

MODELS 1270-1370-1570

new bearing in from flanged end of cover to the dimension shown in Fig. 10. Press only on numbered end of bearing, using a piloted mandrel.

Using a micrometer, measure thickness of the commutator ring (39—Fig. 9) and commutator (40). If commutator ring is 0.0015 or more thicker than commutator, renew the matched set.

Place the stator-rotor set (35, 36 and 37) on the lapped surface of end cover (44). Make certain that vanes and vane springs (36) are installed correctly in slots of rotor.

NOTE: Arched back of springs must contact vanes.

Position lobe of rotor in valley of stator as shown in Fig. 11. Center opposite lobe on crown of stator, then using feeler gage, measure clearance between rotor lobe and stator. If clearance is more than 0.006, renew stator-rotor assembly. Using a micrometer, measure thickness of stator and rotor. If stator is 0.002 or more thicker than rotor, or vanes are worn to 0.250 inch or less in length, renew the assembly. Stator, rotor and vanes are available only as an assembly. Vane springs may be renewed separately if they have lost their arch.

Before reassembling, wash all parts in clean solvent and air dry. All parts, unless otherwise indicated, are installed dry. Install recirculating ball (19—Fig. 9) and plug (28) with new "O" ring (26) in valve body and tighten plug to a torque of 10-14 ft.-lbs. Clamp fitting (installed in valve body port) in a vise so that top end of valve body is facing upward. Install thrust washer (16), thrust bearing (15), wave spring (14), second thrust washer (13) and snap ring (12) on input shaft (17). If actuator

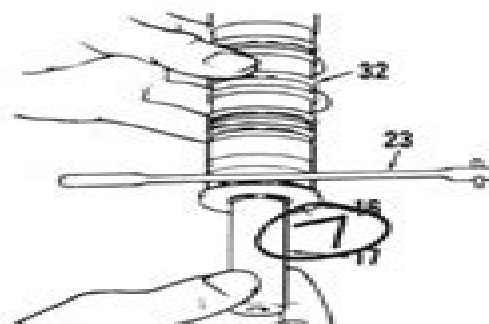


Fig. 12—Use torsion bar as shown to space spool proper distance from thrust washer and bearing assembly. This will establish the neutral position. Refer to Fig. 9 for parts identification.

ball retaining spring (20) was removed install new retaining spring with round head of spring in the larger of the two holes in spool (32). Place actuator ball (19) in its seat from the inside of valve spool (32). Insert input shaft into valve spool, engaging the helix and actuator ball with a counter-clockwise motion. Use the mid-section of torsion bar (23) as a gage between end of valve spool and thrust washer as shown in Fig. 12, to insure assembly in the neutral position of the ball on ramp. Place the assembly in a vertical position with end of input shaft resting on a bench. Insert drive ring (21) into valve spool until drive ring is fully engaged on input shaft spline. Remove torsion bar gage. Install spacer (22) in valve spool, over drive ring (21). Distance from top of spool (32) to top of spacer (22) should be 22/32 inch. Install torsion bar into valve spool. Align cross-holes in torsion bar and input shaft with a 0.120 inch pin punch and install pin (18). Pin must be pressed into shaft until end of pin is about 1/32-inch below flush. Place spacer (24) over spool and install spool assembly into valve body. Position original shims (11) on wave spring (14), lubricate the new seal ring (20), place seal ring in upper cover (8) and install upper cover assembly. Align the match marks on cover flange and valve body and install cap screws finger tight. Tighten a worm drive type hose clamp around cover flange and valve body to align the outer diameters, then tighten cap screws to a torque of 18-22 ft.-lbs.

NOTE: If either input shaft (17) or upper cover (8) or both have been renewed, the following procedure for shimming must be used.

With upper cover installed (with original shims) as outlined above, invert unit in vise so that input shaft is pointing downward. Grasp input shaft, pull downward and prevent it from rotating. Engage drive link (34) splines in valve spool and rotate drive link until end of spool is flush with end of valve body. Remove drive link and check alignment of drive link slot to torsion bar pin. Install drive link until its slot engages torsion bar pin. Check relationship of spool end to body end. If end of spool is within 0.0025 of being flush with end of body, no additional shimming is required. If not within 0.0025 of being flush, remove cover and add or remove shims (11) as necessary. Reinstall cover and recheck spool to valve body position.

