1825 Uni-Loader

Table of Contents

DIVISION/SECTION	SECTION NO.	FORM NO.
1 GENERAL		
Safety Rules, Service Manual Introduction, and Torque Specifications	1001	8-68110
Fluids and Lubricants	1002	8-17680
Gasoline Engine Specifications	1010	8-58790
Diesel Engine Specifications	1024	8-58760
General Machine Specifications	1210	8-68140
2 ENGINES		
Engine Removal and Installation and Radiator Removal and Installation	2000	8-68480
Engine Accessories	2001	8-68490
Cylinder Head and Valve Train - Gasoline Engine	2015	8-58040
Cylinder Head and Valve Train - Diesel Engine	2015	8-58120
Camshafts - Diesel Engine	2020	8-58820
Cylinder Block, Pistons, Rods, Camshaft, Main Bearings, Oil Seals, and Flywheel - Gasoline Engine	2025	8-58050
Cylinder Block, Pistons, Rods, Main Bearings, Oil Seals, and Flywheel - Diesel Engine	2025	8-58130
Crankshaft - Gasoline Engine	2035	8-58060
Crankshaft - Diesel Engine	2035	8-58140
Lubrication System - Gasoline Engine	2045	8-58070
Lubrication System - Diesel Engine	2045	8-58150
Cooling System - Gasoline Engine	2055	8-58080
Cooling System - Diesel Engine	2055	8-58160
Ignition System	2065	8-58720
Engine Lubrication System - Gasoline Engine	2555	8-58090
Engine Lubrication System - Diesel Engine	2555	8-58170
3 FUEL SYSTEM		
Carburetor	3002	8-58730
Fuel Injection Pump	3312	8-58840
Fuel Injectors and Glow Plugs	3313	8-58830
4 ELECTRICAL		
Removal and Installation of Electrical Components	4000	8-68690
Electrical Specifications, Troubleshooting, and Schematics	4002	8-17690
Instruments and Gauges	4004	8-68720
Battery	4005	8-44360
Starter - Gasoline Engine	4006	8-58100
Starter - Diesel Engine	4006	8-58180
Alternator - Gasoline Engine	4007	8-58110
Alternator - Diesel Engine	4007	8-58190

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GENERAL SPECIFICATIONS

Type		Gasoline	
Stroke		4	
No. Of Cylinders		4	
Valve Arrangement		OHV (Over Head Valve)	
Bore x Stroke		2.87 x 2.76 inch	73.0 x 70.0 mm
Displacement		71.45 inch	1.171 cm^3
Compression Ratio		9:0	
Number Of Piston Rings			
Compression		2	
Oil		1	
Number Of Main Bearings		5	
Valve Clearance (Hot)			
Intake And Exhaust		0.014 inch	0.35 mm
Engine Idle Speed		650 rpm	
Ignition Timing At Idle Speed			
BTDC		12° at 650 rpm	
Engine Oil Capacity			
With Oil Filter	3.37 US Quarts	2.87 UK Quarts	3.2 L
Without Oil Filter	2.87 US Quarts	2.37 UK Quarts	2.7 L
Oil Pump Type		Trochoid Gear	
Oil Filter Type		Paper Element (Cartridge)	
Water Pump Type		Centrifugal	
Thermostat Operating Temperature			
Tropical Area		170°F	76°C
Cold Area		180 to 190°F	82 to 88°C
Carburetor Type		Downdraft	
Air Cleaner Type		Dry Paper	
Alternator Model		Mitsubishi A1T24371	
Capacity		12 Volt 35 Amp	
Voltage Regulator Model		Mitsubishi RQB220B5	
Starter Motor Model		Mitsubishi M2T20181	
Capacity		0.8 kW	
Ignition System			
Firing Order		1 - 3 - 4 - 2	
Ignition Coil Model		Mitsubishi HP-BE10	
Distributor		Mitsubishi T3T03571	
Spark Plug Type		NGK B4ES	

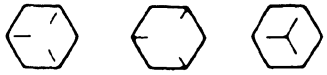
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TORQUE SPECIFICATIONS - DECIMAL HARDWARE

Use the torques in this chart when special torques are not given. These torques apply to fasteners with both UNC and UNF threads as received from suppliers, dry, or when lubricated with engine oil. Not applicable if special graphites, molydisulfide greases, or other extreme pressure lubricants are used.

Grade 5 Bolts, Nuts, and Studs



Size	Pound-Feet	Newton metres
1/4 in	9-11	12-15
5/16 in	17-21	23-28
3/8 in	35-42	48-57
7/16 in	54-64	73-87
1/2 in	80-96	109-130
9/16 in	110-132	149-179
5/8 in	150-180	203-244
3/4 in	270-324	366-439
7/8 in	400-480	542-651
1.0 in	580-696	787-944
1-1/8 in	800-880	1085-1193
1-1/4 in	1120-1240	1519-1681
1-3/8 in	1460-1680	1980-2278
1-1/2 in	1940-2200	2631-2983

Grade 8 Bolts, Nuts, and Studs



Size	Pound-Feet	Newton metres
1/4 in	12-15	16-20
5/16 in	24-29	33-39
3/8 in	45-54	61-73
7/16 in	70-84	95-114
1/2 in	110-132	149-179
9/16 in	160-192	217-260
5/8 in	220-264	298-358
3/4 in	380-456	515-618
7/8 in	600-720	814-976
1.0 in	900-1080	1220-1465
1-1/8 in	1280-1440	1736-1953
1-1/4 in	1820-2000	2468-2712
1-3/8 in	2380-2720	3227-3688
1-1/2 in	3160-3560	4285-4827

NOTE: *Use thick nuts with Grade 8 bolts.*

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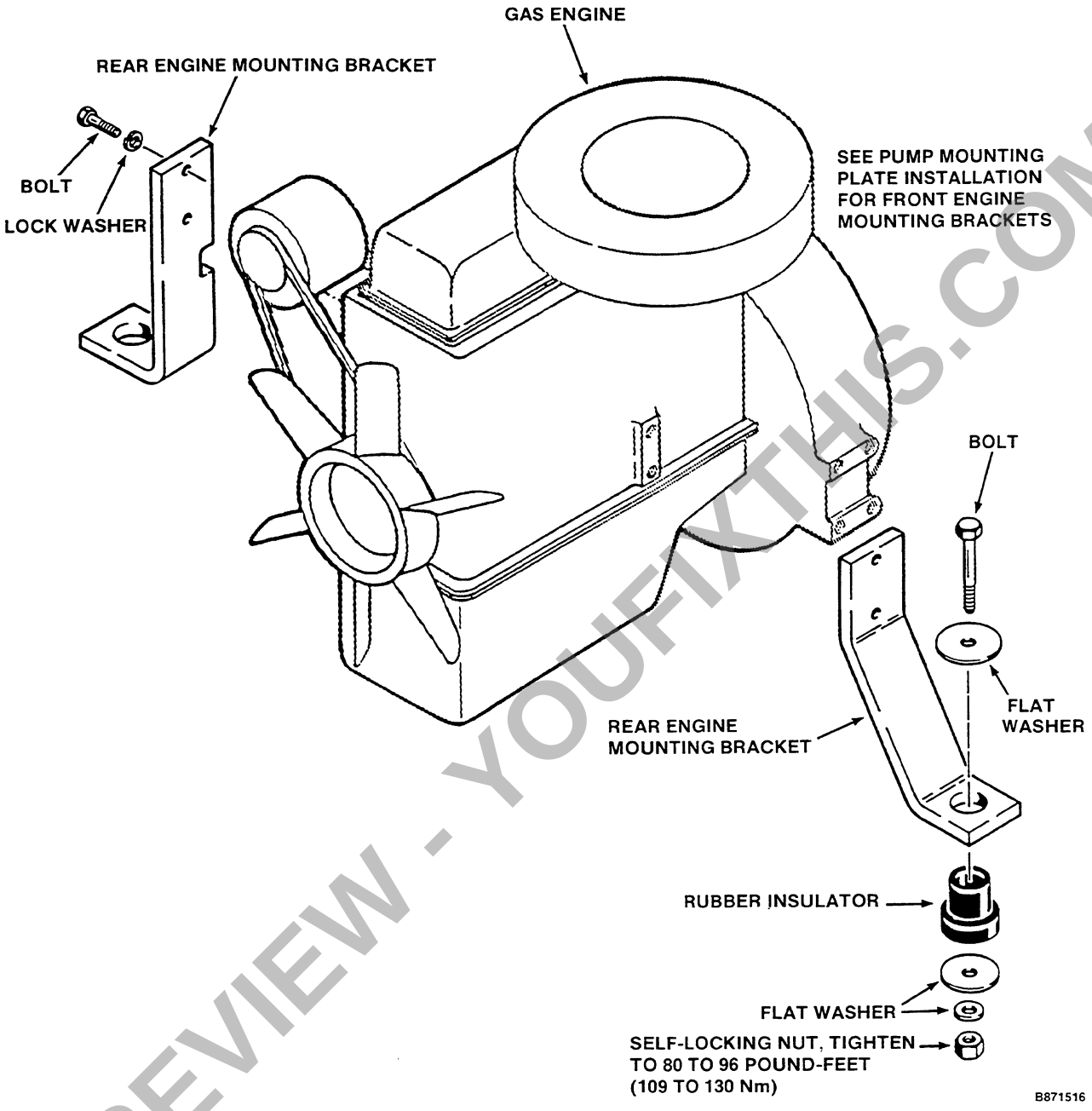
DETAILED SPECIFICATIONS

Cylinder Liners		
Standard Bore	2.8347 to 2.8354 inch	72.00 to 72.019 mm
Max Wear	2.8413 inch	72.169 mm
Oversize Bore	2.8544 to 2.8550 inch	72.500 to 72.519 mm
Max Wear	2.8609 inch	72.699 mm
Cross Hatch Pattern	40 to 60 degrees	
Surface Finish (Max)	1.2 to 2 µm	
Protrusion In Engine Block	± 0.001 inch	± 0.025 mm
Piston And Rings		
Ring Gap In Liner:		
Top Compression	0.0098 to 0.0492 inch	0.25 to 1.25 mm
Bottom Compression	0.0098 to 0.0492 inch	0.25 to 1.25 mm
Oil Control	0.0078 to 0.0492 inch	0.20 to 1.25 mm
Ring Side Clearance In Piston:		
Bottom Compression	0.0033 to 0.0044 inch	0.085 to 0.112 mm
Oil Control	0.0008 to 0.0020 inch	0.020 to 0.052 mm
Piston Pin Hole Diameter	0.7874 to 0.7885 inch	20.00 to 20.03 mm
Oversize Pistons	+ 0.0197 inch	+ 0.5 mm
Connecting Rods		
Piston Pin Bush Diameter	0.7884 to 0.7890 inch	20.025 to 20.040 mm
Piston Pin Diameter	0.7875 to 0.7878 inch	20.002 to 20.011 mm
Clearance Between Pin And Bush	0.0006 to 0.0015 inch	0.014 to 0.038 mm
Alignment And Twist	0.002 inch	0.05 mm
Clearance Between Big End		
Bearing Inserts And Crankshaft	0.0011 to 0.0079 inch	0.029 to 0.20 mm
Crankshaft		
Main Bearing Diameters	1.7297 to 1.7303 inch	43.934 to 43.950 mm
Clearance Between Bearing		
Inserts And No. 1, 2, 3 & 4 Diameters	0.0013 to 0.0079 inch	0.034 to 0.20 mm
Inside Diameter Of No. 5		
Main Bearing (In Engine Block)	1.7317 to 1.7339 inch	43.984 to 44.040 mm
Clearance Between No. 5 Bearing		
And Crankshaft	0.0013 to 0.0079 inch	0.034 to 0.20 mm
Connecting Rod Bearing Diameters	1.4551 to 1.4557 inch	36.959 to 36.975 mm
Clearance Between Connecting Rod		
Inserts And Crankshaft Diameters	0.0011 to 0.0079 inch	0.029 to 0.20 mm
End Play	0.0059 to 0.0197 inch	0.015 to 0.5 mm
Axial Alignment (Max)	0.003 inch	0.08 mm
Flywheel		
Flatness Error (Max)	0.006 inch	0.152 mm

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GAS ENGINE



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Removal

STEP 1
Park the machine on a level surface.

