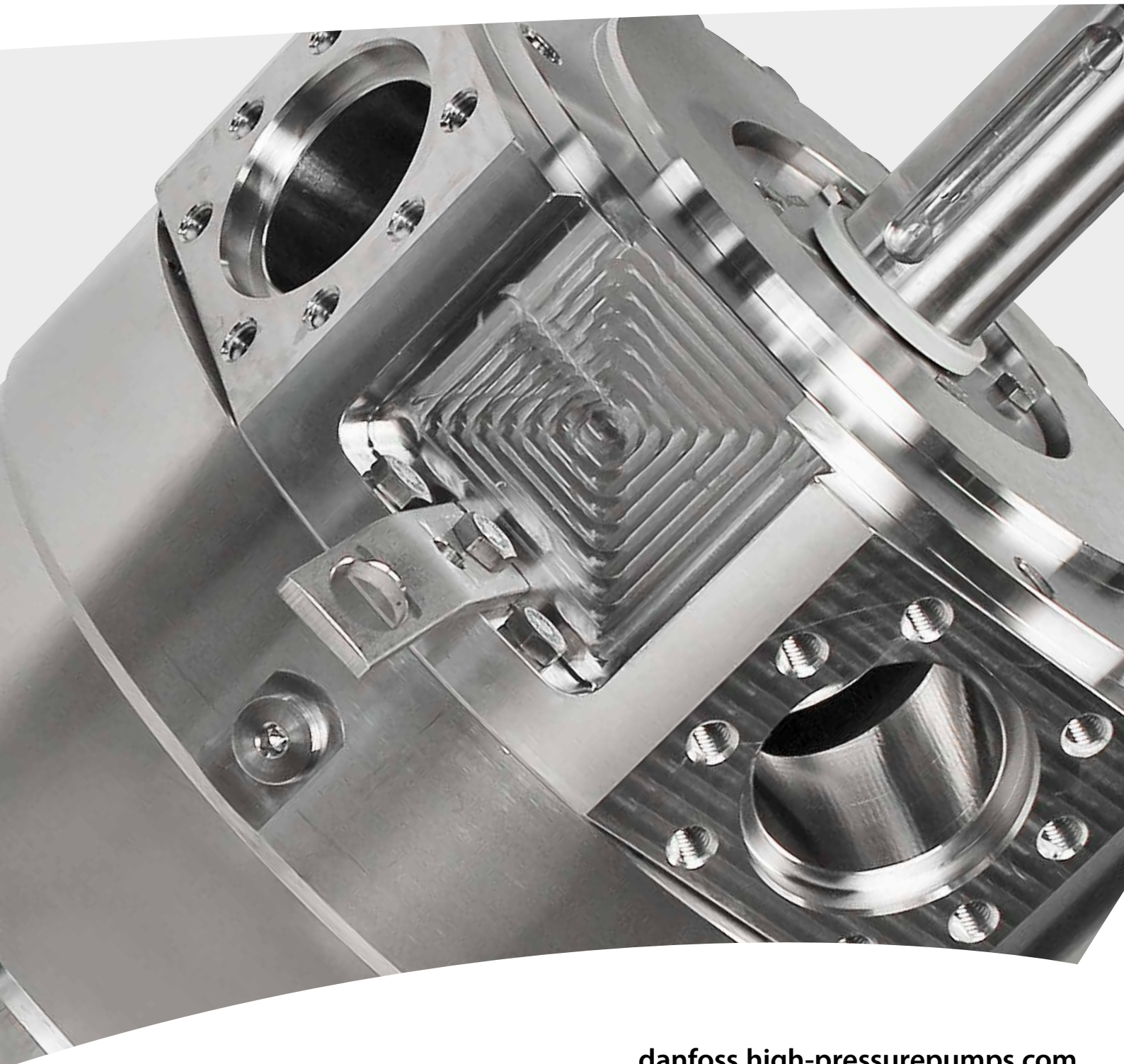


**Instruction**

# Disassembling and assembling PAHT and PAHT G 256-308



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## 1. Introduction

**This document covers the instructions for disassembling and assembling the axial piston pumps PAHT and PAHT G 256-308.**

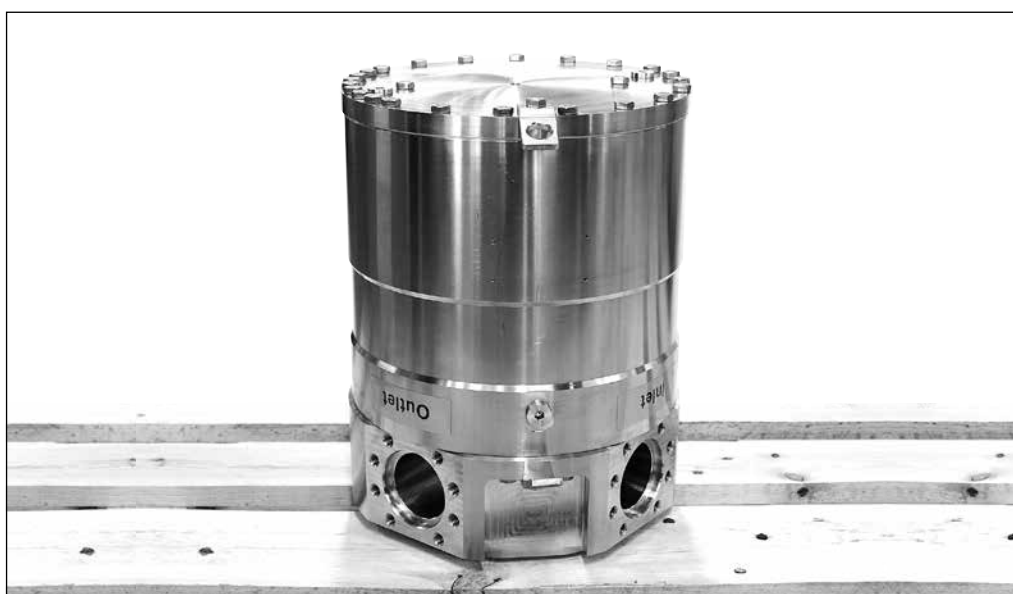
Tools provided with toolset 180B4172:

- 10 mm combination wrench
- 13 mm combination wrench
- 6 mm allen key
- Adjustable pin wrench
- Stop for retainer plate
- Press bush for valve plate
- Shaft seal extractor Ø45
- M8 allen screw (20 mm and 140 mm)
- Press bush Ø45 (Plastic)
- M8 mm eye bolt
- M8 mm nut
- M8 x 70 mm screw

**Important: It is essential that the pump is serviced in conditions of absolute cleanliness.**

Place the pump on a pallet or other stable surface above the ground. Ensure that the pump cannot roll. It must be possible to place the pump vertically with the shaft pointing downwards. This can be done between two pallets or between two boards on a pallet provided that the distance is minimum 50 mm.

