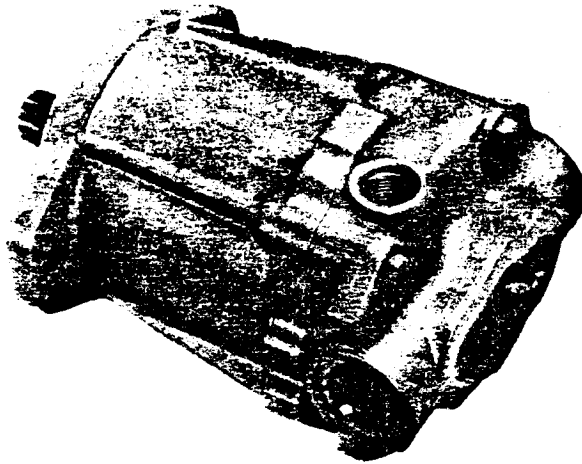


**VICKERS**

**FIXED  
DISPLACEMENT  
TRANSMISSION  
MOTOR**



**SERVICE  
PARTS  
INFORMATION**

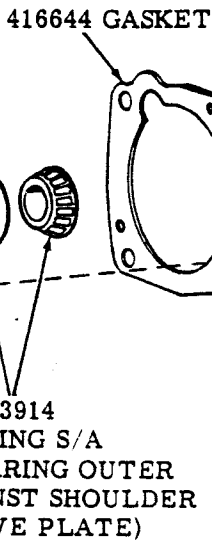
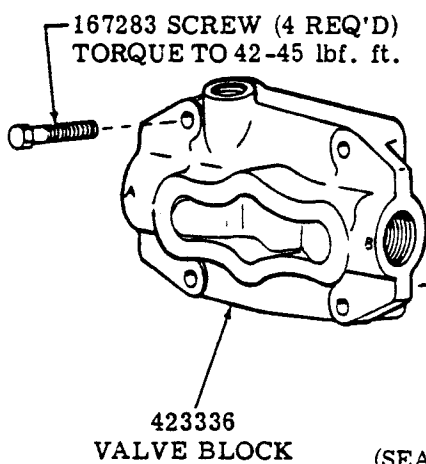
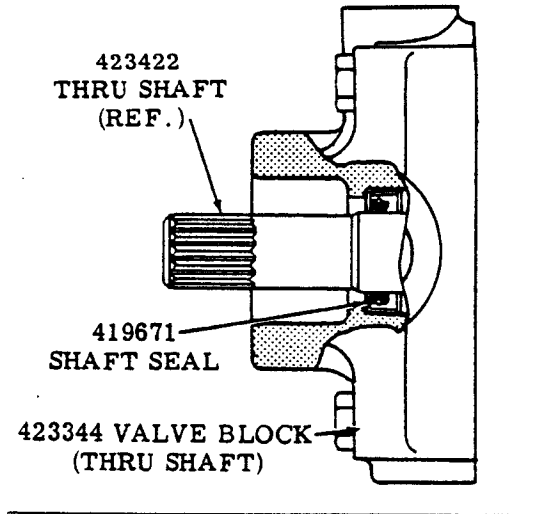
**MFE 19(X)-\*-20/21**

**SPERRY VICKERS  
TROY, MI. 48064**

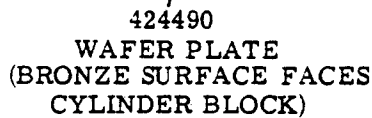
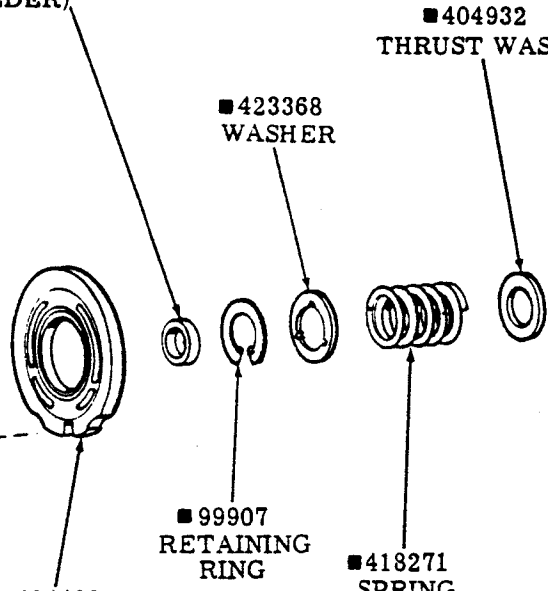
Revised 7-1-78

M-2832-8

MFE 19 X--20-\*\*\*  
THRU SHAFT MODELS



\*942401  
BEARING SPACER  
KIT  
(INSTALL SPACER WITH I. D.  
CHAMFER TOWARD SHAFT  
SHOULDER)



\* 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) lbf. in. Check the opening between the valve plate and housing to be as even as possible after tightening.

