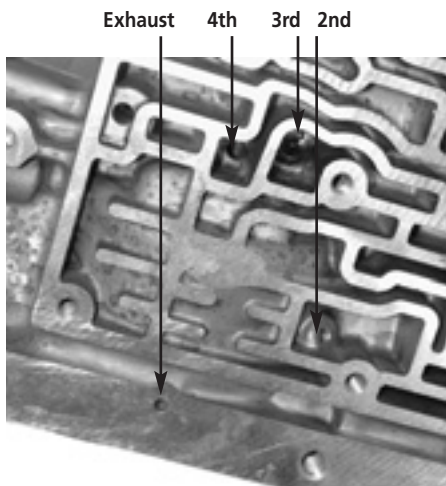


SC-4L60-E Verification Procedures

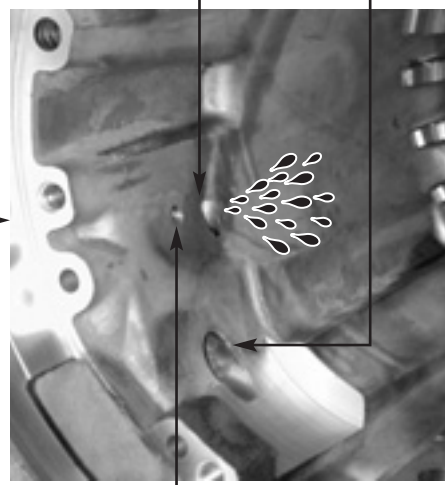
SERVO WET AIR TEST



With servo bore resurfaced and Viton® seals on piston, install and air test. There should be no cross leakage from opposing circuits (when testing 4th there should be no leakage from 3rd, etc.).

Doing this WAT test before unit re-assembly will identify leakage of 3rd accumulator capsule, servo pin or bore. Locating a problem now could save an additional tear-down.

With fluid in servo, WAT. No leakage from 3rd capsule and/ or servo pin bore.

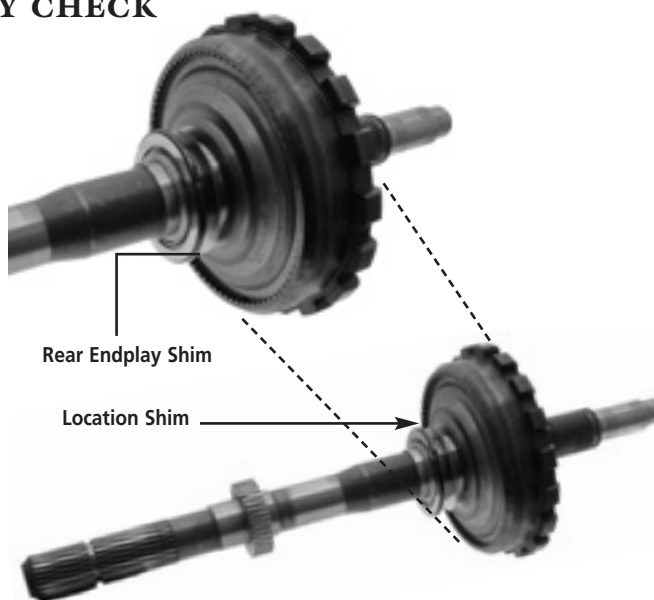


Orificed vent; slight bleed with fluid and air psi of 30-60 is normal.

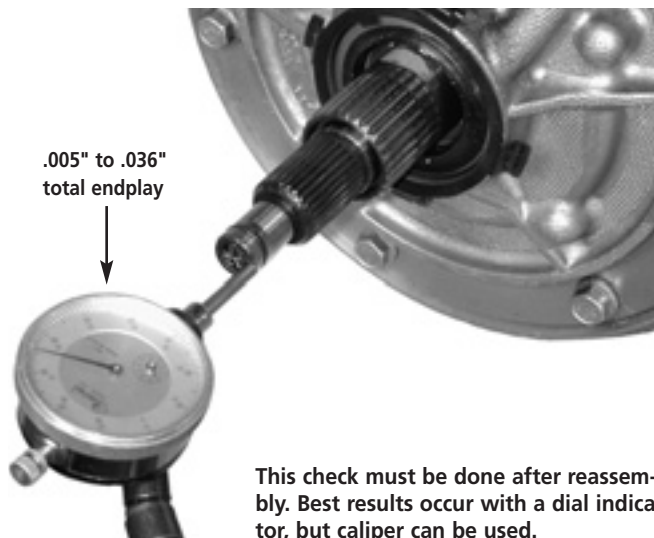
REAR UNIT ENDPLAY CHECK



With output shaft snap ring installed, check the rear shaft movement with either dial indicator or caliper.



FRONT UNIT ENDPLAY CHECK



This check must be done after reassembly. Best results occur with a dial indicator, but caliper can be used.