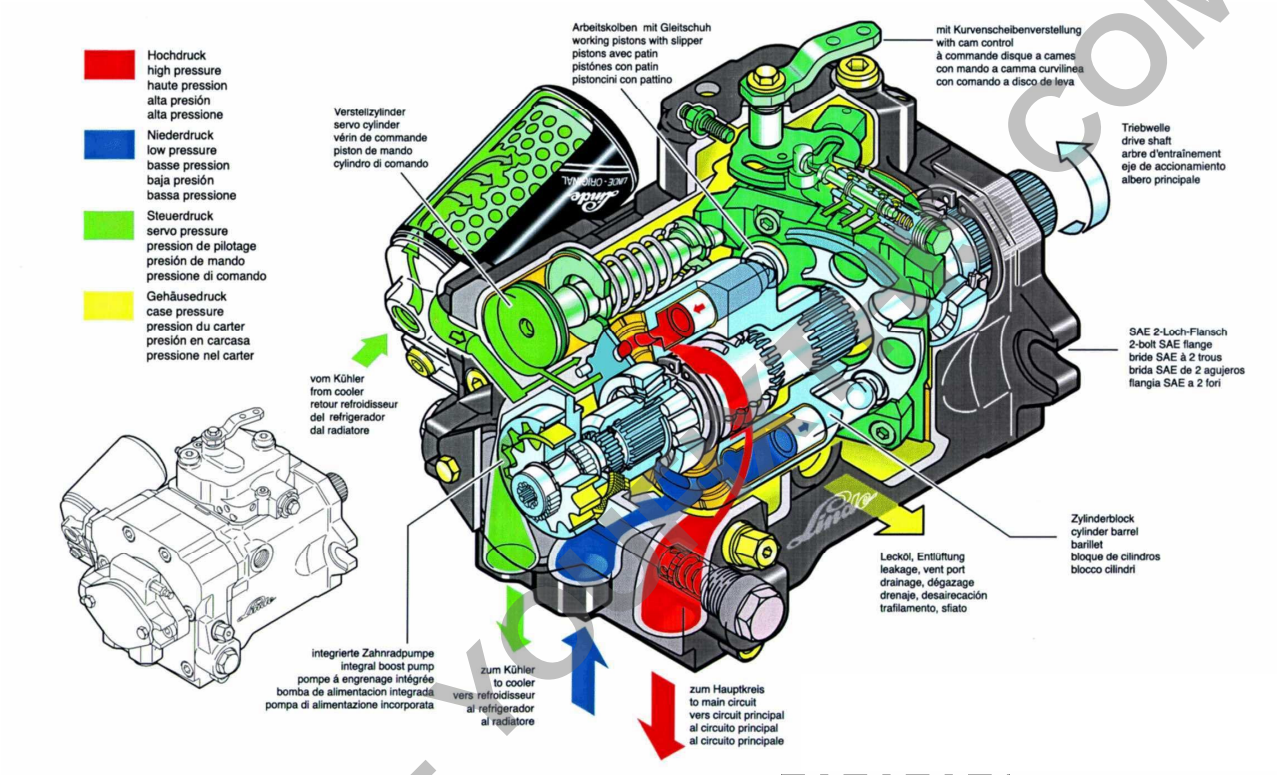
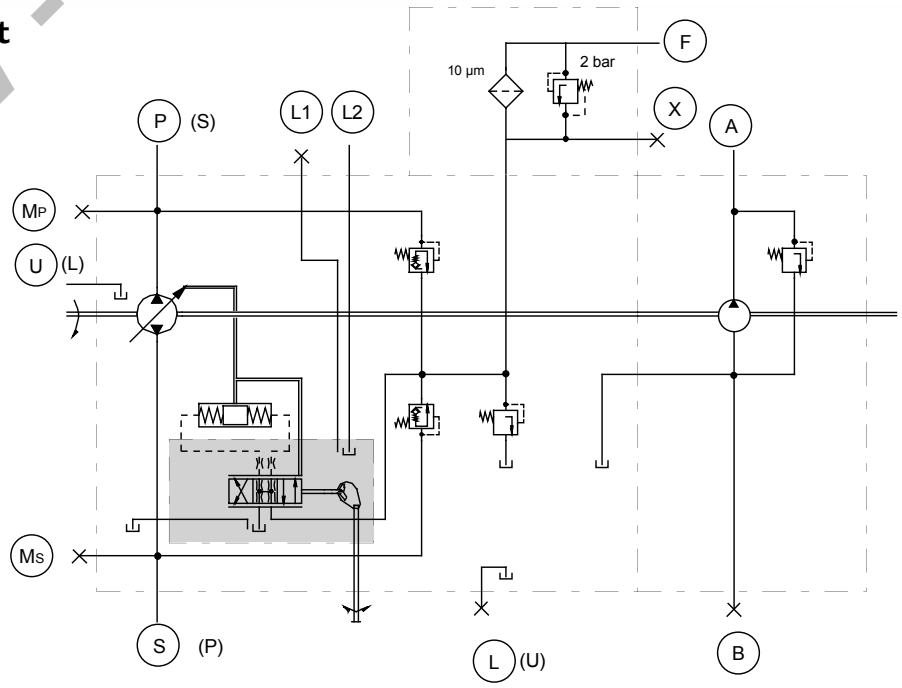
B Sectional view

