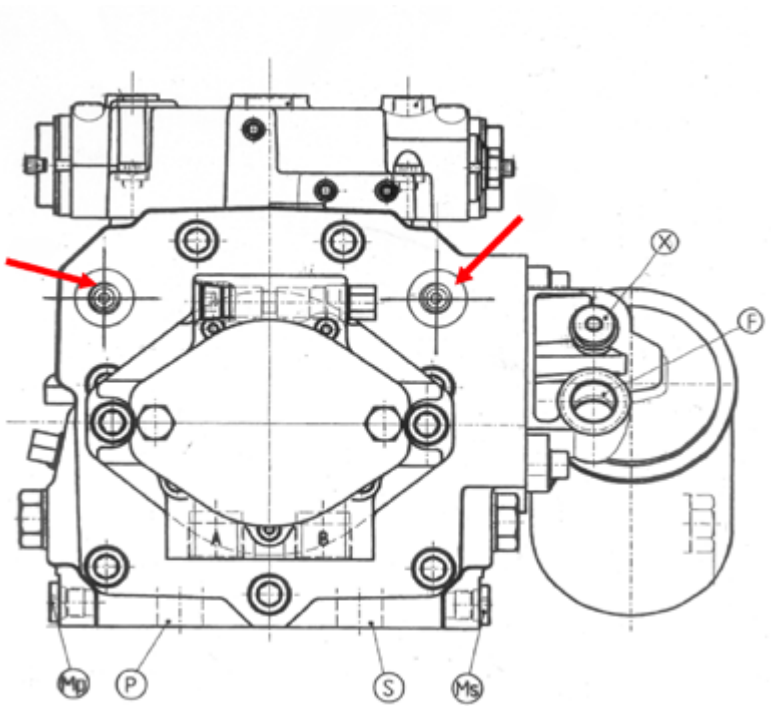
LIFCO HYDRAULICS INC

TECHNICAL ARTICLE
TA-LIF-003

LINDE HPV-02 TAPPED SERVO PORTS

Identification and Acceptance Criteria



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1) Document Summary:

This article identifies the different design versions of the tapped servo ports on the Linde HPV-02.

2) What are Servo Ports:

Servo ports or remote pressure compensation ports, are to remotely change the angle of the swash plate to neutral with hydraulic pressure.

3) The Problem:

The first version of tapped servo ports were machined on the rear surface of the rear cover. They were located here as it was the easiest machining, literally drilling straight into the servo chamber and port SAE. As time went on, Linde realized that these ports were not accessible with some of the thru drives.

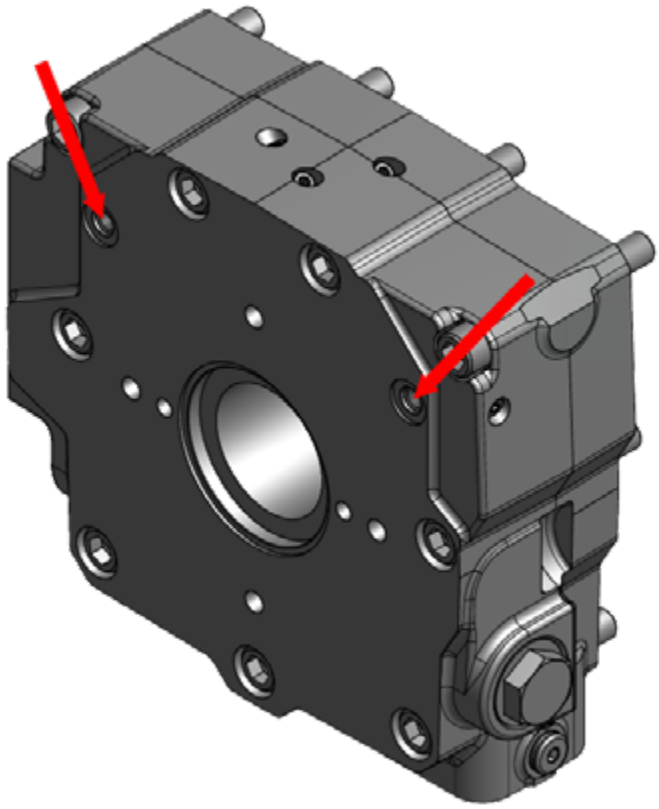


Figure 1 illustrates the tapped servo ports on the rear cover

4) Other Versions:

The next version of tapped servo ports were machined on the top surface of the rear cover. This was done to solve the thru drive interference problem. These ports are SAE.
On some OEM units both tapped servo ports are located on the side as shown in figure 2 below.

