

Keep With Operator's Manual

HYDRAULIC PUMP KIT 65A, 75 and 85 BACKHOES

Pump kit can be installed using tools ordinarily available. Shut off engine and set brakes during installation.

NOTE: *Apply sealant only to all tapered threads unless coupled with swivel adapters. When using teflon tape, wrap tape clockwise (as viewed from end) and wrap only twice. Keep sealant away from first two threads of tapered end to prevent contamination of hydraulic fluid. Do not use sealant on o-ring or flare adapter threads.*

INSTALLING PUMP KIT

1. Fasten PTO adapter (16) to hydraulic pump (6) using 5/16 x 1/2 set screws (17). Fasten hydraulic pump (6) to pump mounting bracket (15) using 3/8 x 1-1/2 cap screws (18) and 3/8 lock nuts (21).
2. Very loosely fasten filter guard (22) to backhoe, as shown, using 5/16 x 3/4 cap screws (23) and 5/16 lock nuts (13).
3. Check inside of tank for any debris. Fasten tank (1) to backhoe using 3/8 x 1 cap screws (19), 3/8 flat washers (20) and 3/8 lock nuts (21).

NOTE: 75 and 85 backhoes using 3-pt adapter - It may be necessary to lower reservoir if it interferes with center link. Add spacers between reservoir and backhoe and use longer bolts.
4. Install 3/4 NPT x 3/4 NPT elbow fitting (8) to filter assembly (9). Install filter assembly (9) and elbow (8) to tank. Install 3/4 NPT x 7/8 JIC elbow fitting (10) to filter assembly.
5. Install 1/2 x 30 hose (11) to fitting on filter assembly. Route hose (11) under backhoe platform and connect to "out" port on backhoe valve.
6. Install 1-3/16 SAE x 3/4 NPT adapter fitting (5) and 3/4 NPT male Swivel x 3/4 NPT female 90° elbow fitting (4) to suction or inlet port on pump. Install strainer (25) into suction port of tank. Assemble 3/4 NPT male x 1 1/16-12 JIC 90° fitting (24) into strainer port. Install suction hose (3) to fittings on tank and pump.
7. Install 7/8 O-ring x 7/8 JIC elbow fitting (14) to "pressure" port on hydraulic pump (6). Install 1/2 x 50" hose (12) to "pressure" port on pump and "in" port on backhoe valve.
8. Fill reservoir to within one inch from top with 10W or 20W hydraulic oil with SAE J183-M2C33F classification. Dextron 1 ATF fluid and 10W engine oil with API "SD" classification are also acceptable.
9. Install breather cap (2) to reservoir and tighten bolts on filter guard.

MOUNTING HYDRAULIC PUMP TO TRACTOR

1. With tractor engine shut off slide hydraulic pump assembly onto tractor PTO shaft with pump mounting bracket sliding over tractor drawbar.

NOTE: *Be sure PTO adapter locks firmly onto tractor PTO shaft.*
2. Start tractor engine and run PTO at recommended speed.
3. Slowly cycle backhoe stabilizers several times and set them on the ground. Cycle all backhoe cylinders to check for proper lever function and purge air from backhoe hydraulic system.
4. Retract all cylinders. Shut off tractor engine and disengage PTO. Check oil in reservoir and fill to within one inch of top. Do not overfill or fluid may be forced out of breather cap.



WARNING: *Escaping hydraulic fluid under pressure can penetrate skin causing serious injury.*

- *DO NOT use your hands to check for leaks. Use a piece of cardboard or paper to search for leaks.*
- *Stop engine and relieve pressure before connecting or disconnecting lines.*
- *Tighten all connections before starting engine or pressurizing lines.*

