

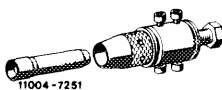
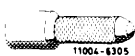
**Data**

End play of input shaft	on new pumps	max. 0.7
	on used pumps	max. 1.0

**Tightening torques**

	Nm	(kpm)
Hex screws to pump housing	35-40	(3.5-4)
Hollow screw for attaching supply tank	35-40	(3.5-4)

**Special tools**

Puller for radial sealing ring (basic tool)		116 589 24 33 00
Punch 33 mm dia.		116 589 14 15 00

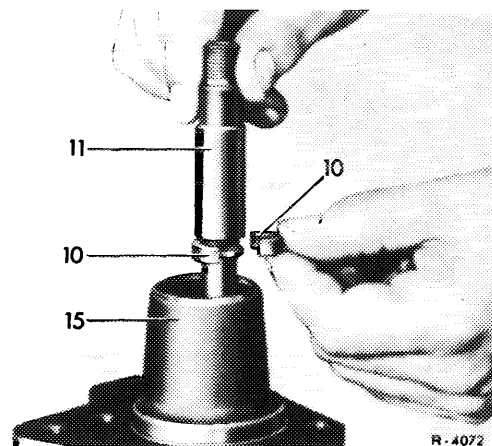
**Self-made tool**

Pressing-in tool for bearing bushing	refer to illustration at item 2
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**Input shaft and sealing ring**

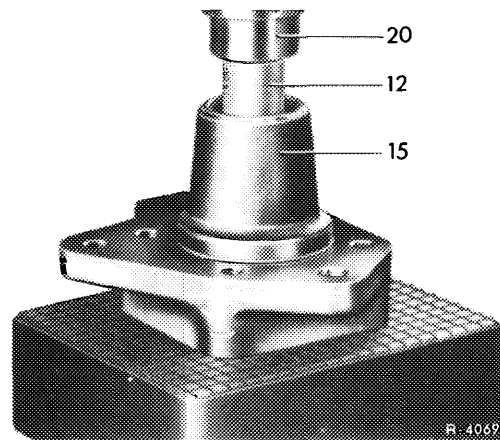
1 Place both shell halves (10) on input shaft (11).

**Note:** The shell halves determine the end play of the input shaft and are contained in repair kit "input shaft".

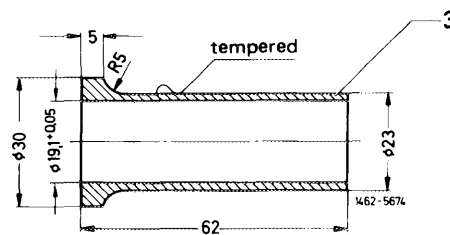


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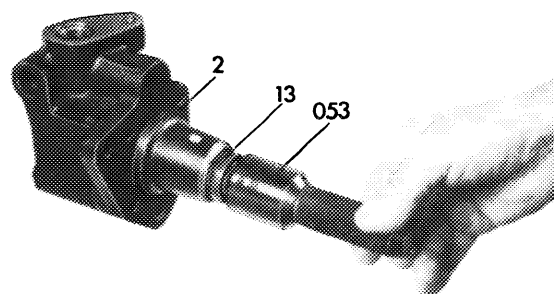
2 Press bearing bushing (12) with input shaft into housing cover (15) by means of pressing-in tool (20).