**WARNING:**  
**Do not reuse disassembled O-rings or shaft seal as they might be damaged. Always use new O-rings.**



2. Disassembling the pump



1. Disconnect the pump from the rest of the system.



2. Using a 10 mm combination wrench, unscrew the four bolts from shaft seal flange. If shaft seal flange is stuck, screw in two bolts in holes in the flange to remove it.



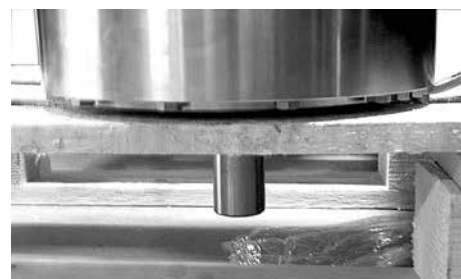
3. Remove ceramic ring from flange by gently pushing it from the back of the sealing ring.



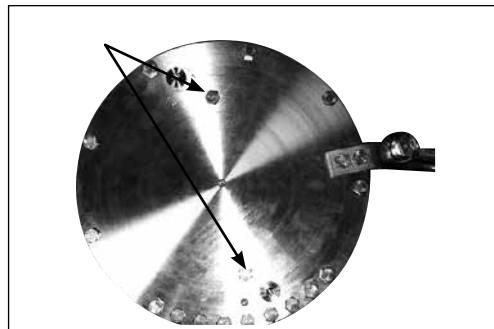
4. Mount the M8 allen screw from the tool set in the top of the shaft.  
5. Wet the shaft and shaft seal with clean filtered water.



6. Carefully remove the shaft seal assembly using the shaft seal extractor supplied in the toolset. The extractor must fit underneath the shaft seal. Press the arms of the extractor together when turning the bolt.



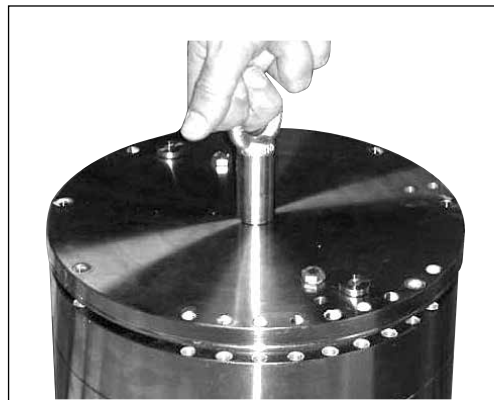
7. Turn pump into vertical position with shaft pointing downwards.



8. Using a 13 mm combination wrench, remove all the bolts on the mounting flange except the three shown in the next picture.  
**WARNING:**  
**Do not loosen the two screws keeping swash plate in place.**



9. Unscrew the remaining three bolts. Turn each bolt one round at the time to make sure that the flange is removed as straight forward as possible.



10. Screw the eye bolt in the M8 hole in the middle of the flange. Pull it straight upwards.



11. Swash plate must be placed so that its surface is not scratched. For further disassembling of swash plate, see page 10.



12. Remove by hand the pistons one by one. Be careful not to scratch the pistons. Tilt the retainer plate to horizontal position for easy removal of pistons, if required.  
**WARNING:**  
**Do not use any tools.**



13. Remove the retainer plate and the retainer ball.  
**Note:** As the retainer ball is not attached to the retainer plate, it might fall out.



14. Remove the retainer guide, the 4 springs and the spring guide.

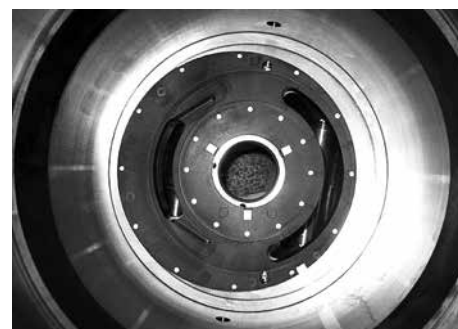


15. Mount a 8 mm eye bolt in the cylinder barrel. Pull straight upwards. A continuous lift will elevate the cylinder barrel out of housing. This can only be done if shaft seal is removed.

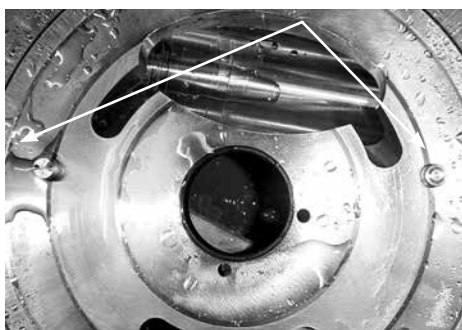
**WARNING:**  
**If the cylinder barrel is dropped or lowered too fast into housing, the main bearing/shaft bearing might be damaged. It is not replaceable.**



16. Place cylinder barrel upside down. For further disassembling of cylinder barrel and valve plate see page 11.



17. Remove the port plate by hand.



18. Remove, by hand, the two pins.  
**Note: The following operation is only necessary if O-ring on port flange is to be changed.**



19. Place the pump horizontally. Remove the remaining screws in port flange by using a 13 mm combination wrench. Carefully separate house and port flange. Ensure that pin for the positioning house is not lost. For further disassembling of flush valve, see page 16.

For further disassembling of flush valve, see page 11.

3. Assembling the pump

**Important:**  
It is essential that the pump is serviced in conditions of absolute cleanliness. All parts must be absolute clean before mounting.

**Note:**  
Place the pump on a pallet or other stable surface above the ground. Ensure that the pump cannot roll. It must be possible to place the pump vertically with the shaft pointing downwards. This can be done between two pallets or between two boards on a pallet provided that the distance is minimum 50 mm.

**WARNING:**  
Do not use silicone when assembling the pump. Do not reuse disassembled O-rings; they might be damaged. Always use new O-rings.



1. Lubrication:
- To prevent seizing-up, lubricate all threads with PTFE lubrication type.
  - O-rings inside pump may be lubricated only with clean filtered water.
  - O-rings for port flange, mounting flange and flushing valve must be lubricated.
  - It is important to lubricate ALL parts to be assembled with clean filtered water (Especially all PEEK parts).