PARTS LIST - PLUMBING KIT

ITEM	PART NO.	DESCRIPTION	QTY.
1	52504	TANK, Assembly	1
2	52526	BREATHER, 3/4 NPT	1
3	51431-1	HOSE, 3/4 x 30	1
4	51430-2	FITTING, Adapter, 3/4-14 NPT Swivel x 3/4 NPT Female 90°	1
5	7361-1	FITTING, 1-3/16-12 SAE x 3/4-14 NPT	1
6	44797	PUMP With 3/16 Sq. X 1.12 LG Key	1
7	6095	FILTER ELEMENT	1
8	34644-3	FITTING, Elbow, 3/4-14 NPT x 3/4-14 NPT, 90°	1
9	6094	FILTER, Assembly (Includes Element)	1
10	39609-1	FITTING, Elbow, 3/4-14 NPT x 7/8-14 JIC, 90°	1
11	38792-10	HOSE, 1/2 x 30	1
12	38792-8	HOSE, 1/2 x 52	1
13	41840-2	NUT, Lock, 5/16-18	2
14	32845-3	FITTING, Elbow, 7/8-14 O-ring x 7/8-14 JIC, 90°	1
15	41362+	BRACKET, Pump	1
16	44848	PTO ADAPTER	1
17	G102582	SET SCREW, 5/16-18 x 1/2	2
18	41838-23	SCREW, Cap, 3/8-16 x 1-1/2	2
19	41838-11	SCREW, Cap, 3/8-16 x 1	4
20	42502-8	WASHER, Flat, 3/8	8
21	41840-3	NUT, Lock, 3/8-16	6
22	44920	GUARD, Oil Filter	1
23	41838-26	SCREW, Cap, 5/16-18 x 3/4	2
24	39609-10	FITTING, Elbow, 3/4-14 NPT x 1 1/16-12 JIC, 90°	1
25	52527	STRAINER, 1-1/4 NPT x 3/4 NPT	1