HPV...-02R with M1 type control



C Standard circuit



EXPLANATIONS	
P, S	High pressure port
A	Pressure port boost pump
B	Suction port boost pump
F	Control pressure supply, Boost
X	Control pressure gage port
Ms, Mp	High pressure gage port
L, U	Drain (filling, vent) ports and flushing return from hydr. motor
L1, L2	Vent ports

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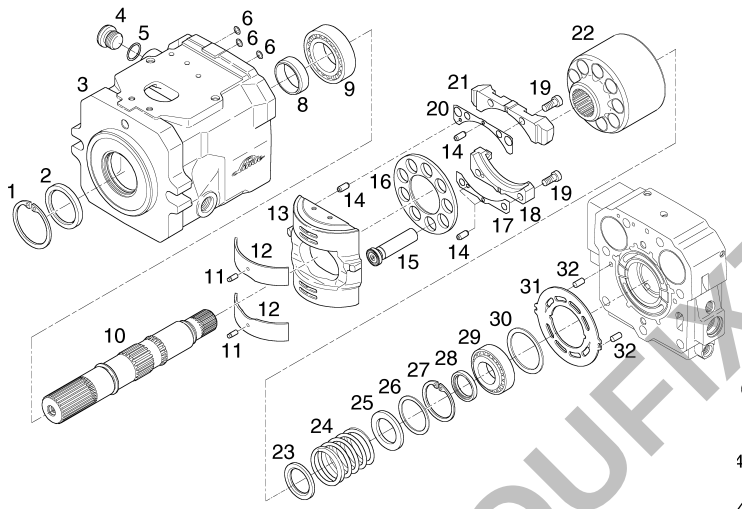
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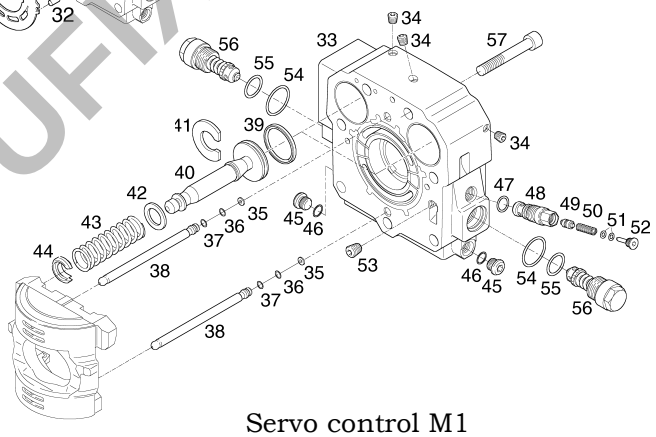
D Detail view

