



REPAIR KIT INSTRUCTIONS FOR ACE M SERIES HYDRAULIC MOTORS

HYDRAULIC MOTOR REPAIR KIT

This kit includes all parts needed to repair or update Ace M Series motors to the second generation shaft seal. The table on the right lists motor part numbers which use this Repair Kit (RK-BAC-75-M).

Please refer to Ace Pump [Product Update 19](#) for complete details.

A video of the seal replacement is available here: www.youtube.com/user/acepump

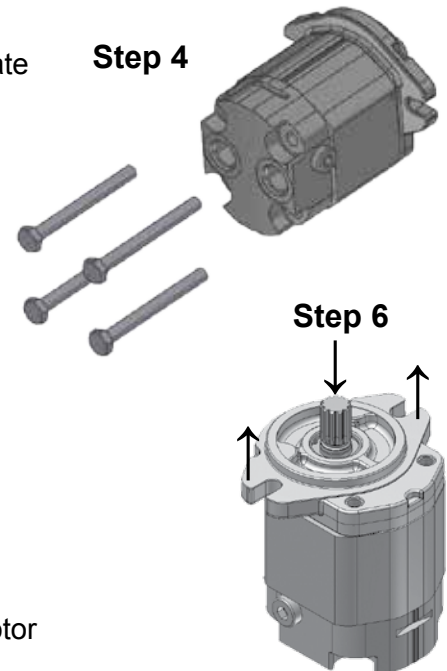
Motor Model	Used on Pump Models
BAC-75-HYD-M16	FMC-650-HYD Series FMC-650F-HYD Series FMC-650FS-HYD Series FMCWS-650F-HYD Series FMCWS-650FS-HYD Series
BAC-75-HYD-M22	FMC-750F-HYD Series
BAC-75-HYD-M25	FMC-750F-HYD Series

REPAIR KIT INSTALLATION

Caution: Do not remove the protective paper tube from the new flange assembly.

DISASSEMBLY:

1. Wipe the motor with a clean cloth to remove dirt which could contaminate the motor.
2. Note port locations then remove hoses and external fittings.
3. Mark the motor section joints to indicate orientation of the motor components.
4. Remove (4) motor assembly cap screws. Motors with hex head cap screws require a 17 mm socket. Motors with socket head cap screws require a 9.5 mm or 3/8" hex key wrench.
5. Set motor on rear cover with shaft pointing up.
6. Remove front motor flange by pressing thumbs against shaft end while pulling up with fingers behind flange ears. Take care to not disturb the other motor components.
7. Remove the housing seal O-ring and discard the old flange assembly. Inspect the motor shaft for grooving or scoring. Moderate to severe damage in the sealing area may prevent proper sealing and require motor replacement.



ASSEMBLY:

8. Place seal installation tool over splined shaft end. Lubricate the tool and seal lips with clean oil.
9. Lightly grease housing seal O-ring and place into groove on rear of new flange.
10. Carefully place new flange/seal assembly over installation tool and press down slowly to body. The tool will push the paper tube out.
Note: Take care to hold the flange level and push evenly on both sides of the flange.
11. Discard seal installation tool and paper tube.
12. Reinstall motor assembly bolts and tighten to 33 ft-lb (45 N-m) torque. Turn the shaft by hand to ensure the motor turns freely.
13. Reinstall external motor fittings.

