

SECTION 5. "T" FLANGE MOTORS (ex. 530540I3828AAAAA)

- A) Remove all shaft related components from shaft (23) (i.e. keys, nuts). To aid in reassembly of the motor, make a "V" shaped set of lines from the endcover (21) to the housing using either paint or a marker. With shaft facing down, secure motor in vise by clamping on to housing (10).
- B) Loosen and remove seven bolts (22) holding motor assembly together. Remove endcover (21) and endcover seal (7). Discard seal. Remove balance plate (19) taking care not to drop the three steel balls (20) located in the three holes in the balance plate (19). Remove rotor assembly (18), manifold (17), drive link spacer (16) (NOTE: Some motors do not use spacer), drive link (15) and thrust bearing (14). Remove body seals (6) from rotor assembly (18) and housing seal (2) from housing (10) and discard seals.
- C) Gently tap shaft (23) upward from housing (10) and remove through rear of housing and lay aside. Remove housing (10) from vise and turn over. Pry dust seal (1) from housing and discard.
- D) Using a slide and hammer bearing puller (see Figure 1) remove rear housing bearing (8) through rear of housing.
- E) Remove the thrust washer (13), front thrust bearing (12), front thrust washer (11), shaft seal (5), back-up seal (4), back-up shim (3a), and back-up ring (3) from housing. Discard items (3, 3a, 4, & 5).

At this point, all parts should be cleaned in an oil-base solvent and dried using compressed air (For safety, observe all OSHA safety guidelines). All new seals should be lightly coated in clean oil prior to installation.

- F) Place shaft (23) on a clean flat surface with output end facing up. Place on shaft, thrust washer (13), then thrust bearing (12), then front thrust washer (11). Lightly coat seal area of shaft with clean oil and place shaft seal (5) down onto shaft (23) making sure that lip on seal faces down (See Figure 2 for correct seal orientation) until it contacts thrust washer (11). Carefully install the back-up seal (4) onto the shaft (23) with the flat side up and the seal lip facing the shaft seal (5). Place the metal back-up shim (3a) onto the shaft, then place the back-up ring onto the shaft with the flat side against the backup shim (3a).
- G) Place housing (10) onto shaft assembly. Place housing shaft assembly back in vise with output shaft facing down. Install rear housing bearing (8) into rear of housing until bearing (8) contacts the stop in the housing (flat side of bearing (8) should face upward away from housing).
- H) Install drive link (15) in shaft end (crowned splines goes into shaft end). Place thrust bearing (14) over drive link (15). If shaft assembly is properly seated in housing (10), thrust bearing (14) will be flush or countersunk with rear surface of housing (10).
- I) Install housing seal (2) into groove in housing (10). Place manifold (17) onto housing, (10) side with only seven holes facing housing (10). Place body seals (6) in grooves in both sides of rotor (18). Place rotor (18) onto manifold (17) with side of rotor with chamfer in splines facing manifold (17). If motor used a drive link spacer (16), place spacer (16) on top of drive link (15).
- J) Install balance plate (19) onto rotor (18) making sure holes for steel balls (20) faces up. Install three steel balls (20) in holes in balance plate (19). Install endcover seal (7) into groove in endcover (21) and place endcover onto balance plate (19). Install seven assembly bolts (22) and pre-torque to 10 ft. lbs. Using the bolt torque sequence shown in Figure 3, final torque all bolts to 50 ft. lbs.

Remove motor from vise and place on work surface with shaft (23) facing up. Making sure that lip on seal (1) faces up, place dust seal (1) over shaft (23). Using a sleeve and a hammer, carefully drive dust seal (1) into place.

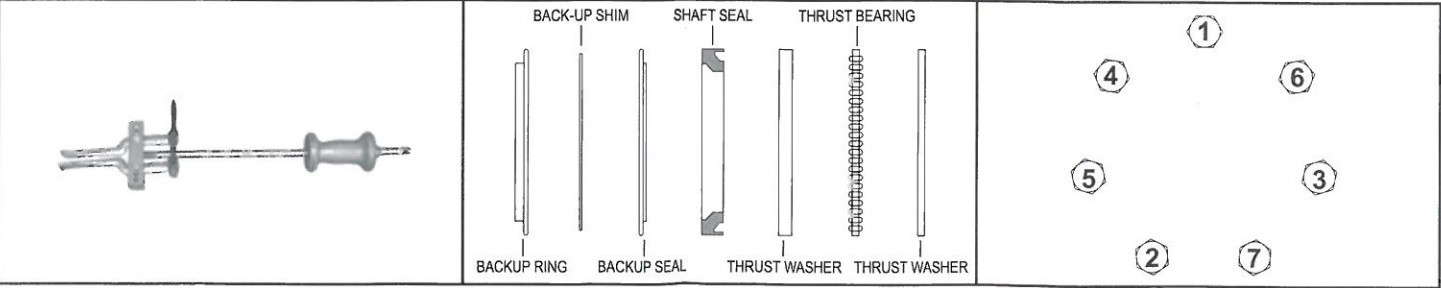


FIGURE 1

FIGURE 2

FIGURE 3

SECTION 5. "T" FLANGE MOTORS - continued

- 1. * Dust Seal
- 2. * Housing Seal
- 3. * Back Up Ring
- 3a. * Back Up Shim
- 4. * Back Up Seal
- 5. * Shaft Seal
- 6. * Body Seals (2)
- 7. * Endcover Seal
- 8. * Rear Housing Bearing
- 9. Front Housing Bearing
- 10. Housing
- 11. Front Thrust Washer
- 12. Front Thrust Bearing
- 13. Thrust Washer
- 14. Rear Thrust Bearing
- 15. Drive Link
- 16. Drive Link Spacer
- 17. Manifold
- 18. Rotor Assembly
- 19. Balance Plate
- 20. Steel Balls (3)
- 21. Endcover
- 22. Assembly Bolts (7)
- 23. Shaft
- 24. Shaft Key
- 25. Shaft Nut

* Contained in Seal Kit 500444004

