

The following instructions in this Conversion Bulletin are valid for all sizes of HMF-02 motors (except for HMF-02 priority swing motors). This Conversion Bulletin should NOT be used for any size HMF-02 motors, HMR-02 motors, HPR-02 pumps, or HPV-02 pumps. For these units, please refer to Conversion Bulletin "VARIABLE-PLATE".

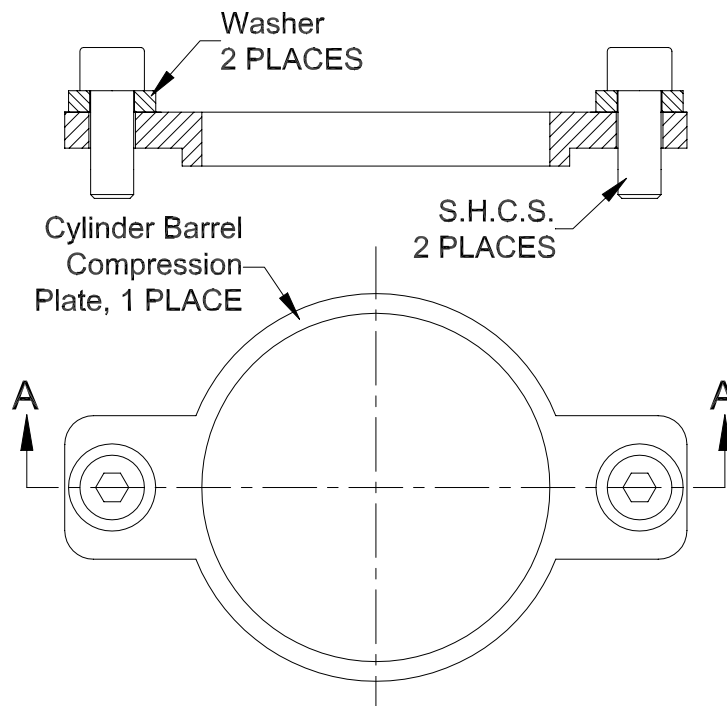
The only tool referenced in this Conversion Bulletin is the *Cylinder Barrel Compression Plate Kit*. Additional tools and materials, of course, will be required when doing conversions to the HMF-02 motors. But keep in mind that this Conversion Bulletin is only intended to instruct the user how to properly use the *Cylinder Barrel Compression Plate Kit*.

Please use the following part numbers to determine which *Cylinder Barrel Compression Plate Kit* is required for the size HMF-02 motor that you are working on:

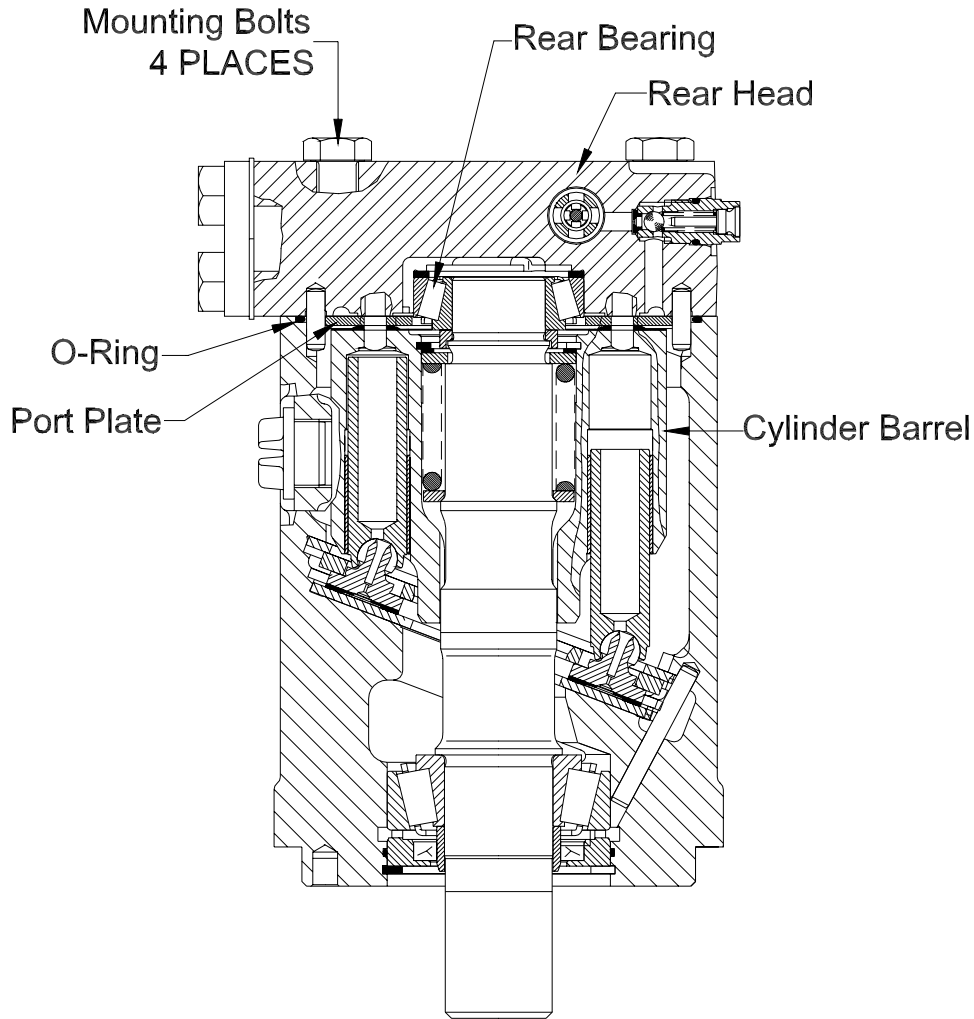
- | | |
|--------------------------------|--------------------|
| • Linde Part Number 0009419757 | HMF28-02, HMF35-02 |
| • Linde Part Number 0009419758 | HMF50-02 |
| • Linde Part Number 0009419759 | HMF75-02 |
| • Linde Part Number 0009419760 | HMF105-02 |
| • Linde Part Number 0009419761 | HMF135-02 |

