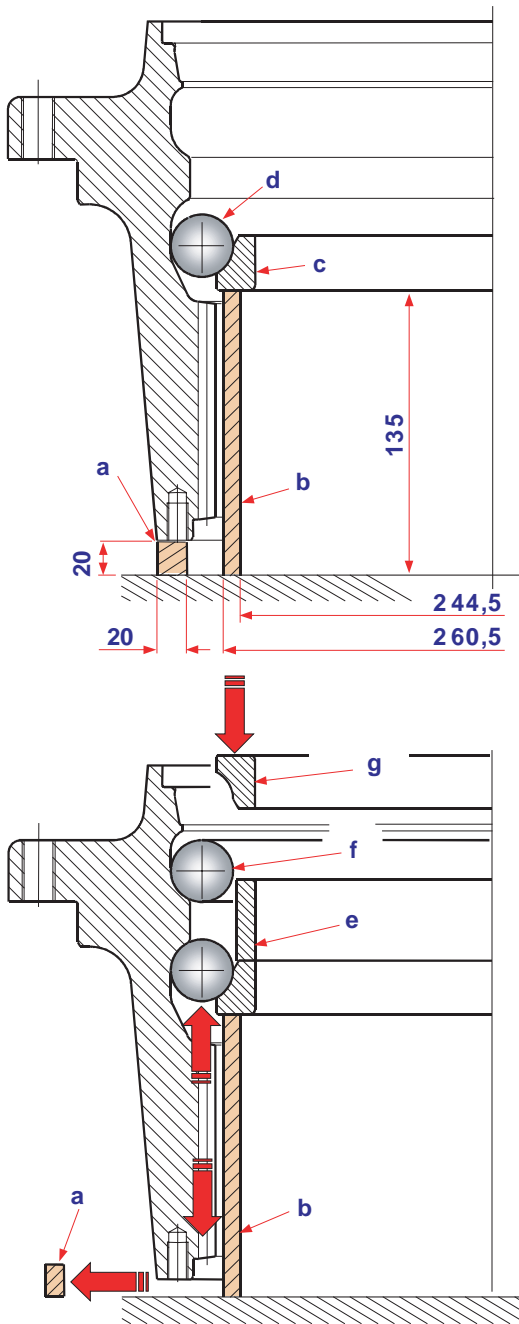


The half seals used in re-assembly require a specific technique to install. Follow the instructions detailed below.

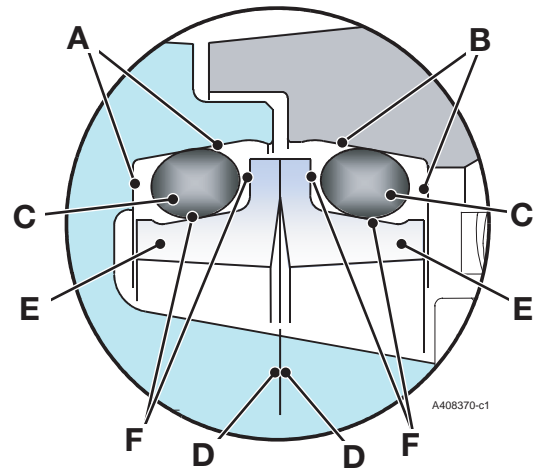
- a Carefully clean the seats **A** and **B** using a small wire brush or solvent if necessary. The surfaces in contact with the O-ring **C** must be perfectly clean and dry.
- b Make sure that the sealing surfaces **D** of the metal rings are free from scratches and abrasions and foreign substances and are clean and dry.
- c Carefully clean the contact surface of the metal rings **E** and remove dust and fingerprints. Lubricate them with a thin film of oil. Take care not to oil the other components



**Fig 40.**

Half Seal Installation

A40836C



**Fig 41.**

- 3 Fit half seal **15**, on resealing tool SST0037

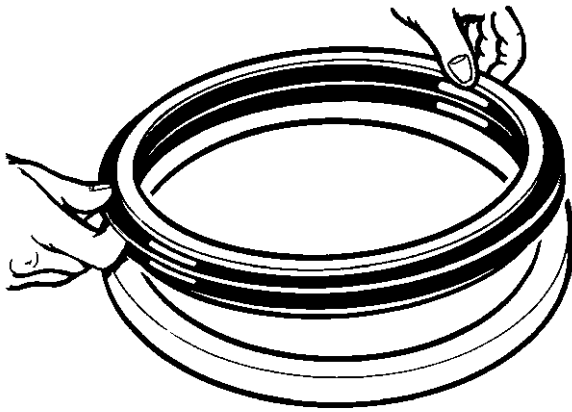


Fig 42.