HPV...-02R with M1 type control

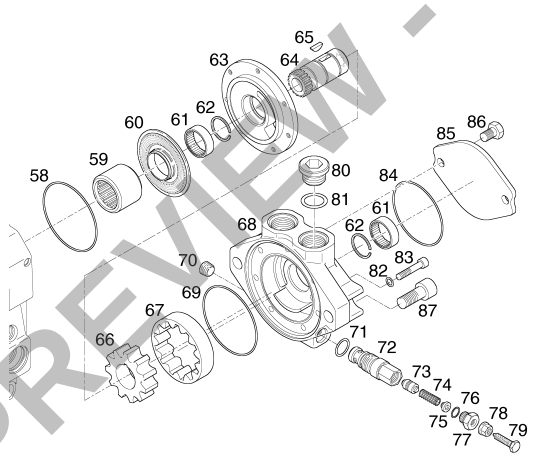
Rotating unit and housing



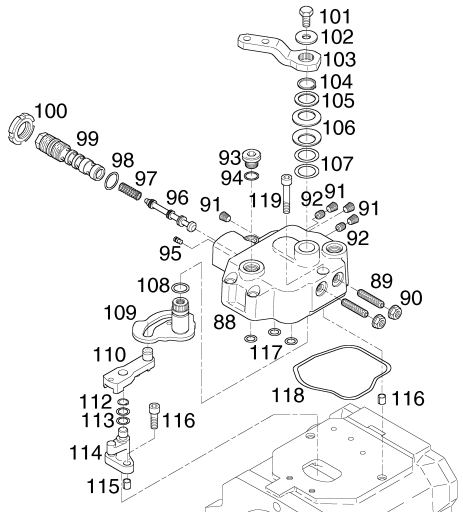
Valve plate housing and valves



Boost pump



Servo control M1

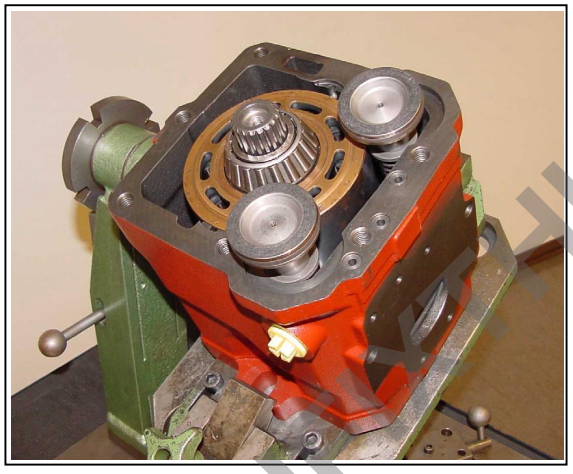


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F 1.11 Disassembly of rotating unit

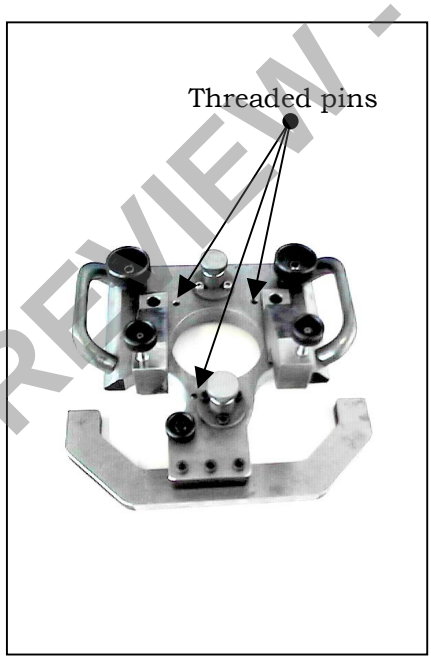
To examine the drive unit thoroughly, or to exchange a part of the drive unit, the latter has to be fitted back in the pump housing.

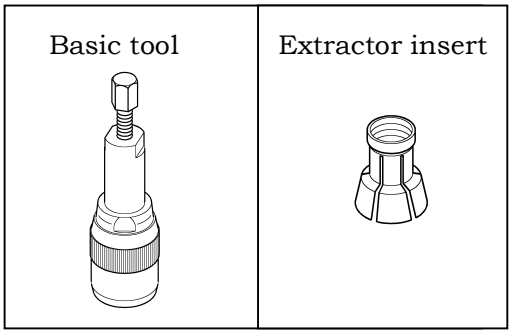


Use the three threaded pins in the device to press the cylinder barrel down **only** as much as not to damage the retainer plate (16).

Important:

When using the prescribed extractor insert (see tools catalogue 200 804 9000/01) make sure to grip the rollers, not the cage, to avoid damage of the cage.







