE AND DIAPHRAGM THIS WILL VOID THE WARRANTY OF THE ACTUATOR SECTION.

PRESSURE REGULATOR SECTION INSTALLATION

1. Install the regulator to the actuator section using the six (6) retaining screws and tighten 70 in. lbs. (8 Nm).
2. Install the EPR refer to EPR Installation.

Temperature Manifold Absolute Pressure (TMAP) Sensor

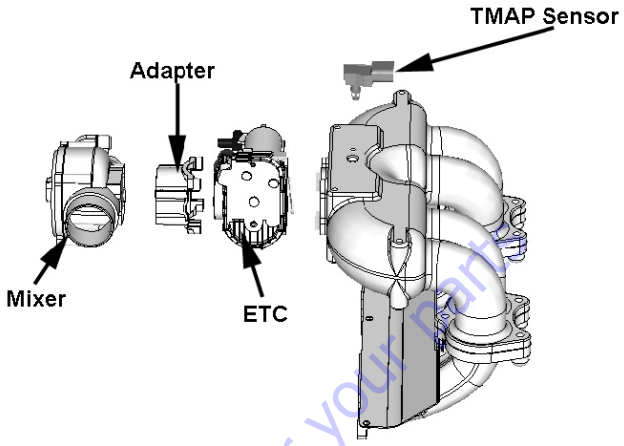


Figure 3-117. (TMAP) Sensor & Electronic Throttle Control (ETC)

REMOVAL

1. Disconnect the TMAP electrical connector.
2. Remove the two retaining bolts.
3. Remove the TMAP.

INSTALLATION

NOTE: *Apply a small amount of o-ring lubricant before installation.*

1. Install in the TMAP.
2. Tighten retaining bolts to 62 lb-in (7 Nm).
3. Start the vehicle and check for proper operation.

Electronic Throttle Control Replacement

See Figure 3-117.

REMOVAL

1. Disconnect the negative battery cable.
2. Remove the air intake duct.
3. Release the hose clamp on the vapor fuel line and remove the vapor hose.
4. Disconnect the TMAP electrical connector.
5. Disconnect the electronic throttle control connector.
6. Remove the manifold to throttle body adapter bolts and remove the throttle body mixer assembly.
7. Pull the throttle body assembly from the adapter.
8. Remove electronic throttle control device.
9. Remove the o-rings gasket and discard.

INSTALLATION

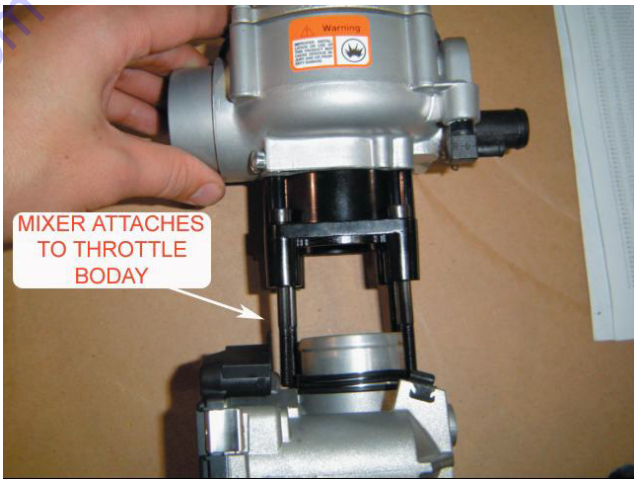
NOTICE

LIGHTLY LUBRICATE BOTH THROTTLE CONTROL DEVICE TO ADAPTER O-RINGS.

1. Install the o-ring on throttle body. Press it down to the bottom of the surface.

2. Install the two quad seals. Install one seal at a time to insure the seal does not roll. The seal must sit flat on the throttle body.

3. Attach mixer and throttle body together. The two parts do not bolt together; they will be secured when you mount it on the intake. Notice the orientation of the air inlet and throttle body cover.



4. Place gasket on intake manifold and attach mixer/throttle assembly to manifold.

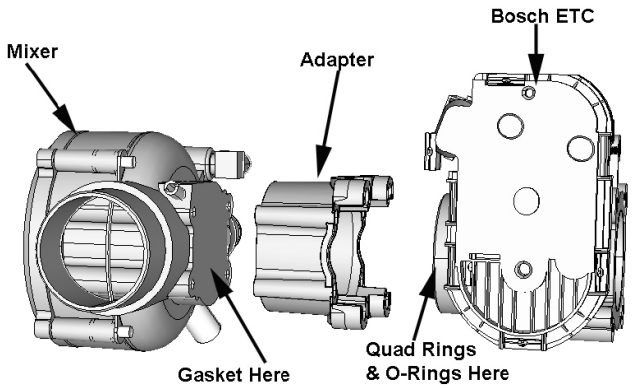


Figure 3-118. Mixer Assembly

Mixer Replacement

See Figure 3-118.

REMOVAL

1. Remove the Throttle control device Refer to Electronic Throttle Body Replacement.
2. Remove the four (4) bolts to the throttle control device to mixer adapter bolts.
3. Remove and discard the mixer to adapter gasket.

INSTALLATION

NOTICE

COVER THROTTLE BODY ADAPTER OPENING TO PREVENT DEBRIS FROM ENTERING ENGINE UNTIL REASSEMBLY.

1. Install Mixer to adapter gasket onto the mixer.
2. Install the mixer to the throttle control device to mixer adapter and secure with the 4 retaining screws. Tighten 80 in. lbs. (9 Nm).
3. Install Throttle body. Refer to Electronic Throttle Control Device Replacement.
4. Start the engine and leak check all fittings and connections.

Coolant Hose Replacement

REMOVAL

1. Drain the coolant.
2. Using hose clamp pliers, disconnect both hose clamps on each hose.
3. Remove the hose from each of the fittings.

