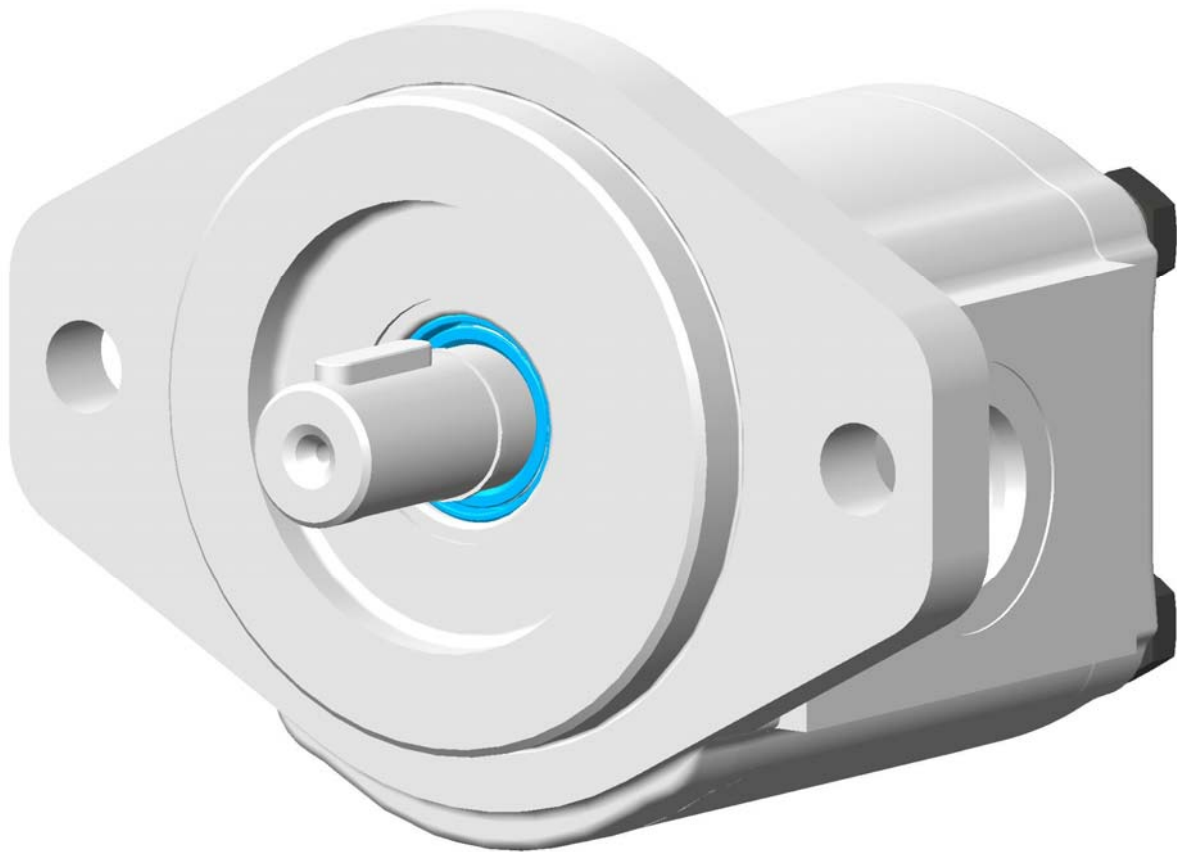


CHANGING ROTATION PL 20 INSTRUCTION

PUMP PL20 SUP



 **CASAPPA**[®]
FLUID POWER DESIGN

Main operations

Components disassembly

Pages 04 – 05

Components reassembly

Page 06


Final bolting and check

Page 07

Notes

Pages 08 – 09

GENERAL SUGGESTION

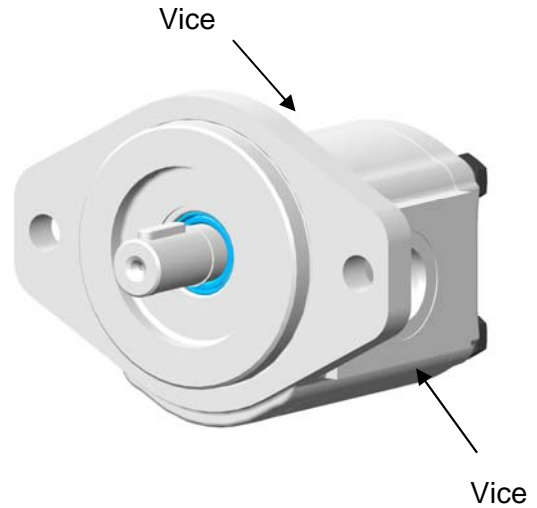
- *Check the parts have not been damaged during the shipment.*
- *Work in a clean area.*
- *Clean with solvent (except the seals) and air dry all components before assembling.*
- *Pay attention not to damage the machined surfaces.*
- *The components need to be fitted in place without forcing them. If 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

