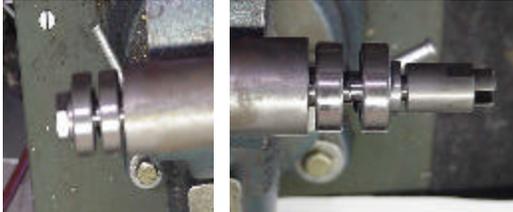




SEAL AND BEARING ASSEMBLY FOR HYDRAULIC VIBRATORS

(FOR FULL INSTRUCTIONS AND SAFETY DETAILS REFER TO OPERATORS MANUAL)

1) BEARING ASSEMBLY



Place Bearings on shafts on rotor. Make sure that a shim is placed between the bearings. Assemble the spacers, nuts and drivers to rotor and tighten.

2) REPLACE SEALS IN MOTOR



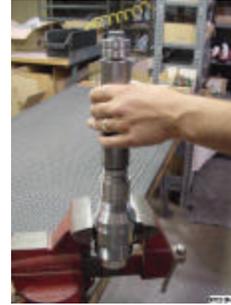
Replace seal with a seating a bullet by placing grease on the tool. Slide the seal on the bullet and press the seal into the motor. Make sure the seal is pressed in completely. Replace lock ring.

3) ASSEMBLE BEARING CUP



Slide the bearing cup evenly across the bearings at the driver. Grease the smaller driver to the drive sleeve.

4) INSERT ROTOR ASSEMBLY



Turn rotor assembly upside down, line up driver with motor tang. Slide assembly down until the driver is fully engaged with motor tang. Turn rotor and listen for the motor gears turning.

5) HOUSING OVER ASSEMBLY



Slide the housing over the bearings until it reaches the threads. Apply Permatex to threads and continue to turn until it is fully tightened.

VIBRATOR TEST PARAMETERS

Pressure: Approximately 850psi. (at 4GPM), plus the back pressure value of hydraulic system.

Flow: Test at 4GPM

Temperature: 140 F

Vibrator Speed: At these pressure, flow and temperature values the vibrators should be running at 10,500 to 11,000 vpm's.