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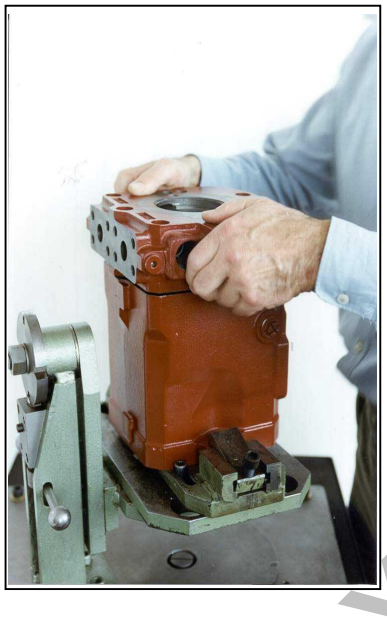
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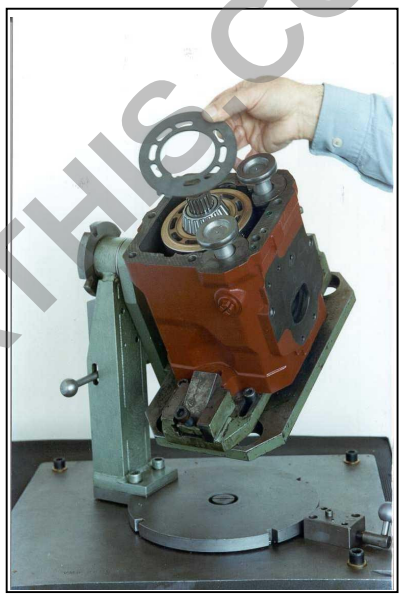
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F 1.8 Continued

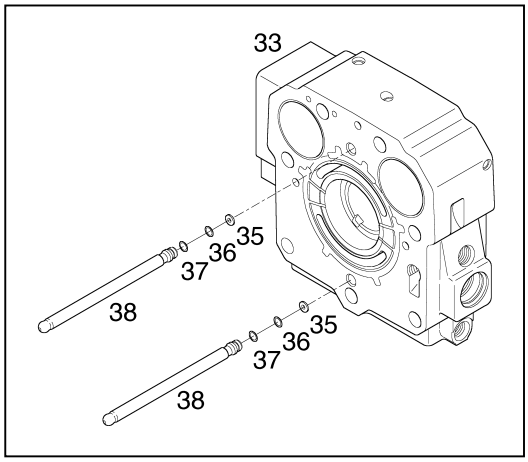
Take valve plate housing (33) off. **Caution:** Do not mix up connecting pipes (38) and shims (35) of P and S, or their axial play will have to be re-adjusted.



Take valve plate away







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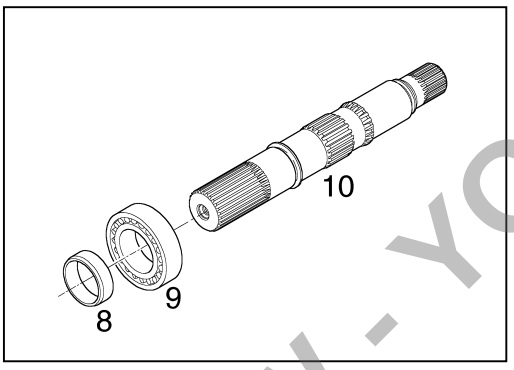
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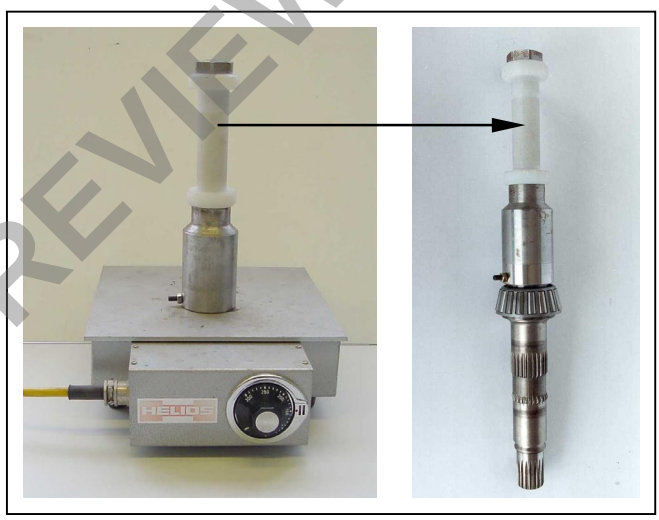
F 2 Assembly

