TO ASSEMBLE HYDRAULIC LIFT COVER (Figures 32, 35, 44) (14A/6)

1. Fit the control linkage assembly to the support bracket (31, Figure 35) and secure with the fulcrum clevis bolt (35) and locknut (32).
2. Assemble the dashpot and secure to the support bracket with the two bolts and washers.
3. Assemble the piston (21) into the cylinder (23).
4. Secure the support bracket assembly (31) to the cylinder (23) with the two bolts (30) and washers (29).
5. Position the connecting rod (10) and ram arm (7) into the lift cover.
6. Fit the lift shaft (9) to the lift cover and ram arm, aligning the master splines on the lift shaft and ram arm.
7. Fit the lift arms (1) to the lift shaft, aligning the master splines. Secure each lift arm with a washer (4), bolts (2) and tabwasher (3). Fully tighten the R. H. lift arm retaining bolts and secure with the tabwasher. Tighten the L. H. bolts so that the lift arms just move freely through their travel with no cross shaft end float, and secure with the tabwasher.
8. Position the draft and position control linkage into the lift cover. Assemble the linkage pivot shaft (43, Figure 32) to the lift cover and linkage and secure with the socket screw (46).
9. Assemble the quadrant and shaft assembly to the lift cover and secure with the socket screw (47).
10. Place the cylinder and support bracket assembly onto the lift cover. Position the four studs on the cylinder into the four holes in the lift cover, simultaneously locating the two guide rods into their holes in the support bracket.
11. Secure the cylinder assembly to the lift cover with the four nuts tightened to 115 to 125 lb. ft. (15. 9 to 17. 3 kg. m.).
12. Refit the position control spring.
13. Remove the spring retainer pins from the guide rods, Figure 44.
14. Carry out the adjustments as stated in operations 14A/7 and 14A/8.

ADJUSTMENTS (14A/7 and 14A/8)

External Adjustments (Figures 45 - 52) (14A/7)

1. Control Spring Internal End Float (Figure 45)

Screw the plunger into the yoke as shown in Figure 45, until all end float is eliminated and the spring is tight to turn by hand.

2. Control Spring External End Float (Figure 46)

Place the draft control lever in the fully lowered position. Fit the spring assembly into the lift cover, then tighten the retainer with tool MF. 163 as shown in Figure 46, until all end float is eliminated. Do not overtighten or end float will re-occur.

Secure the retainer by fitting the ball and socket screw to the lift cover, do not overtighten the socket screw, ($3\frac{1}{2}$ to $5\frac{1}{2}$ lb. ft. torque permissible).