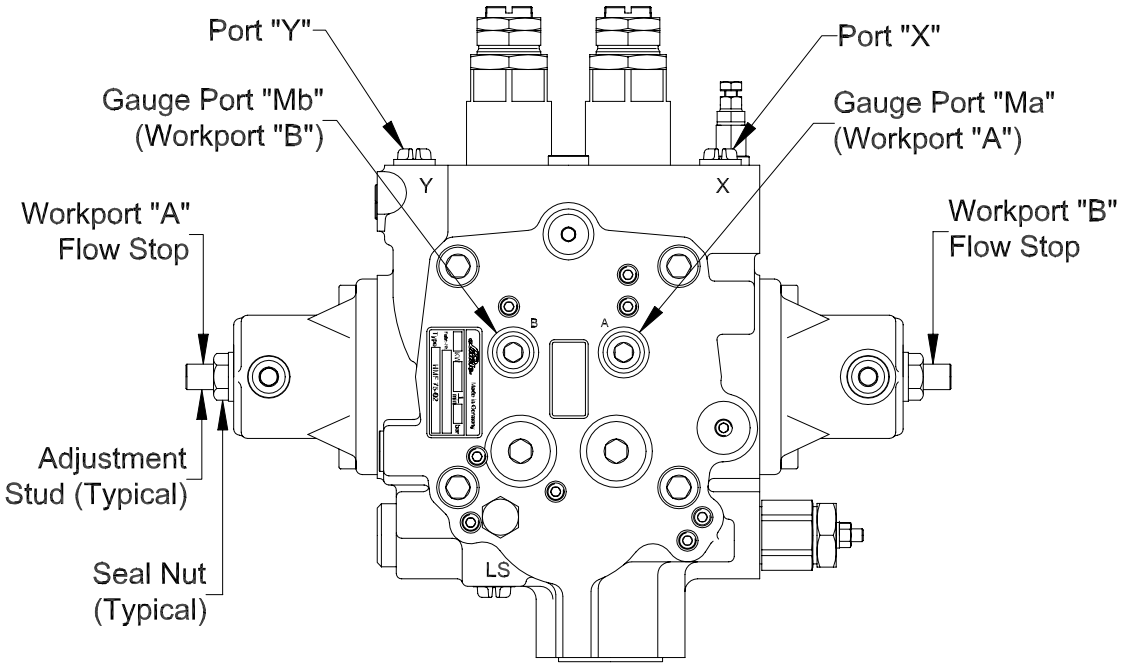

Tools/Equipment Required:

- 17mm wrench (HMF55-02 ONLY)
- 5mm Allen wrench (HMF55-02 ONLY)
- 19mm wrench (HMF75-02 and HMF105-02 ONLY)
- 6mm Allen wrench (HMF75-02 and HMF105-02 ONLY)

Note:
This procedure is valid for all sizes of the HMF-02 Priority Swing Motors.

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) 1121, (2) 1117, (3) 1106, (4) 1118

Adjustment Procedure for the Motor Flow Stops:

1. Start the prime mover and set it to operating speed.
2. Fully actuate *Work-port "A"* by supplying full pilot pressure into *Port "X"*.
3. To adjust the flow setting for *Work-port "A"*:
    a. Use the illustration above to confirm you are adjusting the *Work-port "A" Flow Stop*.
    b. While holding the "adjustment stud" stationary, loosen the "seal nut".
    c. Turn the "adjustment stud" IN to decrease the flow setting or ***OUT*** to ***increase*** the flow setting.

    WARNING:
    Care should be taken to avoid completely removing the "adjustment stud" from the valve end cap. There are no mechanical limits to prevent the "adjustment stud" from being completely removed.
    Care should be taken to avoid completely removing the "adjustment stud" from the "seal nut", because it is very difficult to reinstall it without a leak being initiated in the "seal nut". Typically, a new "seal nut" must be used if the two pieces are separated.

    d. Once the desired setting is acquired, hold the "adjustment stud" stationary and tighten the "seal nut". The proper torque for the "seal nut" is:
        - [For HMF55-02].....29 N-m (21 ft-lb)
        - [For HMF75-02 and HMF105-02].....60 N-m (44 ft-lb)
4. Repeat steps #1 through #3 for the flow setting for *Work-port "B"*.

*****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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