INSTALLATION

NOTE: *Use hose material and lengths specified by JLG.*

1. Install the hose clamps to each hose and set the clamp back on each hose to make installation easier.
2. Fit the hose to the fittings.
3. Secure by positioning each of the clamps.

Vapor Hose Replacement

REMOVAL

1. Using hose clamp pliers disconnect both hose clamps.
2. Remove the vapor hose from each fitting.

INSTALLATION

NOTICE

THE VAPOR SUPPLY HOSE IS SPECIFICALLY DESIGNED, DO NOT USE HOSE MATERIAL OR LENGTH OTHER THAN JLG SPECIFIED PARTS.

1. Install hose clamps and set back on each hose.
2. Reinstall the vapor hose to each fitting.
3. Reset clamps.
4. Start engine and check for leaks.

Engine Control Module Replacement

REMOVAL

1. Disconnect Negative battery cable.
2. Remove controller from mounting bracket.
3. Push connector lock back to unlock connector.
4. Unplug controller and remove.

INSTALLATION

NOTICE

THE CONTROLLER IS CALIBRATED FOR EACH ENGINE VERIFY YOU HAVE THE CORRECT CONTROLLER

1. Plug connector into controller.
2. Push lock into place.
3. Mount controller into mounting bracket.
4. Reconnect the battery cable.
5. Start engine.
6. Check for any DTC codes and clear.
7. Verify engine is in closed loop and no warning lights are illuminated.

Heated Exhaust Gas Oxygen Sensor Replacement

REMOVAL

1. Disconnect Negative battery cable.
2. Disconnect the O2 sensor electrical connector.
3. Using an O2 Sensor socket, remove the O2 Sensor and discard.

INSTALLATION

NOTICE

BEFORE INSTALL THE O2 SENSOR LUBRICATE THREADS WITH ANTI-SEIZE COMPOUND GM P/N 5613695 OR EQUIVALENT. AVOID GETTING COMPOUND ON THE SENSOR TIP.

1. Install O2 sensor. Tighten to 30 lb-ft (41 Nm).
2. Start engine.
3. Check for any DTC codes and clear.
4. Verify engine is in closed loop and no warning lights are illuminated.

3.33 GM ENGINE LPG FUEL SYSTEM DIAGNOSIS

Fuel System Description

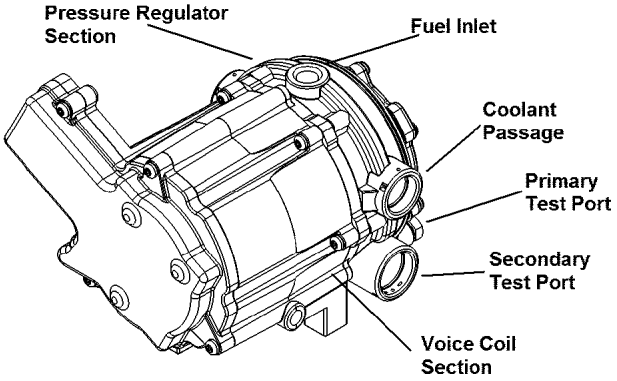


Figure 3-119. EPR Assembly

To maintain fuel and emission control on the LPG fuel system the Engine Control Units (ECM) relies on numerous engine sensor and output data from the Electronic Pressure Regulator (EPR). The ECM will then determine the target fuel calibration and command the EPR to reposition the voice coil to the proper position which, subsequently reposition the secondary lever in the pressure regulator to maintain proper control. The EPR and ECM will continue to communicate back and forth during normal operation.

In the event that the EPR fails to communicate or the Communications Area Network (CAN) cable fails to transmit data the regulator will operate in an open loop configuration. As the air valve vacuum in the mixer venturi is communicated to the secondary chamber of the regulator the secondary diaphragm will be drawn in a downwards motion. This downward motion will cause the secondary lever to open thus allowing more fuel to enter the mixer.

In the (LPR) the fuel is vaporized and the pressure reduced in two stages. The first stage reduces the pressure to approximately 1.0 to 3.0 psi (6.8 to 20.6 kPa). The second stage reduces the pressure to approximately negative 1.5" of water column.

The fuel is then drawn from the secondary chamber of the LPR by the vacuum generated by air flowing through the mixer. This vacuum signal is also used to generate lift for the mixer air valve. This vacuum signal is most commonly referred to as air valve vacuum. In the mixer, the fuel mixes with the air entering the engine. This air/ fuel mixture is then drawn into the engine for combustion.

Diagnostic Aids

This procedure is intended to diagnose a vehicle operating on LPG. If the vehicle will not continue to run on LPG, refer to Hard Start for preliminary checks. Before proceeding with this procedure, verify that the vehicle has a sufficient quantity of fuel and that liquid fuel is being delivered to the LPR. Also, ensure that the manual shut off valve on the LPG tank is fully opened and that the excess flow valve has not been activated.

Tools Required:

- 7/16 Open end wrench (for test port plugs)
- DVOM (GM J 39200, Fluke 88 or equivalent).
- 12 volt test light

Diagnostic Scan Tool

- Diagnostic Display tool.

Pressure Gauges

- IMPCO ITK-2 Test kit
- Water Column Gauge / Manometer (GM 7333-6 or equivalent).
- 0-10 PSI Gauge

Test Description

The numbers below refer to step numbers on the diagnostic table.

5. This step determines if the LPR requires replacement

6. This step determines if the problems are in the mechanical side of the Pressure Regulator or the Electronic Voice Coil

10. This step determines if the Mixer requires replacement

14. This step determines if the Lock Off requires replacement

17. This step determines if the Fuel Filter requires replacement.