

Product: WHEEL DOZER

Model: 844K WHEEL DOZER M4R

Configuration: 844K Wheel Dozer M4R00001-UP (MACHINE) POWERED BY C27 Engine

Disassembly and Assembly 990K Wheel Loader and 844K Wheel Dozer Machine Systems

Media Number -UENR6576-05

Publication Date -01/01/2018

Date Updated -26/01/2018

i07518348

Piston Pump (Steering) - Assemble

SMCS - 4306-016-QP; 5070-016-ZH

Assembly Procedure

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
A	439-3939	Link Bracket	2
B	163-5006	Spring Clip	2
C	171-1113	Measuring Hub	1
D	129-3876	Measuring Bell	1
E	-	Height Gauge	1
F	171-1112	Test Pins	3
G	171-1114	Alignment Plug	1
H	6V-2055	Grease	1
J	-	Loctite 263	-



Illustration 1

g06152922

1. Install retaining ring (61) and bearing (62) onto shaft assembly (60).



Illustration 2

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2. Use a soft faced hammer to install shaft (60) into housing (30).



Illustration 3

g06153868

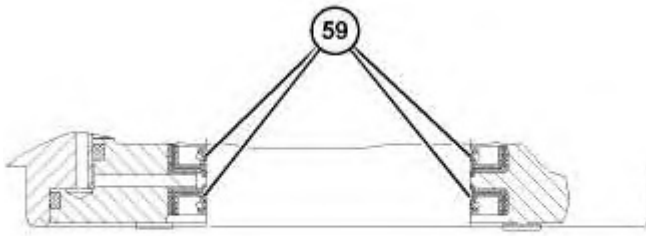


Illustration 4

g06153871

Note the orientation of lip seals (59).

3. Install lip seals (59) and the O-ring seals and into cover (58).



Illustration 5

g06153874

4. Install cover (58) and bolts (57).



Illustration 6

g06146430

5. Install outer races (56) into housing (30).

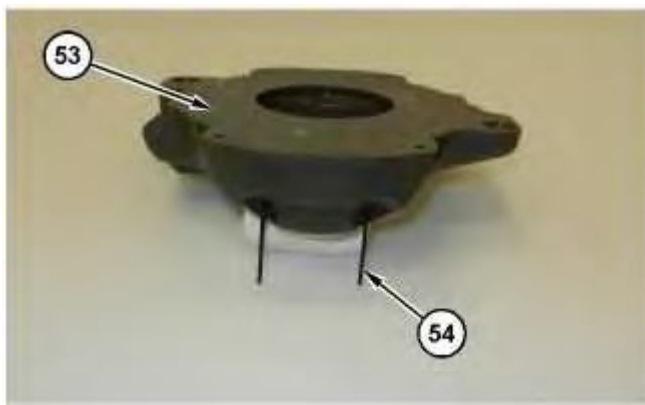


Illustration 7

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6. Install pins (54) onto swashplate (53).



Illustration 8

g06153884



Illustration 9

g06153889

7. Install bearings (55) to swashplate (53). Use Tooling (B) to hold the bearings in place for installation.
8. Install swashplate (53) and remove Tooling (B).

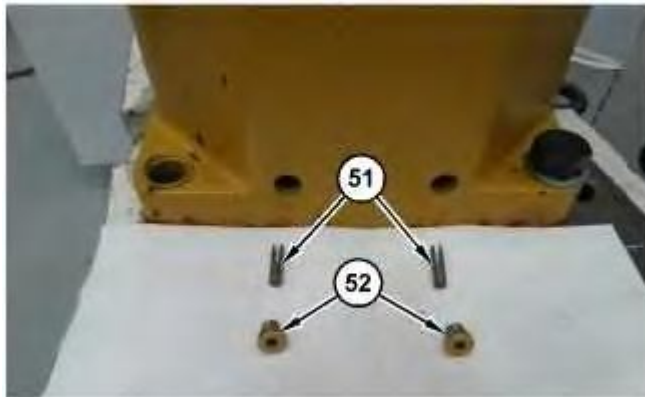


Illustration 10

g06153892

9. Install retainers (51), plugs (52) and the O-rings. Repeat for opposite side.

Note: Ensure retainers (51) lock into pins (54) shown in illustration 7..



