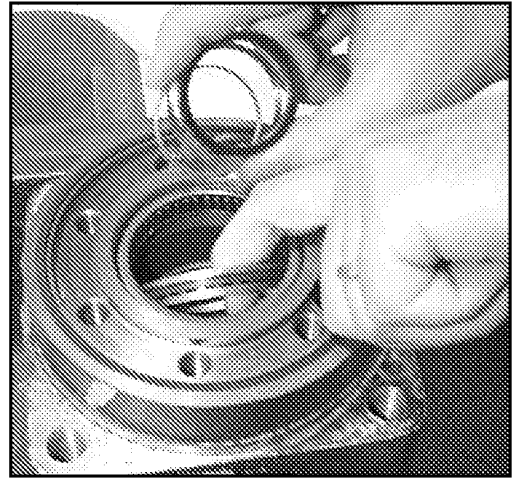


5) If the motor housing (18) did not require replacement of the inner roller bearing, it will require that the two "captured" thrust washers (14) and thrust bearing (15) be unseated and vertical to the counterbore and the new backup washer (17), new backup washer (21), and new seal (16) be worked around the thrust bearing package and placed into their respective counterbores. The seal lip must face out of the seal counterbore and toward the inside of the motor. Be sure the thrust bearing assembly is resealed correctly after assembly of the seal and backup washer. **Figure 26**

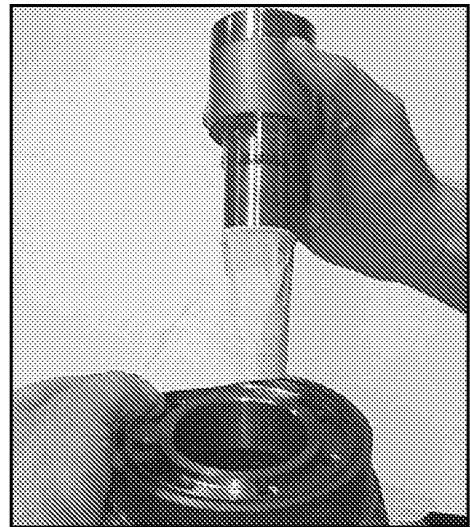


**Figure 26**

6) Apply masking tape around the keyway on the shaft (12) to prevent damage to the seal.

**Figure 27**

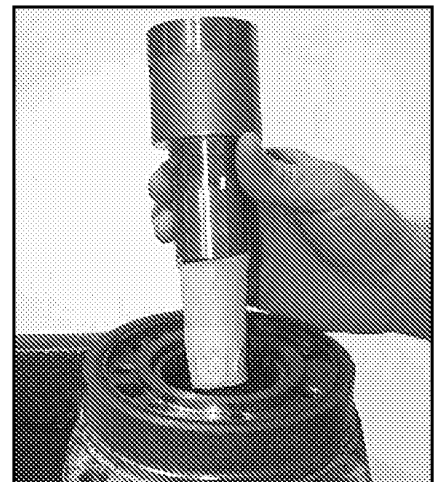
7) Be sure that a generous amount of clean corrosion resistant grease has been applied to the lower (outer) housing bearing (19). Install the coupling shaft (12) into the housing (18), seating it against the second thrust washer (14). **Figure 28**



**Figure 27**

**CAUTION:** The outer bearing (19) is not lubricated by the system's hydraulic fluid. Be sure it is thoroughly packed with the recommended grease.

**NOTE:** Be sure to remove masking tape after coupling shaft has been put into place.



**Figure 28**