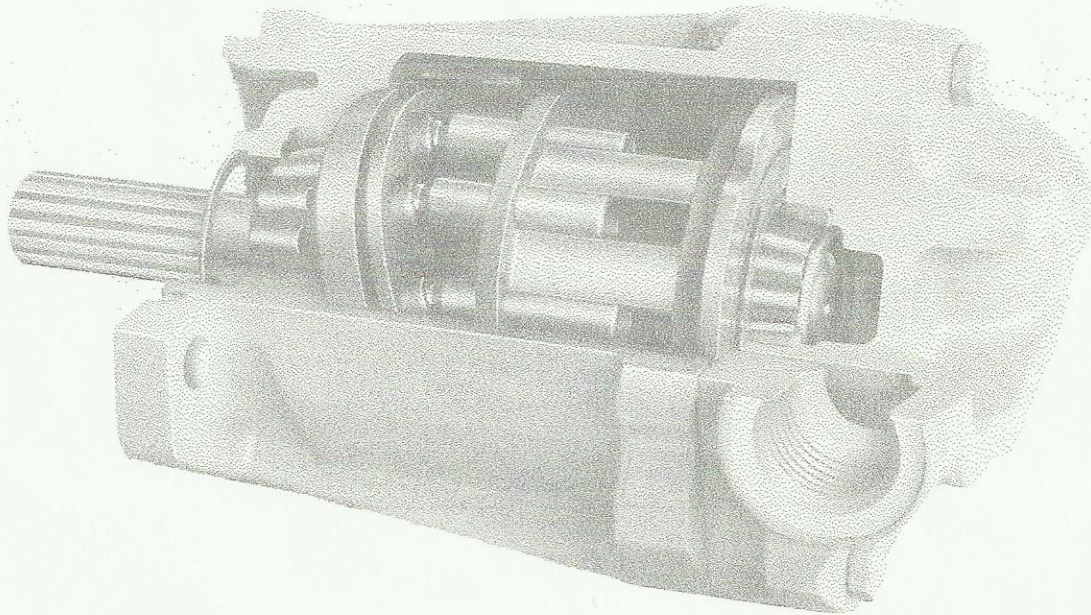




# Service Parts Information

Fixed  
Displacement  
Transmission  
Motors

MFE15(X)-\*-30  
MFE19(X)-\*-30



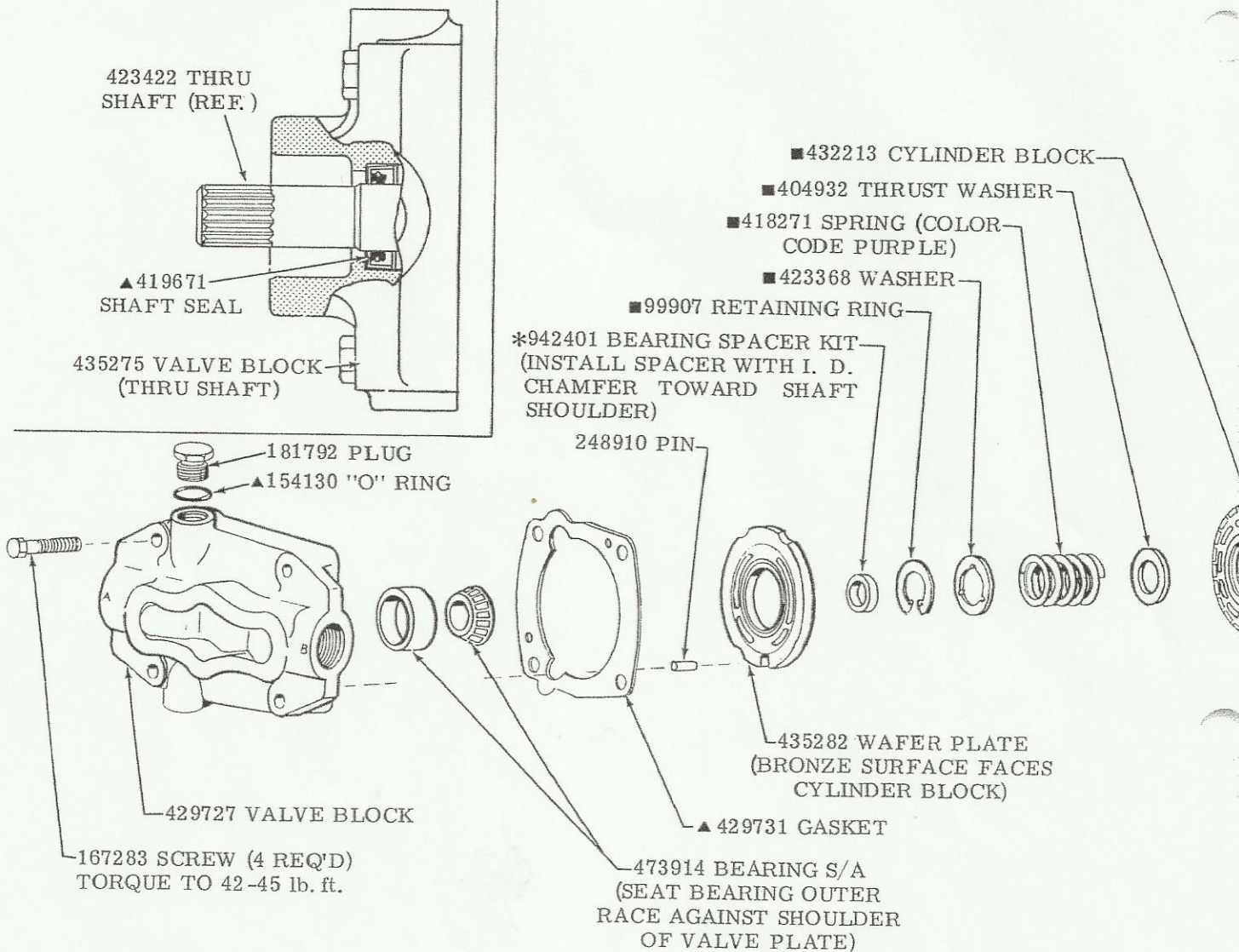
Vickers, Incorporated

1401 Crooks Road  
Troy, Michigan 48084

Revised 11-1-85

M-2837-S

MFE 19X-\* -30-\*\*\*  
THRU SHAFT MODELS



\* SHAFT BEARING PRELOAD ADJUSTMENT PROCEDURE

NOTE

If the shaft bearings, shaft, valve plate or housing were not replaced, use the bearing spacer removed during the disassembly procedure to preload the shaft. If preload is necessary, perform the following steps:

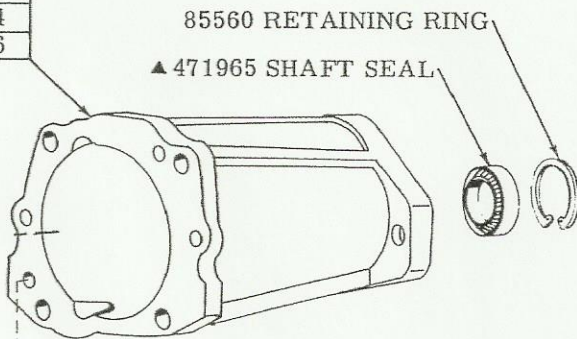
1. Install the thickest bearing spacer from the kit with chamfer facing toward shoulder of the shaft.
2. Slide tapered roller bearing over the shaft and up against the bearing spacer. The small diameter of the tapered roller bearing must face out of the housing.

3. Install valve plate to housing without gasket and rotating group. Turn the shaft to seat bearings then torque the four valve plate attaching screw to two (2) lb. in. Check the opening between the valve plate and housing to be as even as possible after tightening.