2. Place port flange with O-ring pointing upwards.

Insert pin for positioning housing on port flange. Ensure that two screw holes can be reached from below.



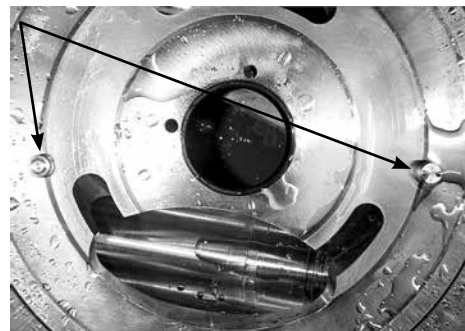
3. Mount O-ring.



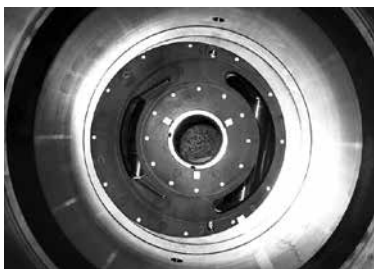
4. Position housing aligning pin hole over pin. Carefully press the port flange downwards. Do not squeeze the O-ring. If the O-ring is damaged, the pump will leak. Screw in at least two screws.



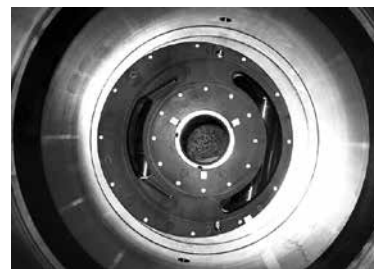
5. Place housing horizontally. Screw in the rest of the screws on port flange. Tighten screws to a torque of  $30 \pm 2$  Nm.



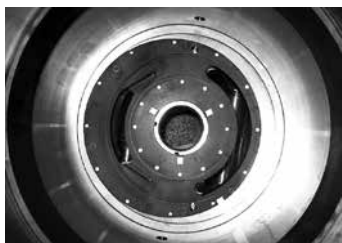
6. Place pump vertically. Place 10.5 mm pins in port flange. Position port plate by using the two pins. Do not use force for this operation.



7. Ensure port plate is fitted tightly against the bottom.  
**IMPORTANT:**  
Lubricate port plate with clean filtered fresh water.  
If valve plate is disassembled from cylinder barrel please see page 11 before continuing.



8. Screw eye bolt in cylinder barrel.



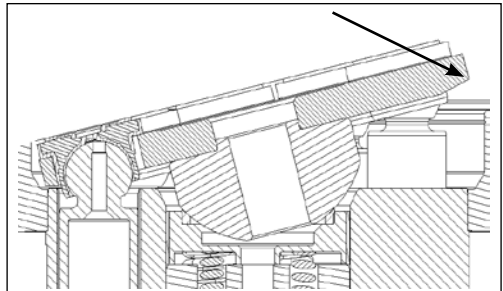
9. Make sure there is enough free space for the shaft beneath the housing. Gently lower cylinder barrel into housing.  
**WARNING!**  
If cylinder barrel is dropped or lowered too fast into housing, main bearing and shaft bearing might be damaged. Replacement can only be done at Danfoss, Nordborg.



10. Unscrew M8 eye bolt. Place the four springs and spring guide in cylinder barrel. Springs must be positioned in the holes.



11. Retaining guide, retaining ball and retaining plate must be mounted as indicated in below picture.



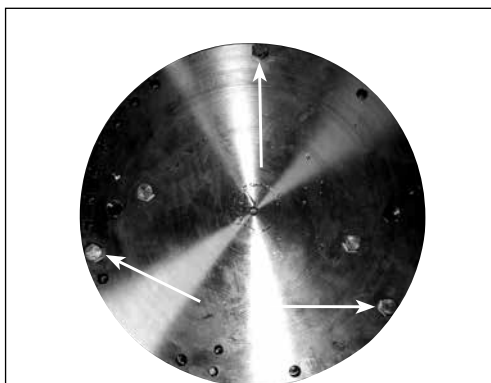
12. Ensure that retaining plate is oriented correctly, i.e. with its slant surfaces pointing downwards.



13. Place retaining guide, retaining ball and retaining plate in cylinder barrel.  
**Note: If pistons are replaced, place new pistons in clean filtered water for a couple of minutes. Exercise piston shoes to make them "run" smoother.**



14. Place pistons in retaining plate and cylinder barrel.  
When pistons are placed, tilt retaining plate for easier placement of swash plate. If swash plate has been disassembled from mounting flange, see page 14 for assembly of swash plate.  
15. Lubricate piston shoes and swash plate with clean filtered water. Remember to place the pins in housing.



16. Place three bolts in mounting flange. Turn each bolt one round at a time to ensure mounting flange is mounted as straight downwards as possible. Be careful not to squeeze O-ring.

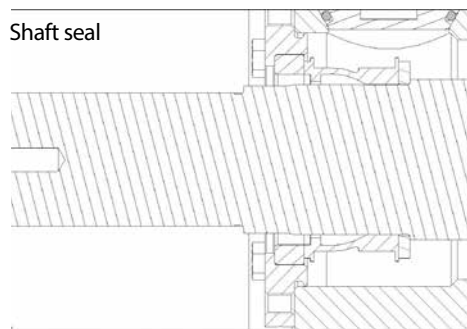


**Note: Screws for lifting eye are shorter than the rest.**

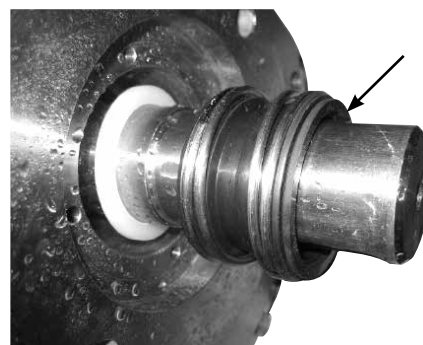
17. Screw in the rest of the bolts and cross tighten all screws to a torque of 30 +/- 2 Nm.



