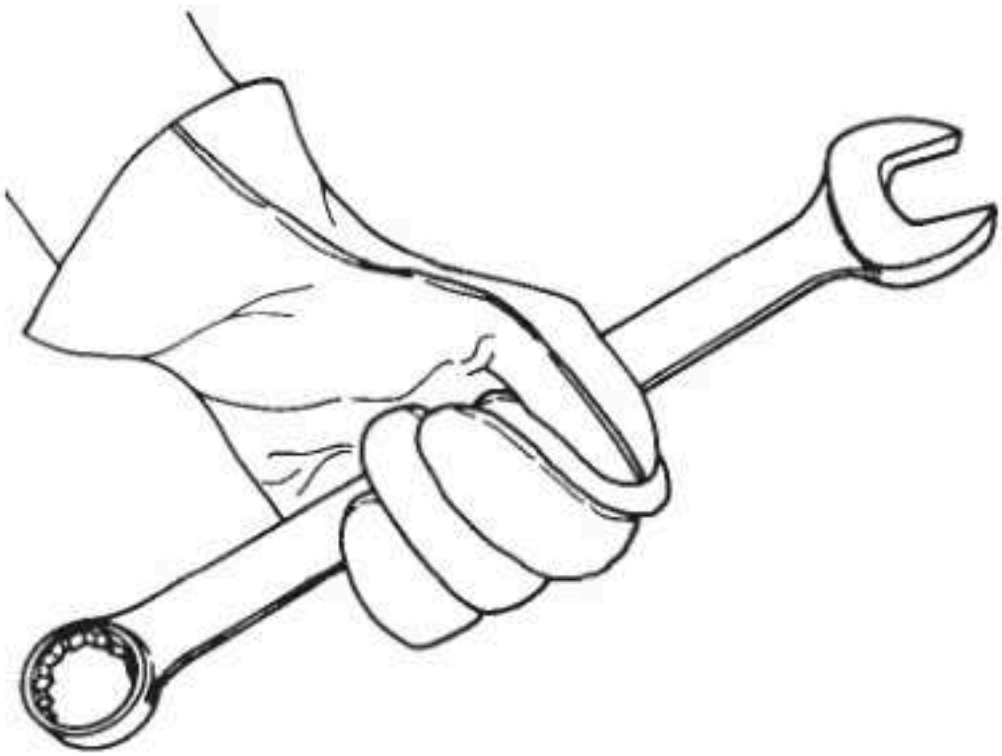
HYDROSTATIC PUMP

COMPONENT REPAIR MANUAL



MELROE
INGERSOLL-RAND

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VICKERS PUMP

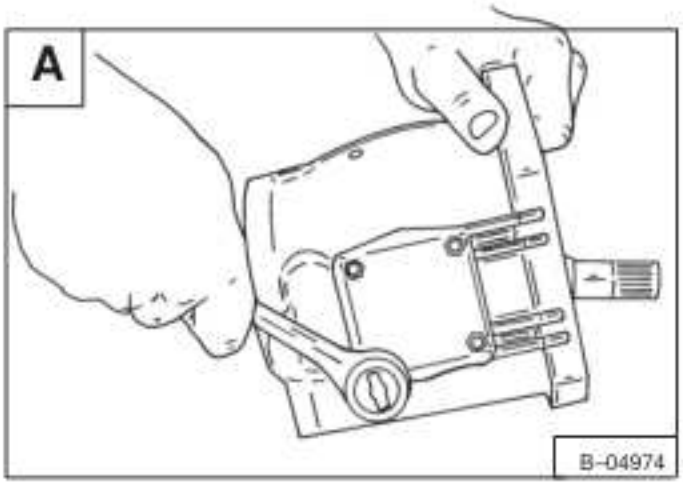
PARTS IDENTIFICATION
MODEL: 630, 631, 632
641, 642, 643
741, 742, 743
1600, 2000 ..... B–1

HYDROSTATIC PUMP
Bearing Pre–Load (Procedure One) B–9
Bearing Pre–Load (Procedure Two) B–13
Disassembly and Assembly B–2
Inspection B–6
Installing the Wafer Plate B–16

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Remove the four bolts and pintle cover at the short pintle shaft **[A]**.

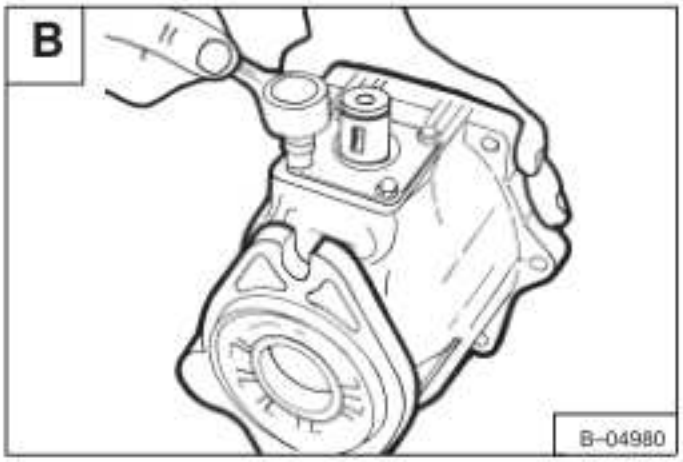
Assembly: Tighten the bolts to 170–190 in.–lbs. (19–22 Nm) torque.