- 4 Fit the half seal 15, inside the gearbox housing 14.

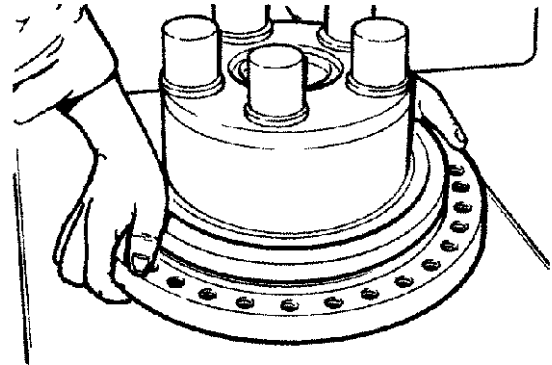


Fig 44.

- 6 Lubricate the metallic face of the half seal with a thin film of oil.

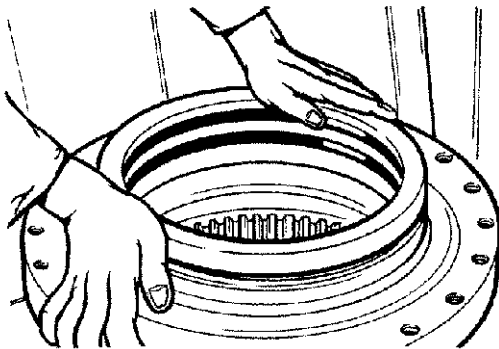


Fig 43.

- 5 Assemble, the half seal, on the hydraulic motor 17 by using service tool SST0037. Carefully clean the metal faces of the half seals.

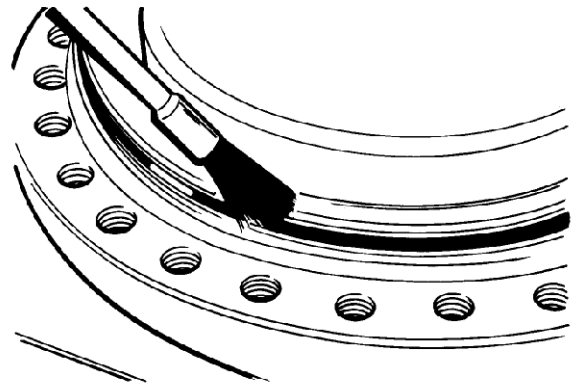


Fig 45.

- 7 Fit a lifting eye on to the hydraulic motor 17 and using suitable lifting equipment, position the hydraulic motor 17 inside the gearbox housing.
- 8 Using a press and a Stopper, see **Service tools, Section 1**. Push the hydraulic motor 17 against the shoulder of the gearbox housing.

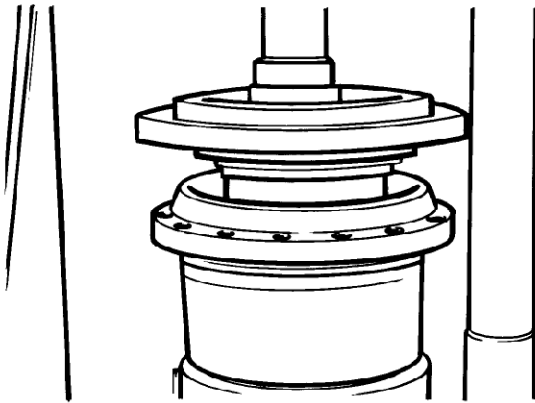


Fig 46.

- 9 By using a press and a drift, assemble the centering ring 16 in its seat on the hydraulic motor 17.

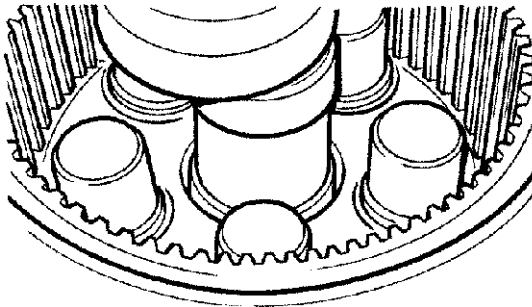
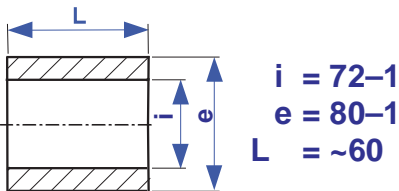


Fig 47.



A408380

Fig 48.

- 10 Using a torque multiplier and service tool SST0040 tighten the new ring nut 13.