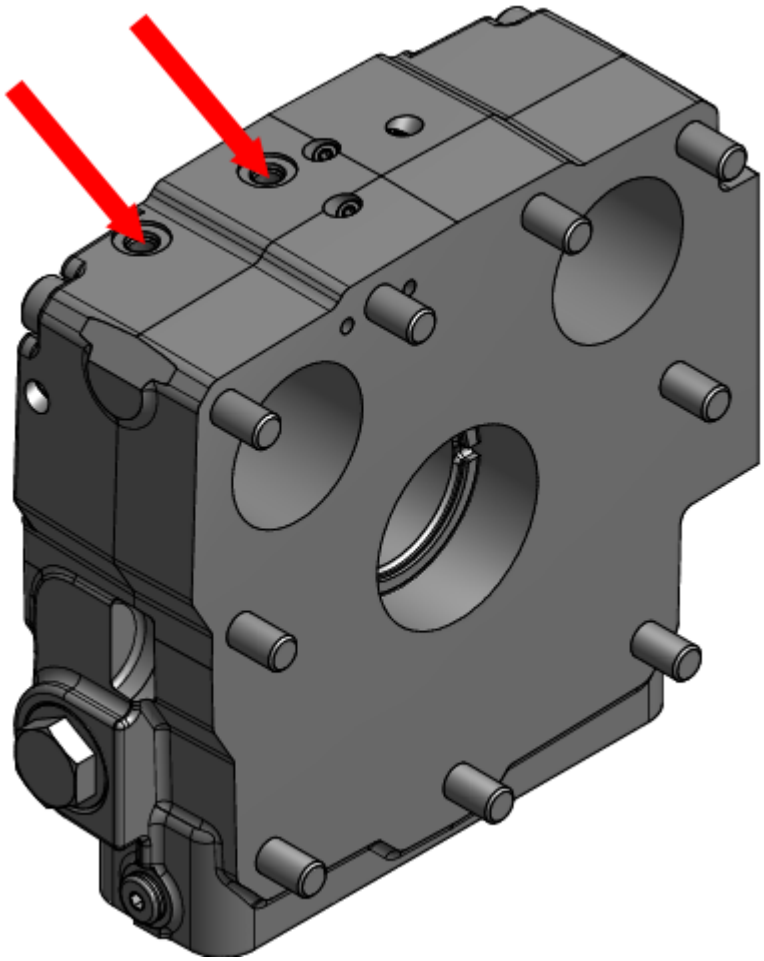


Figure 2 shows both tapped servo ports are located on the side

5) The Latest Version (at time of print):

Linde now offers a design which has the port on each side as shown in figure 3 below.

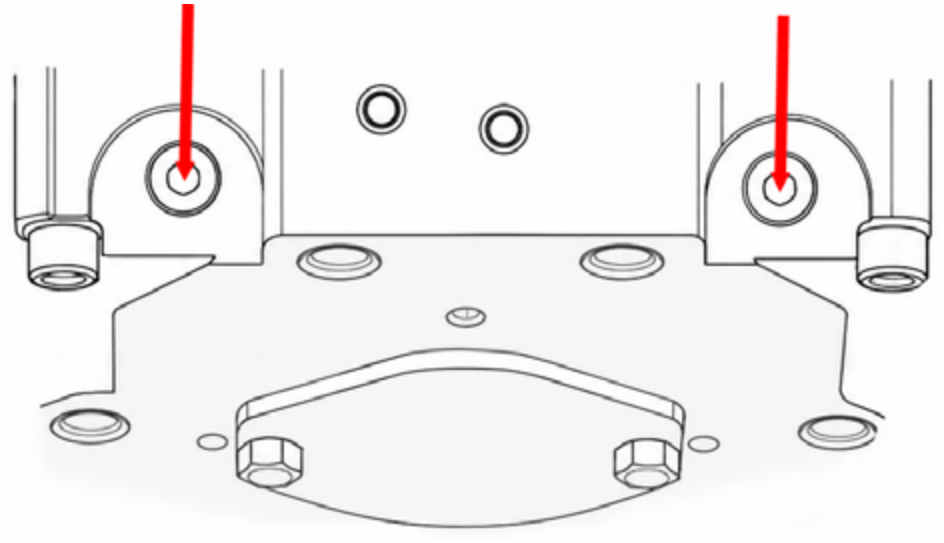


Figure 3 shows the current location of both tapped servo ports

6) When to contact Lifco Hydraulics:

If you still have questions or concerns about the ports or anything else on your unit.