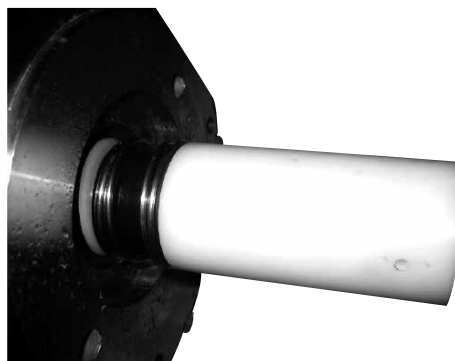
Shaft seal



18. Place pump horizontally to get access to shaft.



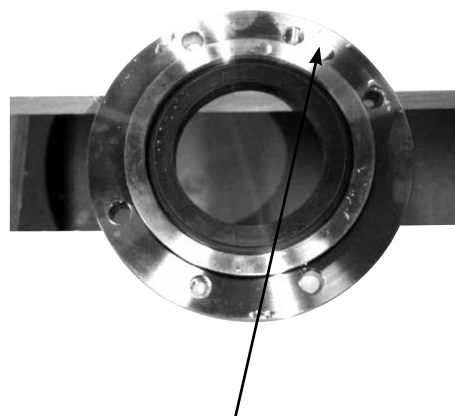
19. Place stop for shaft seal on shaft.  
**WARNING:**  
Ensure that carbon ring is pointing outwards.



20. Use plastic assembly tool provided with large diameter pointing downwards, to press seal home against shoulder of stop for shaft seal.



21. Press new ceramic ring into retainer ring by using plastic tool provided.  
**WARNING:**  
Ensure that the face with rubber seal is positioned against shoulder in shaft seal flange.



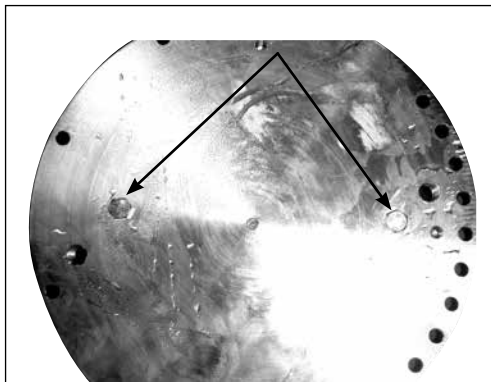
22. Remove old O-ring and fit new one on shaft seal flange.



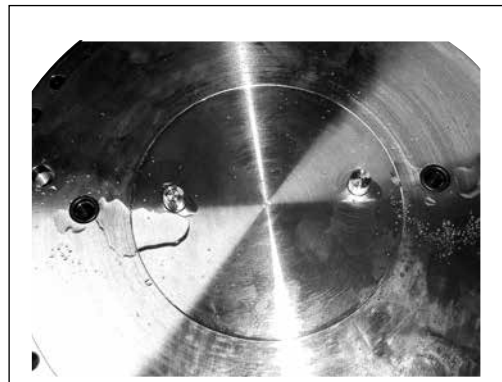
23. Place shaft seal flange on shaft. Tighten the bolts with a torque of 10Nm +/- 2 Nm.

4. Disassembling and assembling of the swash plate

**WARNING:**  
Make sure that the surface on the swash plate does not get any marks.



1. Place the swash plate upside down. Remove the 2 bolts holding the swash plate. Remove the mounting flange from the swash plate.



2. Check that the O-ring and pin are in good condition (Provided with sealing set).

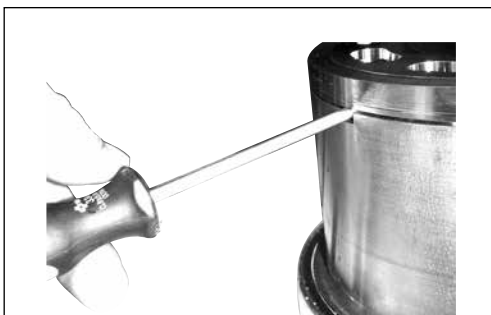


3. Change the O-ring on the mounting flange.

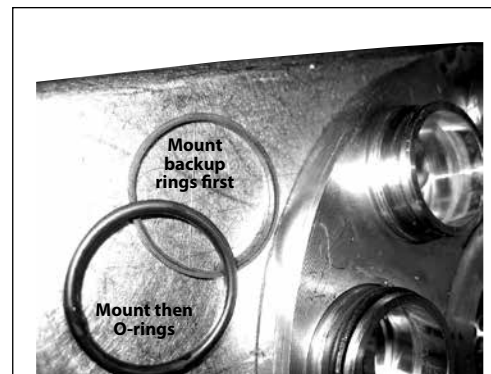


4. Mount the swash plate on the 2 pins. Carefully by hand tilt the unit to horizontal position and mount the 2 bolts which hold the swash plate. Tighten the bolts with a torque of 30 Nm +/- 2 Nm. Finally check the surface on the swash plate for any marks or foreign particles. Mount the assembled part on the pump.

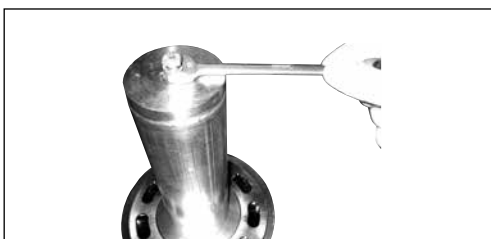
**5. Disassembling and assembling of cylinder barrel and valve plate**



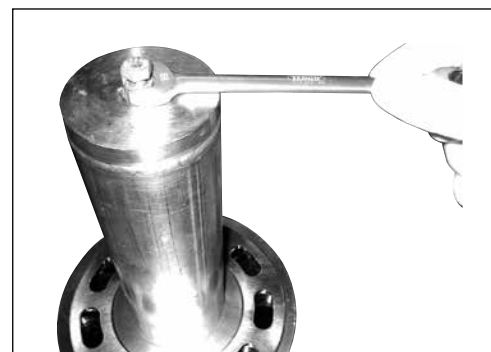
1. Push a screwdriver into the hole between cylinder barrel and valve plate. Carefully push downward the screwdriver so that it makes a gap between cylinder barrel and valve plate. Use this gap to put in another screwdriver and loosen the valve plate from the cylinder barrel.



2. Remove the O-rings and backup rings. If they have been removed they can not be reused. Mount the new back-up rings on the valve plate first and then mount the O-rings.



3. Lubricate the new O-rings/back-up rings and the liners in the cylinder barrel with clean filtered water. Lower the valve plate upside down on the cylinder barrel. Place the press bush for valve plate (provided in tool set) like on the picture. Screw the bolt into the shaft of the cylinder barrel. Turn the nut slowly clockwise. The valve plate must slide carefully into the cylinder barrel. Stop when the gap between cylinder barrel and valve plate is 1-2 mm.