Each Kit contains the following items as illustrated below:

- Cylinder Barrel Compression Plate (1 piece)
- Socket Head Cap Screws [S.H.C.S.] (2 pieces)
- Washers (2 pieces)

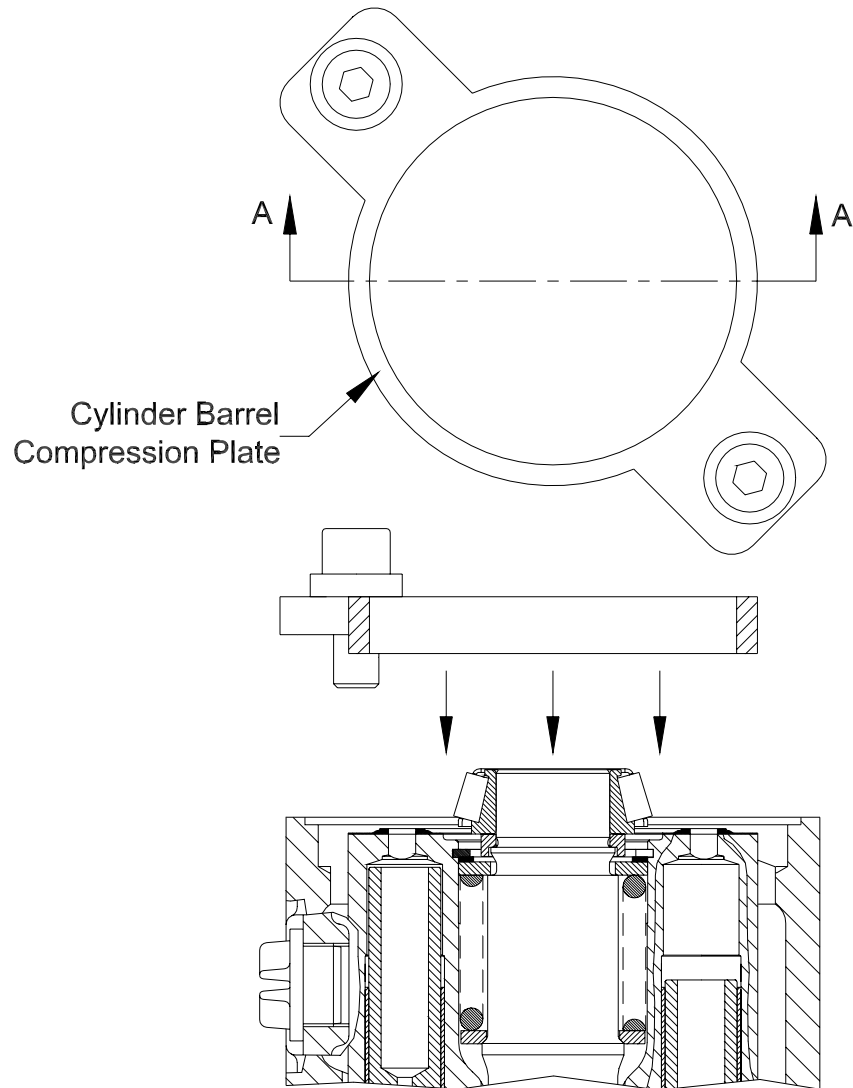


The following illustration highlights some key items that will be referenced throughout this Conversion Bulletin:



Procedure to Install the Cylinder Barrel Compression Plate for Bearing Removal:

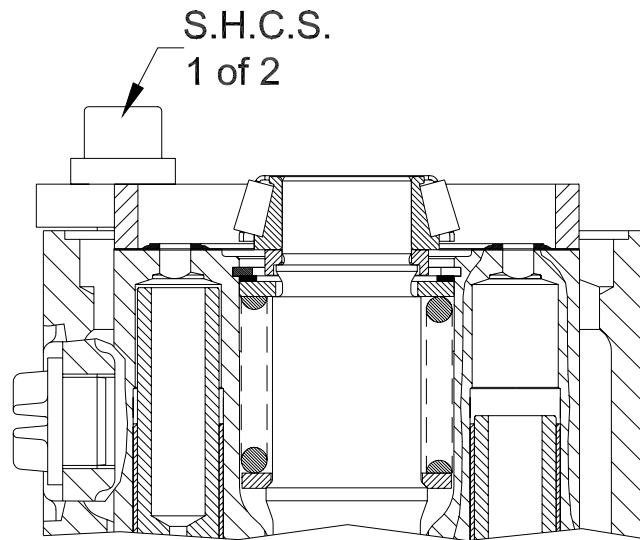
1. Remove the *Rear Head* from the motor as described in Linde Conversion Bulletin "HMF-SHAFT". Make sure to remove the *Port Plate* and the *O-Ring* from the motor. Inspect the *O-Ring* to ensure it is undamaged and replace if necessary.
2. As illustrated on the following page, place the *Cylinder Barrel Compression Plate* on top of the motor housing. Please note that the two *S.H.C.S.* must align with the mounting holes in diagonal corners of the motor housing.



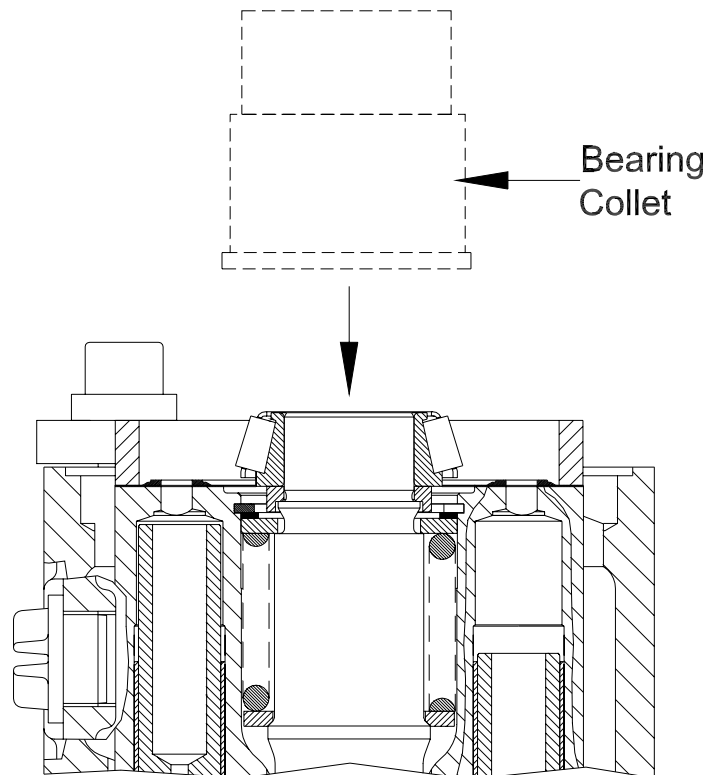
3. Lightly fasten the *Cylinder Barrel Compression Plate* to the motor housing by tightening the two *S.H.C.S.* with a hand tool. Only turn the *S.H.C.S.* IN until you just feel some resistance in the hand tool, then STOP - This is the point where the plate just starts to compress the cylinder barrel.

As illustrated on the following page, turn IN each *S.H.C.S.* at 1/2 turn increments while alternating between each *S.H.C.S.* This will insure that the cylinder barrel is compressed evenly.

Continue to turn IN each *S.H.C.S.* at 1/2 turn increments until the *Cylinder Barrel* is fully compressed.



4. As illustrated below, install the appropriate bearing collet onto the *Rear Bearing*. Then use the appropriate bearing puller body to remove the *Rear Bearing* from the drive shaft.





**Procedure to Use the Cylinder Barrel
Compression Plate for Bearing Removal from
HMF-02 Fixed Displacement Motors**

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5. Once the *Rear Bearing* is removed, the *Cylinder Barrel Compression Plate* can be removed. To do so, use a hand tool to turn OUT each *S.H.C.S.* at 1/2 turn increments while alternating between the two *S.H.C.S.* This will insure that the cylinder barrel is decompressed evenly.

Continue to turn OUT the two *S.H.C.S.* at 1/2 turn increments until the two *S.H.C.S.* are loose.

Remove the two *S.H.C.S.* and the two *Washers* from the plate. Then remove the *Cylinder Barrel Compression Plate* from the motor housing.

6. Refer to Linde Conversion Bulletin "HMF-SHAFT" to properly reassemble the motor.

Note:

You will need to follow the instructions in this Conversion Bulletin to reinstall the *Rear Bearing* onto the HMF-02 drive shaft. Linde Conversion Bulletin "HMF-SHAFT" will instruct you when to refer back to this Conversion Bulletin.



*******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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