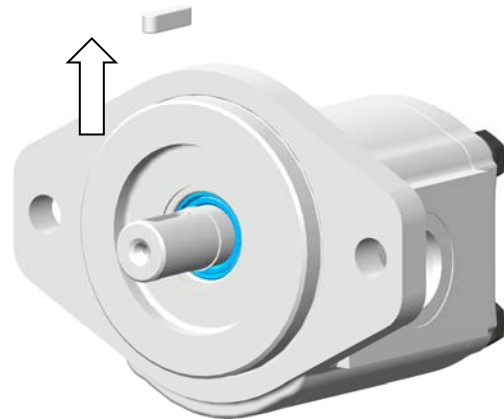


Use some aluminium protection on the vice to not damage the machined surfaces. Put the pump in horizontal position. Grab the pump by the body.

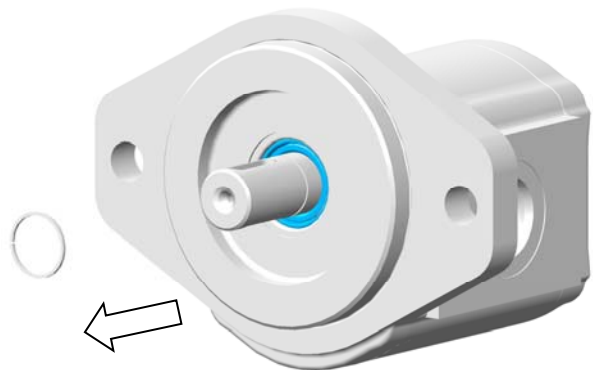
Loosen the screws



Extract the shaft key.

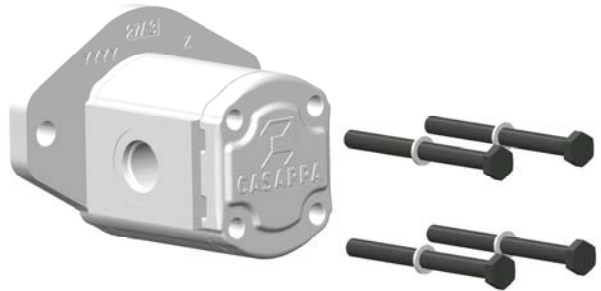


Remove the ring.



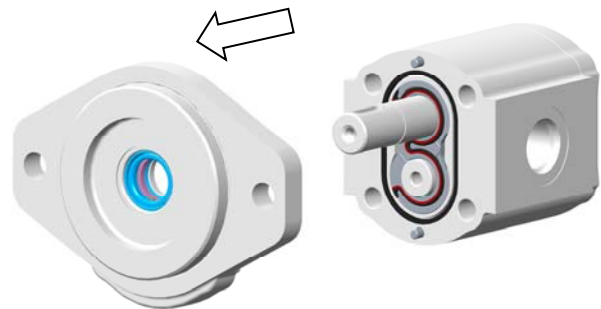
Components disassembly

Remove the screws and the washers.

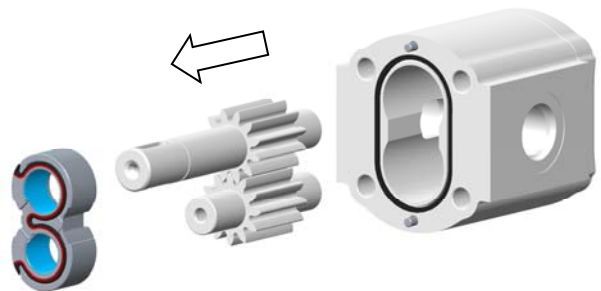


Protect the drive shaft with adhesive tape to avoid damaging the shaft seals.

Remove the front cover.



