

Installation Guide

Flushing, filling, priming and running in a replacement pump or cartridge kit.

Before You Start

Most repeat failures after a pump repair are caused by contamination, a suction restriction or misalignment rather than by the new parts. The steps below are in order for that reason.

Installation Steps

Step	Action
Clean the circuit first	Drain and flush the reservoir, change the pressure and return filters, clean or replace the suction strainer and check the breather. The debris that damaged the old pump is still in the system.
Check the suction side	Inspect the suction hose internally and check every joint for air ingress. A restricted or leaking suction line causes cavitation, which destroys pumps repeatedly until the cause is fixed.
Mount and align	Fit the pump and check coupling alignment and gap against the drive specification. Misalignment puts side load on the shaft and kills the bearing and the seal.
Fill the case	Fill the pump case with clean oil through the case drain port before starting. Running a piston pump dry damages the shoes within seconds.
Prime and bleed	Turn the shaft by hand where possible, start briefly at low pressure with the relief valve backed off and bleed air from the highest point in the circuit.
Run in	Run at low pressure for ten to fifteen minutes, then raise the relief valve setting in steps to working pressure, checking for leaks and noise at each step.
Check after the first shift	Check oil level, filter condition and case drain temperature after the first working shift and again after the first week. Change filters early after any repair.

Vane Pump Cartridge Change

- Drain the pump and mark the cover position before opening it
- Inspect the housing bore and cover face. Scoring means the housing needs attention as well
- Fit the cartridge with the arrow following the direction of drive rotation
- Renew the shaft seal and cover seal at the same time
- Flush the reservoir and change filters, then bleed at low pressure

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