**Note:** Make installation tool yourself according to specified dimensions.



3 Screw guide sleeve on input shaft and press sealing ring (13) into housing cover (2) by means of punch (053).

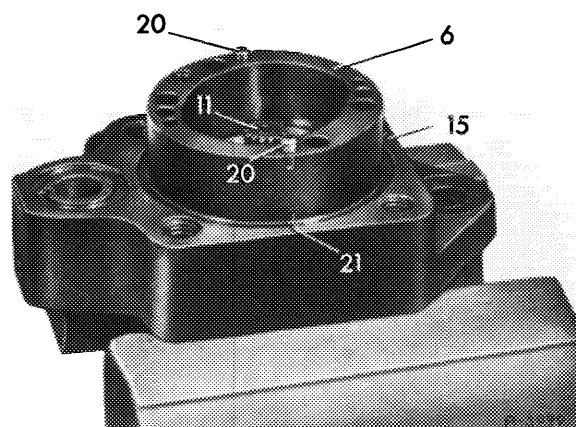


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### Rotor and cam ring

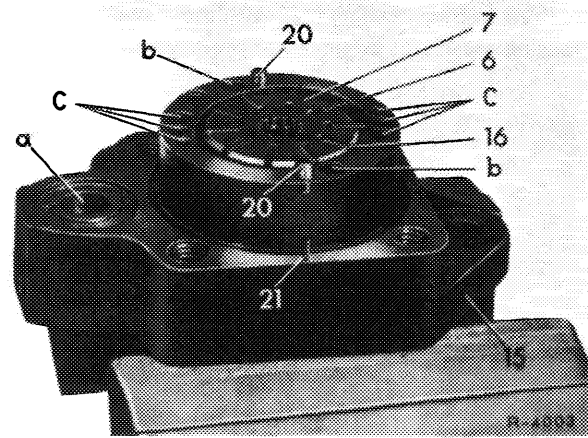
4 Coat all parts with transmission oil.

5 Place cam ring (6) on fitted pins (20) in such a manner that the applied marks (21) on housing cover (15) and on cam ring are in alignment.



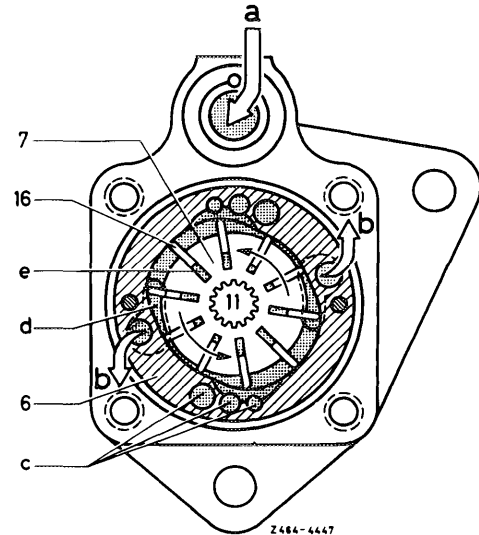
6 Place rotor (7) on input shaft (11) in such a manner that the countersunk end of splined bore faces housing cover.

**Note:** If a new cam ring is installed, mount in such a manner that the pressure oil bore (b) is located accurately above recesses (d) in housing cover.



7 Insert pump blades (16) into grooves of rotor (7) in such a manner that the rounded-off ends are facing outwards toward cam ring (6).

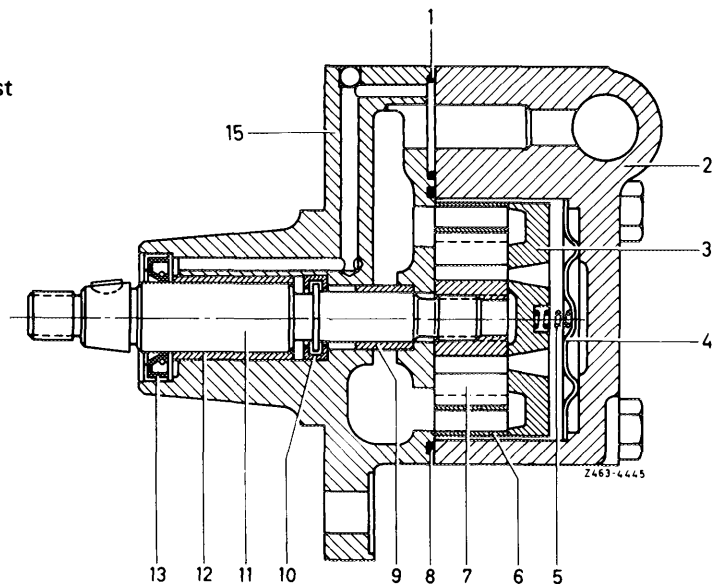
- a Oil feed from supply tank
- b Pressure oil outlet out of cam ring
- c Intake bores
- d Recess in housing for entry of pressure oil into pressure oil bores
- e Pressure oil under pump blade
- 6 Cam ring
- 7 Rotor
- 11 Input shaft
- 16 Pump blade