STEP 2
Remove the pins that hold the strut in position and lower the strut onto the lift cylinder.

STEP 3
Start and run the engine at low idle.

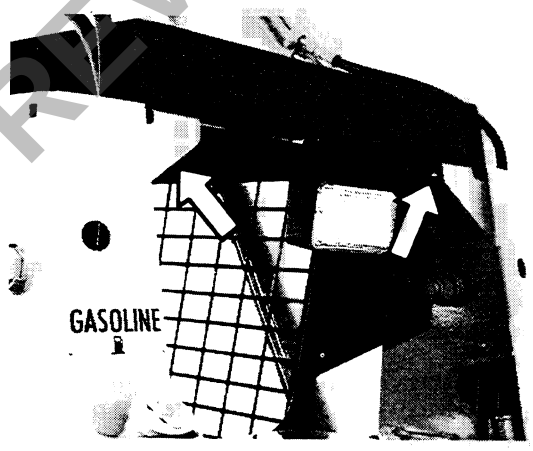
STEP 4
Move the machine forward or backward as required to make sure that the pin in each parking latch engages the cluster sprocket.

STEP 5
Raise the loader frame until the strut falls onto the piston rod. Then lower the loader frame until the strut is against the end of the lift cylinder. Stop the engine.

STEP 6

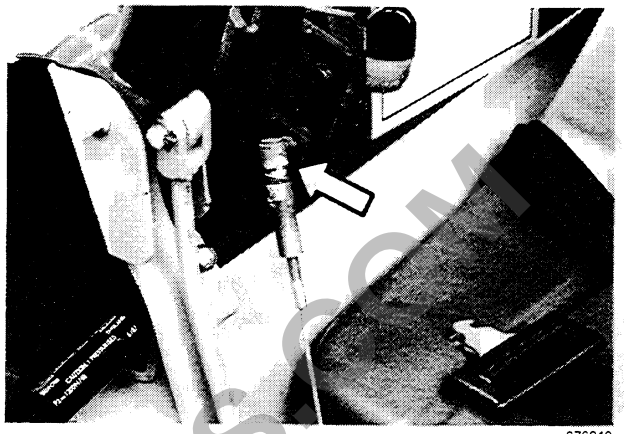
877240

Install the pins that hold the strut.

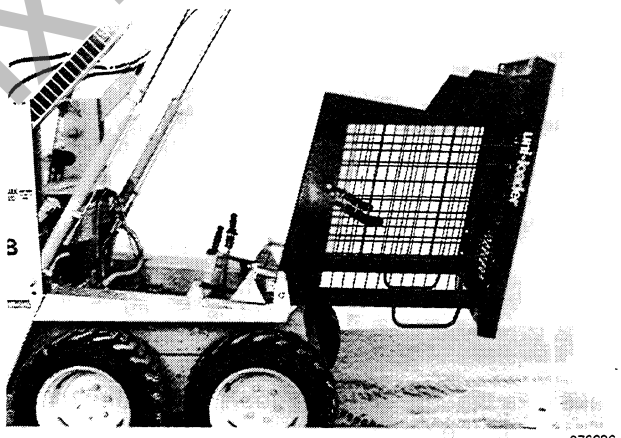
STEP 7


876214

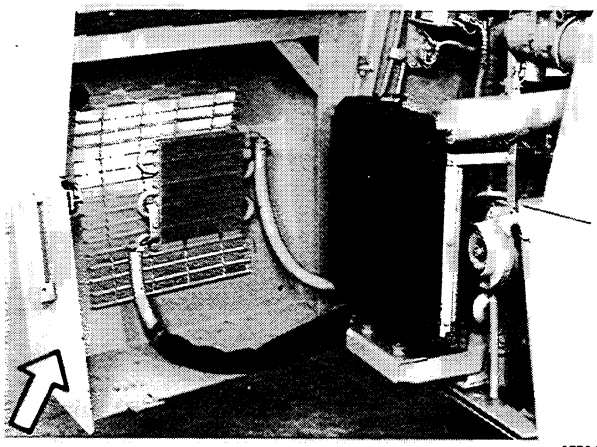
Loosen and remove the cap screws, lock washers, and flat washers that fasten the ROPS canopy to the posts on the rear of the machine.

STEP 8

876240

Disconnect the cables from the protection bars. Push down the sleeve on the socket and remove the socket from the pin.

STEP 9

876236

Use the grab handles and tilt the ROPS canopy all the way forward.

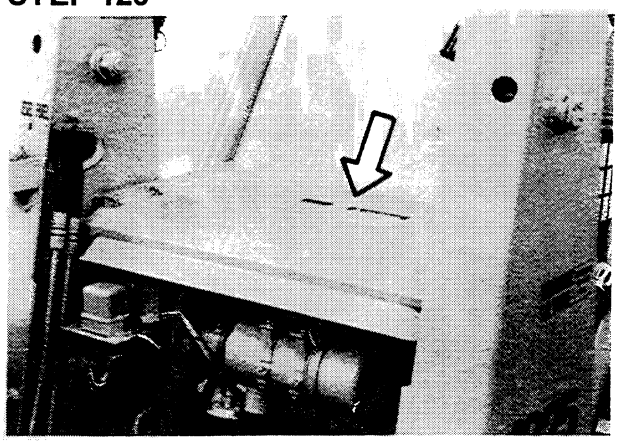
STEP 10

877243

Open the access door on the rear of the machine.

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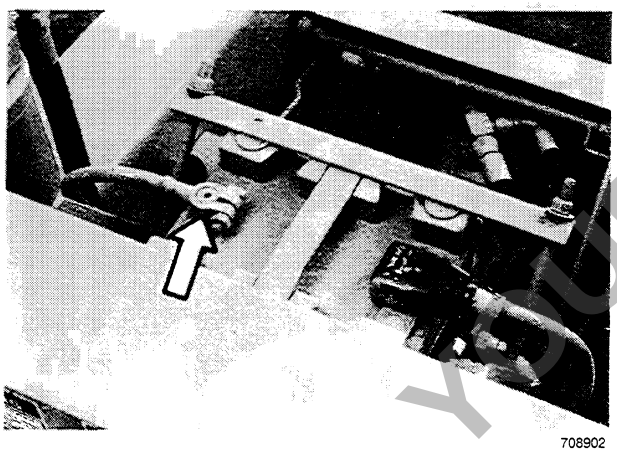
STEP 126



709220

Remove the battery cover from the machine.

STEP 127



708902

Disconnect the ground cable from the negative terminal on the battery.

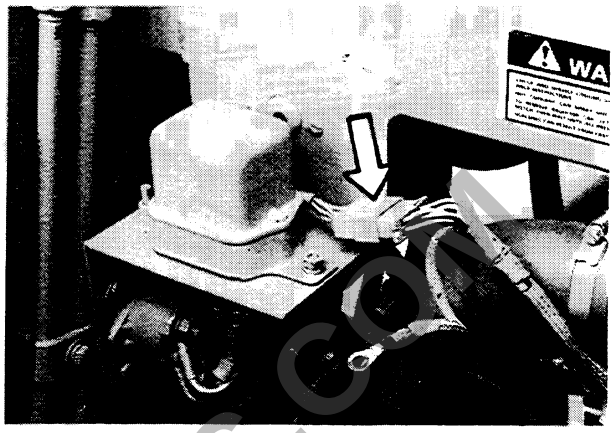
STEP 128



709210

Disconnect the ground cable for the wiring harness.

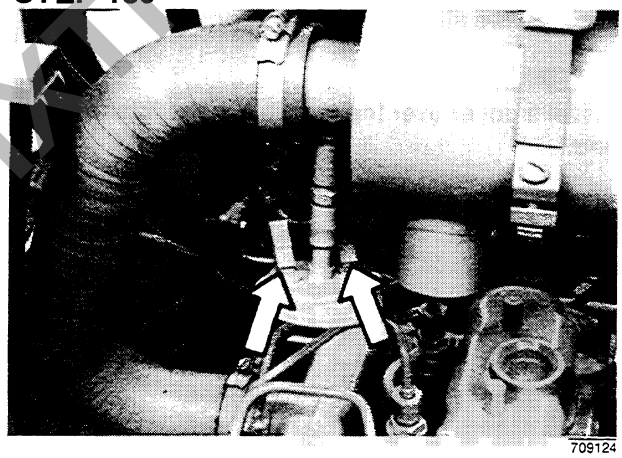
STEP 129



709206

Disconnect the wire connector for the wiring harness.

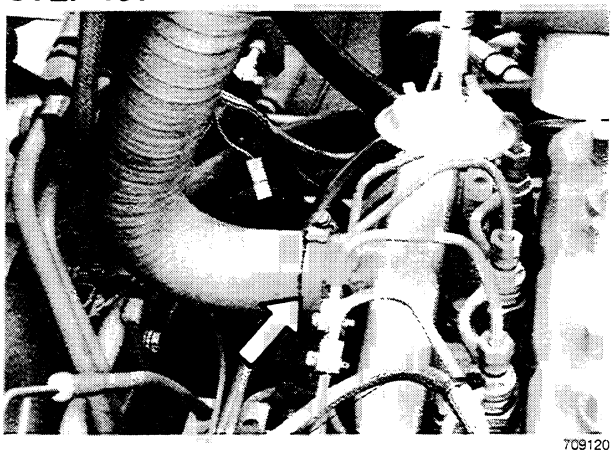
STEP 130



709124

Disconnect the wires from the connections on the air restriction indicator.

STEP 131



709120

Loosen the clamp on the hose for the air cleaner.

