



**Instructions 1013-A00 (En)**

Section	1013
Effective	July 2024
Replaces	New

Original instructions

# ***Bellows maintenance FLO series***



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Your distributor :

# 1. PUMPS FLO 6 - 8 - 11 - 15 - 25

## 1.1 Necessary tools

Press with capacity :

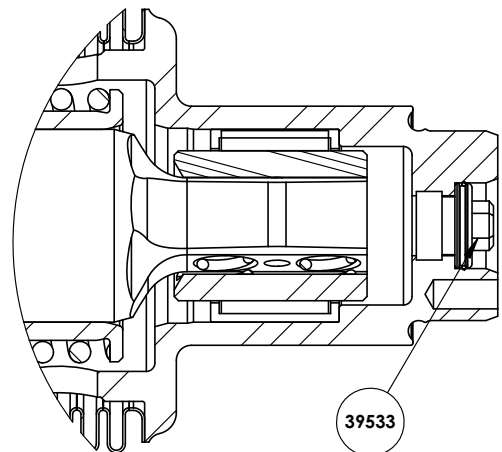
Pump	Minimum capacity (t)	Height under slider (mm)	Wrench for CHC screws
FLO 6- 8	1,5	700	M6
FLO 11 - 15	2,5	800	M10
FLO 25	2,8	900	M10

Screw 39533A supplied with the bellows is for single use.

The front cover, main body, set cylinder piston and their O-rings must be removed beforehand to access the transmission bellows (see Instructions of the pump).

Check and replace the O-rings if necessary.

Remove transmission plug 39533.

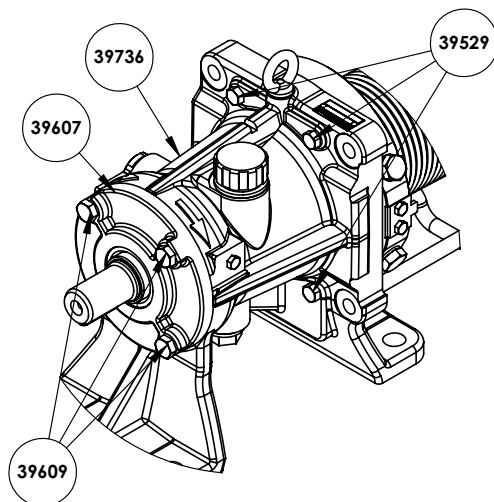


## 1.2 Disassembling the bellows

Drain the transmission oil (see Instructions of the pump).

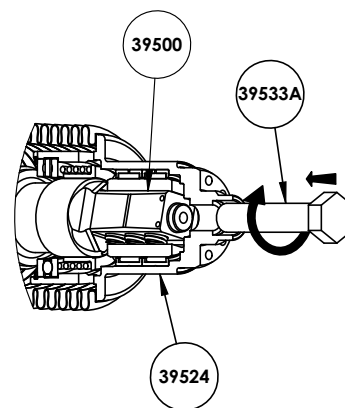
### Flo 6 - 8 - 11 - 15 :

Unscrew the 4 screws 39529 attached to the bearing housing 39736 and the 4 screws 39609 and then remove cover 39607.



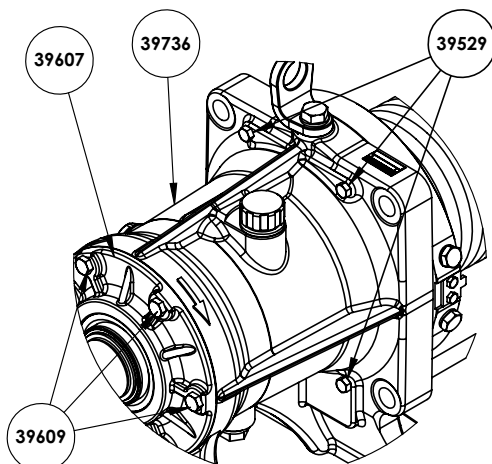
**It is imperative to grease the screw 39533A before use.**

Insert screw 39533A into the bellows hub assembly 39524 until it abuts transmission shaft 39500. Once in the abutment, screw until bellows assembly 39524 is removed from transmission shaft 39500.



