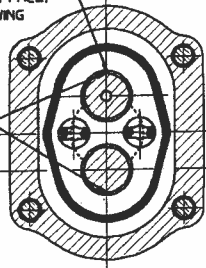


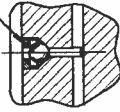
POSITION ALL WRAPPED BUSHES WITH SPLIT LINE WITHIN  $\pm 3^\circ$  OF  $\phi$  AS SHOWN, AND PRESS IN FLUSH TO 0.5 SUB - FLUSH WITH FACE, IN LINE WITH STAGE DRAWING SDB682-018-00C.

WRAPPED BUSH SPLIT LINE



SECTION P - P'

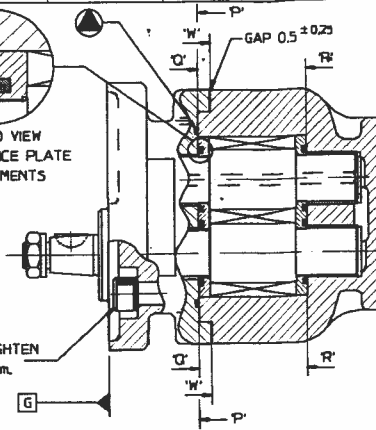
PRESS IN BALL RETAINER FLUSH TO FACE OF FLANGE. NOTE POSITION OF SLOT IN RETAINER TO BE AS SHOWN.



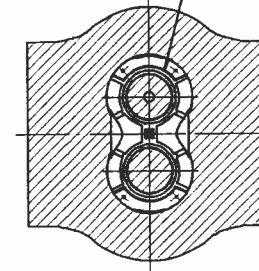
PART SECTION THROUGH CHECK VALVE (2 - PLACES)

ENLARGED VIEW OF BALANCE PLATE SEAL ELEMENTS

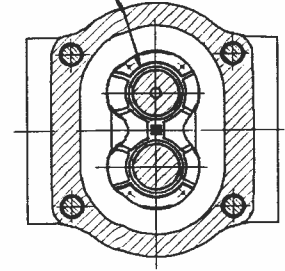
TORQUE TIGHTEN TO  $95 \pm 7$  Nm.



BALANCE PLATES TO BE ASSEMBLED WITH SEAL FREE FACE AGAINST GEAR FACE.

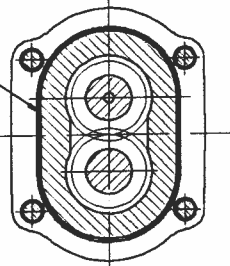


SECTION R - R'



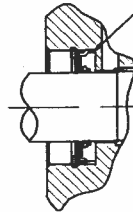
SECTION Q - Q'

APPLY A NOMINAL #2 SECTION CONTINUOUS BEAD OF LOCTITE 518 AROUND BODY AS SHOWN PRIOR TO ASSEMBLY OF MOUNTING FLANGE AND COVER WHEN APPROPRIATE.



SECTION W - W'

SHAFT SEAL ASSEMBLY INSTRUCTIONS :-  
ASSEMBLY IN ACCORDANCE WITH IS 682.



TEST AND CALIBRATION DATA

Part No.	MOTOR TEST INSTRUCTIONS	
	Max Pressure	Max Flow Count
2TR037	3045	*635 revs/ 5 gal

BODY AND GEAR LENGTHS SHOWN ARE ONLY TYPICAL AND MAY VARY. FOR ACTUAL CONFIGURATION SEE INSTALLATION DRAWING  
FASTENERS MAY ACTUALLY BE BOLTS OR NUT/STUD ASSEMBLIES, DEPENDING ON UNIT CONFIGURATION.  
LIGHTLY SMEAR INTERNAL COMPONENTS WITH CLEAN HYDRAULIC OIL ON ASSEMBLY. NOTE :- 'O' RINGS AND GROOVES MARKED THUS  $\odot$  TO BE ASSEMBLED DRY.

UNIT IDENTIFICATION TO IS 675.

WITH EXCEPTION OF AREAS AROUND PORTS, FACE [G] AND ALL COMPONENTS TO LEFT OF FACE [G], ALL SURFACES TO BE PAINTED TO IS 667.

REV	DATE	BY	CHKD	APP
1	20-05-08	AM		
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Part No.	378Y-001-000	THIRD ANGLE PROJECTION
TITLE	2TR037E3E3B1B1-210-BT4C1Y-D1	
UNLESS OTHERWISE STATED	<small>ALL DIMENSIONS IN MILLIMETRES / INCHES GENERAL MANUFACTURING STANDARDS TO BS 200 GEOMETRIC TOLERANCES AND SYMBOLS TO BS 309</small>	
<small>© ULTRA HYDRAULICS LTD LIMITED AND IS CONFIDENTIAL. IF IT IS REPRODUCED WITHOUT THE WRITTEN PERMISSION OF ULTRA HYDRAULICS LTD, IT IS TO BE DESTROYED. IF IT IS NOT DESTROYED IT SHALL NOT BE REPRODUCED IN ANY FORM.</small>		<small>THIS DRAWING IS THE PROPERTY OF ULTRA HYDRAULICS LTD AND IS CONFIDENTIAL. IF IT IS REPRODUCED WITHOUT THE WRITTEN PERMISSION OF ULTRA HYDRAULICS LTD, IT IS TO BE DESTROYED. IF IT IS NOT DESTROYED IT SHALL NOT BE REPRODUCED IN ANY FORM.</small>
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