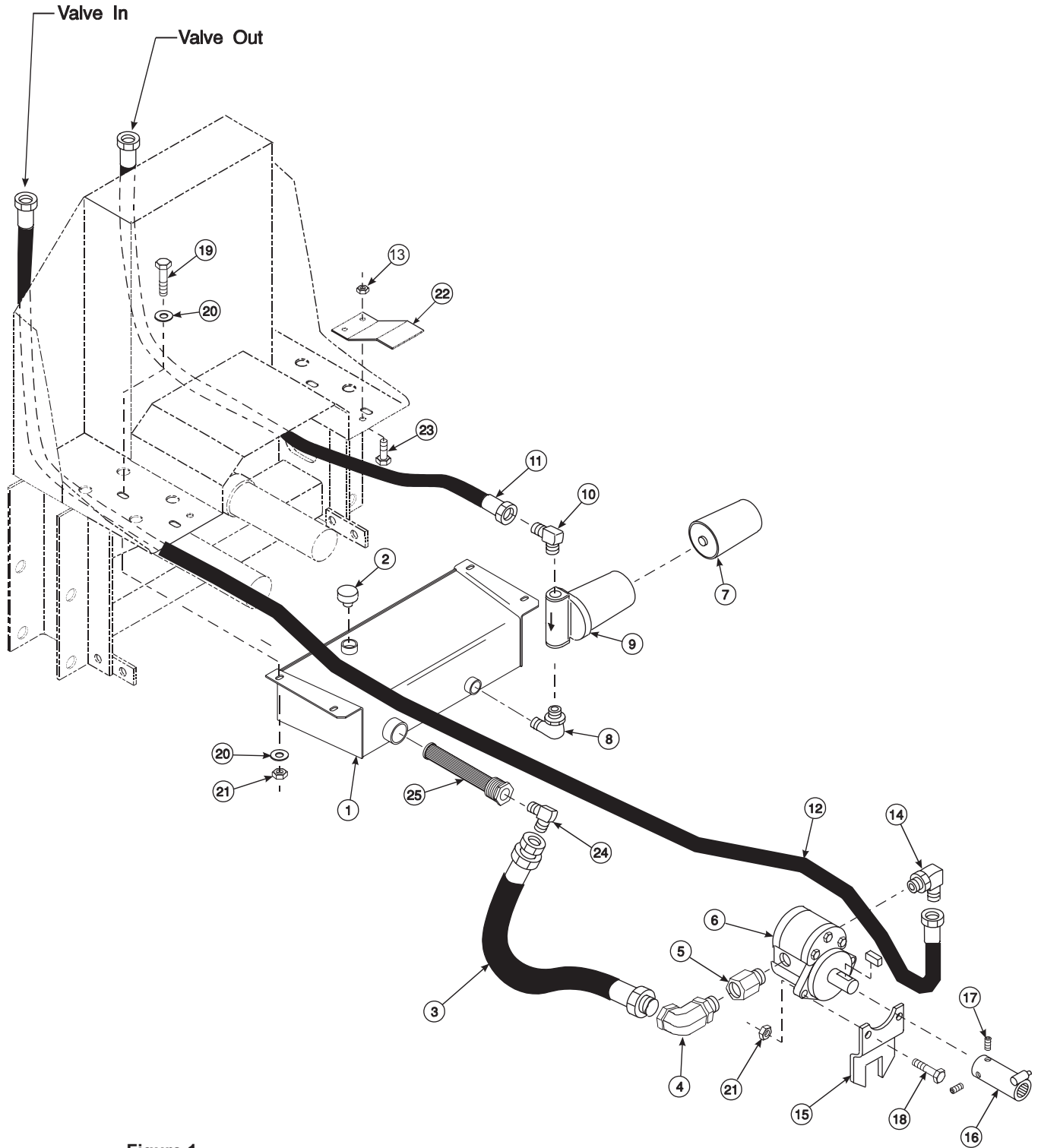
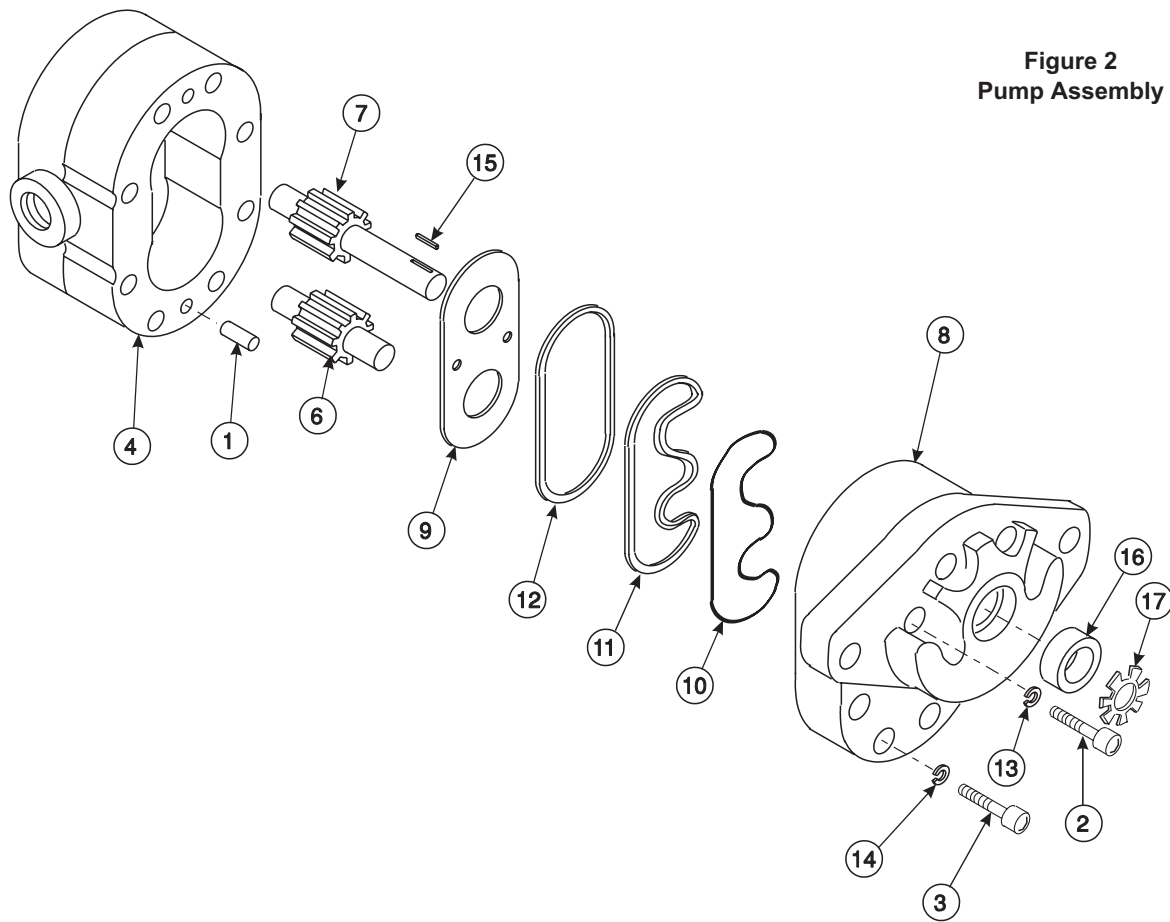