F 2.1 Drive shaft

If the drive shaft (10) is damaged it is replaced incl. bearing (9) and running ring (8).
If the drive shaft can be used again while the bearing and running ring cannot, proceed as follows:

-press old bearing and running ring out under a press.
-Clean the running ring seat on the shaft
-Heat the drive-side bearing up to max.150 °C and fit it.
-Apply Loctite 648 to the seating area of the running ring on the shaft.
-Warm the running ring up, together with the mounting device, to max. 150 °C on a heater and fit it to the shaft using that very mounting device. This is so **important** because the running ring is thus prevented from cooling down too fast, and at the same time it is positioned accurately.

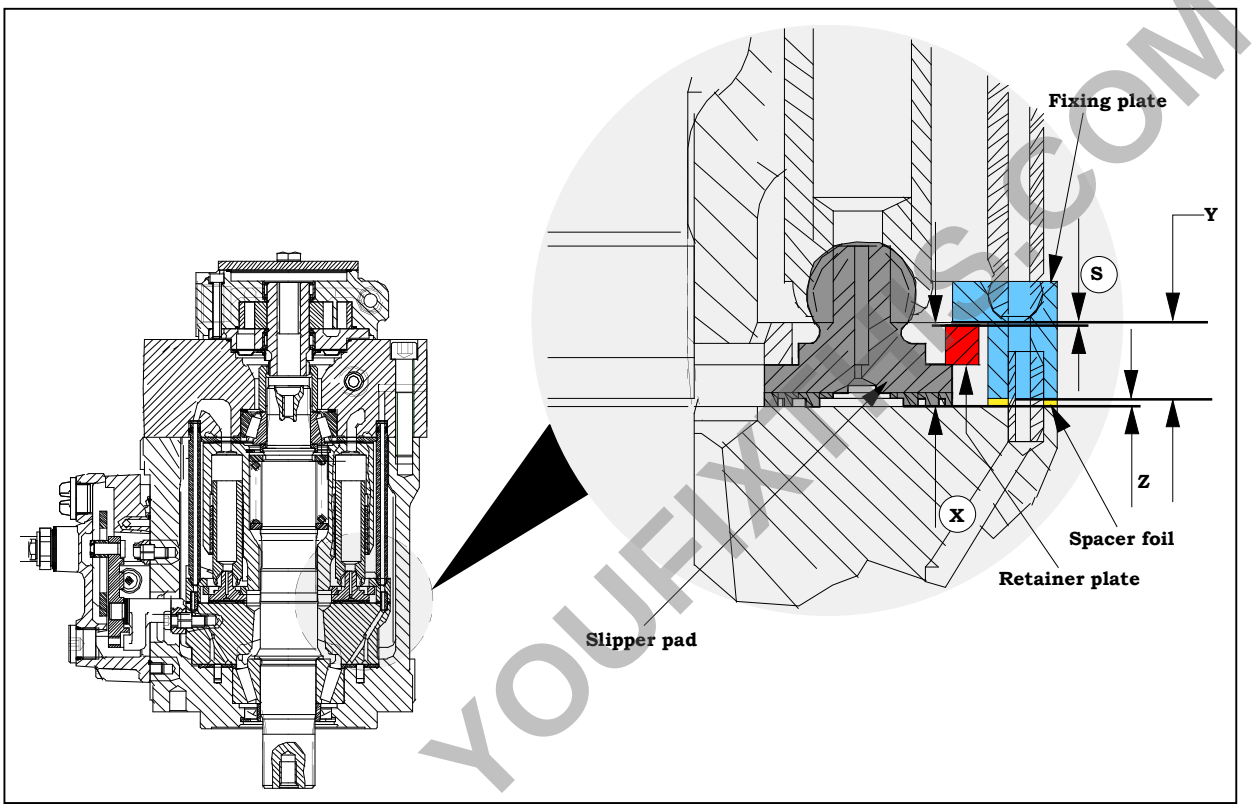


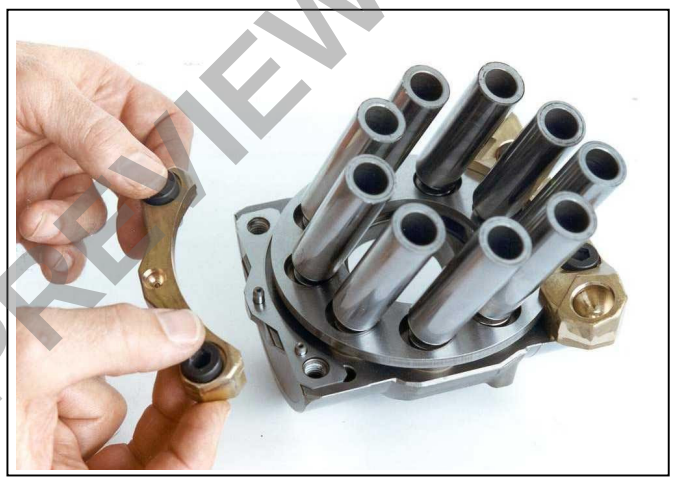


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F 2.3 (continued)





The fixing bolts have to be secured with Loctite Nr. 648. For this dose Loctite moderately in the tap holes of the swash plate (13).