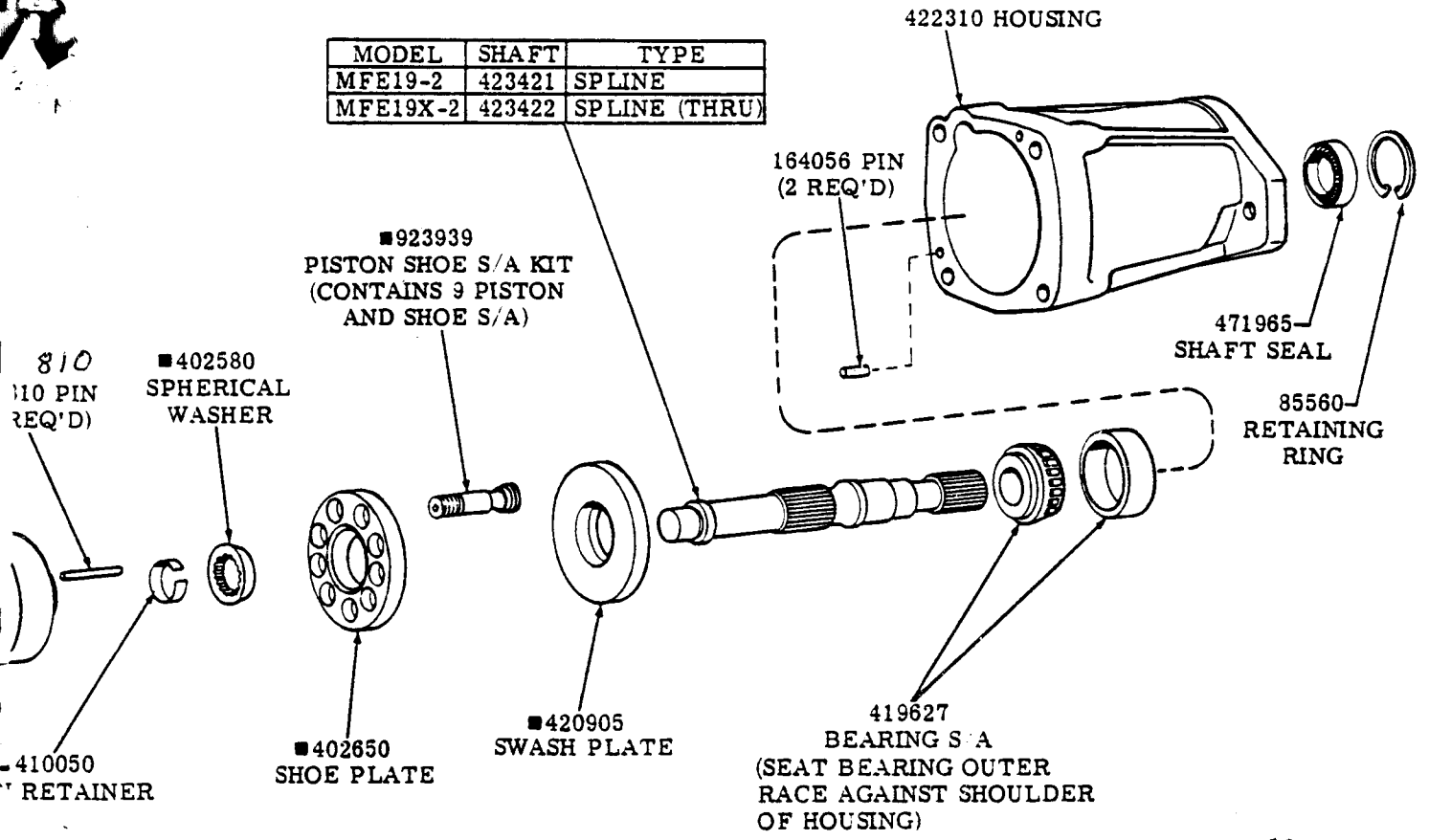
4. Use a feeler gage to measure the opening between valve plate and housing. Four (4) measurements should be obtained equidistant around the unit. A tapered feeler gage is especially useful for this purpose. Average the measurements by adding them together and dividing by four (4). Calculate thickness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

+0.150	Measured thickness of bearing spacer
-0.027	Average gap (assumed)
+0.003 ± 0.001	Preload setting
+0.020	Compressed thickness of gasket
<u>0.146 ± 0.001</u>	Required thickness of spacer to provide a 0.001 to 0.003 bearing preload.

