

Product: TRACK-TYPE TRACTOR

Model: D8R TRACK-TYPE TRACTOR 9EM

Configuration: D8R TRACK-TYPE TRACTOR 9EM00001-UP (MACHINE) POWERED BY 3406C Engine

Disassembly and Assembly D8R Track-Type Tractor Hydraulic System

Media Number -SEN8331-07

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i01022332

Steering Pump - Assemble

SMCS - 4306-016

Note: The internal components of the piston pump are machined to fine tolerances. Take care to protect the surfaces of these components during the maintenance procedure.

Note: Clean all components and apply clean oil to the surfaces of the parts before assembly.

1. Inspect all O-rings for wear and for damage. Replace any damaged O-rings.

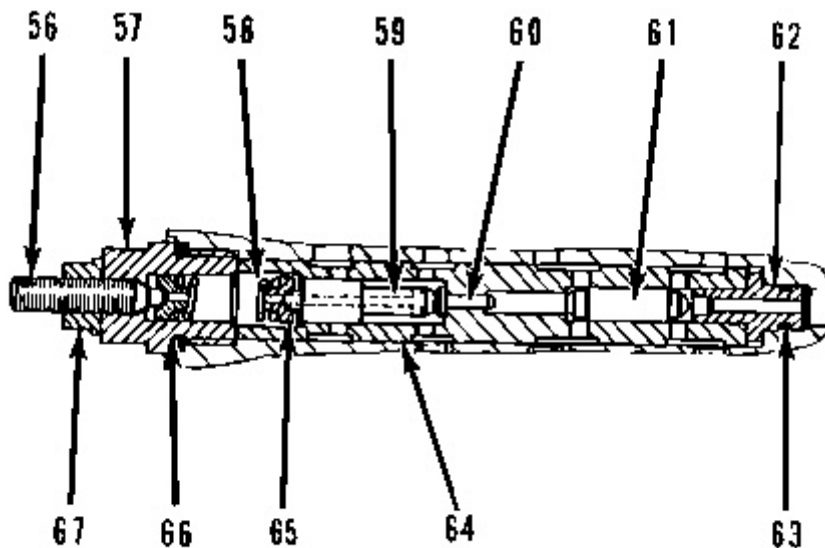


Illustration 1

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2. The following procedure is used to assemble pressure compensator valve (51).
 - a. Install O-ring seal (66) on plug (57). Use the marks from disassembly for reference to align the following parts: adjustment screw (56), plug (57) and locknut (67).
 - b. Install O-ring seal (63) on seat (62).

- c. Install seat (62).
- d. Install valve spool (61).
- e. Install pistons (64), (60), and (59).
- f. Install two retainers (65) and install spring (58).

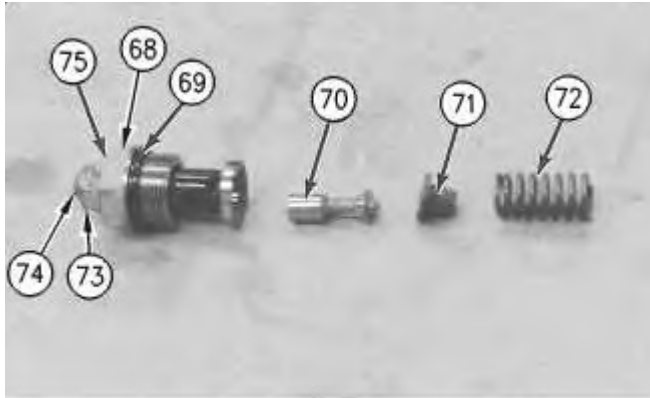


Illustration 2

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- 3. The following procedure is used to assemble relief valve (54):
 - a. Install O-ring seal (69) on plug (68).
 - b. Install the following items in the relief valve: adjustment screw (74), valve spool (70), retainer (71) and spring (72).
 - c. Install O-ring seal (75) and nut (73).

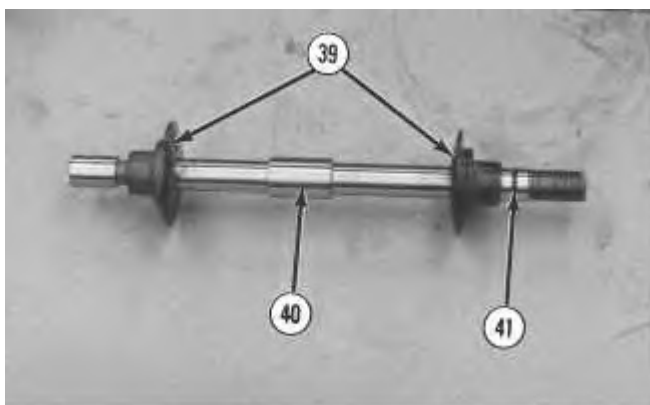


Illustration 3

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- 4. Install two retainers (39) on rod (40). Install O-ring seal (41).
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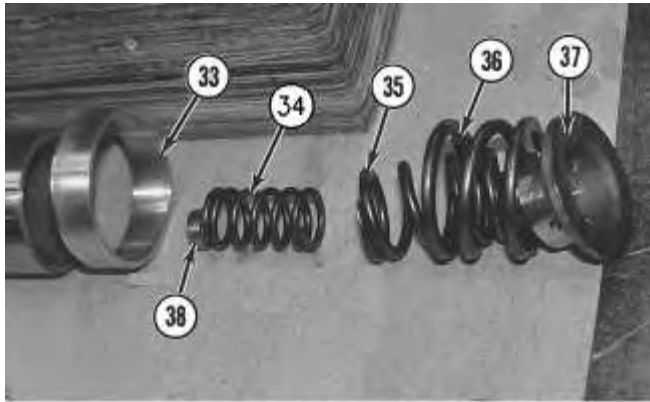


Illustration 4

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5. Install the O-ring seals in bushings (33). Install the following components on each end of the rod: bushing (33), springs (34), (35), and (36), retainer (37) and spacer (38).