### Flo 25 :

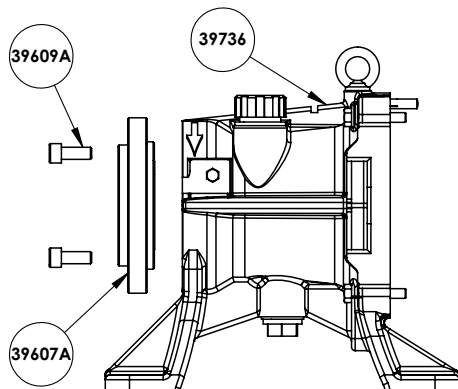
Unscrew the 4 screws 39529 attached to the bearing housing 39736 and the 6 screws 39609 and then remove cover 39607.



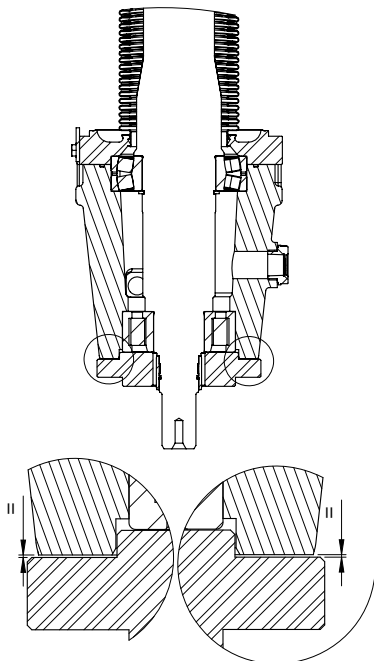
# 1. PUMPS FLO 6 - 8 - 11 - 15 - 25 (continued)

## 1.3 Assembly of the bellows

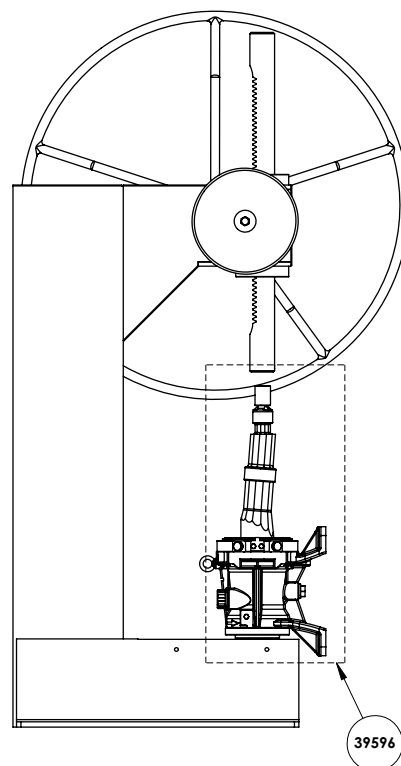
Assemble centering disc 39607A on bearing case 39736 with screws 39609A.



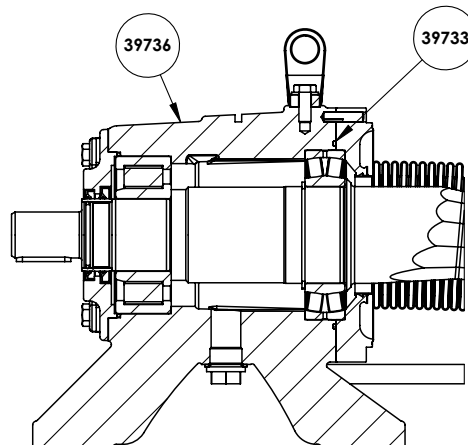
Make sure that there is equal clearance on both sides.



Place the entire transmission 39596 on the press.



Insert a new seal 39733 into the bearing housing 39736.



