

Assembling



1. Place the ring gear on the shaft with the guide pin located against the guide hole.



4. Place the small tapered roller bearing on the shaft as on the picture.



2. Press down the big tapered roller bearing together with the ring gear.



5. Press down the small tapered roller bearing in small steps until correct preload is achieved. Not too tight and no backlash.



3. Place the distance ring on the big tapered roller bearing.

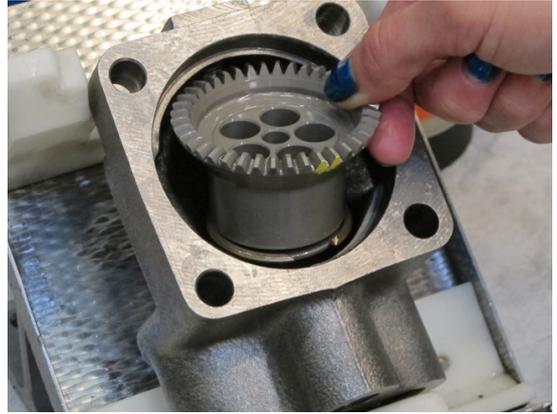


6. Place the lock washer(s) on to the shaft.

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7. Assemble the round nut and tighten it until one opening is in correct position for the lock washer.



10. Assemble the cylinder barrel.
Instructions on page 11.



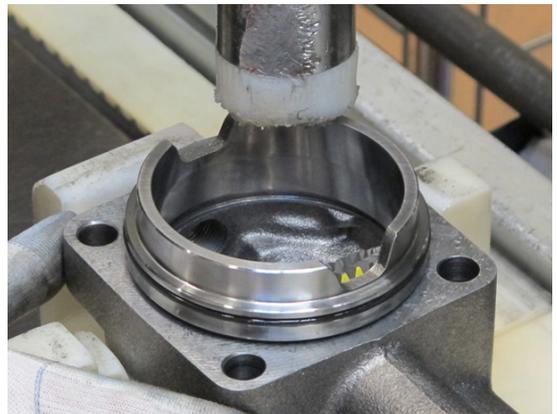
8. Secure the round nut as shown in the picture.



11. Assemble the O-rings on the distance ring.



9. Assemble the valve plate. Make sure the slot is in correct position and the valve plate is located as shown in picture.



12. Carefully tap down the distance ring to the barrel housing. Lubricate them with oil before assembly.

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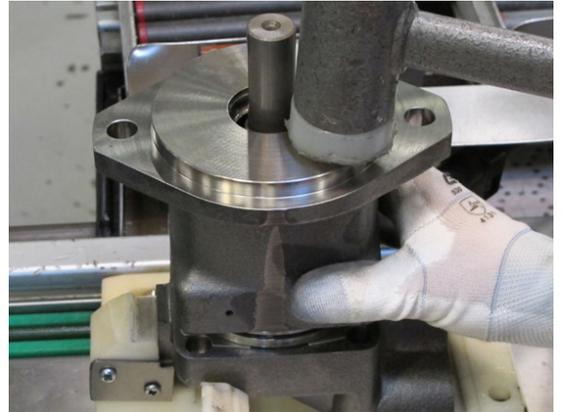
13. Assemble the shims.



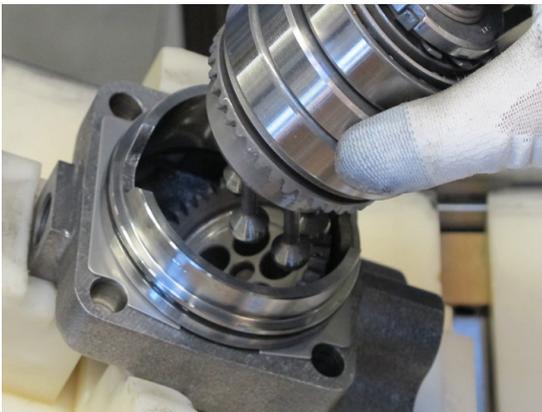
16. Make sure the timing is correct.



14. Assemble the pistons. Lubricate the ball sockets before assembly.



17. Carefully tap down the bearing housing.



15. Assemble the shaft package with pistons in to the cylinder barrel.



18. Lubricate the sealing surface on the shaft before assembling the shaft seal.