### Torque Multiplier

Item	Nm	lbf ft	kgf m
Input	210	155	21.5
Output	6500	4795	663

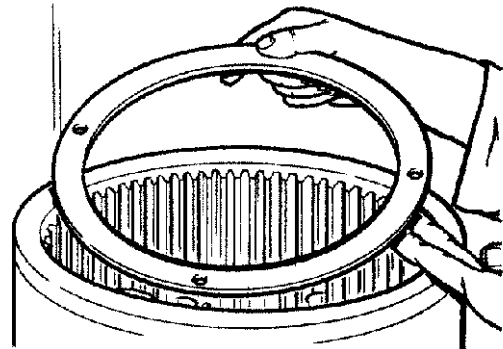


Fig 49.

- 11 Deform the ring nut 13 to a depth of 1-1.5mm, at a position next to a space on the flanged hub on the hydraulic motor 17 using a 4 - 5mm punch.

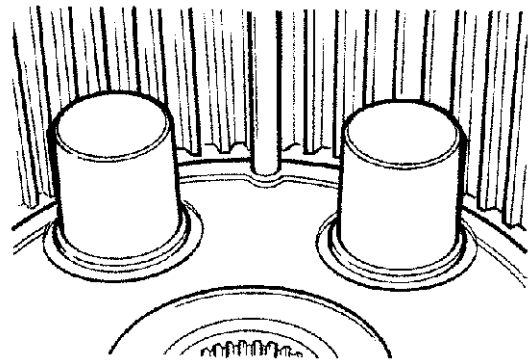
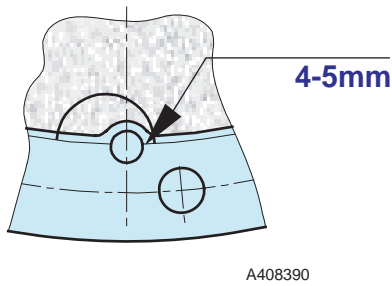
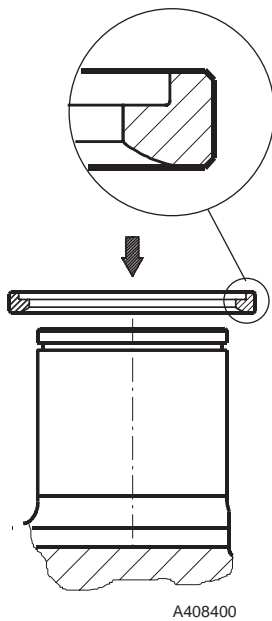


Fig 50.



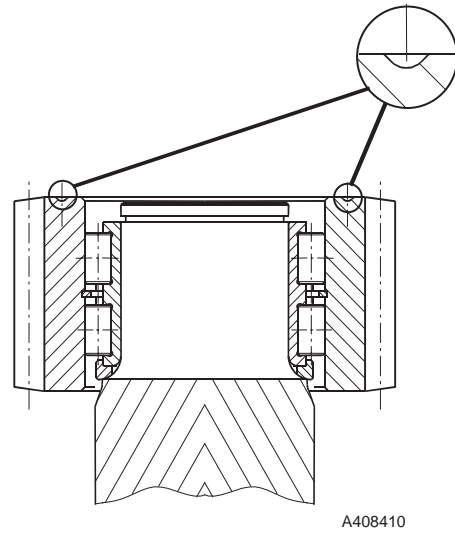
**Fig 51.**

- 12 Place the spacers 12, on the pins of the hydraulic motor 17. Make sure that the spacers are the correct way up.



**Fig 52.**

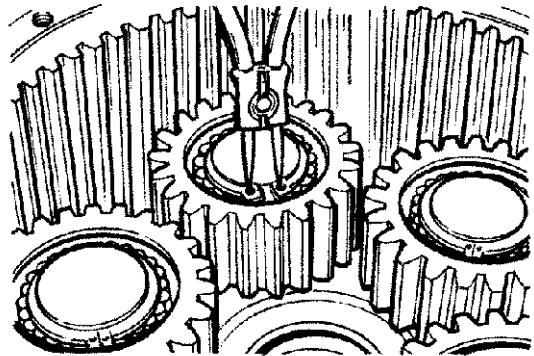
- 13 Place the five planet gears 11 of the third reduction assembly onto the flanged hub of the hydraulic motor 17.



**Fig 53.**

- 14 Using a rubber hammer and a drift, tap the planet gear assemblies 11 against the pins of the hydraulic motor 17.

Using circlip pliers, place the circlip 10, into its groove.



**Fig 54.**

- 15 Insert the second reduction assembly 9.