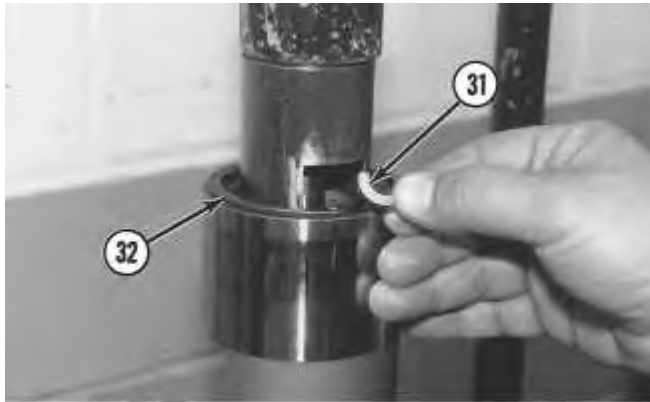


Illustration 5

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6. Install the actuator in a hydraulic press. Apply pressure to the actuator with the press.
7. Install retaining ring (32) and install retainer (31).

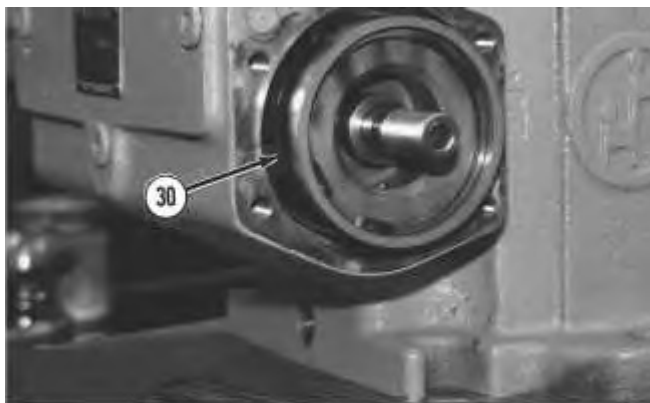


Illustration 6

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8. Install actuator (30) in the piston pump.

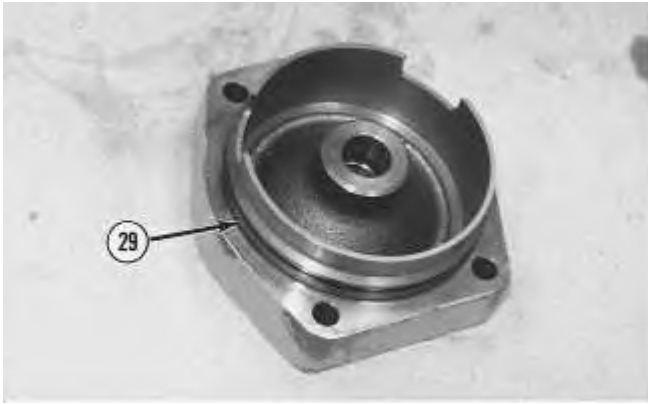


Illustration 7

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9. Install O-ring seals (29) on the two covers.

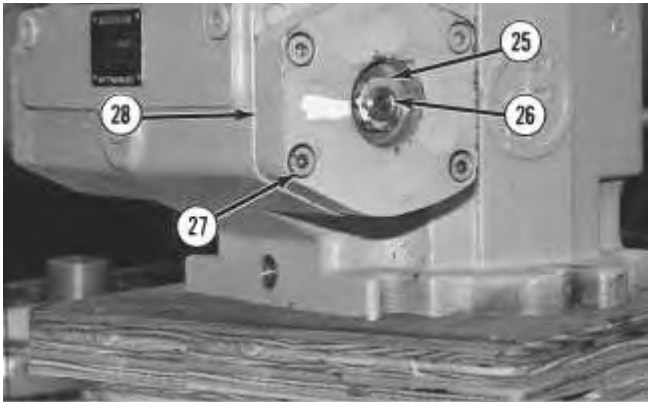


Illustration 8

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10. Install eight bolts (27) and two covers (28) on the piston pump.
11. Install nut (25). Measure the distance from the top of nut (25) to the end of shaft (26). The distance should match the original reference.

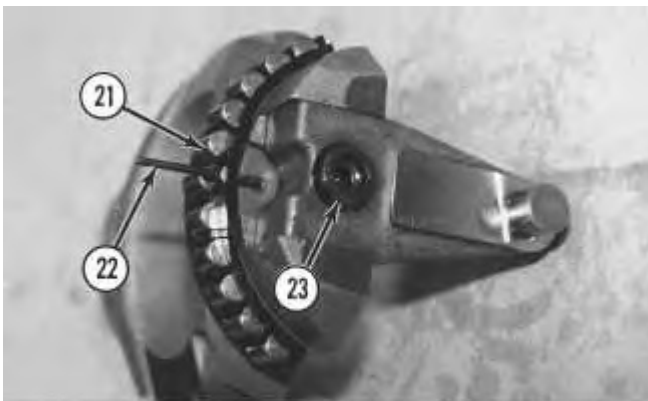


Illustration 9

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