Illustration 11

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10. Install adjustment screw (50) into housing (30). Repeat for opposite side.



11. Place port plate (31) on a flat surface and install Tooling (G).

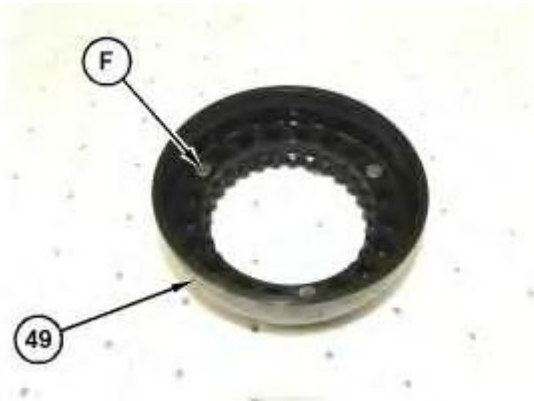


Illustration 13

g06149897

12. Install Tooling (F) into bearing (49).



Illustration 14

g06149905

13. Install shims (47) into bearing (49).



Illustration 15

g06149911

14. Install bearing (49) onto barrel (44).



Illustration 16

g06153902

Dimension (X) is 220.95 - 221.20mm (8.698 - 8.708 inch)

Dimension (Y) is 170.95 - 171.20mm (6.730- 6.740 inch)

15. Install barrel assembly (44) onto port plate (31). Install retainer plate (46) onto barrel assembly (44). Install Tooling (C) and (D) onto retainer plate (46).
16. Use Tooling (G) to measure dimensions (X) and (Y). Adjust the shims under retainer plate (46) as necessary to achieve the dimensions shown in Illustration 16.
17. Remove Tooling (C) and (D). Remove retainer plate (46) from barrel assembly (44). Remove barrel assembly (44) from port plate (31).