Figure 1
Hydraulic Kit Assembly

Figure 2
Pump Assembly



PARTS LIST - WEBSTER PUMP - 44797

ITEM	Part No.	DESCRIPTION	QTY.
1	*	DOWEL PIN	2
2	*	SOCKET HEAD SCREW, 3/8-16 x 1-1/2	4
3	*	SOCKET HEAD SCREW, 5/16-18 x 1-1/4	4
4	*	BODY ASSEMBLY, with Bearings and Seal	1
5	*	BEARING	4
6	*	IDLER SHAFT/GEAR ASSEMBLY	1
7	*	DRIVE SHAFT/ GEAR ASSEMBLY	1
8	*	COVER ASSEMBLY, with Bearings	1
9	**	WEAR PLATE	1
10	**	SEAL, PreLoad, Rubber	1
11	**	SEAL, Load	1
12	**	RING, Sealing	1
13	**	WASHER, 3/8	4
14	**	WASHER, 5/16	4
15	**	KEY, 3/16 Sq. X 1.12" LG	1
16	**	SEAL	1
17	**	RETAINING RING	1
18	45344	SEAL and RETAINING RING contains #16 & #17	1
19	2-3586	SEAL KIT contains one each #9, #10, #11, #12, #15, #16, #17 and four each #13 & #14	1

* Not available as separate repair part.
 ** Order Seal Kit 2-3586

PUMP SERVICE

1. Clean pump exterior thoroughly using cleaning solvent.
2. Remove key (15) from drive gear shaft.
3. Scribe a line across the two housing sections of the pump. This line should be drawn approximately parallel with drive shaft and it will act as a guide during reassembly.
4. Remove screws (2) and (3) which hold the two housing sections together.



CAUTION: *Extreme caution must be used when clamping with a vise to avoid distorting any parts.*

NOTE: *Use a vice to hold front cover. Be careful not to damage any machined surfaces.*

5. Separate the two housing sections by clamping front cover in vise and hitting rear cover with a soft mallet. Maintain alignment between sections to ease separation.



CAUTION: *Do not pry between the sections. Avoid damaging machined surfaces. Place hand over assembly while tapping drive shaft to prevent dropping parts or disengaging gear mesh when separation occurs.*

IMPORTANT: Before removing gear set, apply marking dye to mating teeth to retain "timing" when reassembling.

6. Remove idler gear (6), drive gear (7) and dowel pins (1) from front or back cover.
7. Remove wear plate (9), sealing ring (12), load seal (11) and rubber pre-load seal (10) from front cover using soft mallet.
8. Remove retaining ring (17), then remove shaft seal (16).

NOTE: *Shaft seal (16) is a force fit. Be careful to avoid damage to housing bore. Use an expandable hook type tool. Pull seal straight out to avoid damaging seal bore.*

NOTE: *It is not necessary to remove shaft seal (16) if it is in good condition and does not leak.*

9. Clean all parts in a suitable solvent. Use air pressure to remove any dirt or excess solvent.
10. Examine all parts for wear or damage. Remove nicks and burrs from all parts.

NOTE: *Wear plate (9), sealing ring (12), load seal (11), rubber pre-load seal (10), shaft seal (16), if necessary, and retaining ring (17) should be replaced.*

PUMP REASSEMBLY

1. Install shaft seal (16), if removed, with spring loaded lip facing in. Force seal into place using a flat steel rod larger than seal O.D. Place front cover on a smooth surface to prevent damage. Be sure seal is driven in straight to avoid damaging seal retainer or housing bore.
2. Install retaining ring (17).
3. Install rubber pre-load seal (10), load seal (11) sealing ring (12) and wear plate (9). Apply grease to back of wear plate and position bronze surface toward front cover.
4. Install idler shaft (6) and drive shaft (7) into front cover. Slide drive shaft through shaft seal (16).

IMPORTANT: *Use an oil coated smooth bullet-nosed type seal protector in contact with shaft end chamfer to prevent damage to shaft seal. Diameter of seal protector can be equal but not more than .010 below shaft diameter. If seal protector is not available coat the shaft with oil and rotate it while passing through seal.*

NOTE: *Generously lubricate lips of seal with general purpose grease.*

5. Install dowel pins (1) into front cover. With wear plate seals seated in their cavity, install back cover (4). Align scribed lines on outside of housings.
6. Install and hand tighten screws (2 & 3) and washers (13 & 14).
7. Rotate drive shaft before torquing screws (2 & 3).
8. Torque 5/16 screws (3) to 200 inch lbs and 3/8 screws (2) to 370 inch lbs.
9. Add clean oil to both ports and rotate drive shaft to lubricate pump. Shaft should be free enough to rotate by hand.

INSTALLATION INSTRUCTIONS