### Flo 6 - 8 :

Insert the bellows assembly 39524 on the transmission shaft 39500 by ensuring that the flange indexer groove of bellows assembly 39524 is aligned with bearing indexer groove 39736.

### Flo 11 - 15 - 25 :

Insert the bellows assembly 39524 into the transmission shaft 39500 by ensuring that the pin hole in the flange of bellows assembly 39524 is aligned with the pin hole in bearing 39736.

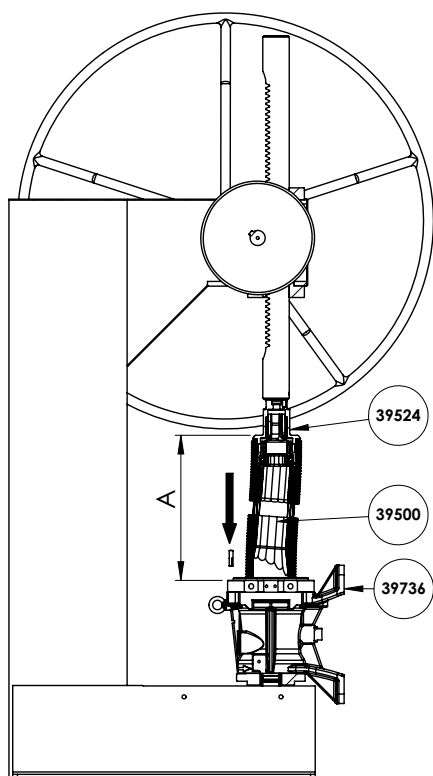
# 1. PUMPS FLO 6 - 8 - 11 - 15 - 25 (continued)

Flo 6 - 8 - 11 - 15 - 25 :

Place a guard on the nose of bellows hub assembly 39524 to avoid damaging it.

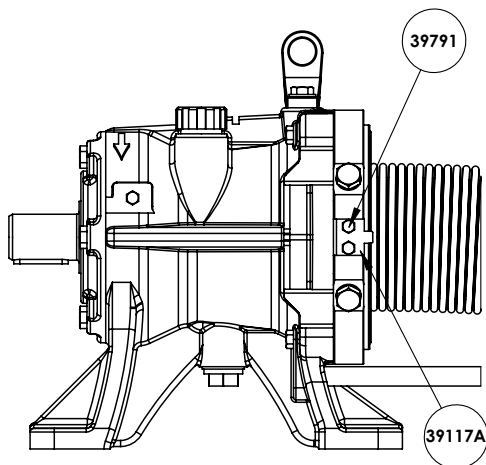
Then fit the bellows assembly hub 39524 so that there is a distance (A) between the hub face of bellows assembly 39524 and the flange face of bellows assembly 39524 :

Pump	Distance A
FLO 6- 8	228 ±1
FLO 11 - 15	299 ±1
FLO 25	320,4 ±1,2



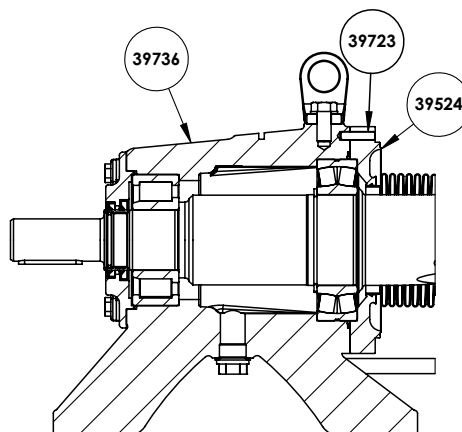
Flo 6 - 8 :

Position the indexer 39117A in its housing. Screw in screws 39791.

