

## HERRS MACHINE HYDROSTATICS INTALLATION GUIDELINES

1. Before rebuilt unit is bolted to rear frame, pull rear PTO out of tractor and inspect for wear. Check inside of reservoir for contamination (particles of steel or brass, sludge, dirt, etc.) that could have come from old unit or the PTO itself. Be sure pipe coupling from reservoir to suction tube is not obstructed. Make sure foot/inch valve pedal is not binding. Pedal should come back in 2 seconds after being released.
2. Flush out the rear end with a suitable cleaning solvent and wipe out the inside with clean lint-free towels.
3. Inspect oil cooler lines for cracks or excessive wear against any contact points along frame of tractor. Replace if necessary.
4. Using an air pressured flush gun (available for purchase through our shop), flush oil cooler hoses, pipes, tubing filter housing and reservoir with CLEAN solvent several times in both directions.
5. Remove cooler lines directly at the oil cooler and repeat flushing procedure for the oil cooler.
6. Reattach cooler lines and using clean oil, repeat flushing procedures.
7. Remove and inspect recirculating filter (if equipped) and main hydraulic filter for debris. Replace both filters before filling unit with new oil.

**IMPORTANT – AFTER 10 HOURS, BOTH FILTERS MUST BE CHANGED!!!**

**\*DO NOT GET DRIVE CONTROL LINES REVERSED GOING INTO THE LEFT SIDE OF TRANSMISSION**

**\*DO NOT REPLACE STEEL DRIVE CONTROL LINES WITH RUBBER HOSES ON HYDRO SECTION & FOOT/INCH VALVE – DAMAGE TO A & B CAPSULE, RELIEF VALVES AND CHECK VALVES WILL OCCUR**

You are now ready to install rebuilt transmission. **REMEMBER, KEEP IT CLEAN.** This includes and oil drums, buckets, transfer pump etc. used to clean and flush the system.

Although these steps will take considerable time to complete, we at Herra Machine Hydrostatics feel that they are extremely important to prevent unnecessary rebuilds and re-rebuilds both of which result in expense and down time.

**No warranty will be allowed on any units that have been contaminated in either relief valve, shuttle valve or scored steel valve plates/bearing plates from metal contamination!**

Remember, we at Herra Machine Hydrostatics want you to get the most from your equipment and our Hydrostatic Transmission Rebuilding Program.

### **SYSTEM START-UP PROCEDURES**

**\*\*YOU MUST HAVE AN OVERHAUL MANUAL TO PROPERLY INSTALL THIS UNIT!**

1. After transmission has been installed, install drive pressure, charge pressure and servo pressure gauges. You must have a 10,000-lb. gauge and two (2) 600 PSI gauges to check servo and charge pressure with snubbers to prevent gauge failure.
2. Fill reservoir through the upper case to fill openings with new, clean pre-filtered fluid. Make certain fluid meets specifications of the equipment manufacturer (Mobile 424, IH Hytran, Amoco 1000 etc. must meet B6 specifications). It is recommended that all fluid be passed through a ten-micron filter.
3. Make sure gear transmission is in neutral. Start engine and if possible, maintain 700-800 RPM engine speed for five minutes **IF YOU HAVE CHARGE PRESSURE.** This will allow the system to fill properly. After a few minutes, check fluid level in reservoir with engine running and add if necessary. During this phase, pressure surges may be seen on 600 PSI gauge. **THIS IS NORMAL.** Operate S&R lever 10-15 min. in forward with gear transmission in neutral to warm up fluid before fluids are checked. On large tractors, servo pressure must be adjusted by installer.