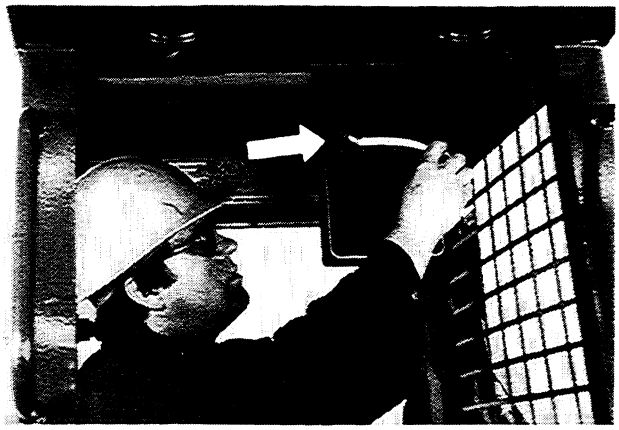
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SAFETY RULES

Most accidents involving machine operation and maintenance can be avoided by following basic safety rules and precautions. Read and understand all the safety messages in this manual, the safety manual, and the safety signs on the machine before you operate or service the machine.

Read the operators manual and make sure you understand the operation of the machine.



Operators Manual Storage 876245

The safety information given in this manual does not replace safety codes, insurance needs, federal, state, and local laws.

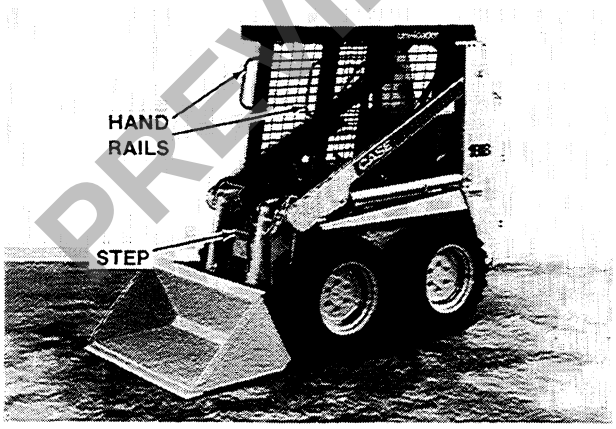
IMPORTANT: *Safety messages in this section point out situations which can be encountered during the normal operation and maintenance of your machine. These safety messages also give possible ways of dealing with these conditions.*

Additional safety messages are used in the text of the manual to show specific safety hazards.

BEFORE OPERATION

Do not wear loose clothing or jewelry that can catch on controls, etc. Safety shoes, heavy gloves, ear protection, etc., can also be required for your protection.

Foreign material or grease on the steps and hand rails can cause an accident. Keep the steps and hand rails clean.



Remove all loose objects from the operators area and from the machine. Loose objects can jam controls and cause accidents.

Engine exhaust fumes can cause death. If you operate this machine in an enclosed area, use good ventilation to replace the exhaust fumes with fresh air.

Make sure all persons are away from the machine before you start the engine.

Before you start the engine, always fasten the seat belt and pull down the operators protection bars.

Use hand rails and step provided. Do not rush.

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Removal

STEP 116
Park the machine on a level surface.

STEP 117
Remove the pins that hold the strut in position and lower the strut onto the lift cylinder.

STEP 118
Start the engine and run the engine at low idle.

STEP 119
Move the machine forward or backward as required to make sure that the pin in each parking latch engages the cluster sprocket.

STEP 120
Raise the loader frame until the strut falls onto the piston rod. Then lower the loader frame until the strut is against the end of the lift cylinder. Stop the engine.

STEP 121

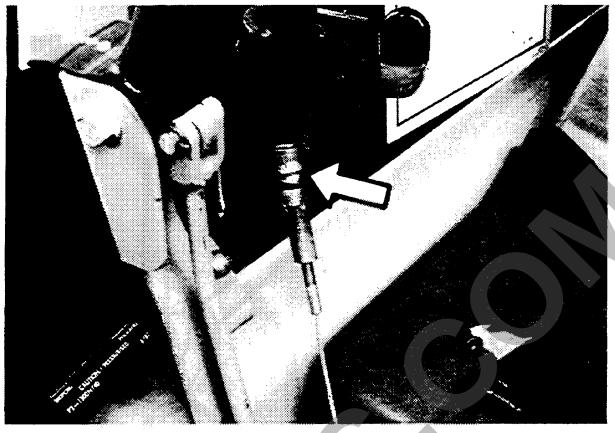
877240

Install the pins that hold the strut.

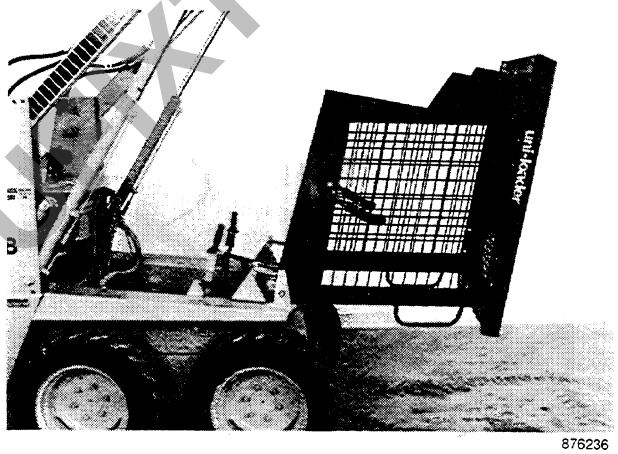
STEP 122


876214

Loosen and remove the cap screws, lock washers, and flat washers that fasten the ROPS canopy to the posts on the rear of the machine.

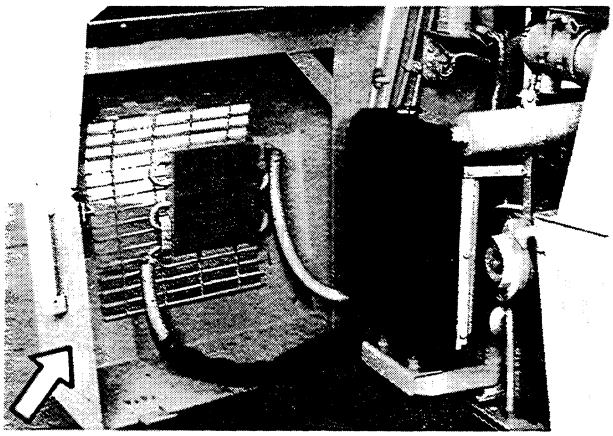
STEP 123

876240

Disconnect the cables from the protection bars. Push down the sleeve on the socket and remove the socket from the pin.

STEP 124


876236

Use the grab handles and tilt the ROPS canopy all the way forward.

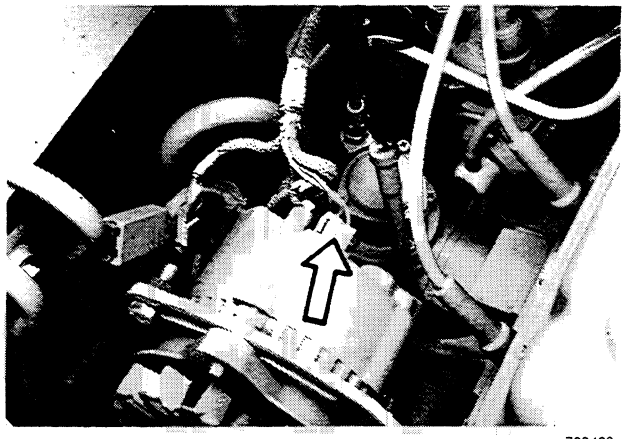
STEP 125

877243

Open the access door on the rear of the machine.

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STEP 81



709408

Connect the electrical connector to the alternator.

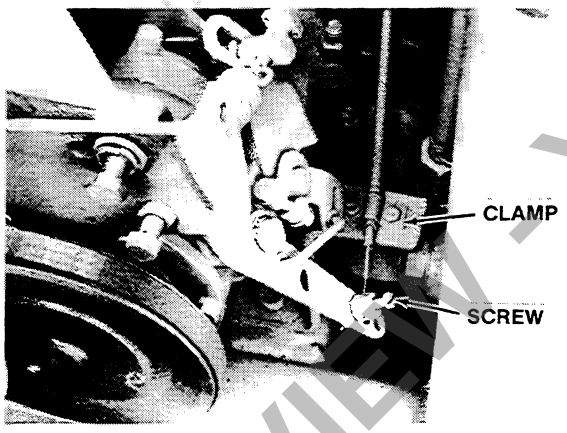
STEP 82

Make sure that the throttle lever is in the low idle position.

STEP 83

Make sure that the arm on the governor is moved all the way toward the rear of the machine.

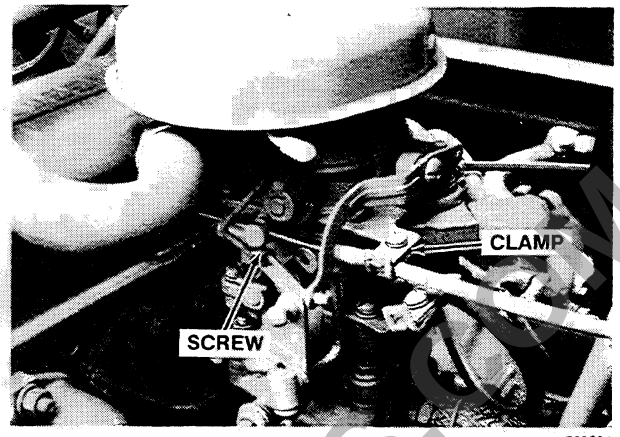
STEP 84



709528

Put the throttle cable in position in the clamp and in the wire lock. Tighten the screw on the wire lock. Tighten the bolts on the clamp.

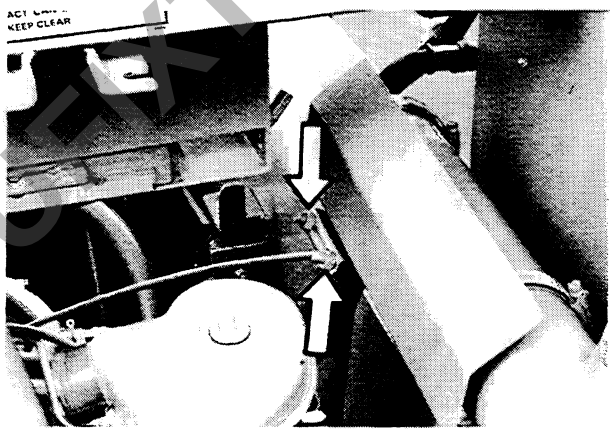
STEP 85



709524

Put the choke cable in position in the clamp and in the wire lock. Tighten the screw on the wire lock. Tighten the bolts on the clamp.

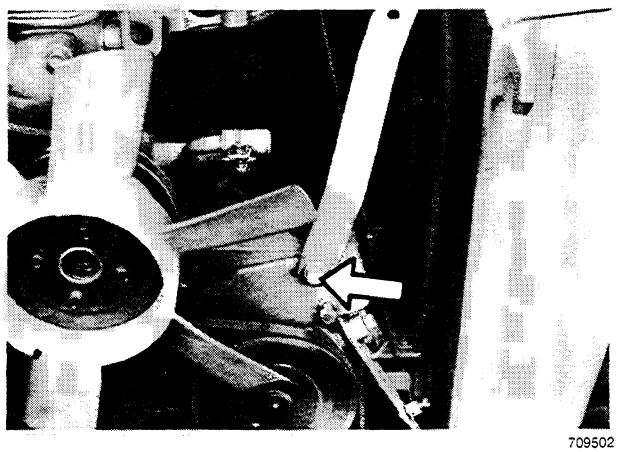
STEP 86



709434

Put the muffler in position on the extension pipe on the engine. Tighten the nuts on the clamp that fastens the muffler to the extension pipe.

