

SEAL KIT REPLACEMENT INSTRUCTIONS FOR CASAPPA MOTORS

Study the Section View(s) prior to making repairs.



CAUTION:

TAKE EVERY PRECAUTION TO KEEP CONTAMINATION FROM GETTING INTO THE HYDRAULIC MOTOR. DISASSEMBLING A HYDRAULIC MOTOR IN A DIRTY ENVIRONMENT WILL SHORTEN THE LIFE OF THE MOTOR.

FRONT COVER SEALS REPLACEMENT

Take special note of the orientation of the Front Cover and the Motor Body. The shaft rotation is clockwise when observed from the shaft side. The rotation arrow on the motor body is stamped closer to the Front Cover side of the motor body. Removing the body and inadvertently turning the body over will cause the motor to run backward (counterclockwise).

Two versions may be encountered: Flat Washer or Ferrule Washer. All other components are the same. See the Section View for the proper orientation of the Ferrule Washer.

1. Carefully remove the key from the shaft keyseat and save for re-use. Wrap the shaft keyseat with masking tape to cover the sharp edges of the keyseat.
2. Loosen the four bolts holding the motor together. Do not remove the bolts from the bolt holes.
3. Remove the Front Cover from the motor. Remove the Dust Shield, Snap Ring, Flat Washer and High Pressure Seal. Save the Snap Ring and the Flat Washer for re-use. Be sure to inspect the Front Cover to assure no foreign material has entered the counterbore or Snap Ring groove.
4. Apply a coating of hydraulic oil or grease to the Front Cover bore to aid re-assembly of the counterbore components.
5. Insert the High Pressure Seal, taking special care to orient the seal properly so that the face groove side of the seal enters the bore first and is facing the bottom of the counterbore. Do not push the seal to the bottom of the counterbore, as it must be tight against the Washer and Snap Ring prior to re-assembly of the Front Cover to the motor.
6. Insert the Flat Washer, stopping when the Snap Ring groove has been passed and there is room to insert the Snap Ring.
7. Insert the Snap Ring and be sure that it is fully engaged in the groove by turning the Snap Ring slightly.
8. Seat the High Pressure Seal and Flat Washer tight against the Snap Ring, **being careful not to damage the High Pressure Seal.**
9. Insert the Dust Shield with the face groove up and to a point where it is flush with or below the surface of the bore face. It is not necessary for the Dust Shield to bottom on the Snap Ring. Use thumb pressure only to install the Dust Shield. Do not mar the bore surface or the bore face.

REPLACEMENT OF BALANCE PLATES SEALS

Take special note of the orientation of the Motor Body to the Balance Plates. The output shaft rotation is clockwise when observed from the shaft side of the motor. Orient the motor assembly with the output shaft on the left side. Note that the “IN” port is facing you and the “OUT” port is away from you. The Balance Plates have the seals “UP” (VIEW “A”) and facing toward you, with the wider seal contacting the Balance Plate and the narrower, stiffer seal on top of the wider seal. This orientation is critical to proper operation of the motor. Replace the seals with parts from the kit. Repeat this for the lower Balance Plate.

REPLACEMENT OF MOTOR BODY O-RINGS

Remove the old O-rings and replace with new O-rings from the kit. Do not mar the O-ring groove surface in the Motor Body and take special care not to damage the O-rings. Be sure to replace both O-rings on the top and bottom of the Motor Body.

RE-ASSEMBLY OF THE MOTOR

Be sure the Balance Plates are oriented properly with the seals in contact with the Bottom Plate. Also be sure the seals are facing you when the output shaft is on the left as in “Replacement of Balance Plates Seals” instructions. Carefully assemble the Motor Body, being sure the “IN” port is facing you and the “OUT” port is away from you.

Note: Prior to re-assembly of the Front Cover to the motor body, be sure to wrap the shaft keyseat with masking tape to avoid the sharp edges of the keyseat from nicking the High Pressure Seal.

Assemble the Front Cover to the Motor Body, being careful not to damage the High Pressure Seal. Install the four mounting bolts and tighten with 45 NM (33 FT.-LBS.) of torque.

Remove the masking tape from the keyseat and reinstall the shaft key.