

## ASSEMBLY OF THE HYDRAULIC PUMP (VICKERS)

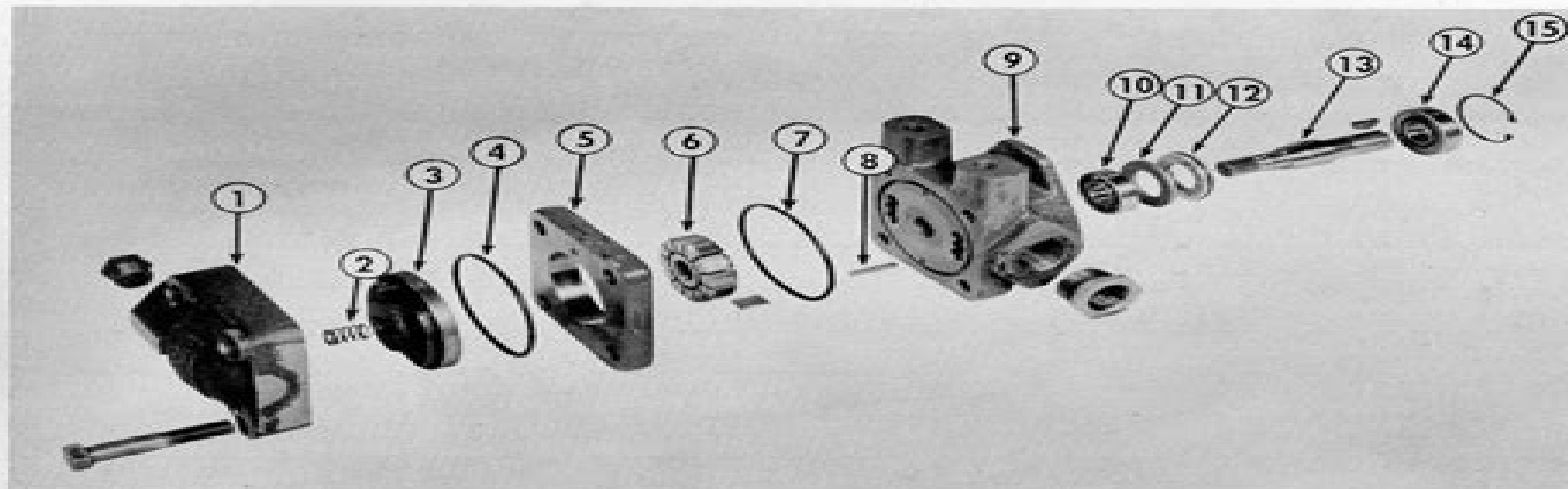


Fig. 37

**Step 14—Reassembly of Low Pressure section of pump.**

- Press bearing (10), into pump body (9).
- Install spacer (11), in pump body.
- Press oil seal (12), into pump body. Be sure sealing lip faces out.
- Using an arbor press, install bearing (14), on splined shaft (13).
- Install shaft and bearing assembly in pump body and tap in place with a soft hammer.
- Install snap ring (15), in place. See Step 9, Fig. 32.

**Step 15—Assembly of high pressure section of the Hydraulic pump.**

- Install "O" Ring seal (7), in pump body.

- Install pins (8), in pump body.
- Install rotor assembly (6), on splined end of shaft.
- Install ring (5), in place on locating pins.  
Be sure arrows on ring point in direction of crankshaft travel.
- Install "O" ring (4).
- Install pressure plate (3), on pins.
- Install spring (2), and cap (1).
- Tighten the 4 cap screws securely. Torqued to 110 ft. lbs.

**Step 16—Install pump.**

**Step 17—Refill the system with oil and operate a few times with air vent screw loose to work air out of system.**

# Vickers Hydraulic Pump Manual

**Walter C. Shelton**



## **Vickers Hydraulic Pump Manual:**

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