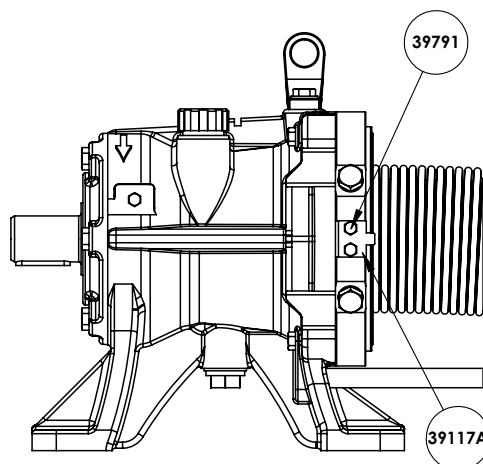


Flo 11 - 15 - 25

Fit the indexing pin 39723 onto flange of the bellows assembly 39524 and bearing 39736.

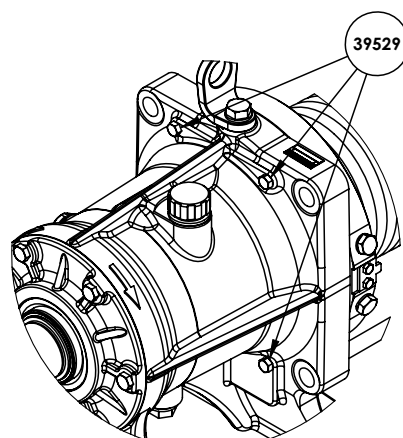


Position the indexer 39117A in its housing. Screw in screws 39791.



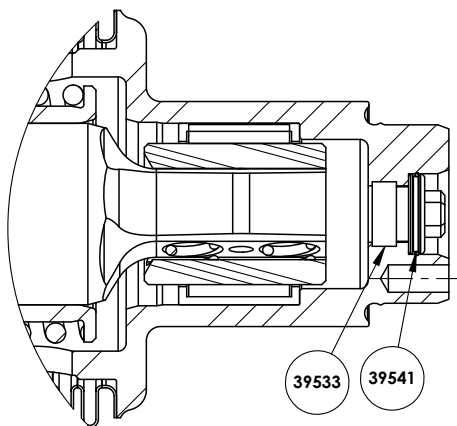
Tighten the 4 screws 39529. Tightening torque :

- FLO 6 - 8 ..... 4 N.m
- FLO 11 - 15 - 25 ..... 10 N.m

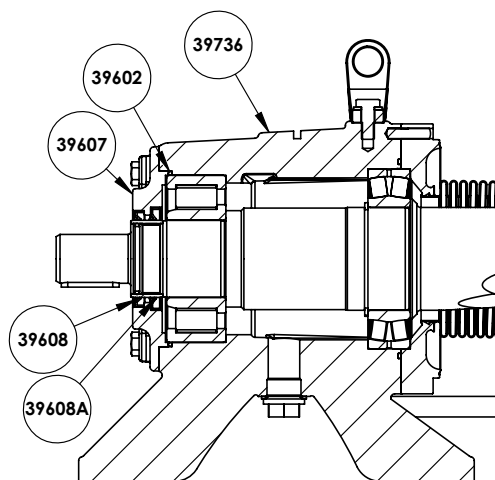


## 1. PUMPS FLO 6 - 8 - 11 - 15 - 25 (continued)

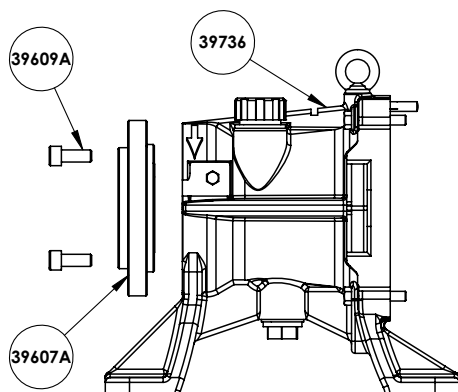
Screw in the plug 39533 and put a new seal 39541.



Insert a new seal 39602 into the bearing housing 39736 before inserting cover 39607 on bearing housing 39736, ensuring that the lips of seals 39608 and 39608A do not turn over.



Unscrew the screws 39609A to remove the centering disc 39607A from bearing housing 39736.



