



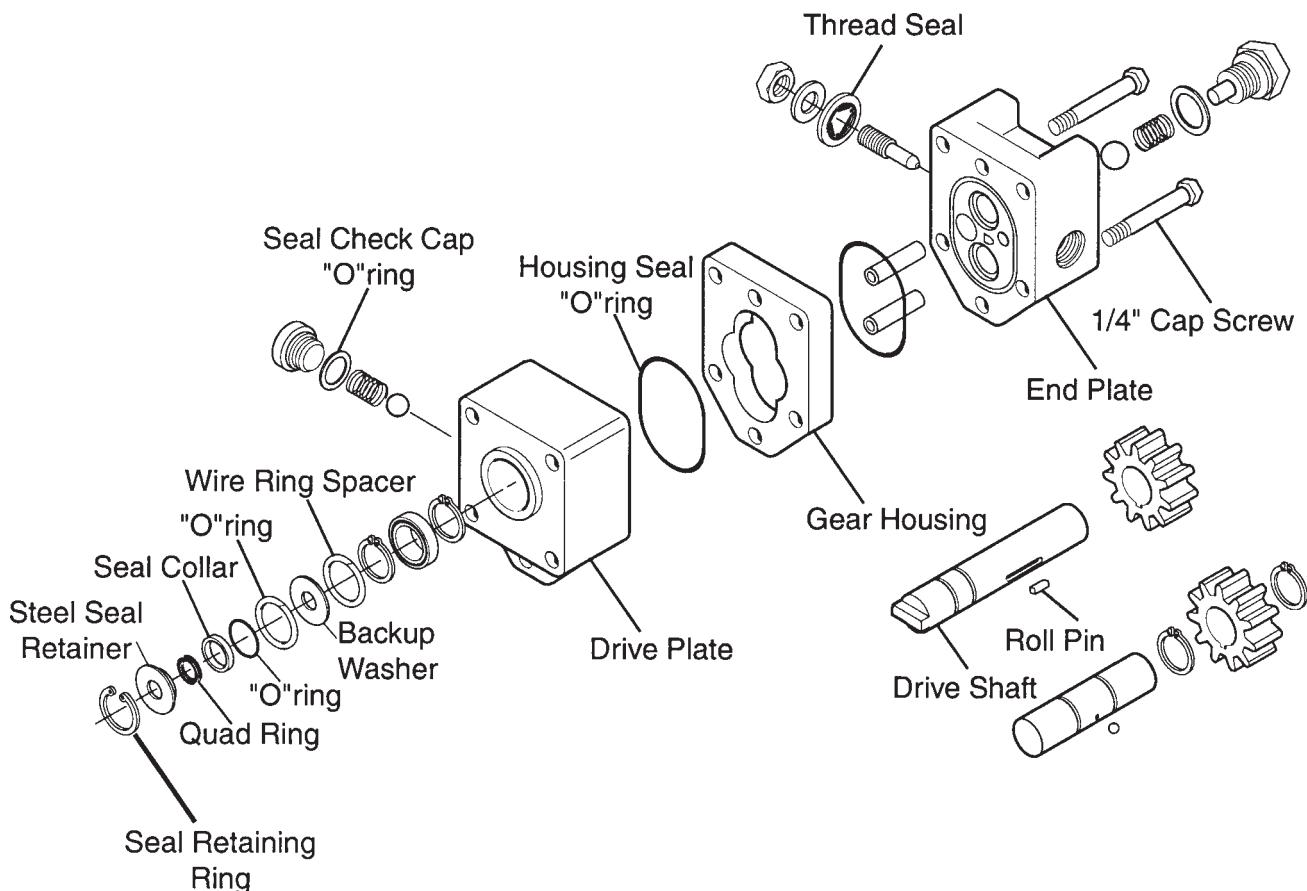
SEAL REPLACEMENT INSTRUCTIONS FOR ACE HYDRAULIC MOTORS

HYDRAULIC MOTOR REPAIR KITS

Ace repair kits include all "O" rings and seals necessary to rebuild motors equipped with a quad-ring shaft seal.

Motor Model	Repair Kit Part #	Repair Kit EDP #
BAC-75-HYD-202, -203	RK-BAC-75-HYD	41371
BAC-75-HYD-204, -206, -210	RK-BAC-75-HYD	41371
BAC-75-HYD-304	RK-BAC-75-HYD-300	41361
BAC-75-HYD-310	RK-BAC-75-HYD-310	41379

HYDRAULIC MOTOR PARTS



See Ace Forms HYD-200 SERIES and
HYD-300 SERIES for complete part listings.

STANDARD MOTOR REPAIR KIT INSTALLATION

DISASSEMBLY:

1. Remove motor from pump by removing four cap screws.
2. Remove seal retaining ring from drive plate.
3. Remove two 1/4" cap screws (200 series) or four 3/8" cap screws (300 series).
4. Scribe a line on motor casing (end plate, drive plate, housing), note orientation, and pull apart.
5. Remove idler gear/shaft assembly, drive gear, and drive shaft dowel pin.
Note: Failure to remove dowel pin will result in bushing damage.
6. Slide drive shaft/bearing assembly, and seal components out of drive plate.
7. Remove and discard old "O" rings and quad ring seal.

ASSEMBLY:

1. Place drive shaft/bearing assembly in drive plate.
2. Insert wire ring bearing spacer against bearing then insert steel backup washer.

Note: 300 series backup washer and spacer are one piece.

3. Insert 1-1/8" "O" ring (1-1/4" for 300 series) against backup washer.
4. Seal assembly(see illustration):
 - (a) Insert 7/8" "O" ring (1-1/8" for 300 series) in steel seal retainer.
 - (b) Insert the quad ring collar inside the 7/8" "O" ring.
 - (c) Insert the quad ring shaft seal inside the collar.

Note: The quad ring appears oversized but conforms to shaft diameter when inserted in seal collar.

5. Slide seal assembly over shaft with beveled side facing bearing.
6. Install shaft seal retaining ring.
7. Lightly grease large "O" rings and insert in plate grooves.
(300 series grooves in gear housing)
8. Place dowel pin and drive gear on drive shaft.
9. Place idler gear/shaft assembly in drive plate bushing.
10. Assemble the drive, center, and end plates aligning scribe marks.
11. Install two 1/4" cap screws - torque 6-8 ft-lbs (200 series) or four cap screws - torque 24 ft-lb (300 series). **Caution:** Do not over tighten.
12. Remove needle valve, replace thread seal (metal washer with rubber insert), and reassemble.
13. Remove seal check cap from drive plate with 5/32" allen (200 series) or 7/8" wrench (300 series), replace seal check cap "O" ring, and reassemble.
14. Position coupler in pump shaft slot, fill coupler cavity with grease, align motor tang with coupler slot, and attach with four cap screws - torque to 13 ft-lbs.

