



Medium Duty Series Danfoss® Pumps

Kit 70160-903 -02 Design Shimming Process

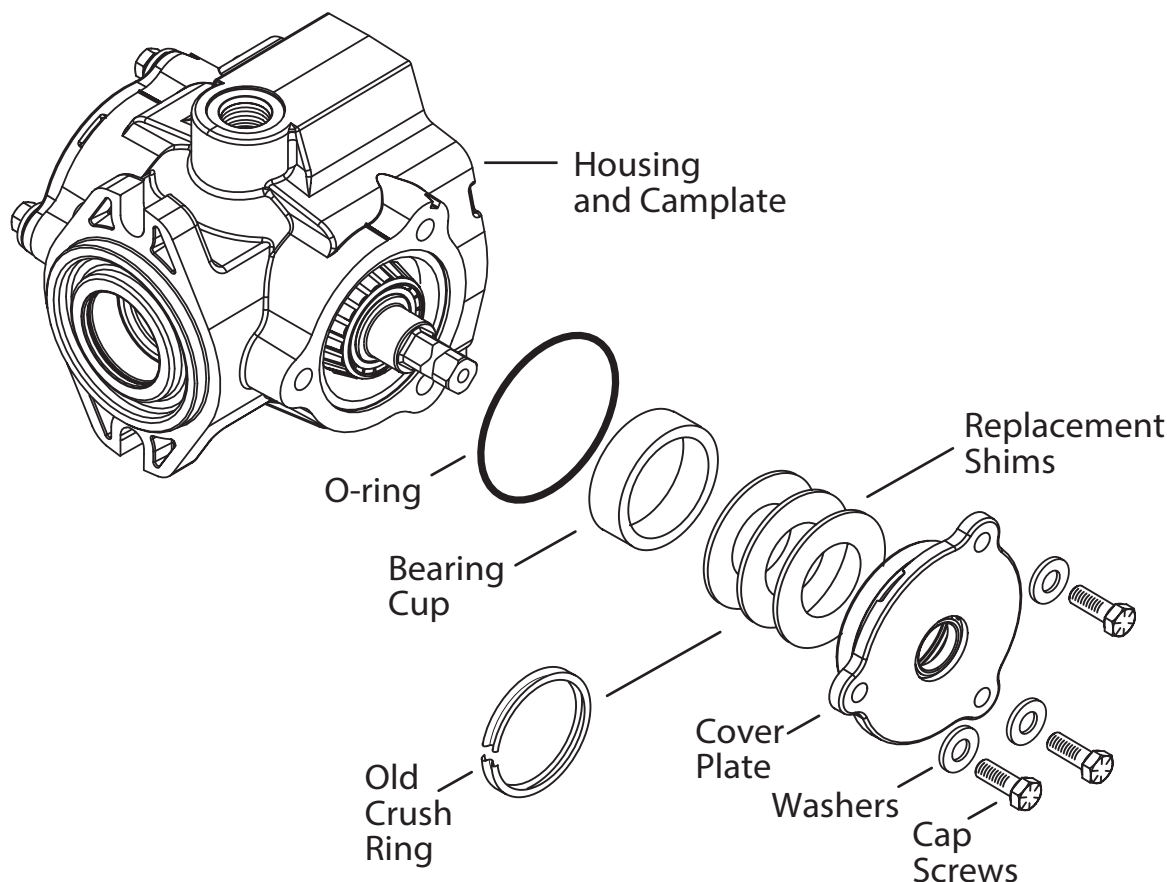
Introduction

This shim kit is to replace the crush ring within the trunnion cover. If the camplate, trunnion cover or housing is replaced during servicing, the old crush ring can no longer be used to assure proper preload.

Shimming procedures:

- 1 Measure the thickness of the existing crush ring.
- 2 To obtain a starting point stack shims to the measurement of existing crush ring. Then insert shims into the trunnion cover in the same location as the removed crush ring.
- 3 Assemble the housing sub-assembly consisting of the housing, camplate, bearings and trunnion covers. Install the trunnion cover bolts and torque to 56,9 N·m [42 lbf·ft].
- 4 With a torque wrench, check the torque required to rotate the control shaft. The specified torque level is $2,26 \pm 0,6$ N·m [205 lbf·in].
 - If torque level is too low, add additional shims and repeat steps 3 and 4 until specified torque levels are achieved.
 - If torque level is too high, remove shims and repeat steps 2 and 3 until specified torque levels are achieved.
- 5 Finish the assembly of the pump.

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