STEP 87



709502

Install the bolt, flat washers, and self-locking nut that fastens the muffler mounting clamp to the bracket.

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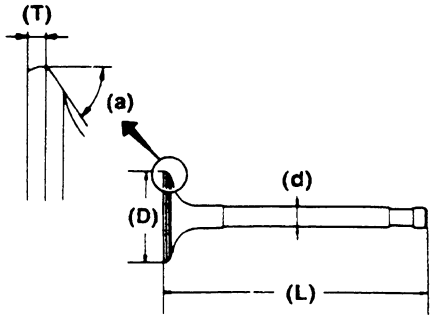
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DETAILED SPECIFICATIONS

Cylinder Head

Maximum Warpage	0.0020 inch	0.05 mm
Limit	0.004 inch	0.1 mm

Valves



Valve Head Diameter (D)		
Intake	1.378 inch	35.0 mm
Exhaust	1.142 inch	29.0 mm
Valve Stem Diameter (d)		
Intake	0.3134 to 0.3140 inch	7.960 to 7.975 mm
Exhaust	0.3128 to 0.3134 inch	7.945 to 7.960 mm
Valve Length (L)	4.0748 to 4.0945 inch	103.5 to 104.0 mm
Valve Seat Angle (a)	45° 30'	45° 30'
Valve Margin (T)		
Standard	0.051 inch	1.3 mm
Limit	0.020 inch	0.5 mm
Valve Stem End Surface Grinding Limit	0.020 inch	0.5 mm
Valve Clearance (In.& Ex)		
Hot	0.014 inch	0.35 mm
Cold	0.010 inch	0.25 mm

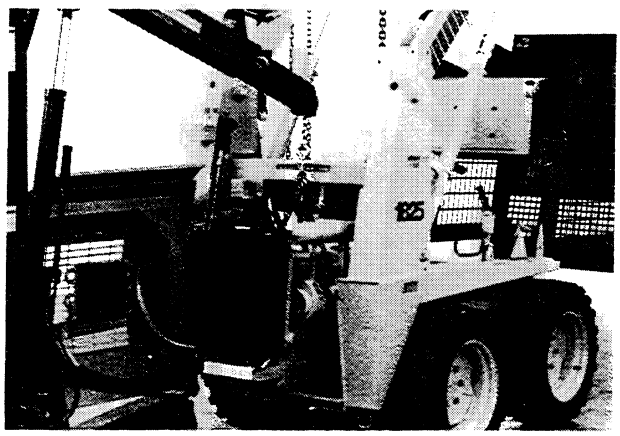
Valve Spring

Free Height	1.831 inch	46.5 mm
Pressure Height	1.189 inch	30.2 mm
Pressure	120 to 138 lb	54.4 to 62.6 mm
Out Of Square Limit	0.063 inch	1.6 mm

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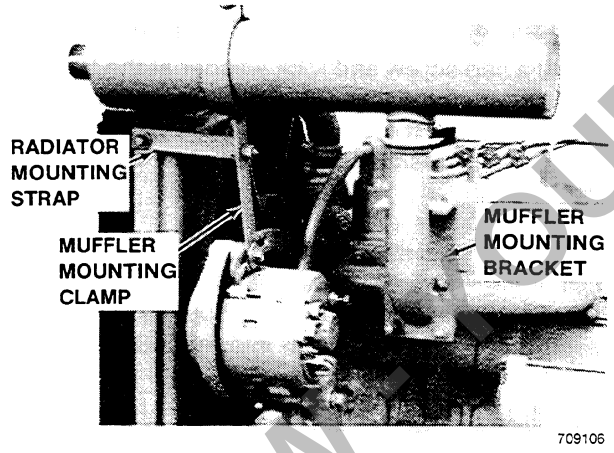
STEP 158



709006

Move the rear of the engine up until the oil pan is clear of the frame. Remove the engine and radiator from the machine. Be careful not to damage the clamps for the air cleaner.

STEP 159



709106

Remove the cap screw, lock washer, and flat washer that fasten the muffler mounting clamp to the alternator. Move the muffler mounting clamp out of the way. Install the cap screws, lock washer and the flat washer in the alternator. Remove the cap screw, lock washer, and flat washer that fasten the radiator mounting strap to the radiator.

STEP 160

Loosen and remove the nuts and lock washers that fasten the muffler mounting bracket to the exhaust manifold. Remove the muffler from the engine.

STEP 161

Open the drain valve on the bottom of the radiator. Drain the coolant from the radiator. The radiator capacity is approximately 7 U.S. quarts (6.6 litres).

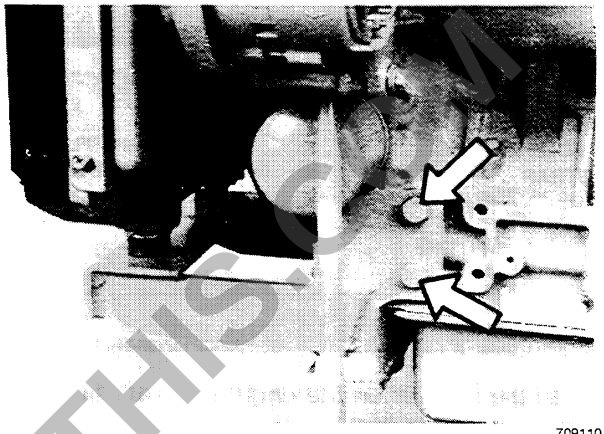
STEP 162

Disconnect the top and bottom radiator hose from the radiator.

STEP 163

Remove the cap screws and lock washers that fasten the radiator mounting strap to the radiator and the left side of the engine.

STEP 164

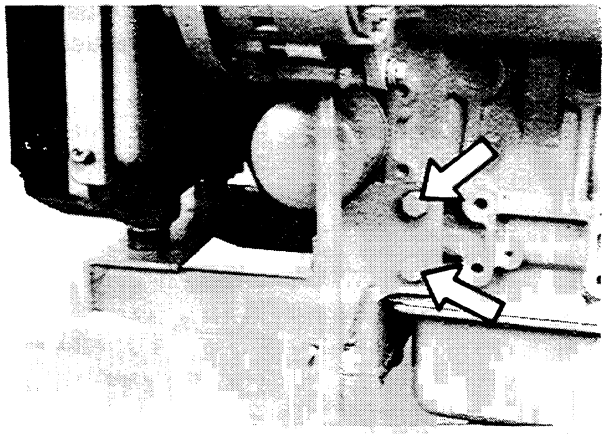


709110

Loosen and remove the cap screws and lock washers that fasten the radiator and rear engine mounting bracket to the engine. Remove the radiator and rear engine mounting bracket from the engine.

Installation

STEP 165



709110

Put the radiator and rear engine mounting bracket in position on the engine. Install the cap screws and lock washers that fasten the radiator and rear engine mounting bracket to the engine.

STEP 166

Install the cap screws and lock washers that fasten the radiator mounting strap to the radiator and the left side of the engine.

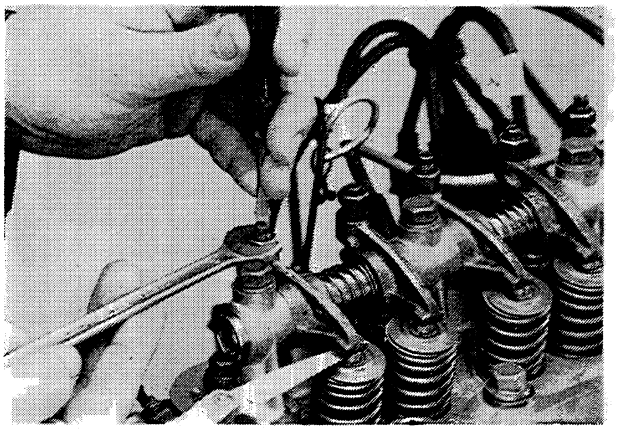
STEP 167

Connect the top and bottom radiator hose to the radiator.

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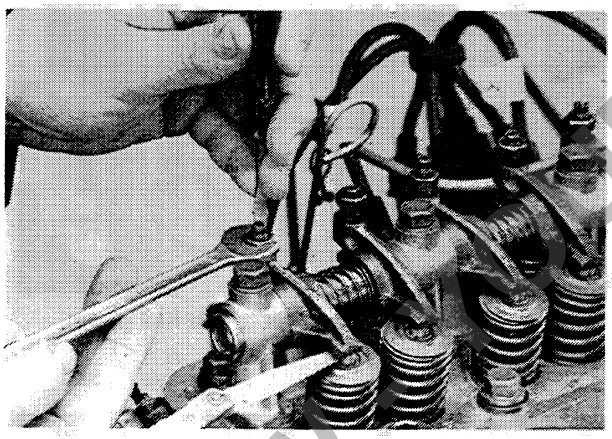
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STEP 155



Hold the locknut with a spanner and turn the adjusting screw down until a clearance of 0.098 inch (0.25 mm) is reached.

STEP 156

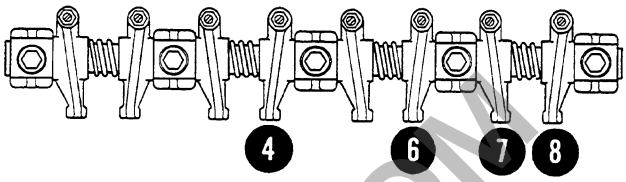


Hold the adjusting screw, tighten the locknut and check the valve clearance.

STEP 157

Put your fingure over No 4 spark plug hole and crank the engine by hand in a clockwise rotation (as seen from the front) until air is exhausting, (compression stroke).

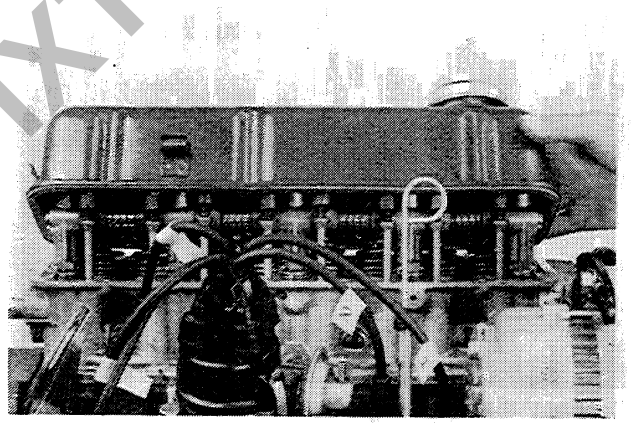
STEP 158



Repeat Steps 153 to 155 and adjust valves 4, 6, 7, and 8.

