CHANGING ROTATION PL 20 INSTRUCTION

PUMP PL20 STD

CASAPPA®
FLUID POWER DESIGN

Ed. 06/2018

Main operations

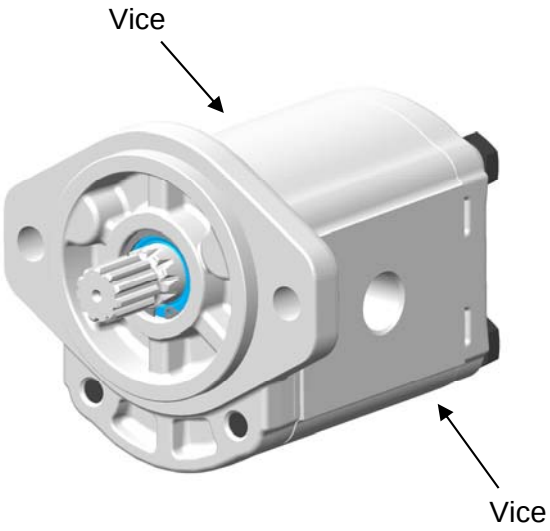
GENERAL SUGGESTION

- *Check the parts have not been damaged during the shipment.*
- *Work in a clean area.*
- *Clean with solvent (except the seals) and air dry all components before assembling.*
- *Pay attention not to damage the machined surfaces.*
- *The components need to be fitted in place without forcing them. If too much force is required, it is due a bad clearances issues.*
- *When hand pressure is not enough, use only mallet and never hammer.*
- *Respect the tightening torque for bolts.*
- *Pay attention when you see this sign:* 

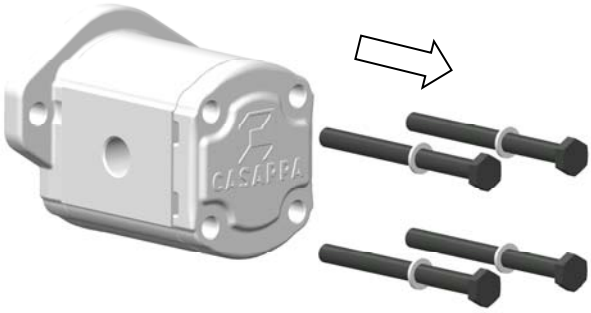
Components disassembly

Use some aluminium protection on the vice to not damage the machined surfaces. Put the pump in horizontal position. Grab the pump by the body.

Loosen the screws

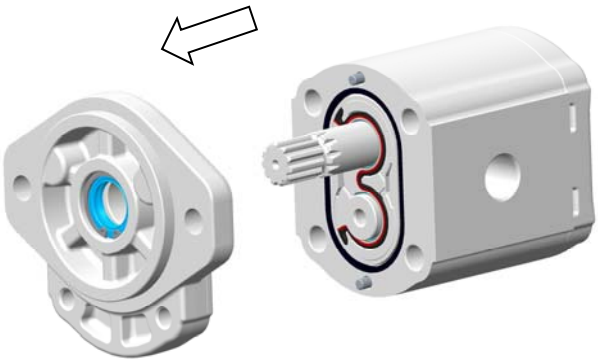


Remove the screws and the washers.



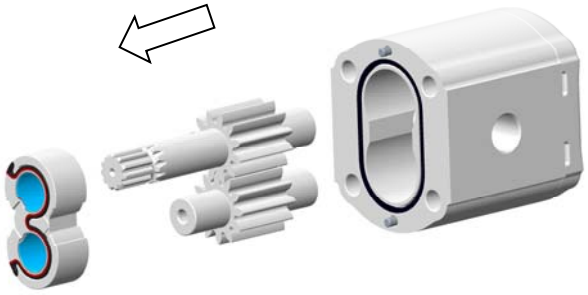
Protect the drive shaft with adhesive tape to avoid damaging the shaft seals.

Remove the front cover.



Components disassembly

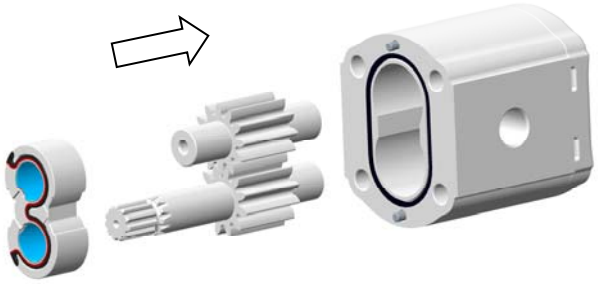
Remove the front pressure plate and the gears.
The rear plate has not to be removed.



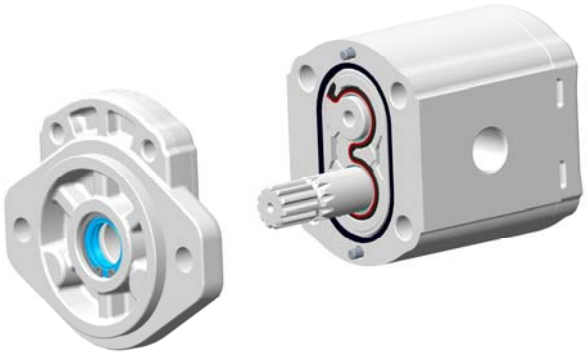
Components reassembly

Reassemble the gears:
- re-locate the driven gear in the position previously occupied by the drive gear;
- re-locate the drive gear in the position previously occupied by the driven gear;

Reassemble the front pressure plate in its original position



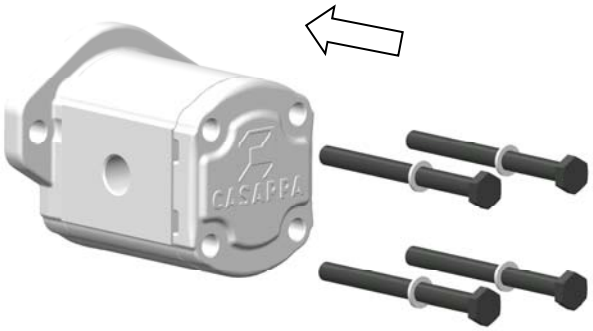
Reassemble the front cover turned 180 from its original position*



Final bolting and check

Tighten the screws with a torque wrench. Tighten a crisscross pattern with the following torque value:

- *70 Nm with cast iron covers*
- *45 Nm with one or both cover in aluminium*



Put the pump on the work bench.

With a clamp verify the shaft of the pump can turn after of the operation. The shaft must easily rotate. If the shaft is locked this mean some of the seals went out or a pressure plate seal may be pinched.
If it happens the whole operation needs to be done again and the damaged seals to be replaced.

Notes

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