



Tools / Equipment Required

- 5mm Allen wrench
- new pressure compensator spring
- torque wrench capable of setting 14 N-m (10 ft-lb)

Procedure to Exchange Pressure Compensator Springs

- 1 Remove the four S.H.C.S. from the Side Cover with the 5mm Allen wrench. Keep them for reuse.

NOTE

Care should be taken when removing the last S.H.C.S. The Side Cover is spring-loaded by the Pressure Compensator Spring and it may **spring-out** at you when the last S.H.C.S. is removed.

- 2 Remove the Side Cover from the pump control. Make sure not to lose or damage the two o-rings between the Side Cover and the pump control. Keep the two o-rings for reuse.
- 3 Remove the Spring Hat from the Pressure Compensator Spring, Keep for reuse.
- 4 Remove the existing Pressure Compensator Spring from the pump control. Either discard it or keep it for reuse.
- 5 Install the new *Pressure Compensator Spring* into the pump control. See table at the end of this document for available springs.

- 6 Reinstall the Spring Hat from step #3.
- 7 Prior to reinstalling the Side Cover, make sure that the two o-rings are in good condition (i.e. not damaged) and are properly positioned in the o-ring grooves.
- 8 Reinstall the Side Cover onto the pump control. Secure the Side Cover with the four S.H.C.S. removed in step #1.

NOTE

Since the Pressure Compensator Spring pre-loads the Side Cover, you will have to compress the spring in order to get the threads of the first S.H.C.S. started. To do this, you will have to push in the Side Cover to compress the spring. For the higher pressure rated springs, the assistance of a second person or a clamping device may be required.

- 9 Tighten each S.H.C.S. with the 5mm Allen wrench and torque each one to 14 N-m (10 ft-lb).
- 10 Restamp the pump control with the new Control Part Number to reflect the correct spring. Refer to LINDOS for a listing of control part numbers.

Pressure Compensator Spring Part Number	Spring Pressure Range, Bar	Spring Free Length, mm	Spring Wire Diameter, mm
000 921 2428	125-230	35.4	2.4
000 921 2447	230-350	40.0	2.4
000 921 2551	350-420	45.1	2.5



Procedure to Exchange Pressure Compensator Springs on HPR-02 Pumps

ATTENTION

You have been provided information on conversion, repair and/or service of Linde components. Proper application of the information requires specific training and may require use of specialized tooling and equipment. If you choose to proceed with the conversion, repair and/or service of the Linde component(s) absent the necessary training and/or these specialized tools, you do so at your risk.

Linde Hydraulics Corporation will accept no claim for warranty or other consideration resulting from deficiencies in the conversion, repair and/or service done in accordance with the guidance offered herein when the necessary training has not been conducted and/or required specialized tooling and equipment has not been utilized.

All requests for training must be coordinated through your Linde Account Manager. He can also provide you price and availability of any specialized tooling.

Questions regarding the information provided or this disclaimer should be addressed to the Warranty & Service Department, Linde Hydraulics Corporation.

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