4. Remove the press bush again by screwing the nut counter-clockwise. Turn the nut slowly clockwise. The valve plate must slide gently into the cylinder barrel. Stop when the gap between cylinder barrel and valve plate is 1-2 mm.

6. Changing pistons

**Note : It is essential that the pump is serviced in conditions of absolute cleanliness.**

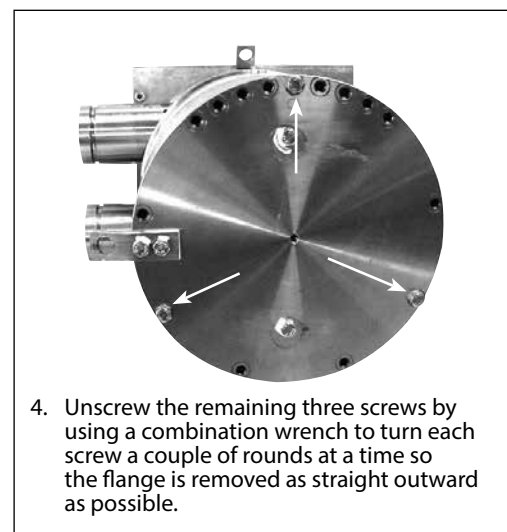
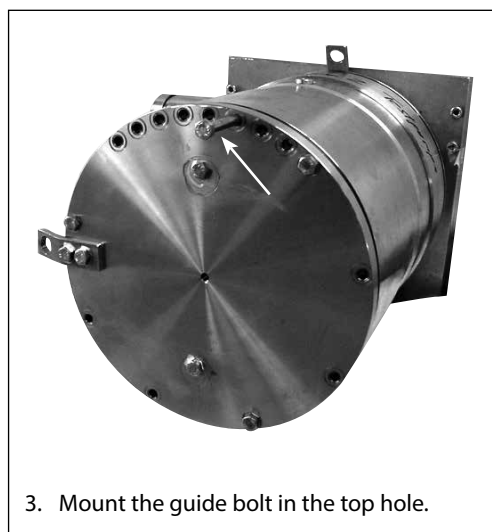
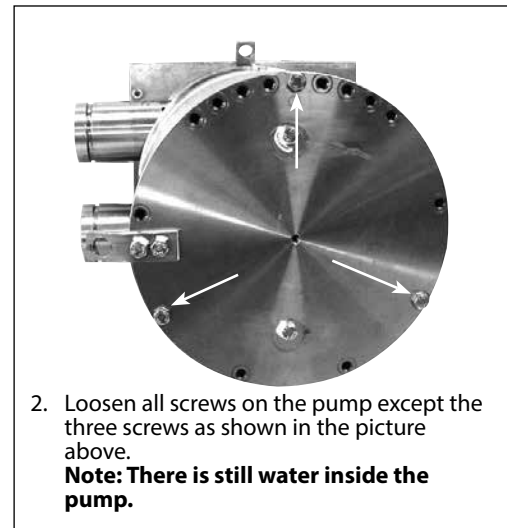
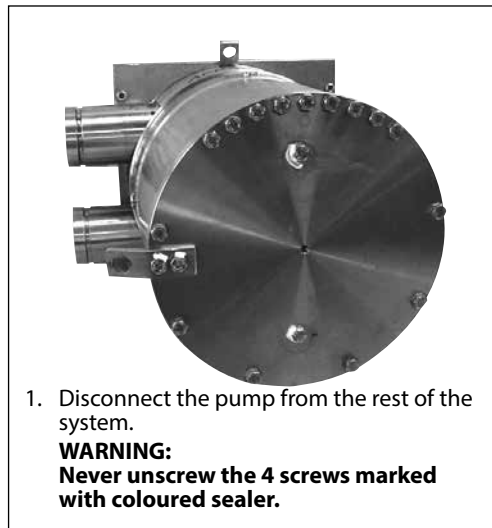
**Tools needed:**

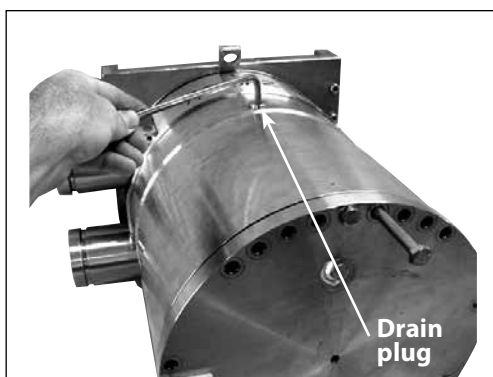
- 13 mm combination wrench
- 6 mm allen key
- Tool set 180B4347



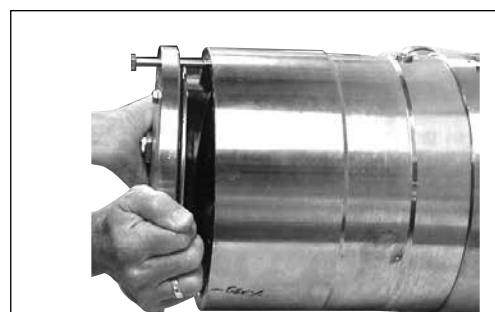
**6.1 Disassembling**

To understand the pump design better, please also see the exploded view in item 8.

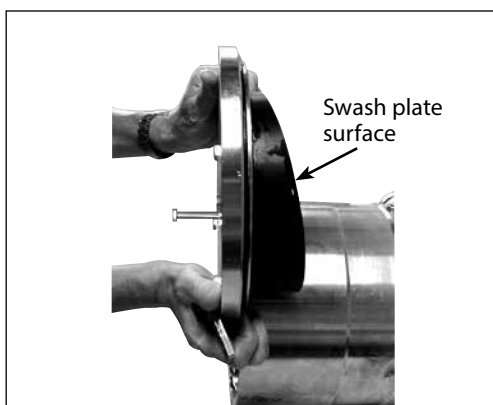




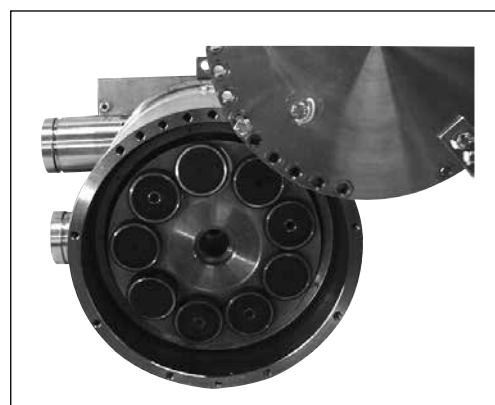
5. If the flange does not move forward - loosen the drain plug to empty the pump from water by releasing vacuum.



