

Assembly Procedures (ctd.)

15) Install the two (2) aligning pins, and install a new end cap gasket onto the housing.

16) Lubricate the running surfaces of the end cap and cylinder blocks. Position the housing with the housing opening **UP** and install the end cap onto the housing.

CAUTION: Be certain all parts are properly aligned. Do not force the end cap into position on the housing. Caution must be exercised to prevent damage to the end cap and cylinder block sealing surfaces.

17) When the end cap is properly installed, the internal springs will hold it away from the housing approximately 3/8 inch.

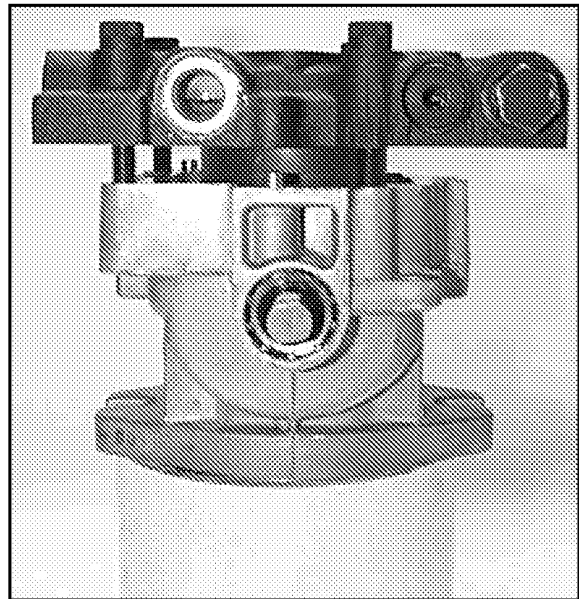
18) Install the four (4) screws which retain the end cap to the pump housing. Torque the screws evenly to **10-15 ft. lbs. Figure 26**

19) Rotate the shaft to assure correct assembly. When properly assembled, minimal torque should be required to turn the shaft.

20) Wrap the end of the displacement control shaft with thin plastic to prevent damage to the seal lip during installation. Lubricate the new displacement control shaft seal with petroleum jelly. Slide the seal over the shaft and press it into the housing bore. Be careful not to damage the seal.

21) Assemble the following components as described in the "Minor Repair" section of this manual. (See page 29-32) These include the following:

Plug/Fitting	Shaft Seals
Charge Check Valves	Bypass Valve
Charge Pump	



Install end cap. **Figure 26**