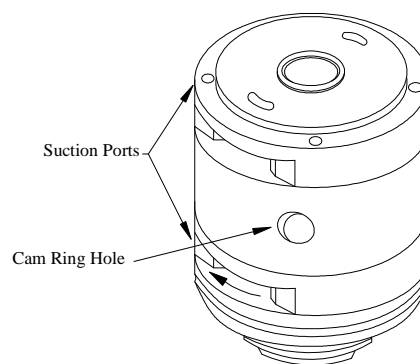
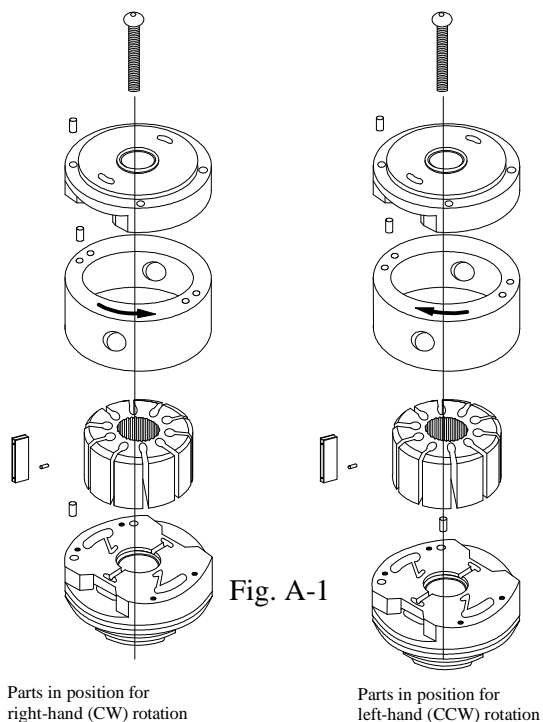


IFP T6 VANE PUMP CARTRIDGE KIT ASSEMBLY



Cartridge Assembly/Rotation Change Procedure

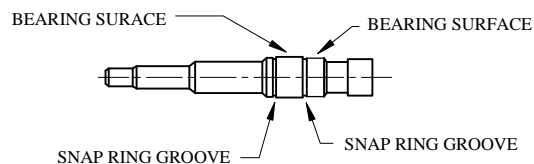
Cartridge assembly rotation may be changed by inverting cam ring and re-positioning dowel pins in holes of the pressure plate and port plate corresponding to the direction of rotation as shown in Fig. A1. Pour clean hydraulic fluid over vane/rotor assembly and tighten two screws to 40 in.lbs. To check proper assembly, both suction ports in the pressure plate should be inline along with fill hole in the cam ring, see Fig.A2(fill hole on cam ring will be slightly offset).



Shaft and Bearing Assembly

-When installing bearing shaft use care not to damage or distort snap ring by applying too much force, Fig. B. Snap ring must be removed by passing over **bearing surface** of the shaft and not the **shaft seal surface**, as this will damage shaft seal surface and cause shaft seal leakage.

-When installing shaft make certain not to damage the seal during installation.



Initial Start Up New or Reconditioned Units

-To prevent possible damage to internal parts, the pump should never be started dry or without internal lubrication.

-Manually fill pump housing with system fluid. Prime mover should be jogged until pump has primed.

-Initial start up should be at a low pressure and increased gradually at 500 psi increments until system pressure has been reached.