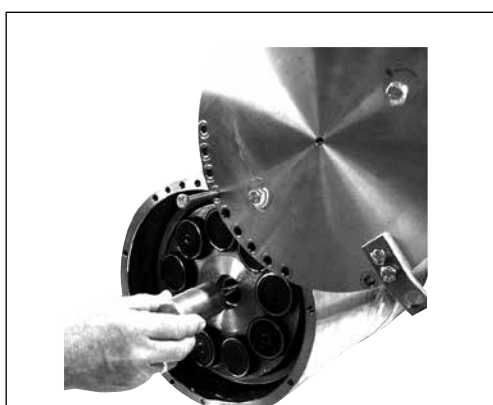
6. Remove the flange when the remaining three screws have been loosened. The guide bolt must remain mounted.



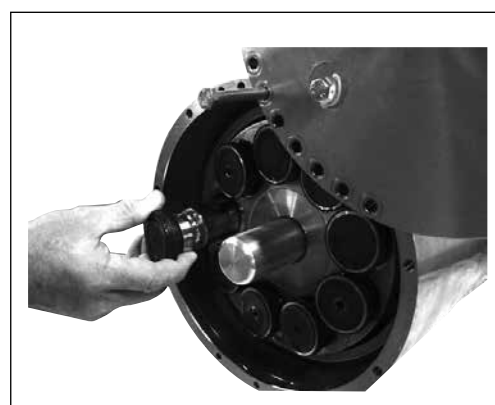
7. Carefully turn the flange and push it backwards to make it rest on the housing surface. Ensure not to scratch the swash plate surface.



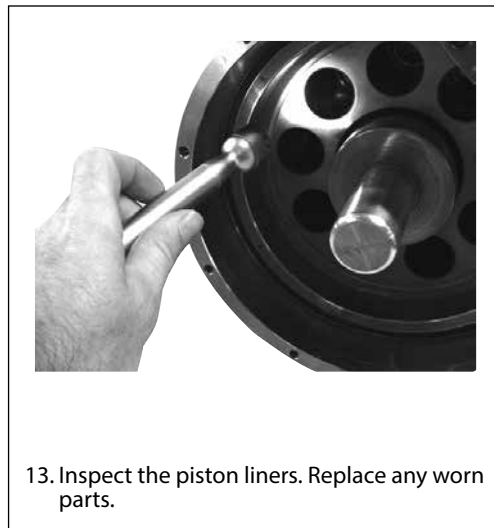
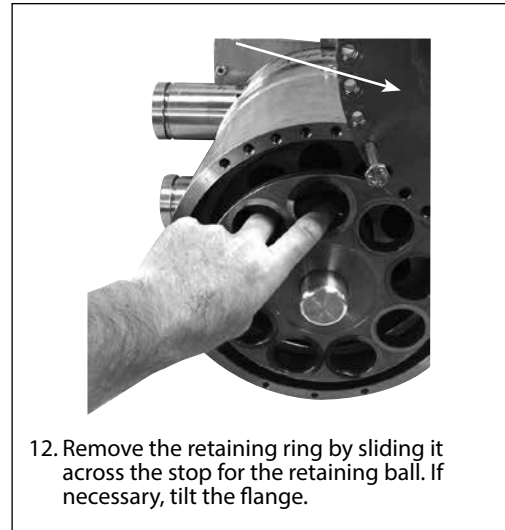
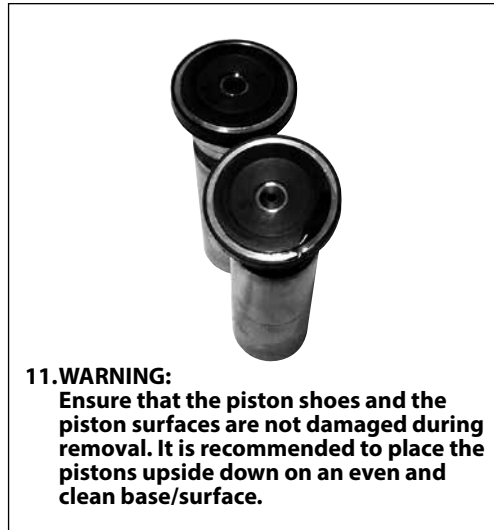
8. Adjust the retaining plate to be parallel to the end flange.