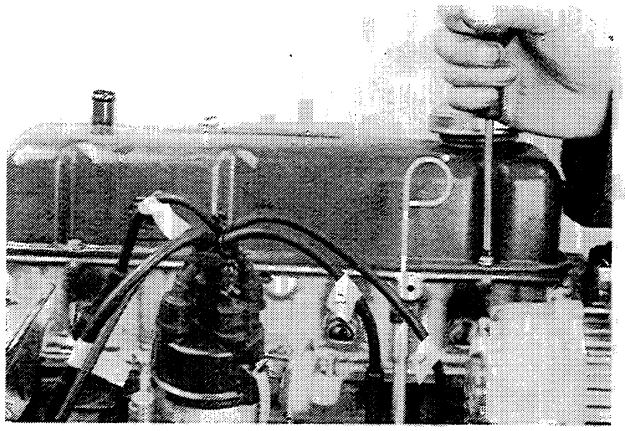
NOTE: *The valve clearance settings given in this Section is for a cold engine only. The valves must be adjusted to the correct clearances of 0.014 inch (0.35 mm) when the engine is warm.*

STEP 159



Fit a new gasket and install the valve cover.

STEP 160

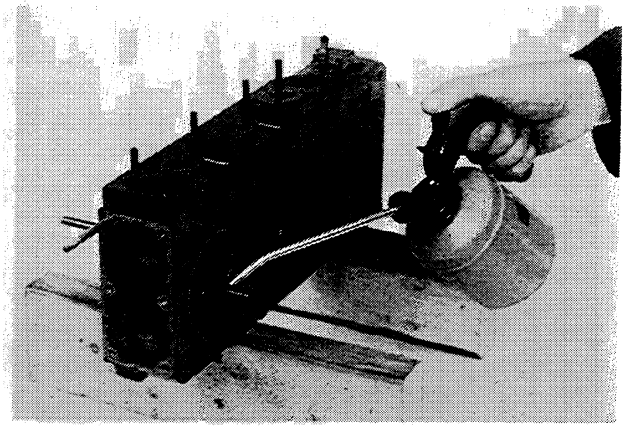


Install and tighten the valve cover screws.

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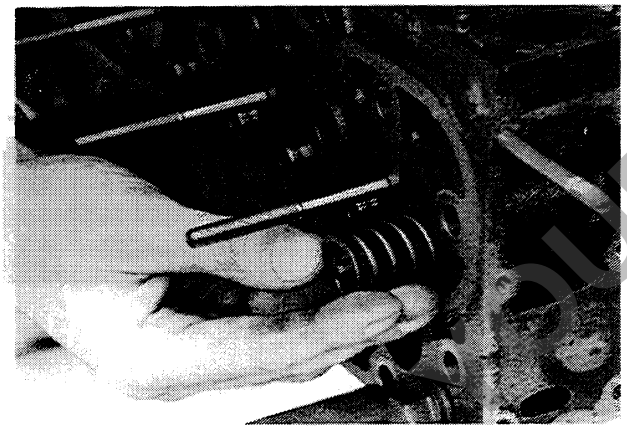
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STEP 97



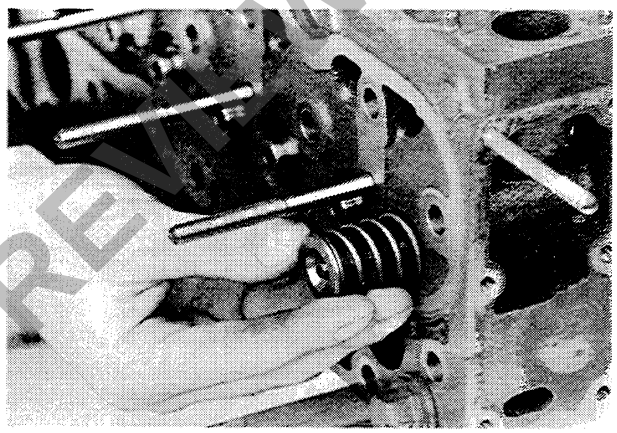
Install the exhaust valve into the cylinder head.

STEP 98



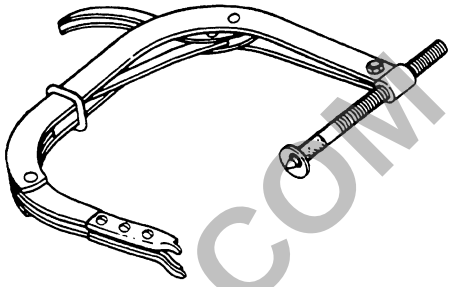
Install the valve spring.

STEP 99



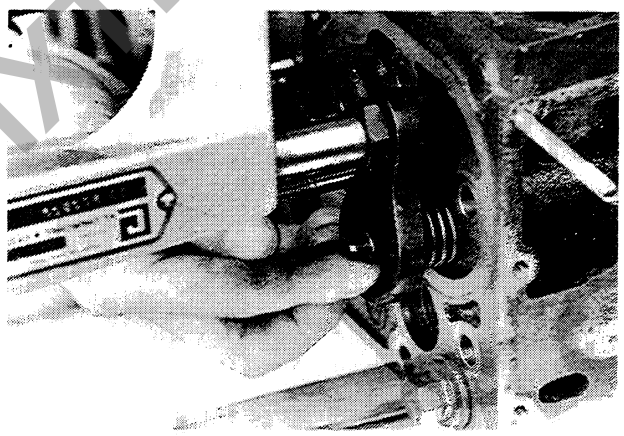
Install the valve retainer.

STEP 100



Use a spring compressor to compress the valve spring.

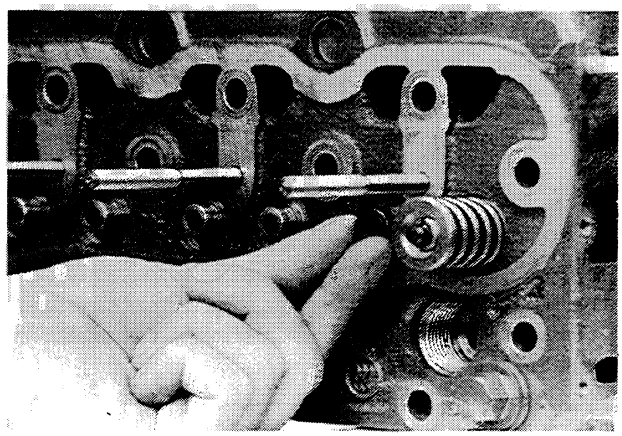
STEP 101



Fit the two valve keepers

NOTE: *If a new valve has been installed, fit new valve keepers.*

STEP 102

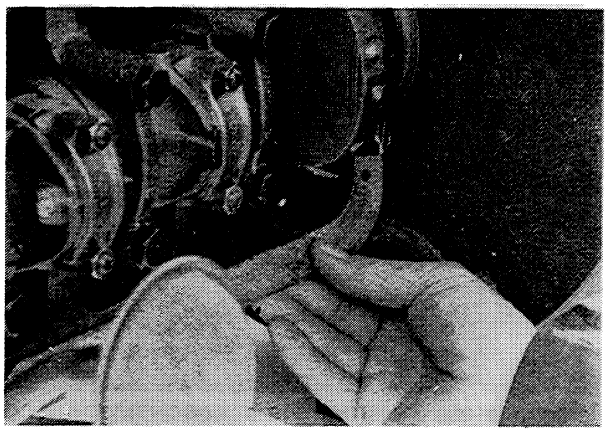


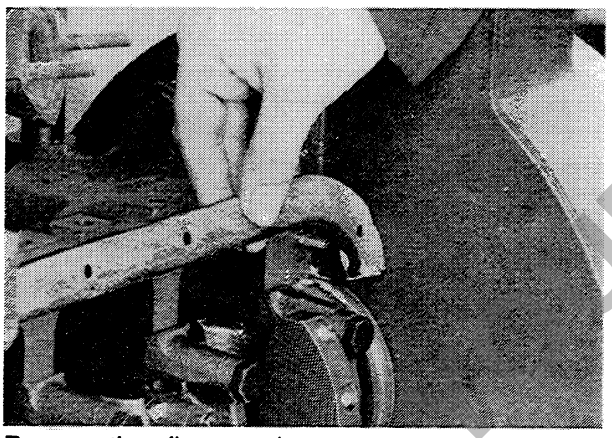
Install a new valve stem seal onto the inlet valve guide.

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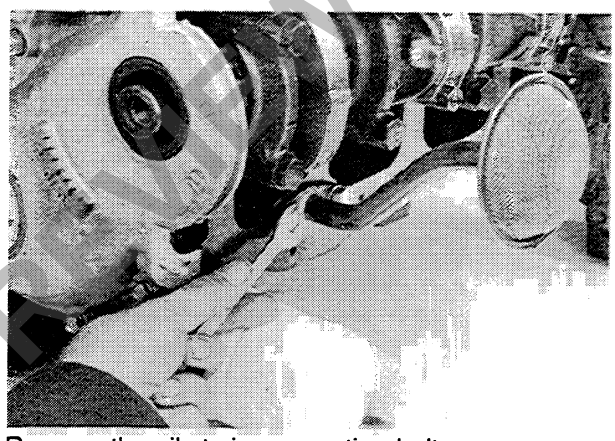
STEP 7





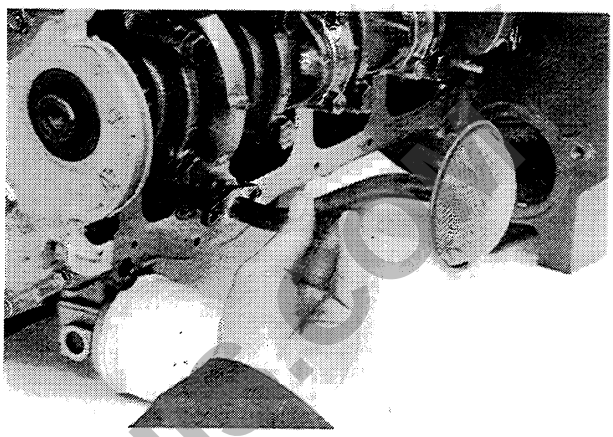
Remove the oil pan gaskets.

STEP 8



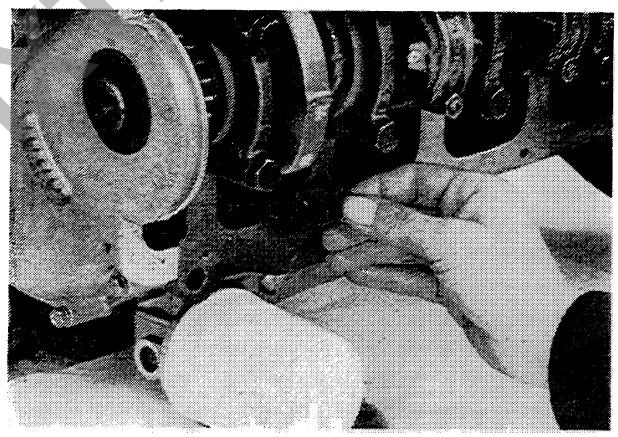
Remove the oil strainer mounting bolts.