Illustration 17

g06149911

18. Remove bearing (49) from barrel (44).
-



Illustration 18

g06149905

19. Remove shims (47) from bearing (49).

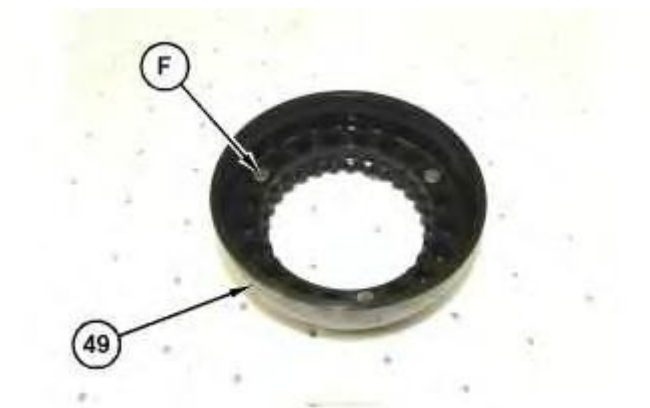


Illustration 19

g06149897

20. Remove Tooling (F) from bearing (49).

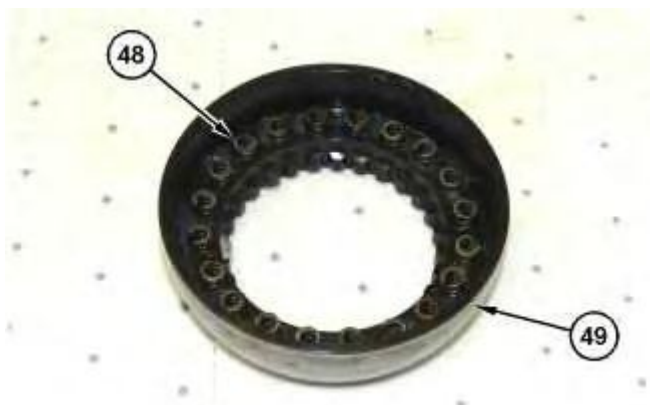


Illustration 20

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Illustration 21

g06149905

21. Apply Tooling (H) to springs (48). Install springs (48) and shims (47) into bearing (49).



Illustration 22

g06149911

22. Install bearing (49) onto barrel (44).



Illustration 23

g06146401

23. Install retainer plate (46) and pistons (45) into barrel (44).

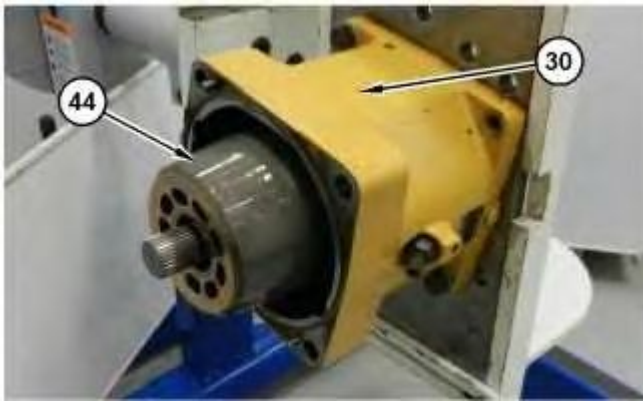


Illustration 24

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24. Rotate housing (30) to a horizontal position. Use a suitable string to install barrel assembly (44) into housing (30).

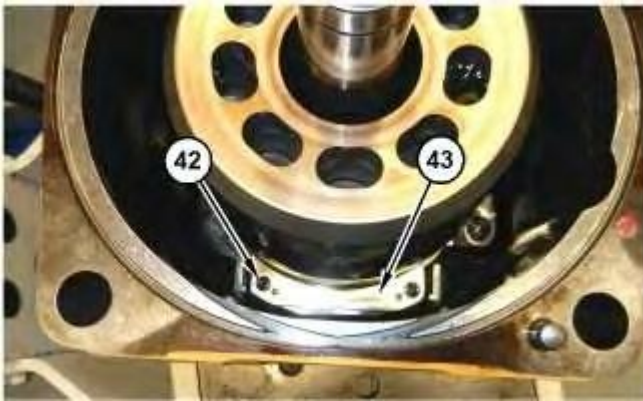


Illustration 25

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25. Apply Tooling (J) to bolts (42). Install retainer (43) and bolts (42). Repeat for opposite side.

Note: Bolts (42) should be replaced with new bolts.



Illustration 26

g06146295

26. Install cover (41). Repeat for opposite side.



Illustration 27

g06154614



Illustration 28

g06154626

27. Install O-ring seal (39). Install rods (40) and (38). Install piston (37), spring (36), spring (35), and piston (34).

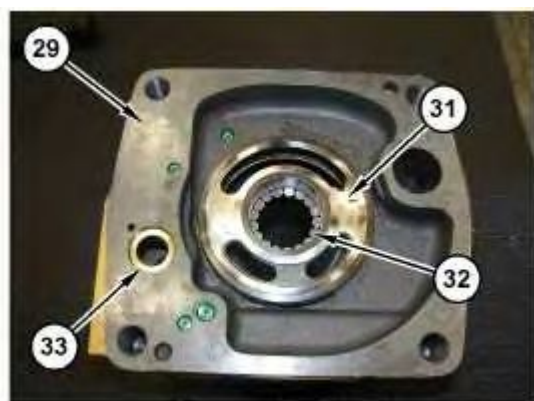


Illustration 29

g06153915

28. Install bushing (33) and bearing (32) into head (29). Apply Tooling (H) to port plate (31) and install into head (29).
-