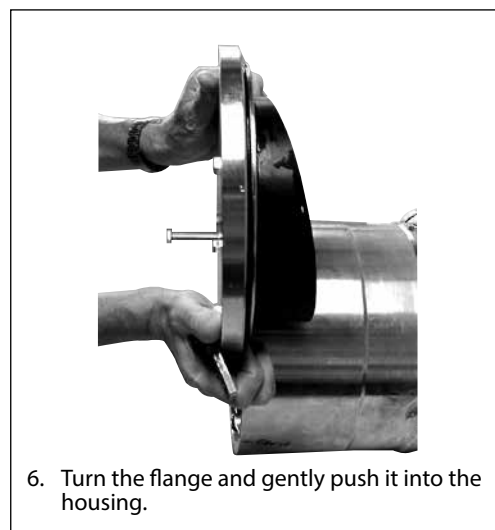
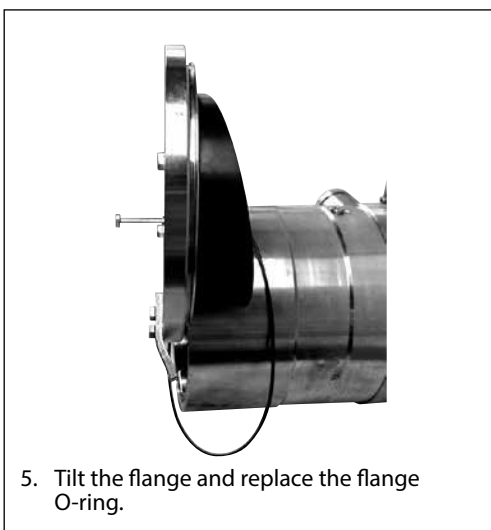
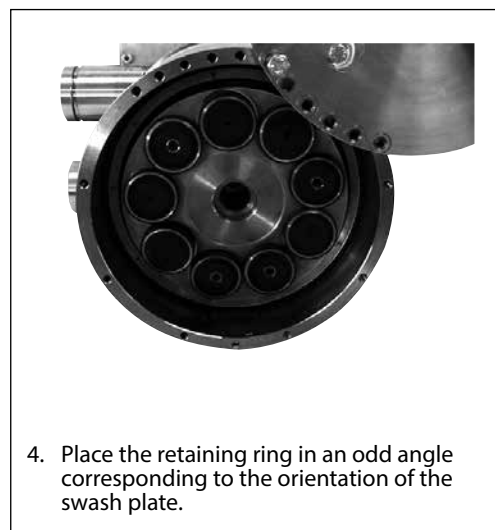
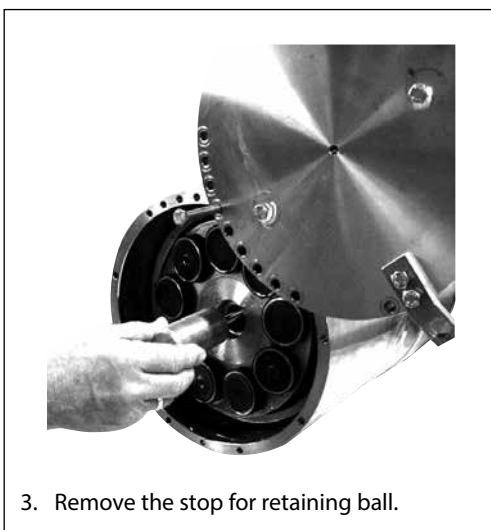
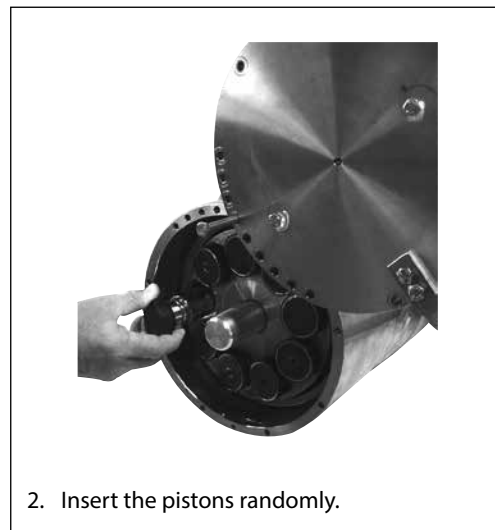
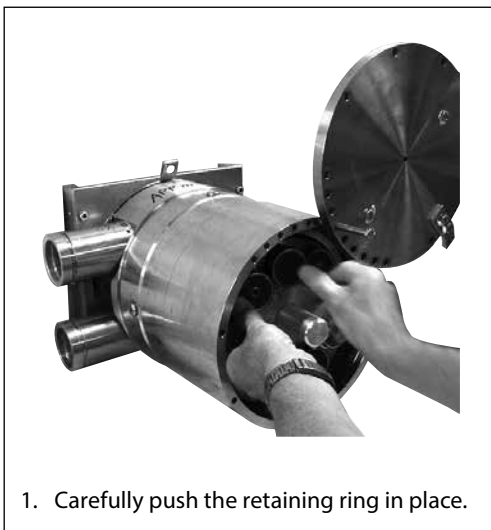
9. Screw the stop for the retaining ring into the centre to keep the retaining ball in place.

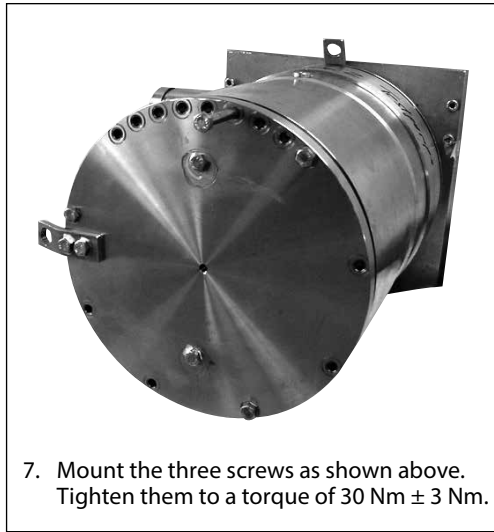


10. Carefully remove the pistons one by one.

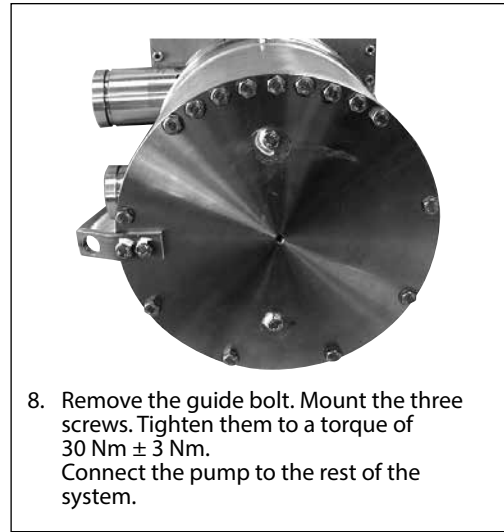


6.2. Assembling





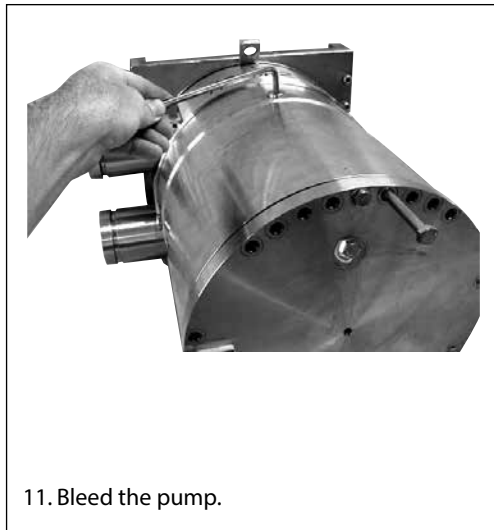
7. Mount the three screws as shown above. Tighten them to a torque of  $30 \text{ Nm} \pm 3 \text{ Nm}$ .



8. Remove the guide bolt. Mount the three screws. Tighten them to a torque of  $30 \text{ Nm} \pm 3 \text{ Nm}$ . Connect the pump to the rest of the system.