STEP 9



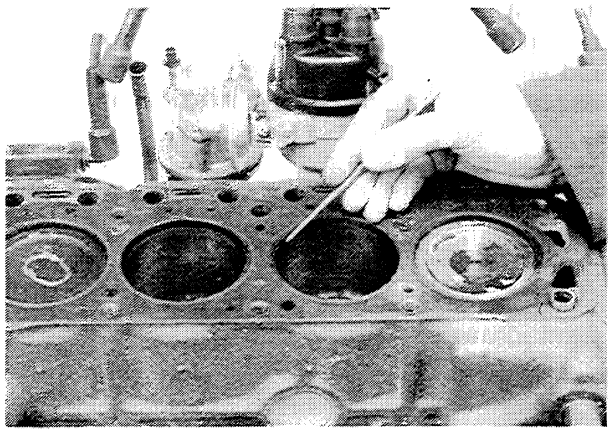
Remove the oil strainer.

STEP 10



Remove the oil strainer gasket.

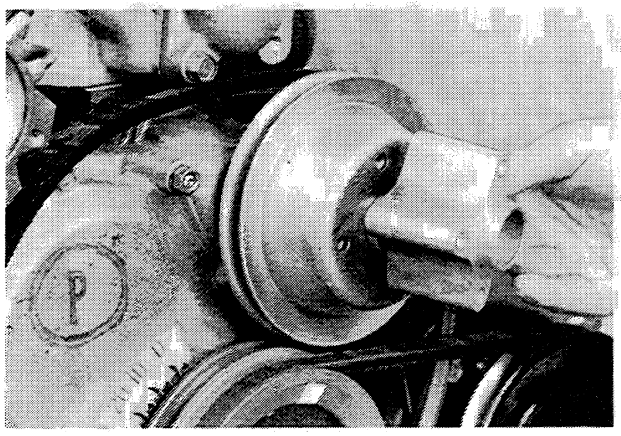
STEP 11



Remove the carbon from the top of the cylinder bores. Check the bore walls for a ridge at the top of the piston ring movement zone. A ridge will cause damage to the piston during removal. If a ridge is present, remove it using a suitable ridge reamer.

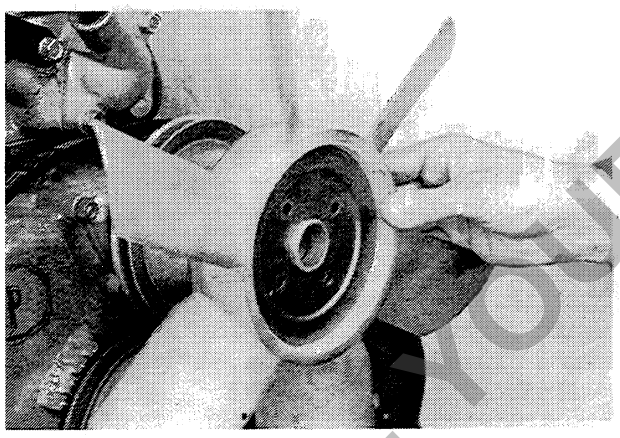
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STEP 65



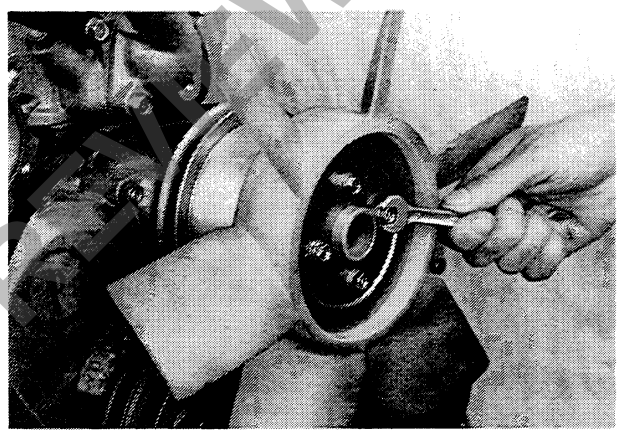
Install the spacer.

STEP 66



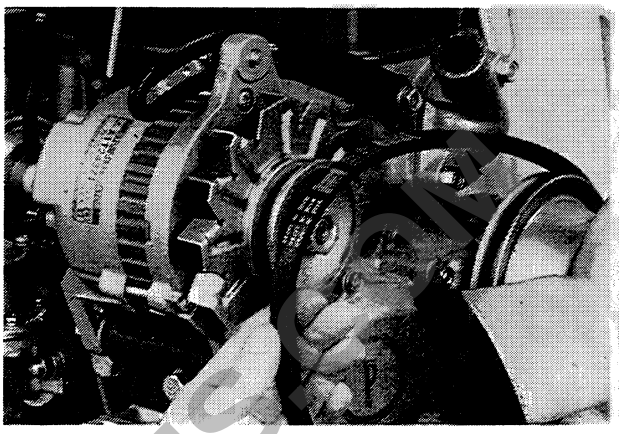
Install the fan.

STEP 67



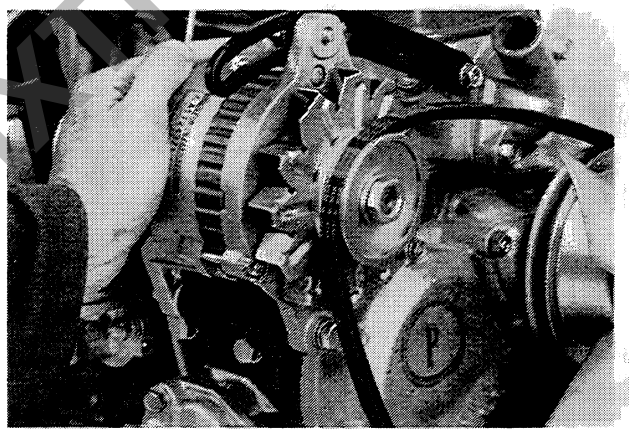
Install and tighten the fan mounting bolts.

STEP 68



Install the alternator drive belt.

STEP 69

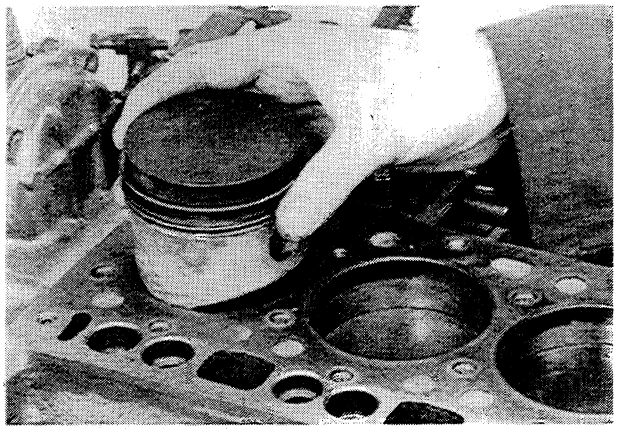


Pull the alternator away from the engine to apply the correct tension to the drive belt. The correct tension is when the deflection of the drive belt is 0.31 to 0.47 inch (8 to 12 mm), with a force of 22 lb (10 kg) applied to the drive belt in the middle of the alternator pulley and water pump pulley.

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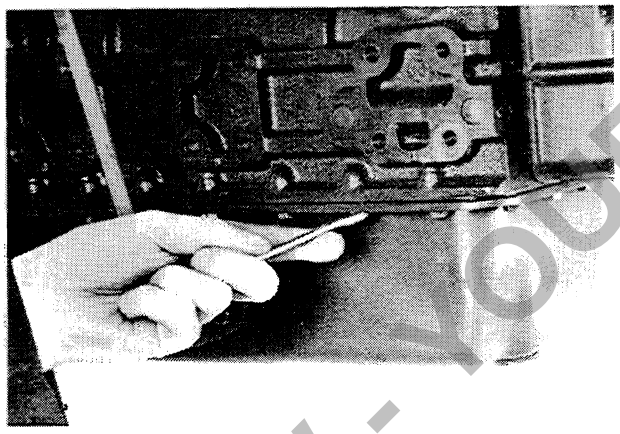
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STEP 181



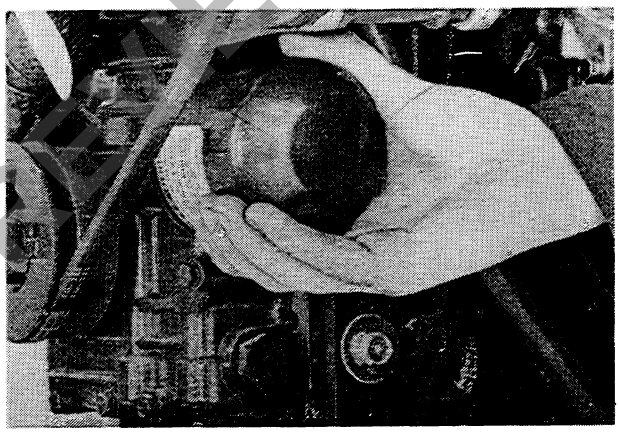
Install the connecting rods and pistons. Refer to Secton 2025.

STEP 182



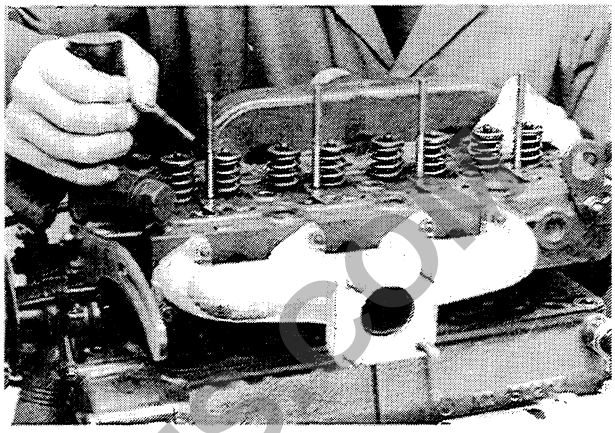
Clean and then install the oil strainer and oil pan. Refer to Section 2045.

STEP 183



Replace the oil filter cartridge. Refer to Section 2045.

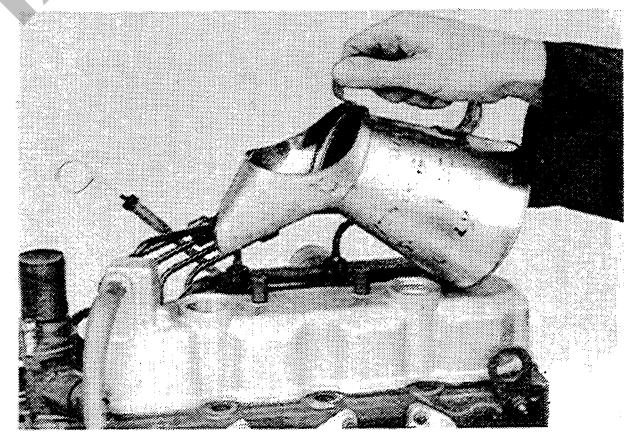
STEP 184



Install the cylinder head. Refer to Section 2015.

IMPORTANT: *Check the height of each piston above the top of the engine block. Do this so that if necessary shims can be added between the cylinder head and gasket. Refer to Section 2015.*

STEP 185



Add new engine oil through the rocker shaft cover. Check the oil level on the dipstick.

