

Service Parts Information

MULTI-TORQUE VANE MOTORS

MODEL	SHAFT	SNAP RING (2 REQ'D)	RING	BEARING (2 REQ'D)	PLUG
MHT-190/95/95-*1-30-S20	345769	354386	364468	310539	7074
MHT-220/125/95-*1-30-S20			375223		

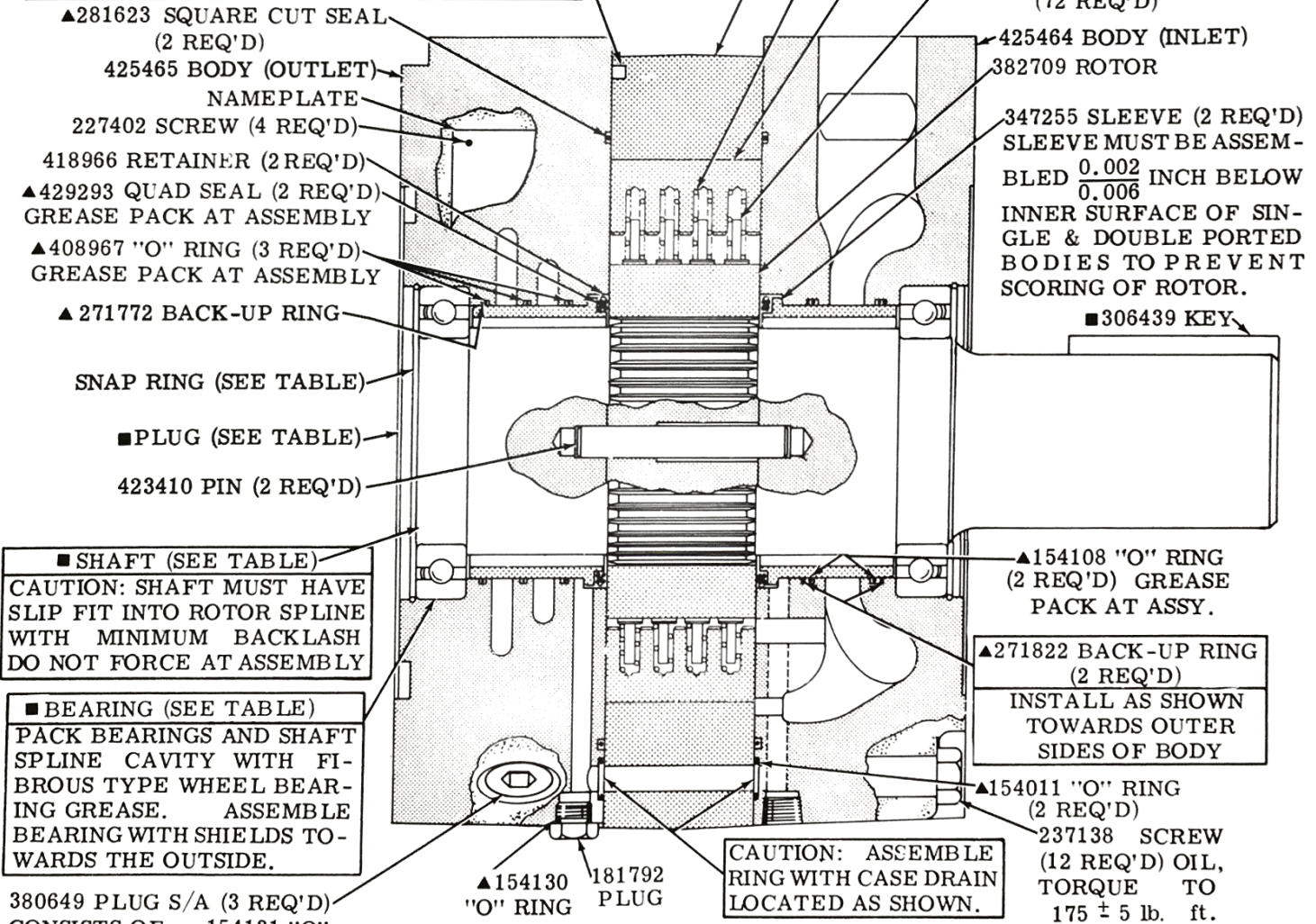
F3 SEAL KIT
919880

■ OMIT ON
N1 MODELS

▲ INCLUDED IN
919769 SEAL KIT

WARNING: WEAR SAFETY GLASSES TO PREVENT EYE INJURY

WHEN ASSEMBLING A MHT-220/125/95, THIS .25 DIA. HOLE IN ONE SIDE OF RING 375223 MUST FACE THE DOUBLE PORT BODY 425465.



- ▲ 281623 SQUARE CUT SEAL (2 REQ'D)
- 425465 BODY (OUTLET)
- NAMEPLATE
- 227402 SCREW (4 REQ'D)
- 418966 RETAINER (2 REQ'D)
- ▲ 429293 QUAD SEAL (2 REQ'D)
- GREASE PACK AT ASSEMBLY
- ▲ 408967 "O" RING (3 REQ'D)
- GREASE PACK AT ASSEMBLY
- ▲ 271772 BACK-UP RING

- 396438 SPRING (72 REQ'D)
- 424384 VANE (18 REQ'D)
- 382716 SPRING GUIDE (72 REQ'D)
- 425464 BODY (INLET)
- 382709 ROTOR
- 347255 SLEEVE (2 REQ'D)
- SLEEVE MUST BE ASSEMBLED 0.002 INCH BELOW 0.006 INNER SURFACE OF SINGLE & DOUBLE PORTED BODIES TO PREVENT SCORING OF ROTOR.