9. Mount the three screws as shown below. Tighten them to a torque of  $30 \text{ Nm} \pm 3 \text{ Nm}$ .

10. Connect the pump to the rest of the system.



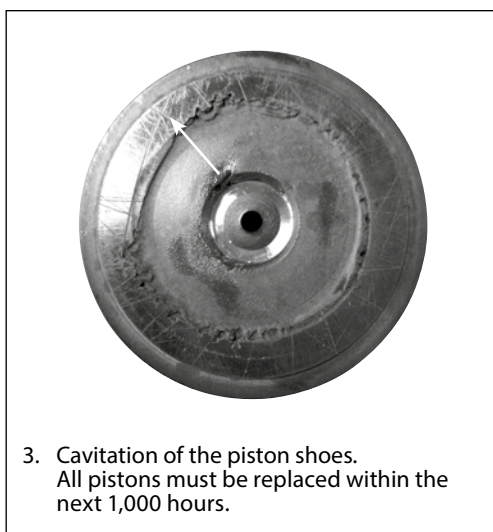
11. Bleed the pump.



**7. When should the pistons be replaced**

This section provides guidance on, how to determine whether the parts of the pump are worn and should be replaced. In case of doubt - the pistons must be replaced. The pictures below are meant as a guideline for evaluating the wear of the sliding surface.

**Note: If the pistons break down, the pump will suffer a disastrous breakdown.**



**8. Spare parts list for PAHT 256-308**

Pos.	Qty.	Designation	Material	180B4082 - Screw & seal set (PAHT 256-308)	180B4079 - Cylinder barrel set (PAHT G 256-308)	180B4078 - Valve plate set (PAHT 256-308)	180B4084 - Retainer set (PAHT 256-308)	180B4083 - Piston set (PAHT 256-308)	180B4080 - Swash plate set (PAHT 256)	180B4081 - Swash plate set (PAHT 308)
Pos	Qty	Designation	Material							
1	1	Housing	Duplex / PEEK							
2	2	Pin ø6 x 10	AISI 316	x						
3	4	Bleeding plug G 1/4"	Super duplex	x						
4	4	O-ring ø11 x 2	NBR	x						
5	17	Screw M8 x 30	AISI 316	x						
9	1	O-ring ø228 x 4	NBR	x				x	x	x
10	2	O-ring ø9,19 x 2,62	NBR	x					x	x
11	1	End cover CW	Duplex							
13	2	Screw M8 x 16	AISI 316	x						
31	1	Swash plate	Super Duplex						x	x
34	2	Pin ø10,5 x 20	Duplex	x					x	x
61	1	Cylinder barrel	Super duplex / PEEK		x					
62	4	Spring	Duplex				x			
63	1	Spring guide	Polypropylen				x			
64	1	Retainer Ball	Super duplex				x			
65	1	Retainer plate	Super duplex				x			
66	9	Piston	Super duplex / PEEK					x		
67	1	Key 12 x 8 x 70	AISI 316	x						
71	1	Retainer Guide	Super duplex / PEEK				x			
91	1	Port plate	Super duplex / PEEK			x				
92	1	Valve plate	Super duplex			x				
93	9	Back up ring	PTFE			x				
94	9	O-ring ø30,2 x 3	NBR			x				
121	1	Port flange	Duplex							
122	1	O-ring ø68 x 2	NBR	x						
123	1	O-ring Ø228 x 4	NBR	x						
124	1	Shaft sealing	Hasteloy C276	x						
125	1	Cover	Super duplex							
126	2	Pin ø10,5 x 20	Super duplex	x		x				
127	4	Screw M6 x 16	AISI 316	x						
128	15	Screw M8 x 90	AISI 316	x						
132	2	Bleeding plug G 1/4"	Super duplex	x						
133	2	O-ring ø11 x 2	NBR	x						
142	1	Washer for shaft seal	Polypropylen	x						
147	1	Screw M8 x 16	AISI 316	x						
	1	Service instruction		x	x	x	x	x	x	x



**9. Spare parts list for PAHT G 256-308**

Pos.	Qty.	Designation	Material	180B4370 - Screw & seal set (PAHT G 256-308)	180B4369 - Cylinder barrel set (PAHT G 256-308)	180B4367 - Valve plate set (PAHT G 256-308)	180B4366 - Retainer set (PAHT G 256-308)	180B4368 - Piston set (PAHT G 256-308)	180B4331 - Swash plate set (PAHT G 256)	180B4332 - Swash plate set (PAHT G 308)
Pos	Qnt	Designation	Material							
1	1	Housing	Duplex / PEEK							
2	2	Pin ø6 x 10	AISI 316	x						
3	4	Bleeding plug G 1/4"	Super duplex	x						
4	4	O-ring ø11 x 2	NBR	x						
5	17	Screw M8 x 30	AISI 316	x						
9	1	O-ring ø228 x 4	NBR	x				x	x	x
10	2	O-ring ø9,19 x 2,62	NBR	x					x	x
11	1	End cover CW	Duplex							
13	2	Screw M8 x 16	AISI 316	x						
31	1	Swash plate	Super Duplex						x	x
34	2	Pin ø10,5 x 20	Duplex	x					x	x
61	1	Cylinder barrel	Super duplex / PEEK		x					
62	4	Spring	Duplex				x			
63	1	Spring guide	Polypropylen				x			
64	1	Retainer Ball	Super duplex				x			
65	1	Retainer plate	Super duplex				x			
66	9	Piston	Super duplex / PEEK					x		
67	1	Key 12 x 8 x 70	AISI 316	x						
71	1	Retainer Guide	Super duplex / PEEK				x			
91	1	Port plate	Super duplex / PEEK			x				
92	1	Valve plate	Super duplex			x				
93	9	Back up ring	PTFE			x				
94	9	O-ring ø30,2 x 3	NBR			x				
121	1	Port flange	Duplex							
122	1	O-ring ø68 x 2	NBR	x						
123	1	O-ring Ø228 x 4	NBR	x						
124	1	Shaft sealing	Hasteloy C276	x						
125	1	Cover	Super duplex							
126	2	Pin ø10,5 x 20	Super duplex	x		x				
127	4	Screw M6 x 16	AISI 316	x						
128	15	Screw M8 x 90	AISI 316	x						
132	2	Bleeding plug G 1/4"	Super duplex	x						
133	2	O-ring ø11 x 2	NBR	x						
142	1	Washer for shaft seal	Polypropylen	x						
147	1	Screw M8 x 16	AISI 316	x						
	1	Service instruction		x	x	x	x	x	x	x



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