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SAFETY RULES

CAUTION: *Add coolant to the radiator only when the engine is stopped or slowly idling. To avoid being scalded when the pressure-type filler cap is being removed, turn the cap slowly to the first stop position to relieve pressure before removing the cap.*

To remove the system pressure, slowly turn the radiator cap counterclockwise to the FIRST stop. This will permit a gradual release of pressure with little coolant loss.

Never put coolant in a hot engine. The engine block or cylinder head can get cracks because of the difference in temperature between the metal and coolant.

HOW TO CLEAN THE COOLING SYSTEM

Clean the cooling system every 400 hours or when changing from winter to summer coolant. In areas when the water has minerals, clean the system with more frequency.

1. When the coolant is hot, open the radiator and engine block drain valves. Close the valves when the system is empty.

2. Add a radiator cleaner and fill the system with clean water. Use a good type of radiator cleaner. Follow the instructions given with the radiator cleaner.

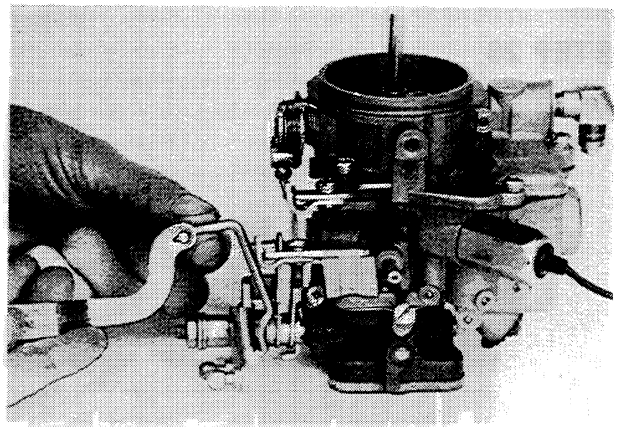
3. Remove the radiator cleaner solution. Flush the system with clean water. Fill the system with antifreeze and water for operation. Check the hoses, radiator and water pump for leaks.

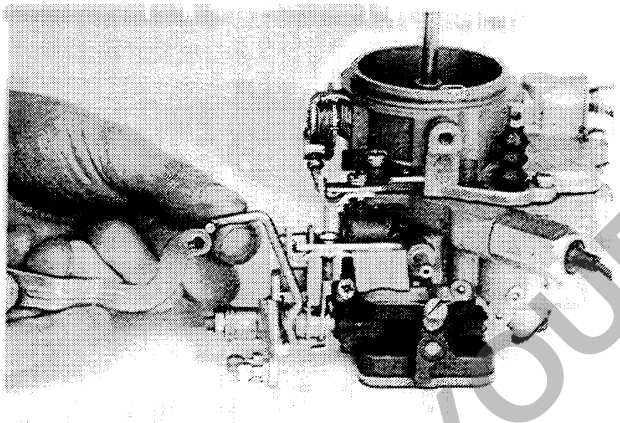
NOTE: *After the cooling system is completely filled, run the engine for approximately 20 minutes to remove all the air from the system. Check coolant level and add coolant if necessary.*

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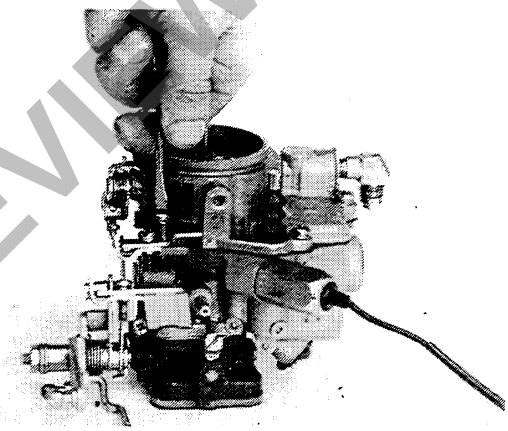
STEP 21





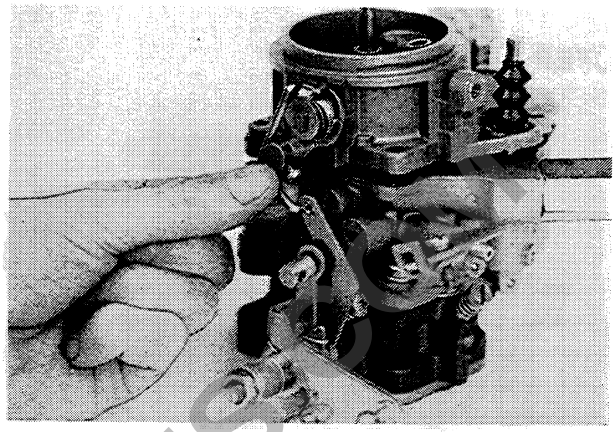
Disconnect the accelerating pump lever from the accelerating pump rod by correctly aligning the notch with the lug.

STEP 22



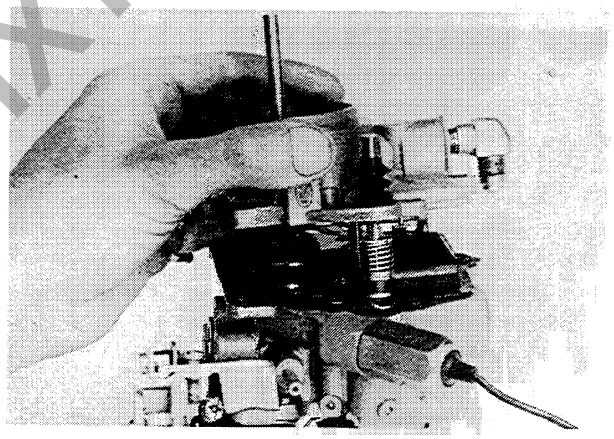
Remove the five screws that secure the choke chamber to the centre body. Make a note of the position of the choke cable arm.

STEP 23



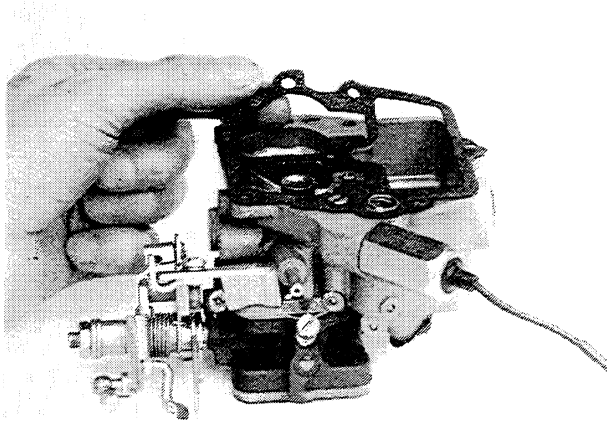
Lift up the choke chamber and disconnect the choke connecting rod from the starting lever by correctly aligning the notch with the lug.

STEP 24



Remove the choke chamber assembly.

STEP 25

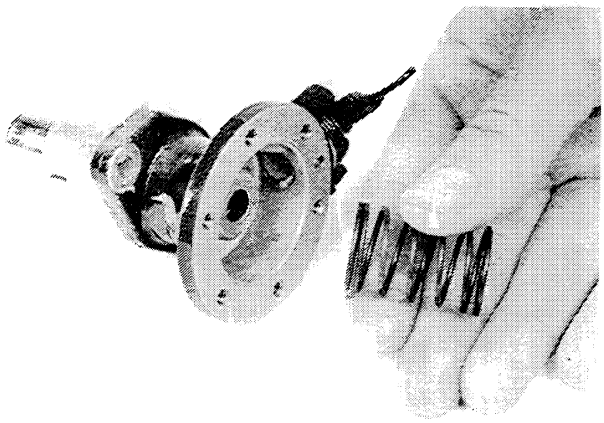


Remove and discard the gasket.

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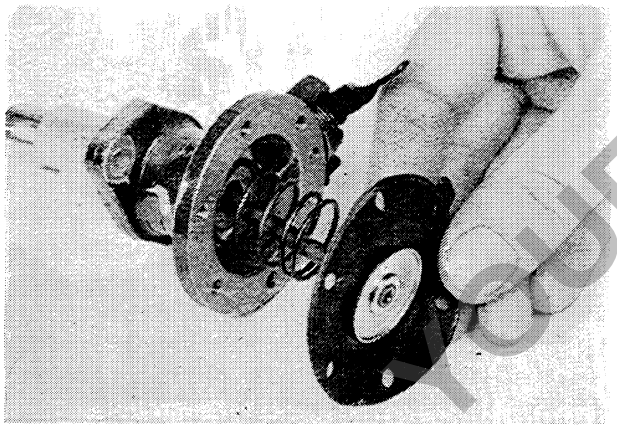
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STEP 22



Install the diaphragm spring.

STEP 23



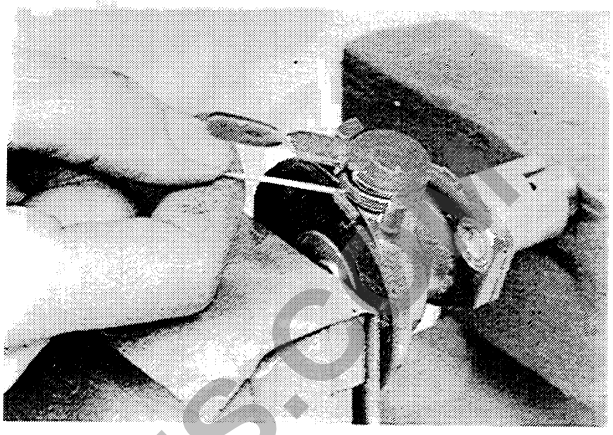
Install the diaphragm so that the tab is aligned with the hand operating lever.

STEP 24



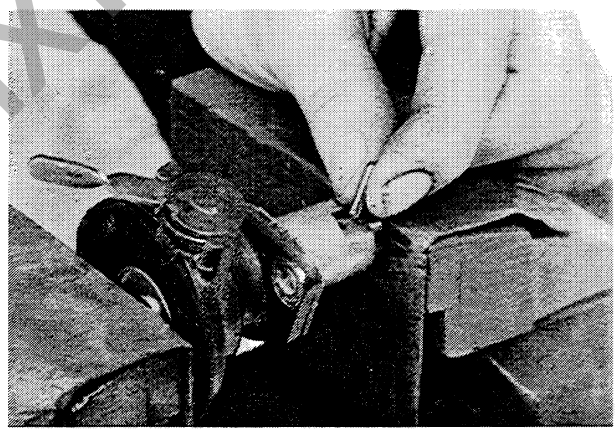
Turn the cam follower to align the pin hole with the hole in the diaphragm.

STEP 25



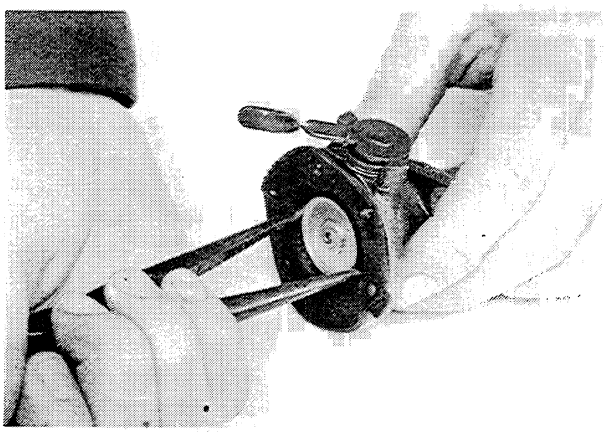
Carefully hold the assembly in a vise fitted with soft jaw plates. Check that the diaphragm tab is aligned with the hand operating lever.

