

Tools / Equipment Required:

- 10mm Wrench
- 3mm Allen Wrench
- 0-7000 psi pressure gauge or transducer
- 0-300 psi pressure gauge or transducer

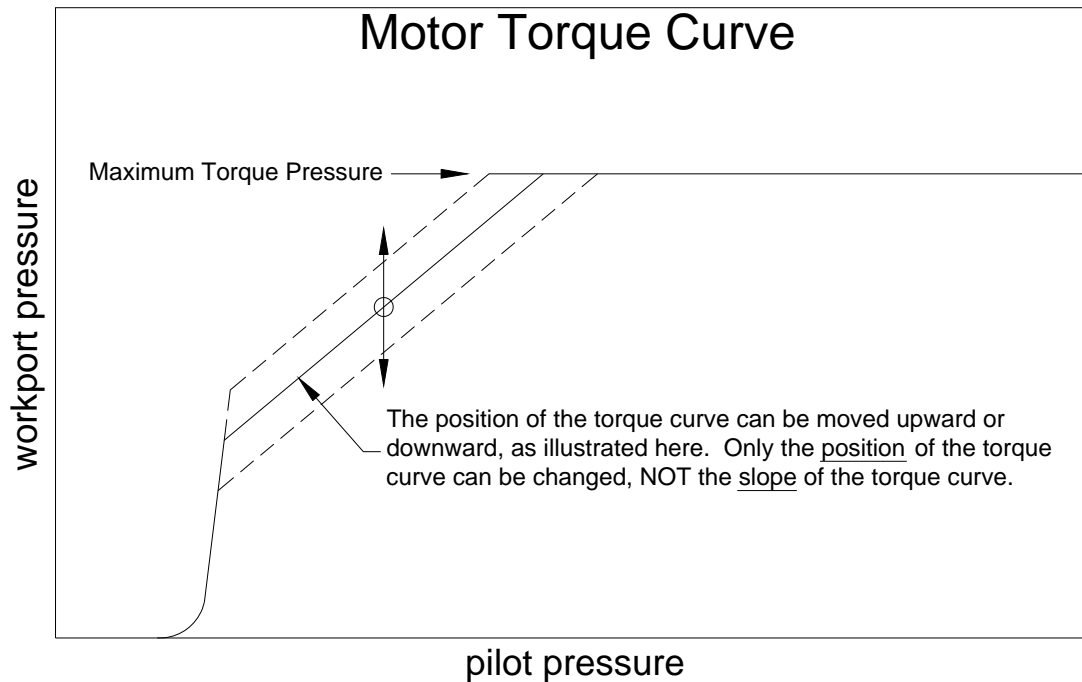
WARNING:

If performing this procedure on a vehicle, care must be taken. The pump will be put on stroke during this procedure; hence all personnel should be removed from the area of the machine.

Note:

Use the following Linde Service Bulletins in the order listed below when setting up or adjusting the HMF-02 Priority Swing Motor:

1. HMF-02 Priority Swing Motor Regulation Begin Adjustment Procedure (Doc. No. 932)
2. VD20-05 Externally Adjustable Relief Valve Adjustment Procedure (Doc. No. 930)
3. HMF-02 Priority Swing Motor Flow Stop Adjustment Procedure (Doc. No. 931)
4. HMF-02 Priority Swing Motor Torque Curve and Max Torque Adjustment Procedure



Note:

The torque curve feature on this motor provides the operator with a feel of smooth acceleration, and it optimizes operational efficiency by preventing oil from passing over the cross-over relief valves. The position of the torque curve has no impact on the deceleration of the motor, only on the acceleration.

Adjustment procedure for the Torque Curve Position:

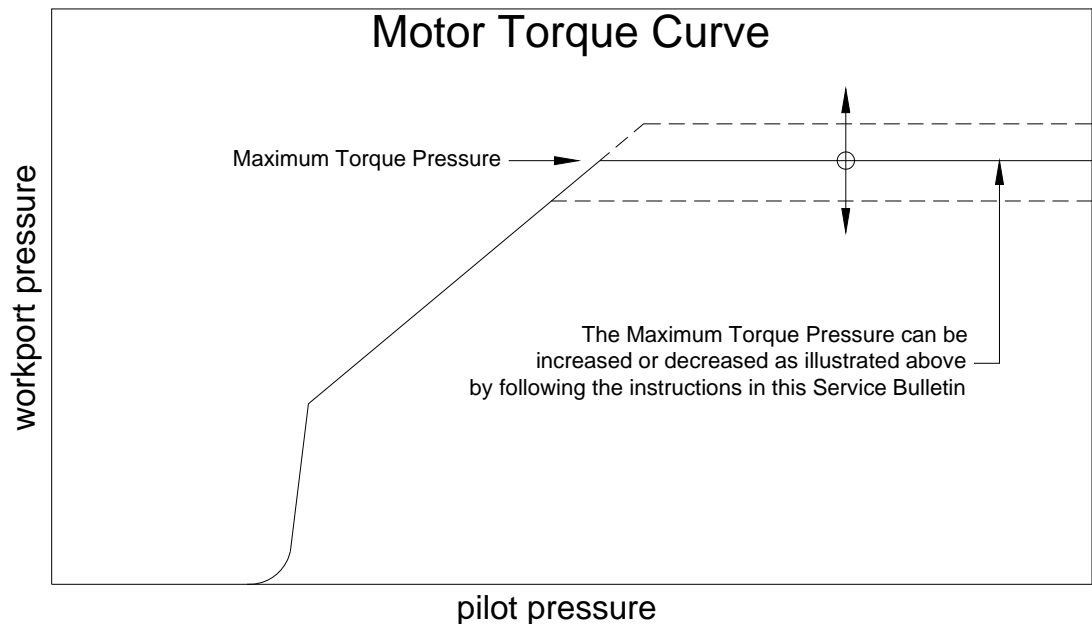
IMPORTANT: Specified pressure values for the following steps are different for each HMF-02 Priority Swing Motor execution number. These values must be obtained from Linde Engineering department using the unit's Serial Number prior to any adjustment.

1. Install the 0-7000 psi pressure gauge into the gauge port "Ma" to measure the pressure at Work port "A".
2. Install the 0-300 psi pressure gauge into port "MST".
3. Lock the function that the motor actuates as to prevent the motor from rotating. This will make the measurement of the torque curve position easier.
4. Back out Max Torque Adjustment **TWO TURNS**.
5. Actuate the motor so Port "Ma" is pressurized.

6. While monitoring the pressure at port "MST", adjust the "Max Torque Adjustment" until the previously specified value is reached.
7. While monitoring the pressure at port "Ma", adjust the "Torque-Curve Position Adjustment" until the previously specified value is reached.
8. Lock the "Torque-Curve Position Adjustment" locking nut.

Adjustment procedure for the Maximum Torque Value:

IMPORTANT: In order to successfully measure and adjust the maximum torque setting on the HMF-02 Priority Swing Motor, the "high setting" cracking pressure on the two dual-stage cross-over relief valves must be set at or higher than the desired maximum torque setting for the motor. This adjustment to the dual-stage cross-over relief valve must be done prior to using this Service Bulletin.



1. Lock the function that the motor actuates as to prevent the motor from rotating
2. Actuate the motor so port "Ma" is pressurized.
3. While monitoring the pressure at port "Ma", adjust the "Max Torque Adjustment" until the previously specified Maximum Torque value is reached.
4. Lock the "Max. Torque Adjustment" locking nut.

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.

5089 Western Reserve Road
Canfield, OH 44406
330.533.6801 (Telephone)
330.533.9873 (Facsimile)
www.lindeamerica.com (Web Site)