

# MAJOR REPAIR KIT FOR SERVICING BENDIX HYDROVAC

Single Piston Hydrovacs—373853, 374000, 374070, 374550, 374750, 374980, 375100, 376862.

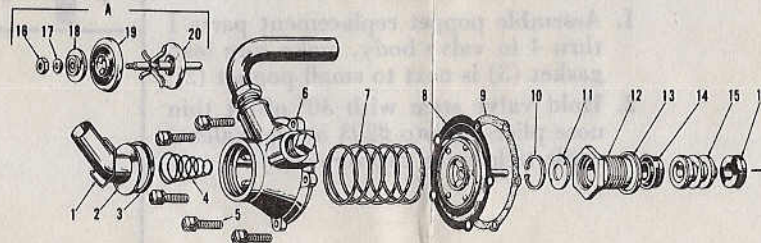
Guided Piston Hydrovacs—375278, 375279, 376710

## PARTS IDENTIFICATION

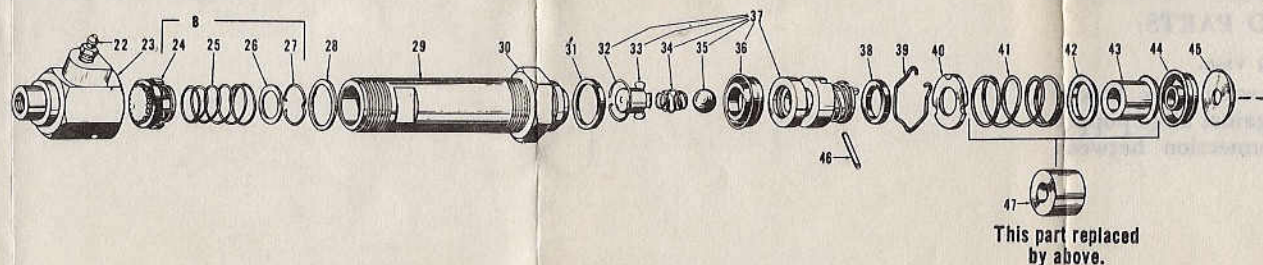
KEY NO.	PART NAME
1	SNAP RING—A.C. Tube & Cover
2	TUBE & COVER
3	GASKET—A.C. Tube & Cover
4	SPRING—Poppet Valve (Small)
5	SCREW & LOCKW.
6	HOUSING—Valve
7	SPRING—Valve Seat
8	DIAPHRAGM & PLATE
9	GASKET—Valve Body
10	RING—Retainer (Valve Piston Stop)
11	WASHER—Valve Piston Stop
12	FITTING—Hydraulic Valve Piston
13	SEAL—Hydraulic Valve Fitting
14	CUP—Hydraulic Valve Piston
15	PISTON—Hydraulic Valve
16	NUT—Valve Poppet
17	WASHER—Seal (Poppet Valve)
18	VALVE—Atmospheric Poppet (Small)
19	VALVE—Atmospheric Poppet (Large)
20	VACUUM POPPET & SHAFT
21	SEAL—End Plate (Rubber)
22	VALVE—Bleeder
23	CAP—End (Hydraulic Cyl. Tube)
24	VALVE—Residual Check
25	SPRING—Return (Residual Valve)
26	WASHER—Stop (Residual Valve)
27	SNAP RING (Residual Valve)
28	GASKET—Copper (End Cap)
29	CYLINDER—Tube
30	NUT—Check (Hyd. Cyl. Tube)
31	SEAL—Hydraulic Cyl. Tube Nut
32	SNAP RING (Hyd. Pis. Check Valve)
33	RETAINER—Ball (Hyd. Pis. Check Valve)
34	SPRING—Ret. (Hyd. Pis. Check Valve)
35	BALL (Hyd. Pis. Check Valve)
36	CUP—Hydraulic Piston
37	HYDRAULIC PISTON
38	SEAL—Rubber (Hyd. Cyl. End)
39	SNAP RING (Hyd. Pis. Stop Washer)
40	WASHER—Hyd. Pis. Stop
41	SPRING—Retainer (Push Rod)
42	WASHER—Expander (Push Rod)
43	RETAINER—Seal (Push Rod)
44	CUP—Hyd. Seal (Push Rod)
45	WASHER—Guide (Push Rod)
46	PIN—Retainer (Hyd. Pis.)
47	SPACER—Replace with parts (41), (42), & (43)

The Major Repair Kit contains the parts that are normally required for complete overhaul of a Hydrovac. For ease of installation the instructions are set up in Steps 1 through 5 with parts illustrated for identification and relationship to other parts in the Hydrovac. A complete Service Manual covering the Bendix Hydrovac is available upon request (See reverse side).

**STEP 1**—Clean all metal parts in Bendix Metalclene. After cleaning, wash all hydraulic system parts in clean alcohol before assembly. Inspect all parts for excessive wear or damage. Replace any questionable parts.



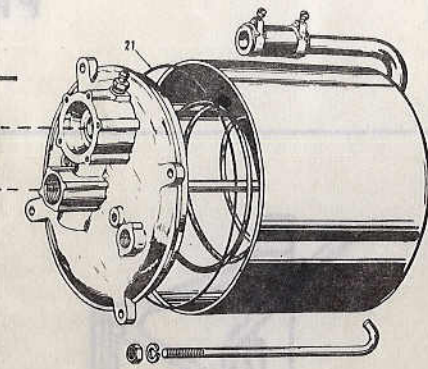
**STEP 2**—Assemble control valve parts 10 through 15, into end plate. Securely tighten fitting (12). On Hydrovacs with double atmosphere poppet, assemble group "A" parts in to housing (6) as a sub-assembly. For replacement of control valve poppets in other Hydrovacs, see reverse side. Attach remaining parts 1 through 9 to end plate.



**STEP 3**—Assemble new type stationary seal parts 39 through 45 into center bore of end plate. Discard stationary seal retainer (47). Assemble end seal (38) in against shoulder of end plate. Assemble hydraulic piston parts (32) through (37) as a sub-assembly. Assemble parts (23) through (31) as a sub-assembly. Securely tighten cylinder (29) into end cap (23). Note: Group "B" parts not used in all Hydrovacs.

**STEP 4**—Compress vacuum piston return spring so that push-rod projects from end plate. Hold spring compressed while attaching piston to push-rod with pin (46) and then guide cylinder over piston and thread cylinder into end plate. Align bleed screw in end cap with bleed screw in control valve and securely tighten check nut (30).

**STEP 5**—Release vacuum piston spring. Coat inside of vacuum cylinder with Bendix Vacuum Cylinder Oil and saturate cotton wicking and leather piston packing in oil. Place gasket (21) on end plate, insert vacuum piston in cylinder shell and assemble cylinder to end plate. Slide hose back in position on control tube. Note: If Hydrovac is to be stored for a prolonged period of time, it is recommended that stationary seal cup (44) be dipped in Bendix Assembly Fluid, Part No. 377854, before assembly into Hydrovac.



This part replaced by above.