8 Place pressure plate (3) on cam ring (6) and on fitted pins, paying attention to applied marks.

**Note:** The outlet openings for the pressure oil must be located above the pressure oil bores of the cam ring.

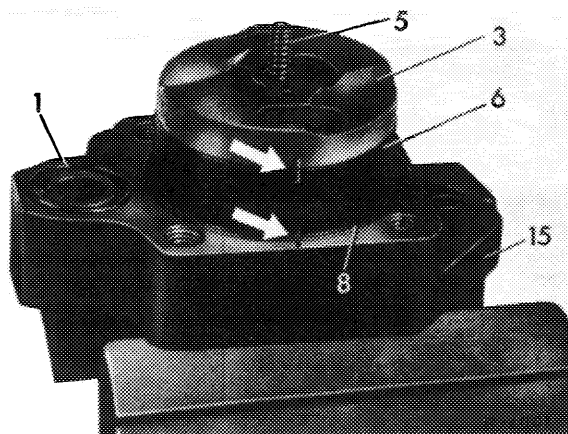
- 1 O-ring
- 2 Pump housing
- 3 Pressure plate
- 4 Oil guide plate
- 5 Compression spring
- 6 Cam ring
- 7 Rotor with blade
- 8 O-ring
- 9 Bearing bushing
- 10 Shell half
- 11 Input shaft
- 12 Bearing bushing
- 13 Sealing ring
- 15 Housing cover



9 Place both O-rings (1 and 8) on housing cover (15).

10 Insert compression spring (5) into bore of pressure plate (3). If oil guide plate (4) pressed into pump housing (2) has been removed, insert guide plate into housing in such a manner that the recess for the compression spring faces the pump housing.

11 Place pump housing (2) on housing cover (15). Screw-in the four hex screws and tighten to 35 to 40 Nm (3.5 to 4 kpm).



### Volume control valve

12 Clean volume control valve prior to assembly, immerse in transmission oil and introduce into housing bore. Valve should slide easily in housing bore.

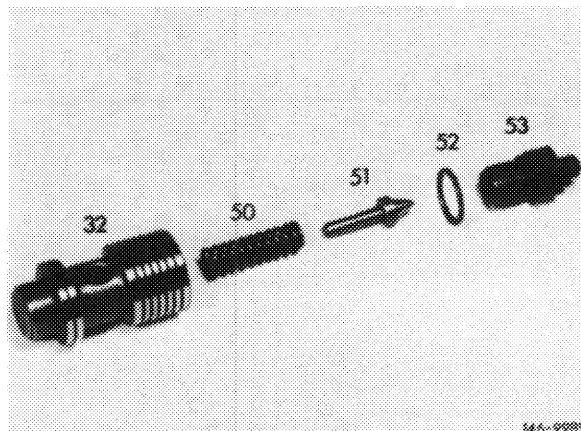
**Note:** The pressure relief valve in volume control valve of repair set 000 586 46 46 opens at 60 bar gauge pressure (60 atü).

13 Install pressure relief valve in volume control valve. Insert compression spring (50) first, then valve cone (51). Then insert spacing washers (52) for adjusting opening pressure into valve screw (53).

#### Attention!

**Always use the same washers which were previously installed.**

14 Clamp volume control valve (32) at its unground portion into vice. Screw-in valve screw (53) and tighten.



15 Insert compression spring (16) into bore of pump housing (18). Rinse volume control valve once again, immerse in transmission oil and introduce into housing bore in such a manner that the pressure relief valve faces inwards.

16 Fit a new O-ring (14) to closing cover (1). Push closing cover with bolt toward inside into housing bore and secure by knocking-in locking pin (13).

