



For Use With Seal Kits: 700666300

AX00000340en-US0101 | PI666300

dimensions: mm [in]

NOTE: Housing and body seals on products manufactured after July 1, 2016 are o-ring seals. Prior to this date these seals were square cut seals. It is recommended that if the product being serviced has square seals to replace with the square seals in this kit, likewise if the product has o-ring seals, replace with the o-ring seals in this kit.

The special tools and fixtures required, the housing/hub assembly is not field serviceable. For repair work, the housing/hub assembly must be returned to the factory. To insure the fastest possible turn around time, please contact our Technical Support Department at 800-323-7298 for return instructions. For breakdown situations requiring immediate repairs, new housing/hub assemblies are available for immediate shipment.

MOTOR SECTION DISASSEMBLY AND ASSEMBLY

- A)** To aid in reassembly of the motor, make a “V” shaped set of lines from the endcover (18) to the housing/hub (10) using either paint or a marker. With housing/hub (10) facing down, secure motor in vise.
- B)** Loosen and remove seven bolts (19) holding motor assembly together. Remove endcover (18) carefully as piston (16) and spring (17) may fall out. If piston does not come out, carefully pry piston (16) out of endcover (18) and lay aside. Remove O-ring seal (5) and backup seal (6) from endcover and discard seals. Remove spring (17) and lay aside.
- C)** Lift commutator container and commutator (15) from motor and lay aside. Place commutator on a flat, clean surface with the seal (4) facing up. Place the tip of a small screwdriver on the seal (4) and gently tap until opposite side of seal lifts from groove. Remove seal (4) and discard.
- D)** Remove manifold (14), rotor assembly (13) and divider plate (12). Remove all seals (2 & 3) from components and discard. **(Caution- Do not allow rolls to drop from rotor assembly (13) when removing rotor assembly from motor.)** Remove drive link (11) from motor and lay aside.

At this point, all parts should be cleaned in an oil-based 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.

- E)** Install drive link (11) into end of shaft with tapered end facing up. Place rear housing seal (2) in groove in housing/hub (10). Place body seals (2) in grooves in both sides of rotor assembly (13). Place rotor assembly (13) onto housing/hub (10) with side of rotor assembly with chamfer in splines facing housing (10). Place manifold (14) over rotor assembly (13) with seal groove side up. Install manifold seal (3).
- F)** Install the commutator seal (4) into the commutator (15) with the metal side facing up. Use finger pressure to press the seal down flush with the surface of the commutator. Place the commutator container onto the manifold (14) and then place the commutator onto the protruding end of the drive link (11) making sure that the seal side faces up.
- G)** Install the remaining body seal (2) in the groove in the face of the endcover (18). Install piston spring (17) into endcover (18), then the white backup seal (6) followed by the O-ring seal (5). Lining up the alignment pin on the piston (16) with the hole in the endcover (18), press piston (16) into the endcover (18). While holding the piston (16) in the endcover, lower the endcover assembly onto the commutator assembly (15). Check to make sure that the endcover ports are in their original position.
- H)** Install the seven assembly bolts (19) and pre-torque to 13.6 Nm [10 ft. lb.]. Final torque all bolts to 69.8 ± 7.5 Nm [51.5 ± 5.5 ft. lb.] using the bolt torque sequence shown in Figure 1.

SERVICE GUIDE
DT [740] SERIES MOTORS

ENGINEERING
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EXPLODED VIEW DIAGRAM

- | | |
|--------------------------|-----------------------------------|
| 1. * Cap Seal | 12. Divider Plate |
| 2. * Body Seal (4) | 13. Rotor Assembly |
| 3. * Manifold Seal | 14. Manifold |
| 4. * Commutator Seal | 15. Commutator Assembly |
| 5. * O-Ring Seal | 16. Endcover Piston |
| 6. * Backup Seal | 17. Piston Spring |
| 7. Capscrews (6) | 18. Endcover |
| 8. Flange Cap | 19. Assembly Bolts (7) |
| 9. Lug Nuts (6) | |
| 10. Housing/Hub Assembly | * Contained in Seal Kit 700666300 |
| 11. Drive Link | |

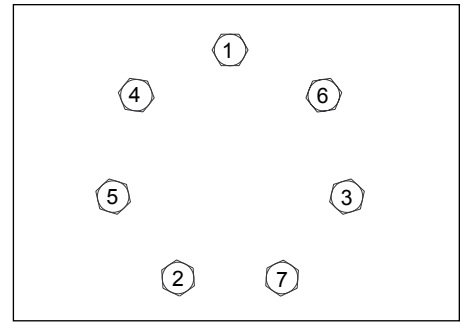


FIGURE 1