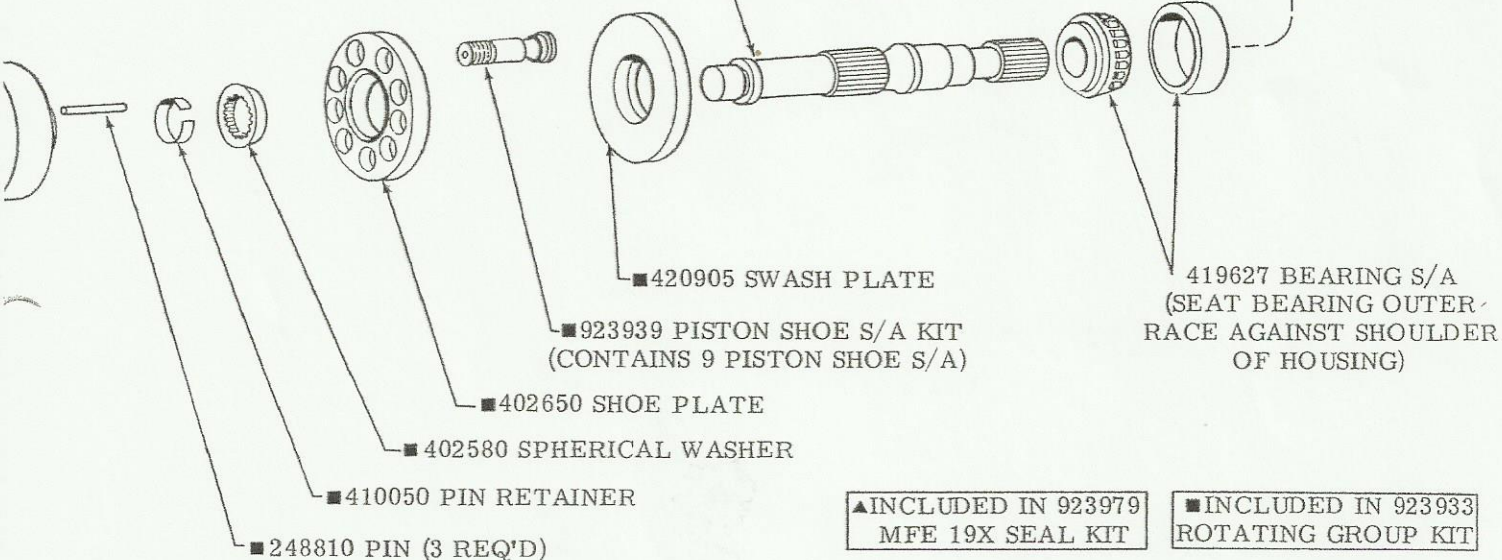
4. Use a feeler gage to measure the opening between valve plate and housing. Four (4) measurements should be obtained equidistant around the unit. A tapered feeler gage is especially useful for this purpose. Average the measurements by adding them together and dividing by four (4). Calculate thickness of the shaft bearing spacer as follows:

MODEL	HOUSING
MFE15	435304
MFE19	435276

MODEL	TYPE	SHAFT
MFE15/19-2	SPLINE	423421
MFE15/19-6		425424
MFE15/19-9		429700
MFE15/19-21		581109
MFE15/19X-2	SPLINE (THRU)	423422
MFE15/19X-5		575313
MFE15/19X-9		429734
MFE15/19X-13		426791
MFE15/19X-17		434797



164056 PIN (2 REQ'D)



▲ INCLUDED IN 923979 MFE 19X SEAL KIT

■ INCLUDED IN 923933 ROTATING GROUP KIT

Measured thickness of bearing spacer

Average gap (assumed)