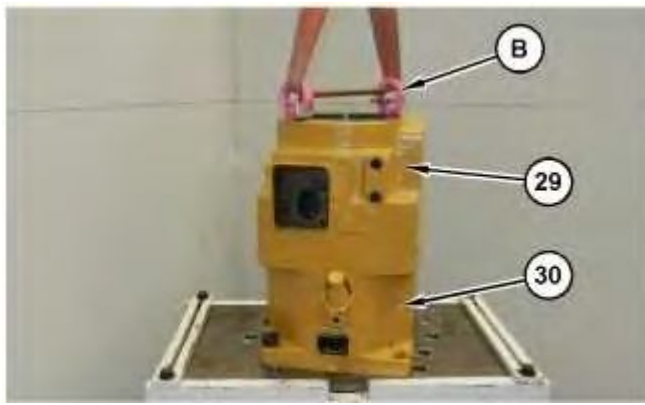


Illustration 30

g06146219



Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.

29. Attach Tooling (B) and a suitable lifting device to head (29). Install head (29) onto housing (30).

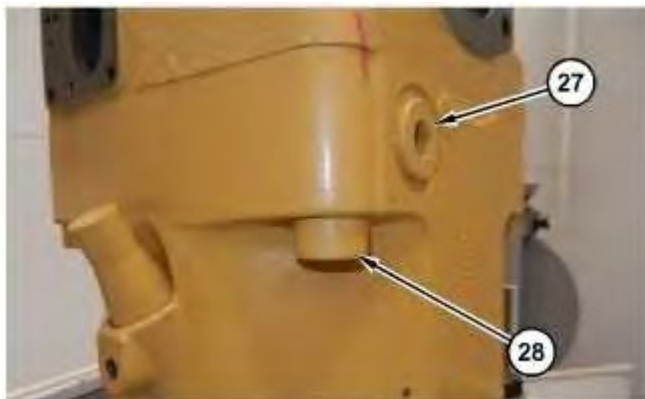


Illustration 31

g06146174

30. Install bolts (28). Tighten bolts (28) to a torque of $780 \pm 78 \text{ N}\cdot\text{m}$ ($575 \pm 58 \text{ lb ft}$). Install plug (27) and the O-ring seal. Tighten plug (27) to a torque of $198 \pm 20 \text{ N}\cdot\text{m}$ ($146 \pm 15 \text{ lb ft}$).

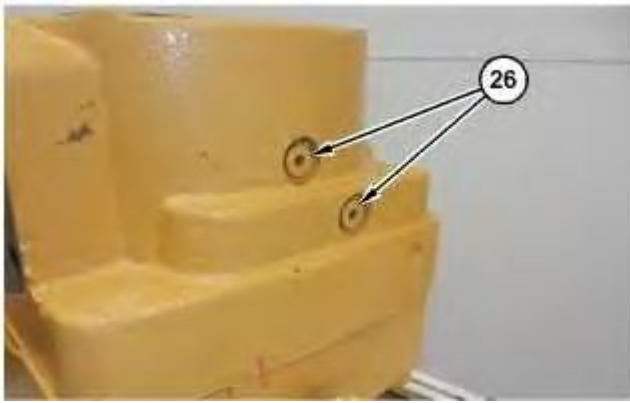


Illustration 32

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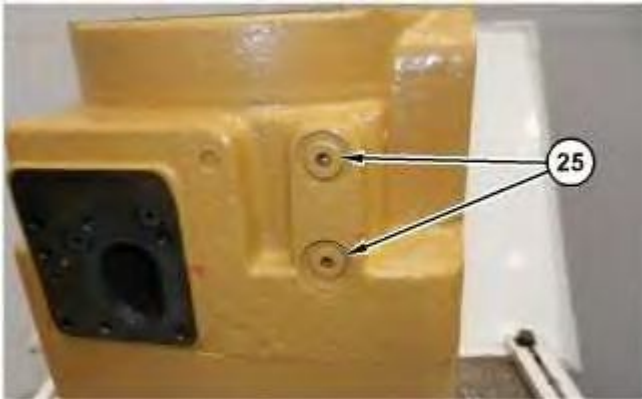