Tighten the bolts (19) with the corresponding torque.

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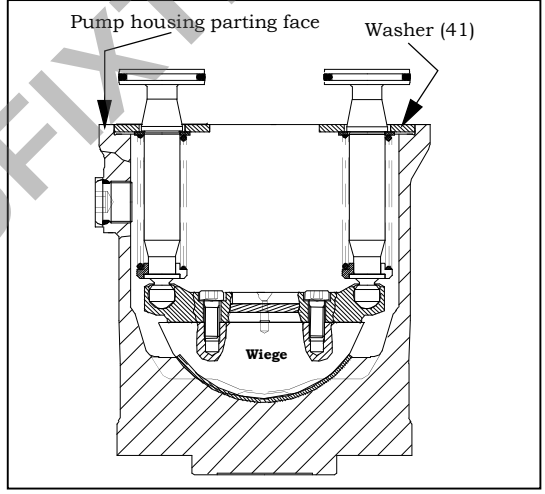
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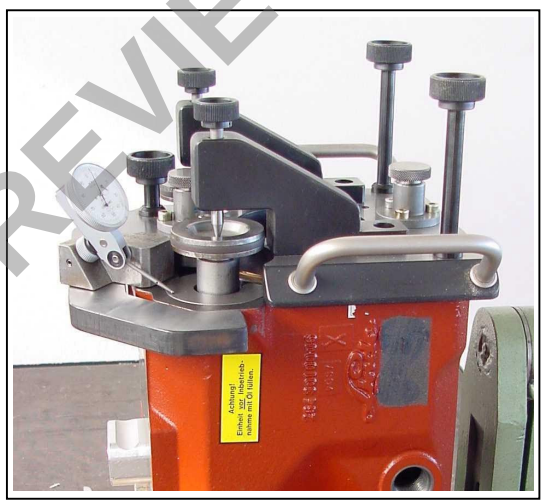
F 2.7 Checking and setting the mechanical zero position

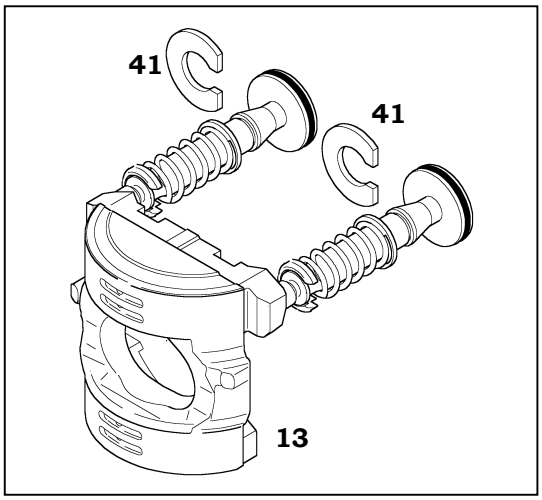
Every time a pump is assembled the mechanical zero position must be checked and adjusted if need be.

Procedure:
Utilize the control piston centering feature of the assembly jig to bring the swash plate (13) in zero position by means of a micrometer gauge. Do not tighten too firmly. Put one washer (41) each on the spring plate (42) of the control piston (40).
Select the washer in such a way that the pump housing parting face is on one level with the upper side of the washers or that the washers exceed the pump housing parting face by 0.2 mm maximum.At the same time the maximum allowable difference in height between the two sides is 0.06 mm.









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