

Figure 5

- 13 Remove seal from housing.
- 14 Remove Teflon back-up ring, o-ring and Teflon seal from spool end.
- 15 Place housing on soft cloth, then remove set screw, see Fig. 5.
- 16 Screw 1/8"–24 machine screw into end of check ball seat. Pull on screw to lift seat from housing. Do not lose check ball and check ball retainer from check hole of housing.
- 17 Remove 2 seals from check ball seat.

Reassembly

Replace all parts that have nicks, scratches, or excessive wear which could cause leakage. Don't file or grind any parts of this unit. Clean disassembled parts in clean solvent, then blow dry with air. Don't dry parts with cloth or paper towel.

Note: Lubricate all seals (except new quad ring seal) prior to installation with petroleum jelly such as Vaseline.

Do not use excessive lubricant on seals for meter section.

Control End

Note: Check ball retainer must be straight (not tilted on edge) and positioned below check ball located in check valve hole of housing.

- 18 Lubricate 5/8" diameter seal and 7/16" diameter seal. Install seals on check ball seat as shown in Fig. 1.
- 19 Lubricate check ball seat and seals thoroughly before installing seat in housing. When installing seat, do not twist or damage seals. Install check ball seat (insert open end first) in housing.
- 20 Install and torque set screw to 100 inch pounds.
- 21 Install 2-1/8" diameter seal in control end of housing, see Fig. 5.
- 22 Install dust seal in seal gland bushing, flat or smooth side down, see Fig. 6.
- 23 Install the Teflon seal, o-ring and Teflon back up ring over the spool end.
- 24 Install seal gland bushing over spool end with a twisting motion. Tap bushing in place with a rubber hammer. Make sure bushing is flush against bearing race.

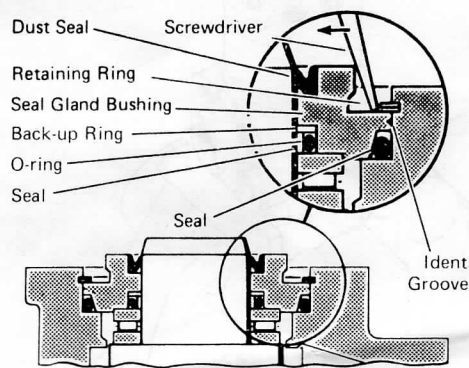


Figure 6

- 25 Install retaining ring in housing. After installing ring, tap on ring end or pry with screwdriver around entire circumference of ring to properly seat ring in groove.

Meter (gerotor) End

- 26 Clamp housing as shown in Fig. 2. Don't over-tighten jaws.
- Note:** Push spool and sleeve down flush with or slightly below 14 hole surface of housing. Clean upper surface of housing with palm of clean hand. Clean remaining meter end parts in a similar way before reassembling.

- 27 Install 3" diameter seal in housing.
- 28 Install spacer plate. Align holes.
- 29 Rotate spool and sleeve assembly until pin is parallel with port face, see Fig. 7, (ref. C). Install drive, make sure you engage drive with pin. To assure proper alignment, mark drive as shown in Fig. 7, (ref. B). Note relationship between slotted end of drive to splined end of drive when marking.
- 30 Install 3" diameter seal in meter (gerotor).

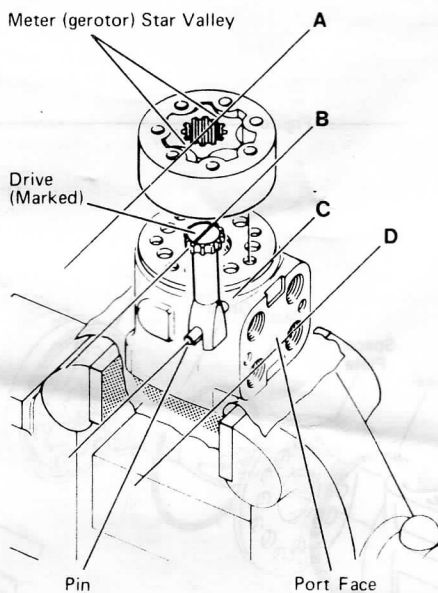


Figure 7

- 31 With seal side of meter (gerotor) toward spacer plate, align meter (gerotor) star valleys (ref. A) on drive (ref. B). Note the parallel relationship of reference lines A, B, C, and D Fig. 7. Align bolt holes without disengaging meter (gerotor) from drive.

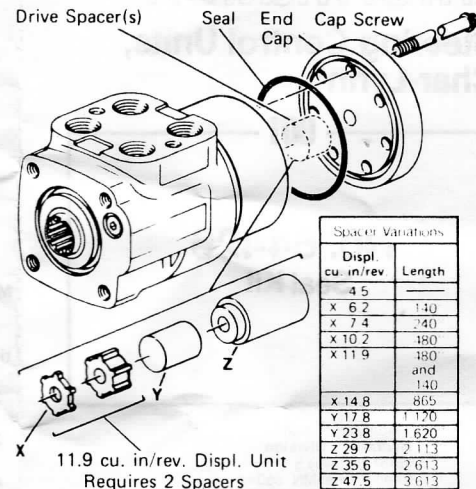


Figure 8

- 32 Install drive spacer(s) when used in meter (gerotor) see Fig. 8.
- 33 Install 3" diameter seal in end cap.

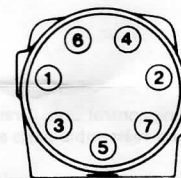


Figure 9

- 34 Install end cap, align holes.
- 35 Install 7 dry cap screws. Pretighten screws to 150 inch pounds, then torque screws to 275 inch pounds in sequence, see Fig. 9.