Illustration 33

g06146158

31. Install plugs (26), (25), and the O-ring seals.



Illustration 34

g06153150

32. Install retaining ring (24A).
-



Illustration 35

g06153932

33. Install impeller (23) and retaining ring (24).



Illustration 36

g06145926

34. Install adapter (22) and the O-ring seal. Install bolts (21).

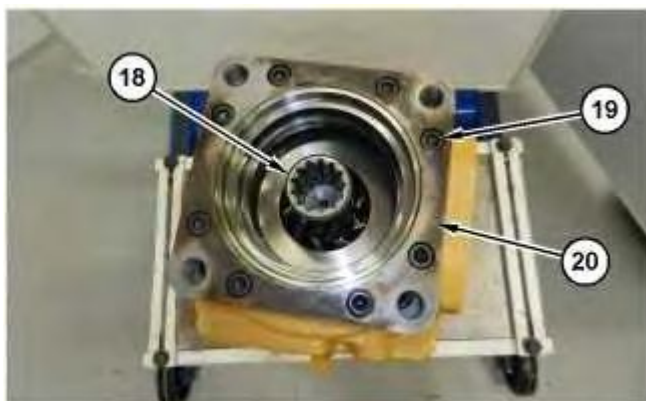


Illustration 37

g06145925

35. Install adapter (20) and the O-ring seal. Install bolts (19). Install coupler (18).

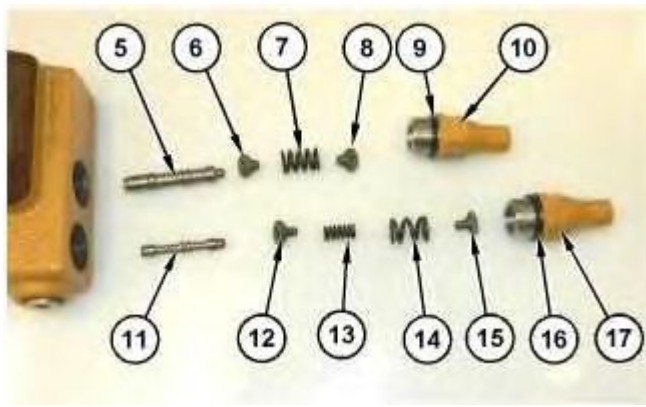


Illustration 38

g06145907



Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.

36. Install spool (11), guide (12), spring (13), spring (14), guide (15), O-ring seal (16), and valve (17).
37. Install spool (5), guide (6), spring (7), guide (8), O-ring seal (9), and valve (10).



Illustration 39

g06145896

38. Install O-ring seals (4).

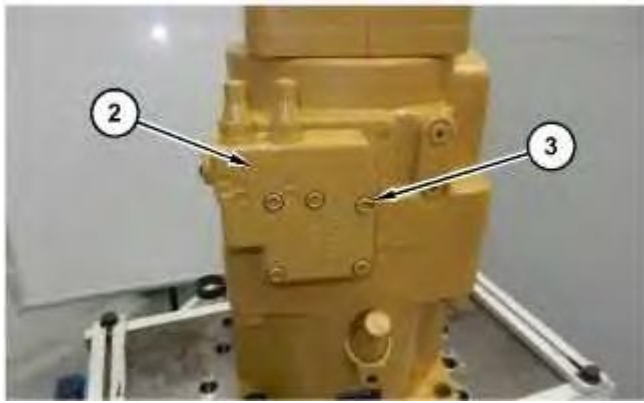


Illustration 40

g06145891

39. Install valve (2) and bolts (3).



Illustration 41

g06145889

40. Install plug (1) and the O-ring seal. Remove the piston pump from Tooling (A).

End By:

- a. Install the piston pump.

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