## 2. PUMPS FLO 40 - 50 - 65

### 2.1 Necessary tools

Torque wrench :

- FLO 40 . . . .M8 socket . . . .35 N.m
- FLO 50 . . . .M10 socket . . .35 N.m
- FLO 65 . . . .M12 socket . . .70 N.m

The threaded rod 39585A supplied with the bellows is single-use.

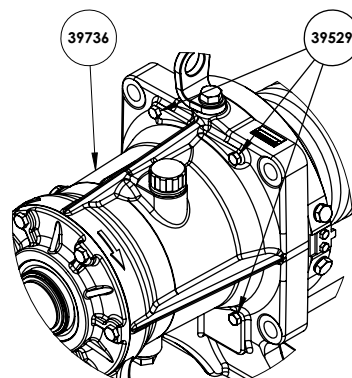
The front cover, main body, set cylinder piston and their O-rings must be removed beforehand to access the transmission bellows (see Instructions of the pump).

Check and replace the O-rings if necessary.

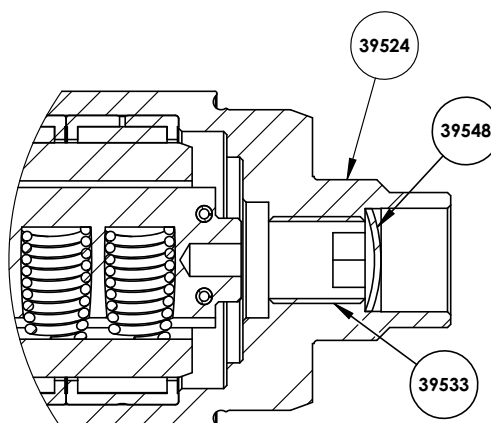
### 2.2 Disassembling the bellows

Drain the transmission oil (see Instructions of the pump).

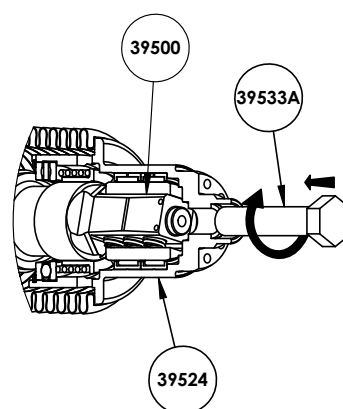
Unscrew the 4 screws 39529 fixed on bearing housing 39736.



Drill and remove disc 39548 and grub screw 39533 from bellows hub assembly 39524.



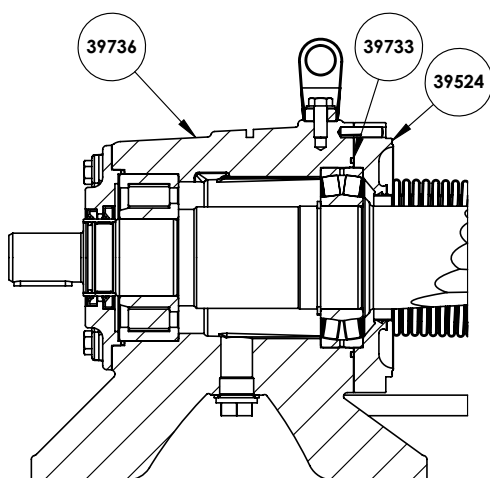
**It is mandatory to grease screw 39533A before disassembly.** Insert screw 39533A into the bellows hub assembly 39524 until it abuts against transmission shaft 39500. Once in the abutment, screw until bellows assembly 39524 is removed from transmission shaft 39500.