With drive link installed, place spacer plate (33) on valve body with plain side up. Install stator-rotor set over drive

Paragraph 8 Cont.

link splines and align cap screw holes. Make certain vanes and vane springs are properly installed. Install manifold (38) with circular slotted side up and align cap screw holes with stator, spacer and valve body. Install commutator ring (39) with slotted side up, then install commutator (40) over drive link end with counterbore for washer (43) facing out. Make certain that link end is engaged in the smallest elongated hole in commutator. Install seal (41) and retainer (42). Apply a few drops of hydraulic fluid on commutator (40) and manifold (38). Use a small amount of grease to stick washer (43) in position over pin on end cover (44). Install end cover making sure that pin engages center hole in commutator. Align holes and install cap screws. Alternately and progressively tighten cap screws while rotating input shaft. Final tightening should be 18-22 ft.-lbs. torque.

Relocate the unit in vise so input shaft is up. Lubricate new seal ring (5) with clean grease and install against bearing (10). Lubricate shaft seal (4) and carefully work seal over shaft and

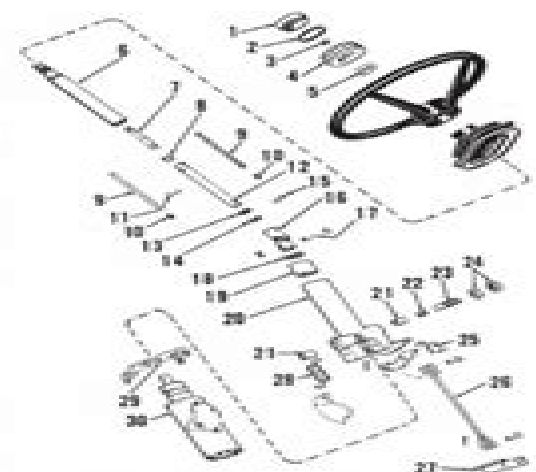


Fig. 13—Exploded view of DIT and telescoping steering mechanism.

- | | |
|------------------------|-------------------|
| 1. Cap | 24. Jam nut (24) |
| 2. "O" ring | 25. Latch spring |
| 3. Nut | 26. Latch rod |
| 4. Lock knob | 27. Tilt pedal |
| 5. Steering arm | 28. Return spring |
| 6. Outer shaft | 29. Shock |
| 7. Lock shaft | 30. Pump |
| 8. Locknut | |
| 9. Lock ring (2) | |
| 10. Friction lock (2) | |
| 11. Stop pin | |
| 12. Inner shaft | |
| 13. Washer | |
| 14. Internal snap ring | |
| 15. Ball pin | |
| 16. C-joint | |
| 17. Pin w/stop | |
| 18. Seal | |
| 19. Bearing | |
| 20. Column | |
| 21. Bushing (2) | |
| 22. Rubber boot (2) | |
| 23. Pivot stud (2) | |

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I & T Shop Service



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Table of Contents David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1

1. Understanding the eBook David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - The Rise of Digital Reading David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Advantages of eBooks Over Traditional Books
2. Identifying David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - User-Friendly Interface
4. Exploring eBook Recommendations from David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Personalized Recommendations
 - David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1 User Reviews and Ratings
 - David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1 and Bestseller Lists

5. Accessing David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1 Free and Paid eBooks
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 - David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1 eBook Subscription Services
 - David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1 Budget-Friendly Options
6. Navigating David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1 eBook Formats
 - ePub, PDF, MOBI, and More
 - David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1 Compatibility with Devices
 - David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1 Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Highlighting and Note-Taking David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Interactive Elements David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
8. Staying Engaged with David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
9. Balancing eBooks and Physical Books David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Setting Reading Goals David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1
 - Fact-Checking eBook Content of David Brown Case 1270 1370 1570 Tractor Workshop Service Repair Manual 1

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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