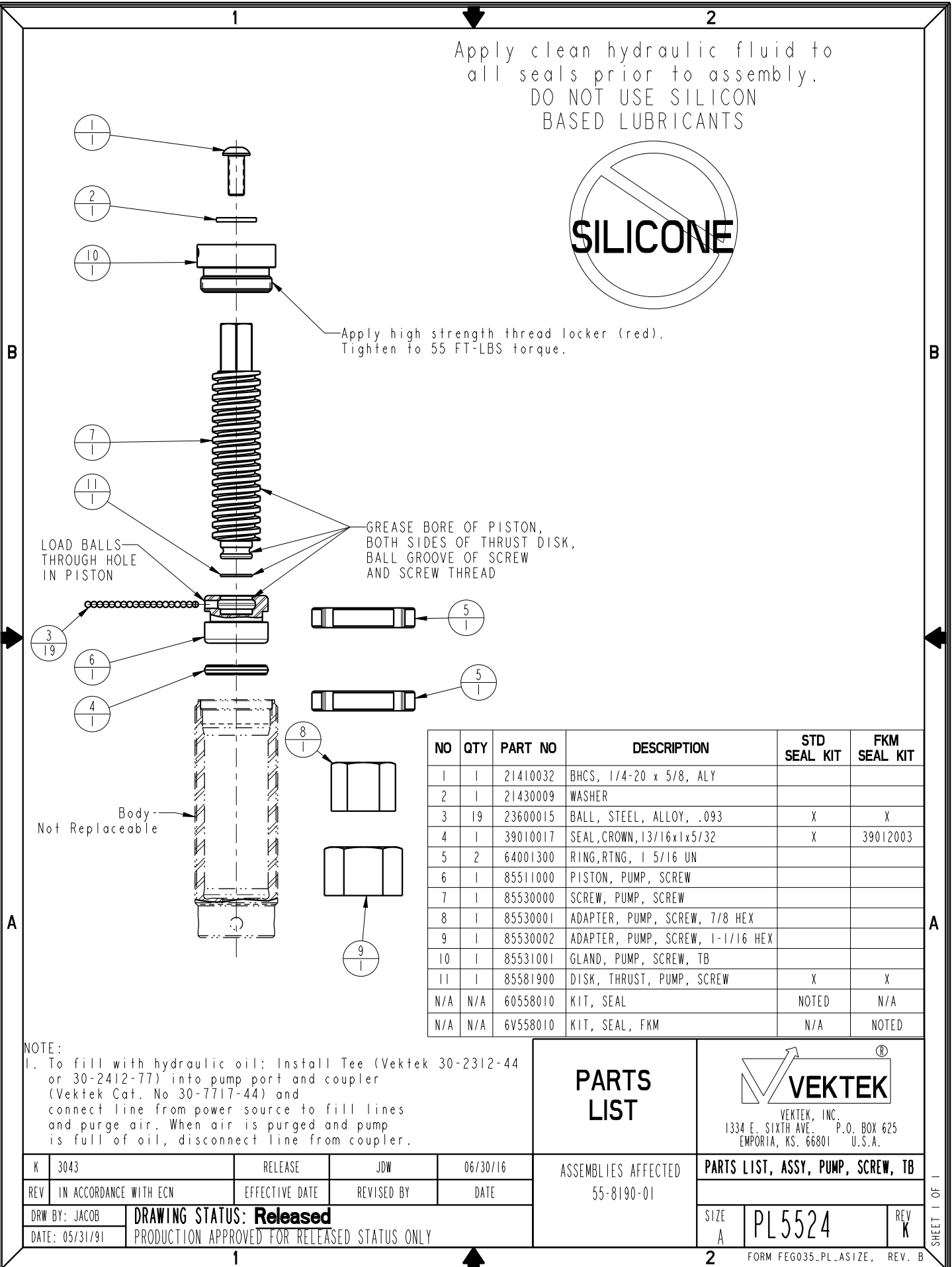


Apply clean hydraulic fluid to all seals prior to assembly.
DO NOT USE SILICON BASED LUBRICANTS



Apply high strength thread locker (red).
Tighten to 55 FT-LBS torque.


GREASE BORE OF PISTON,
BOTH SIDES OF THRUST DISK,
BALL GROOVE OF SCREW
AND SCREW THREAD

LOAD BALLS
THROUGH HOLE
IN PISTON

Body
Not Replaceable

NO	QTY	PART NO	DESCRIPTION	STD SEAL KIT	FKM SEAL KIT
1	1	21410032	BHCS, 1/4-20 x 5/8, ALY		
2	1	21430009	WASHER		
3	19	23600015	BALL, STEEL, ALLOY, .093	X	X
4	1	39010017	SEAL,CROWN,13/16x1x5/32	X	39012003
5	2	64001300	RING,RTNG, 1 5/16 UN		
6	1	85511000	PISTON, PUMP, SCREW		
7	1	85530000	SCREW, PUMP, SCREW		
8	1	85530001	ADAPTER, PUMP, SCREW, 7/8 HEX		
9	1	85530002	ADAPTER, PUMP, SCREW, 1-1/16 HEX		
10	1	85531001	GLAND, PUMP, SCREW, TB		
11	1	85581900	DISK, THRUST, PUMP, SCREW	X	X
N/A	N/A	60558010	KIT, SEAL	NOTED	N/A
N/A	N/A	6V558010	KIT, SEAL, FKM	N/A	NOTED

NOTE:
1. To fill with hydraulic oil: Install Tee (Vektex 30-2312-44 or 30-2412-77) into pump port and coupler (Vektex Cat. No 30-7717-44) and connect line from power source to fill lines and purge air. When air is purged and pump is full of oil, disconnect line from coupler.

PARTS LIST	 VEKTEK VEKTEK, INC. 1334 E. SIXTH AVE. P.O. BOX 625 EMPORIA, KS. 66801 U.S.A.
	ASSEMBLIES AFFECTED 55-8190-01
PARTS LIST, ASSY, PUMP, SCREW, TB	SIZE A PL5524
DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY	REV K

K	3043	RELEASE	JDW	06/30/16
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	JACOB	DRAWING STATUS: Released PRODUCTION APPROVED FOR RELEASED STATUS ONLY		
DATE:	05/31/91			

SHEET 1 OF 1