

**Fig. 14—Installing Rotor Vanes**

mounting studs. Tighten pressure hose fitting to 30-40 foot-pounds and rear mounting studs to 25-35 foot-pounds.

(17) Remove pump assembly from vise and install mounting brackets.

(18) Clamp pump assembly securely into vise at mounting bracket.

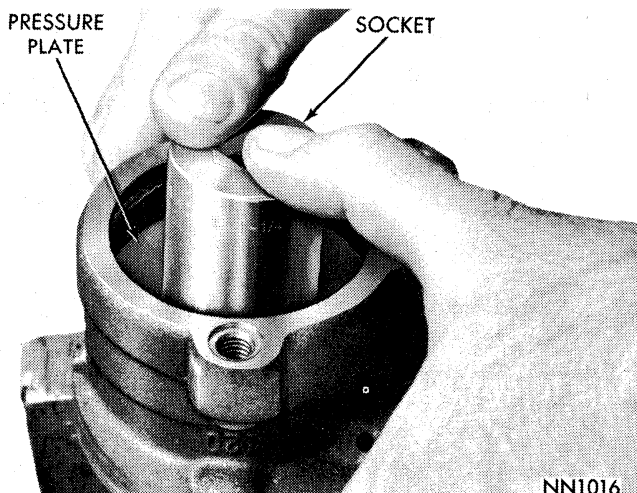
(19) Using Tool C-4063 without adapters SP5397 and SP5399, install pulley on shaft. Be sure tool remains in alignment during installation. Tighten until tool bottoms on shaft (Fig. 18).

(20) Install pump assembly on engine and refill reservoir. Start engine, inspect for leaks and recheck fluid level.

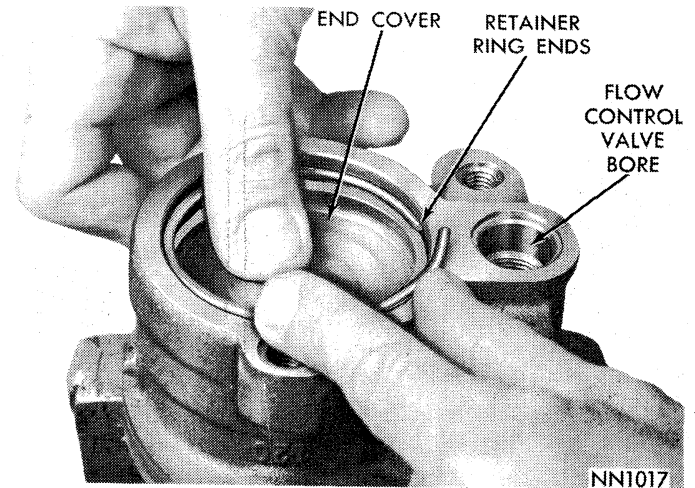
## FLOW CONTROL VALVE

### .94 Model

The flow control valve is serviced as an assembly. Nicks or burrs that might cause the valve to stick in the bore may be removed by rubbing valve over flat surface covered by crocus cloth. Care should be taken to prevent rounding the sharp edges of the lands.



**Fig. 15—Seating Pressure Plate**



**Fig. 16—Installing End Cover Plate and Retainer Ring**

The valve may be disassembled for cleaning if dirt has caused pump failure. It is important that if the valve is disassembled to be cleaned, the entire pump should be disassembled and cleaned.

### Disassembly

(1) Remove pressure hose fitting from pump reservoir. Discard "O" ring on fitting.

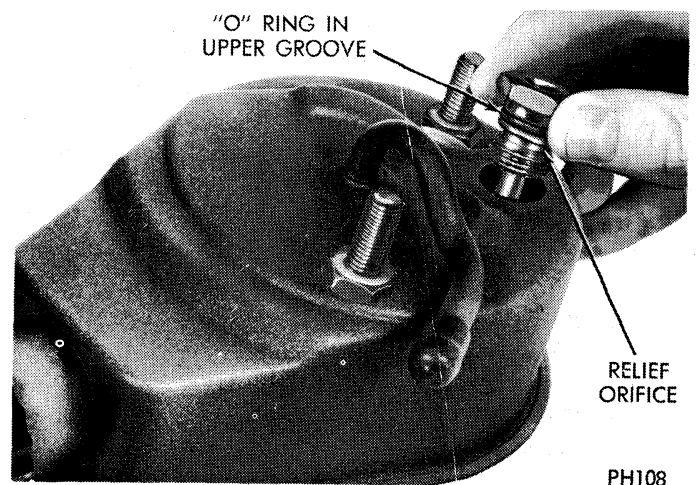
(2) Withdraw valve with a magnet. If valve is stuck in bore, it may be necessary to push in on valve against spring pressure. Release pressure exerted against valve abruptly and allow valve to spring out of bore.

(3) Clamp land end of valve in a soft jawed vise and remove hex head plug and shim(s). Note number of shims on plug. Same number of shims should be installed on assembly of valve.

(4) Remove valve from vise and remove pressure relief ball, guide and spring.

### Assembly

(1) Insert spring, guide and pressure relief ball in



**Fig. 17—Installing Pressure Hose Fitting**