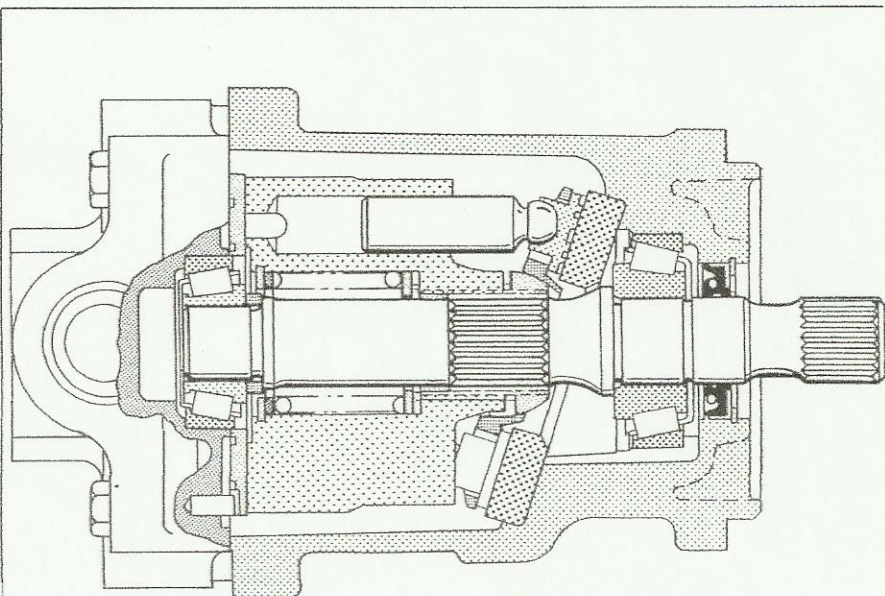
$\pm 0.001$  Preload setting

Compressed thickness of gasket

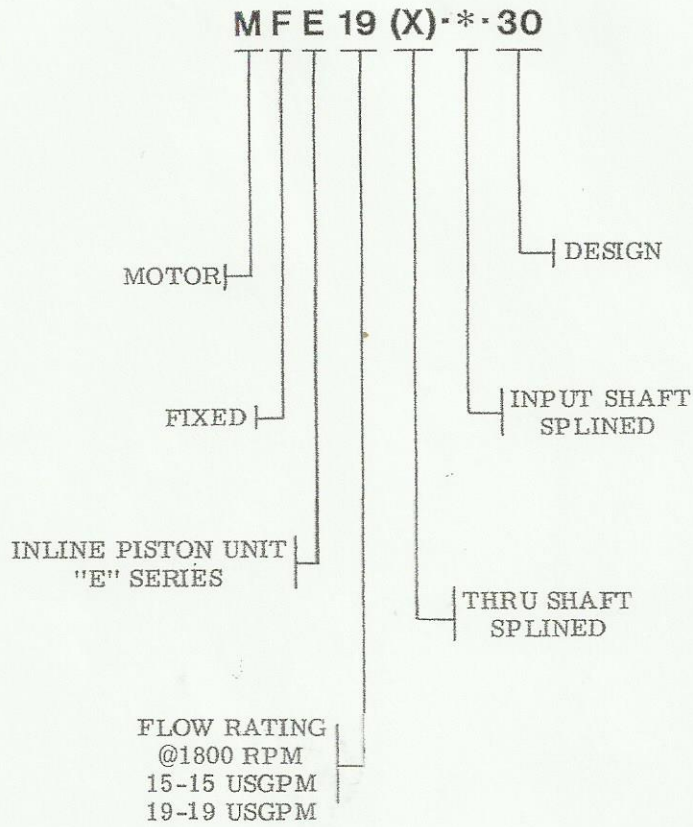
$\pm 0.001$  Required thickness of spacer to provide a 0.001 to 0.003 bearing preload.

Remove the large spacer and replace with one the calculated dimensions.

Assemble the motor with rotating group and a sket. Cross torque the valve plate screws to  $\frac{1}{2}$  ft.



# MODEL CODE BREAKDOWN



For satisfactory service life of these components, use full flow filtration to provide fluid which meets ISO cleanliness code 19/15 or cleaner. Selections from Vickers OFF, OFR, and OFRS series are recommended.