■ SHAFT (SEE TABLE)
CAUTION: SHAFT MUST HAVE SLIP FIT INTO ROTOR SPLINE WITH MINIMUM BACKLASH DO NOT FORCE AT ASSEMBLY

■ BEARING (SEE TABLE)
PACK BEARINGS AND SHAFT SPLINE CAVITY WITH FIBROUS TYPE WHEEL BEARING GREASE. ASSEMBLE BEARING WITH SHIELDS TOWARDS THE OUTSIDE.

380649 PLUG S/A (3 REQ'D) CONSISTS OF: 154131 "O" RING & 326976 PLUG. MUST BE BELOW CAST SURFACE.

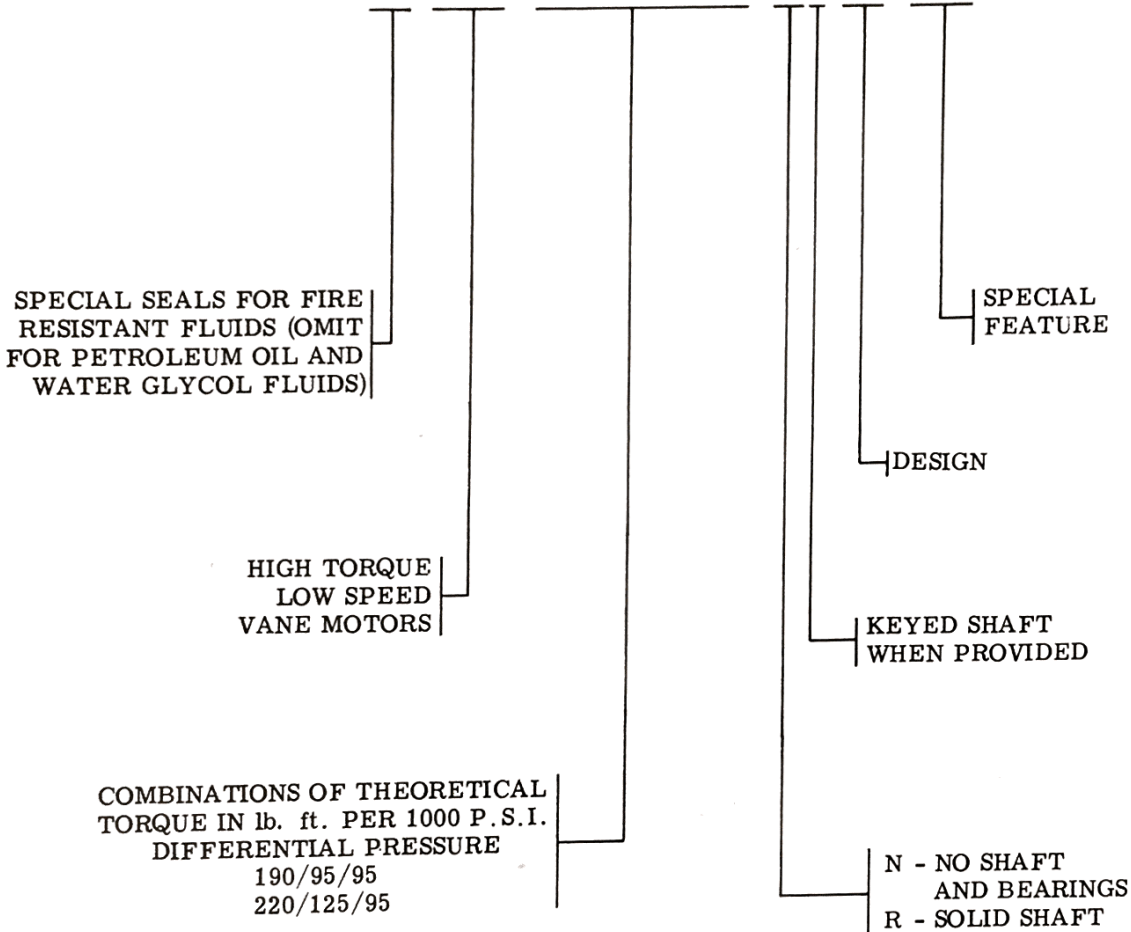
- 306439 KEY
- ▲ 154108 "O" RING (2 REQ'D) GREASE PACK AT ASSY.
- ▲ 271822 BACK-UP RING (2 REQ'D)
- INSTALL AS SHOWN TOWARDS OUTER SIDES OF BODY

CAUTION: ASSEMBLE RING WITH CASE DRAIN LOCATED AS SHOWN.

CAUTION: WHEN ASSEMBLING CARTRIDGE, INSERT VANES IN ROTOR SLOTS AT THE MINOR DIAMETER OF CAM RING. ROTATE CARTRIDGE ONE COMPLETE REVOLUTION BY HAND PRIOR TO ASSY WITH BODIES TO PREVENT MISALIGNMENT OF SPRINGS AND GUIDES.

MODEL CODE BREAKDOWN

F3-MHT-*/**(*)/**-(*)1-30-S20**



To insure sustained efficiency and maximum trouble-free life of this precision equipment, initial and continuous filtration of the fluid medium to 25 microns absolute or less is essential. (For information pertaining to Sperry Vickers economical 3 or 10 micron filters, see installation drawing 522140.)