STEP 26



Install the pin.

STEP 27



Remove the assembly from the vice. Turn the diaphragm 90 degrees (1/4 of a revolution) clockwise.

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BATTERY TEST

NOTE: *To correctly test a battery, do each part of the battery test until you know the condition of the battery.*

Visual Checks

1. Make sure the cable connections are clean and tight. Clean foreign material from the top of the battery.

2. Inspect the battery case, battery posts, and cables for damage.

3. Check the electrolyte level. See page 4005-3.

4. If you added water to the battery, the battery must be charged for 15 minutes at 15 to 25 amperes to mix the water with the electrolyte.

Specific Gravity Check

A hydrometer is used to check the specific gravity (weight) of the electrolyte. The specific gravity is an indication of the level of charge for each cell.

Hydrometers are made to show the correct specific gravity when the temperature of the electrolyte is 80°F (26.7°C).

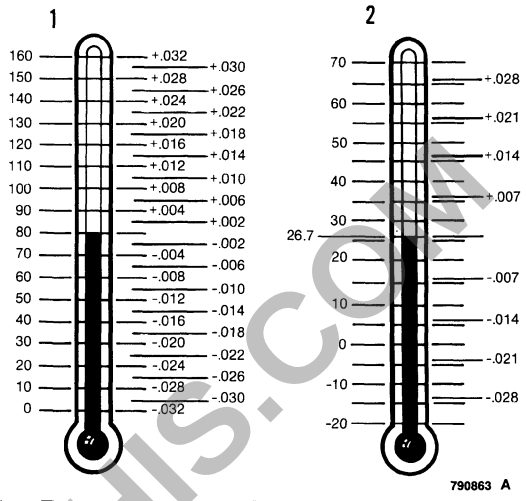
When you check the specific gravity, you must know the temperature of the electrolyte. If your hydrometer does not have a thermometer, get a thermometer to check the temperature of the electrolyte. The thermometer must indicate a high temperature of at least 120°F (52°C).

1. Remove enough electrolyte from a cell so that the float is free in the tube.

NOTE: *If the specific gravity cannot be checked without first adding water to the cell, the battery must be charged for 15 minutes at 15 to 25 amperes to mix the water with the electrolyte. Then check the specific gravity.*

2. Read the float.

3. Read the thermometer. If the reading is above 80°F (26.7°C) add specific gravity points to the reading for specific gravity. If the reading is below 80°F (26.7°C) subtract specific gravity points from the reading for specific gravity. See the following illustration and add or subtract specific gravity points as needed.



1. *Temperature in °F*
2. *Temperature in °C*

Specific Gravity Chart

4. Make a record of the corrected specific gravity reading for each cell.

5. If the difference between the high reading and the low reading is .050 or more, charge the battery and check the specific gravity again. If after charging, the difference is still .050 or more, install a new battery.

6. The corrected specific gravity reading shows the level of charge for the cell. The level of charge must be at least 75% in each of the cells. In maintenance free batteries the level of charge is at least 75% if the corrected specific gravity reading is 1.240 or higher. In all other batteries the level of charge is at least 75% if the corrected specific gravity reading is 1.230 or higher.

7. If the difference between the high reading and the low reading is less than .050, and the level of charge is at least 75% in all of the cells, do the Capacity (Load) Test.

8. If the difference between the high reading and the low reading is less than .050, but the level of charge is less than 75% in any of the cells, charge the battery and check the specific gravity again. If after charging:

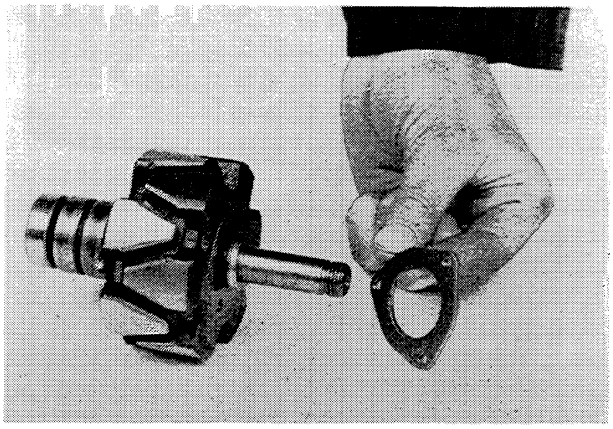
   a. The level of charge is less than 75% in any of the cells, discard the battery.

   b. The level of charge is at least 75% in all of the cells, do the Capacity (Load) Test.

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STEP 56



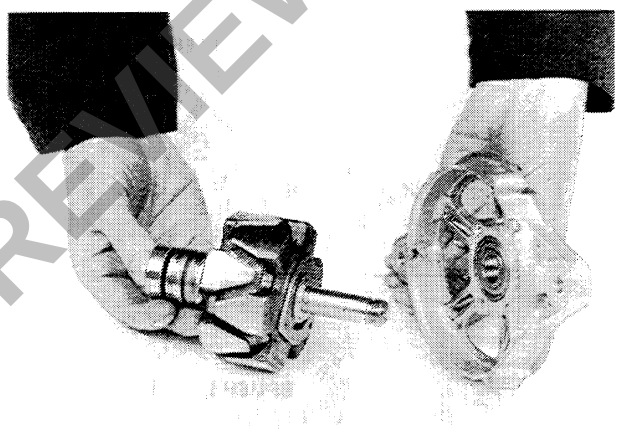
Install the bearing retainer.

STEP 57



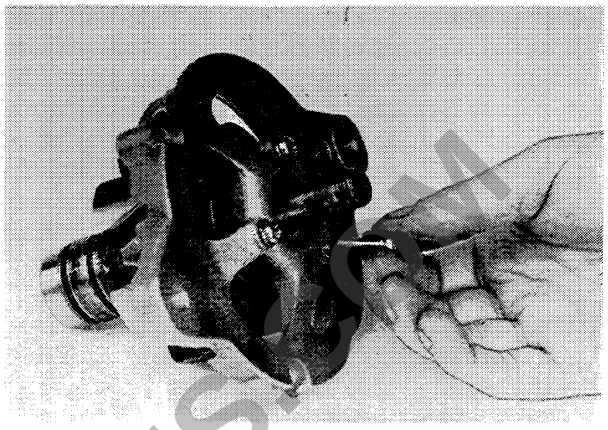
Use a suitable drift and install the front bearing into the front cover.

STEP 58



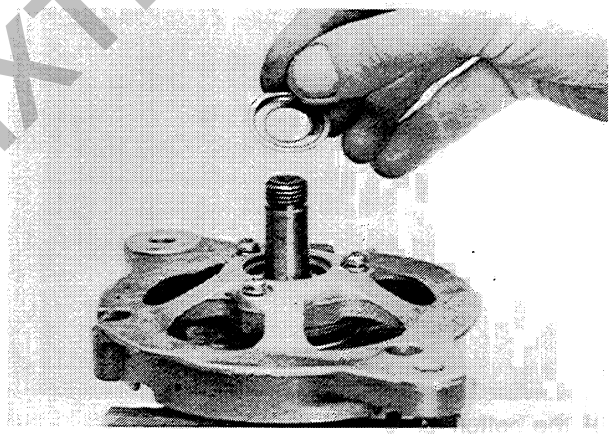
Install the front cover onto the rotor.

STEP 59



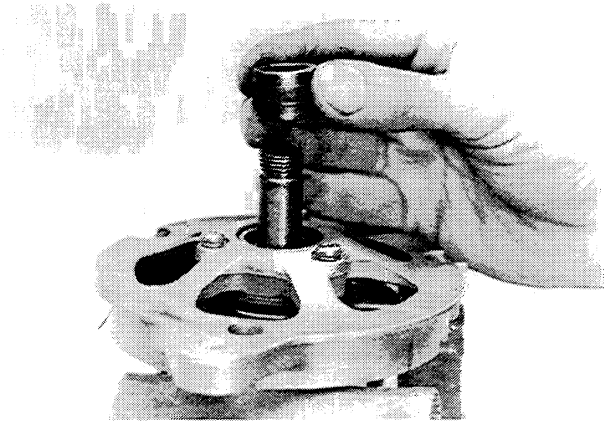
Install and tighten the three bearing retainer screws to a torque of 2.2 to 3.3 lb ft (2.9 to 4.4 Nm).

STEP 60



Install the outer bearing dust cover in its correct position.

STEP 61

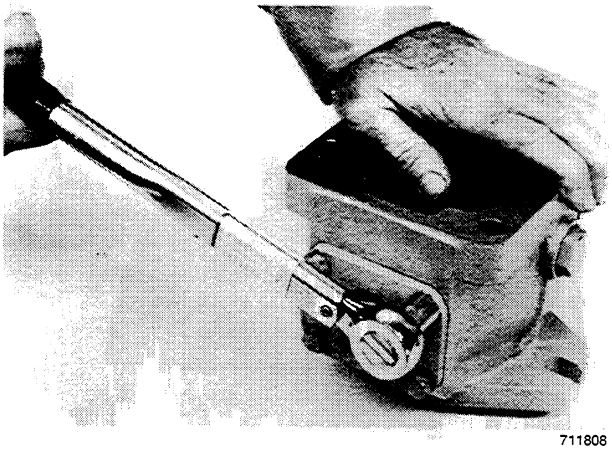


Install the fan spacer.

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STEP 157



711808

Install the remainder of the cap screws and tighten the cap screws to 192 to 219 pound-inches (22 to 25 Nm).

STEP 158



711810

Lubricate the bores in the cylinder block with clean oil.

STEP 159



711814

Install the snap ring.

STEP 160



710517

Install the pistons in the guide.

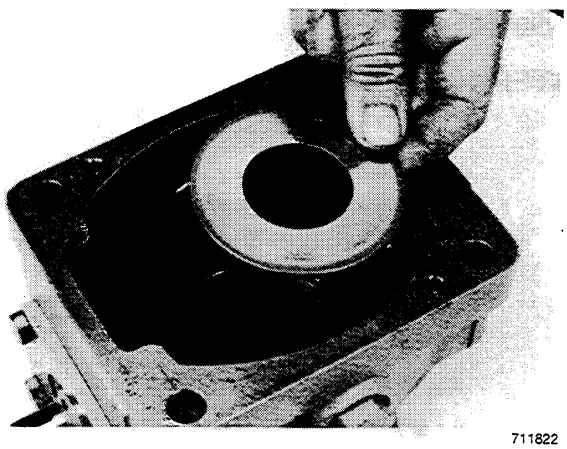
STEP 161



711818

Install the pistons in the cylinder block.

STEP 162



711822

Install the wear plate in the swash plate so that the chamfer on the OD is down.

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8004

HYDRAULIC PUMP

TABLE OF CONTENTS

Specifications 8004-2

Disassembly 8004-3

Inspection 8004-7

Assembly 8004-9

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