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



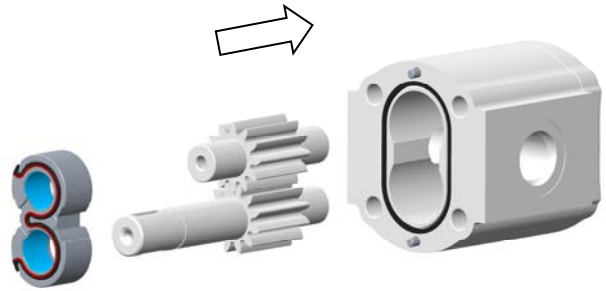
Components reassembly



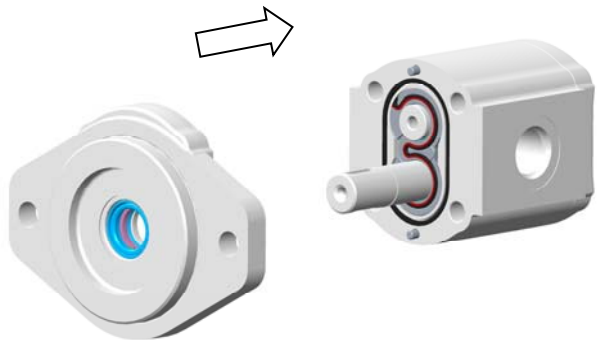
- Reassemble the gears:*
- re-locate the driven gear in the position previously occupied by the drive gear;
 - re-locate the drive gear in the position previously occupied by the driven gear.

Replace the front pressure plate with:

*CW = 25930040
CCW = 25930042*



Reassemble the front cover turned 180° from its original position

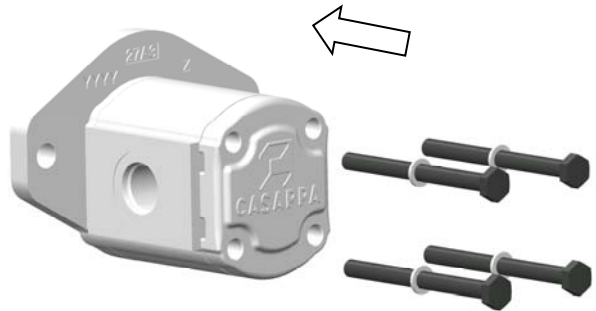


Final bolting and check

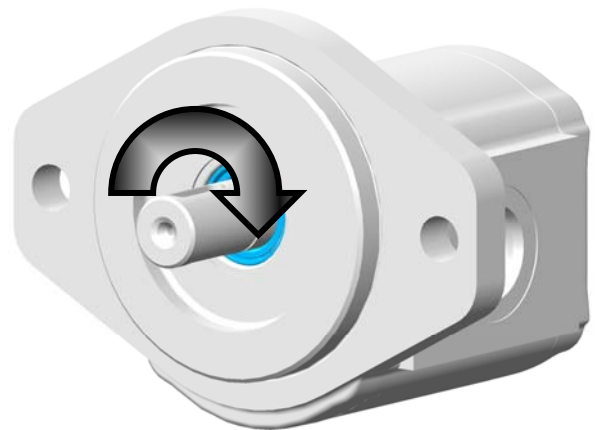


*Tighten the screws with a torque wrench.
Tighten a crisscross pattern with the following
torque value:*

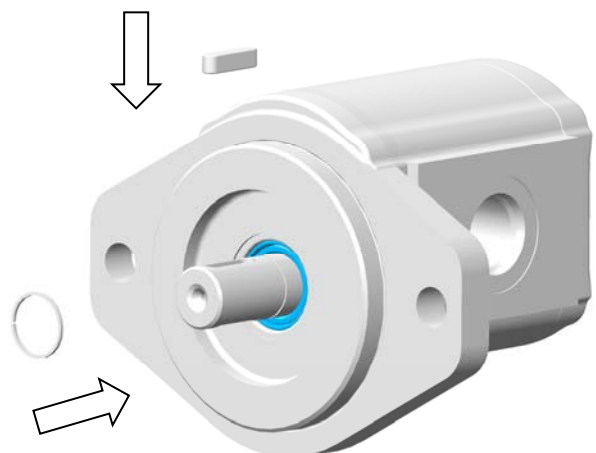
- 70 Nm with cast iron covers
- 45 Nm with one or both cover in aluminium



*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.*



Put back the shaft key and the ring.



Notes

Notes



CASAPPA[®]

F L U I D P O W E R D E S I G N