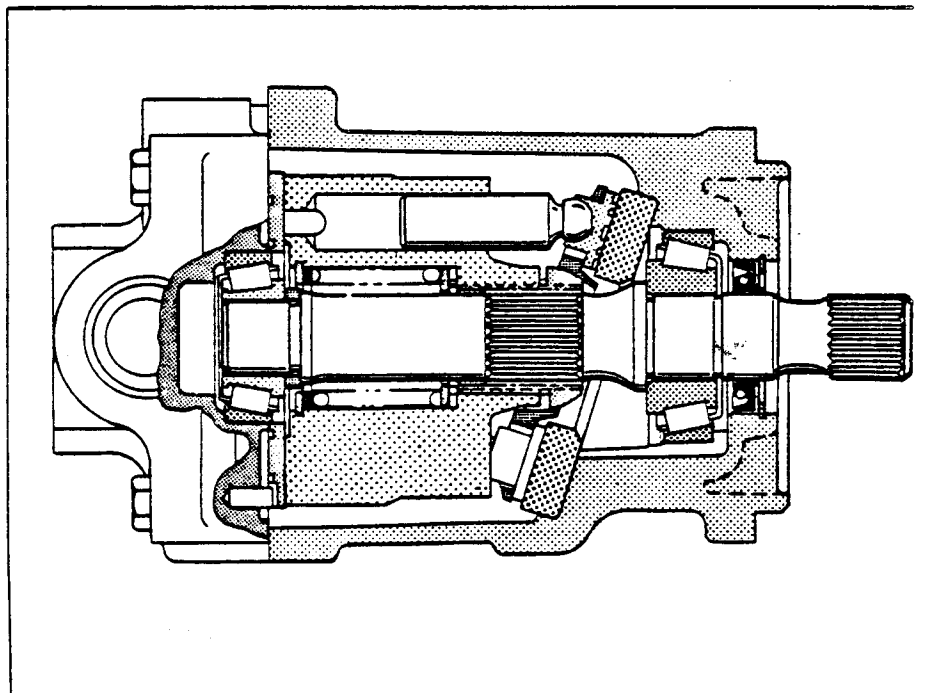
5. Remove the large spacer and replace with one having the calculated dimensions.
6. Assemble the motor with rotating group and a new gasket. Cross torque the valve plate screws to 42-45 lbf. ft.

432213

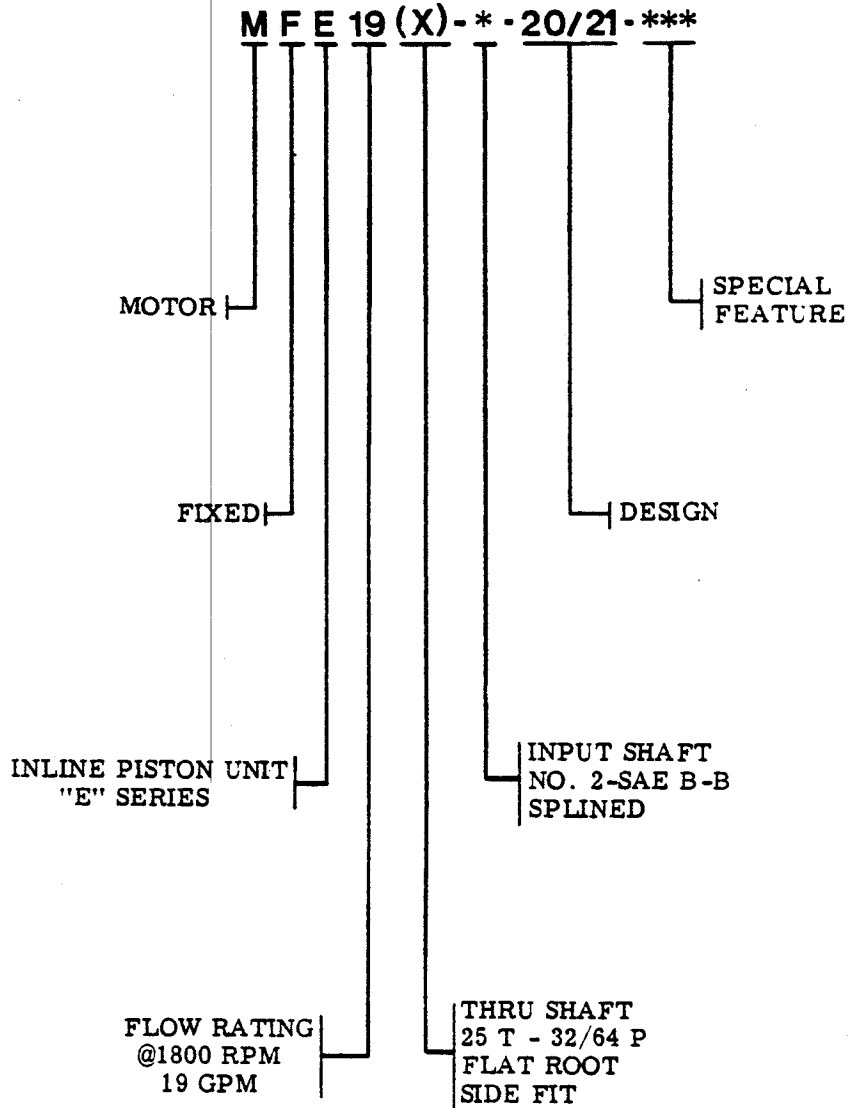
MODEL	SHAFT	TYPE
MFE19-2	423421	SPLINE
MFE19X-2	423422	SPLINE (THRU)



■ INCLUDED IN ROTATING GROUP KIT 923933



# MODEL CODE BREAKDOWN



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.)