Remove the four bolts and pintle cover at the long pintle shaft **[B]**.

Assembly: Tighten the bolts to 170–190 in.–lbs. (19–22 Nm) torque.

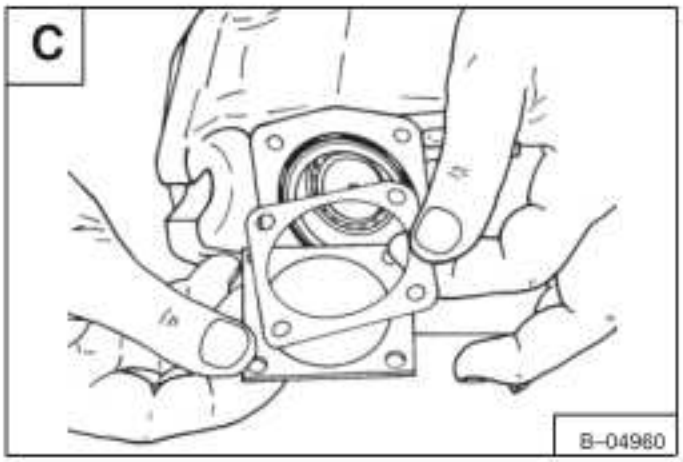
NOTE: If the bearings are replaced you must set the pre–load when assembling the pumps. There are two procedures that can be used for setting the pre–load, see page B–9 Tab 2 for Procedure One and page B–13 Tab 2 for Procedure Two.



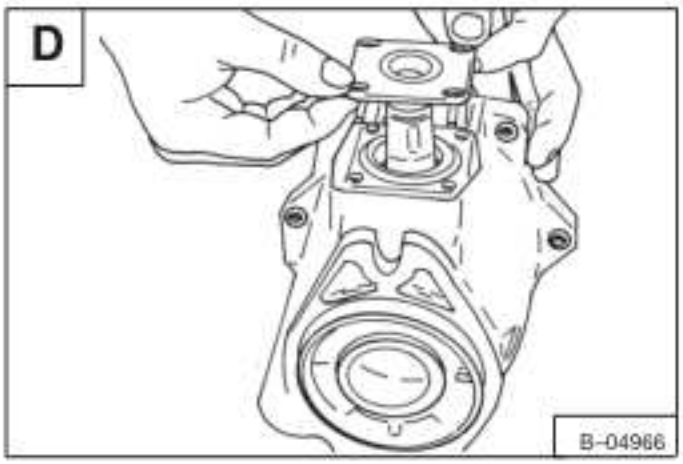
Remove the shims at the short pintle shaft cover **[C]**.

IMPORTANT

Be sure not to damage the shims under the pintle covers. If the shims are damaged, the shims must be replaced with shims of the exact same thickness unless new bearings are installed).

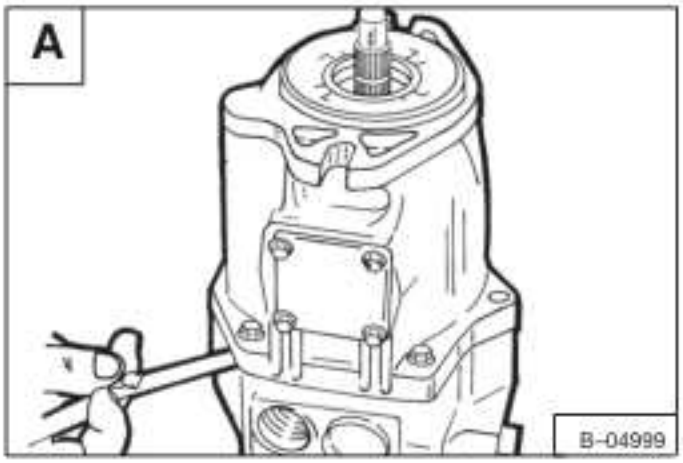


Remove the shims at the long pintle shaft cover **[D]**.



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6. Use a feeler gauge to check the gap **[A]**. A tapered feeler gauge is very good for this purpose. Measure the gap at four different corners. Add the four dimensions together and divide by 4 to get an average gap dimension.



EXAMPLE (in inches):

0.150	Measured thickness of the thickest bearing spacer.
–0.027	Average gap (from above)
+0.003	± 0.001 necessary pre–load
+0.020	Compressed thickness of the gasket.
=0.146	± 0.001 thickness of the bearing spacer needed to give 0.002 to 0.004 bearing pre–load.

7. Remove the four bolts and remove the housing from the manifold block so that the correct spacer gasket and internal parts can be installed.

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INTRODUCTION

Melroe recommends that all service technicians attend either field or factory Bobcat Service Workshops for necessary information and education.

Workshops are held many times a year at various locations throughout the U.S. and Canada. Contact your District Service Manager or Melroe Service Office Gwinner, N.D. (701) 678–6165 for schedule.

This Component Repair Manual provides the Service Technician with information for servicing Hydrostatic Pumps.

Make reference to the SERVICE MANUAL for your MODEL Loader to troubleshoot, test, remove and installation of the hydrostatic pumps.

See the INDEX Page to find your MODEL Loader, S/N listing, Tab # and Manufacturer.

SAFETY INSTRUCTIONS

We Care About Your Safety.



BEFORE YOU WORK ON THE HYDROSTATIC PUMP

Read the complete sequence so you know the complete disassembly or assembly procedure before the work is actually started.





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