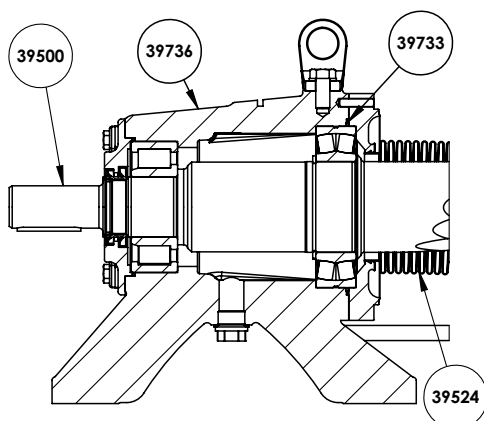
## 2. PUMPS FLO 40 - 50 - 65 (continued)

### 2.3 Assembly of the bellows

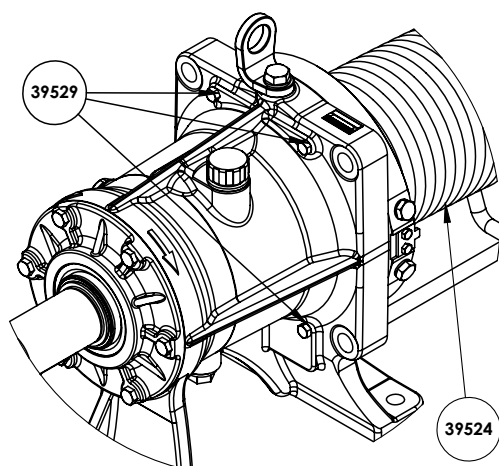
Replace seal 39733 before inserting the of bellows assembly flange 39524 onto bearing housing 39736.



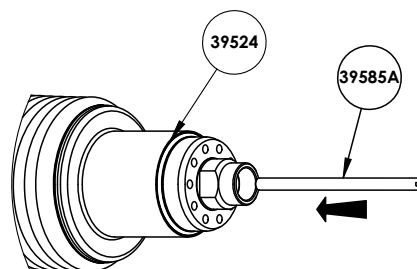
Ensure that seal 39733 is in place on bearing housing 39736. Insert the new bellows assembly 39524 onto transmission shaft 39500, ensuring that the pin hole in the flange of bellows assembly 39524 is aligned with the pin hole in bearing 39736.



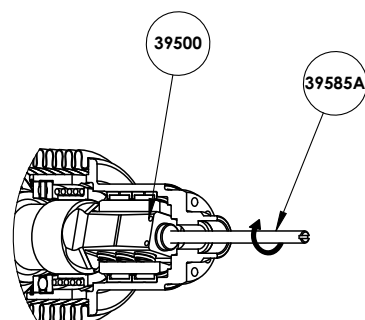
Partially screw in the 4 screws 39529 in order to block the rotation of bellows assembly 39524.



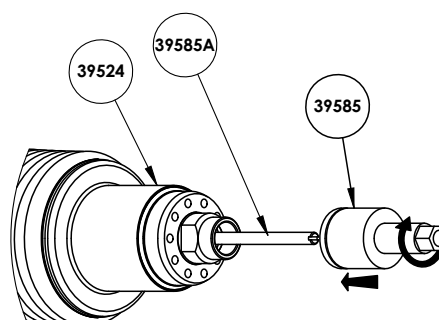
It is mandatory to grease threaded rod 39585A before assembly. Insert threaded rod 39585A through hub of bellows assembly 39524.



Screw threaded rod 39585A completely into shaft 39500.



Screw tool assembly 39585 onto threaded rod 39585A until it is in contact with the hub of bellows assembly 39524.



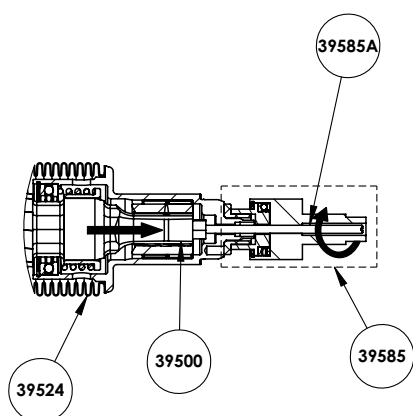
Screw the tool 39585 with a torque wrench to push the bellows assembly 39524 onto shaft 39500. When the torque wrench is triggered, the hub of bellows assembly 39524 is correctly mounted on shaft 39500. Remove tool assembly 39585 and threaded rod 39585A.

Torque wrench settings :

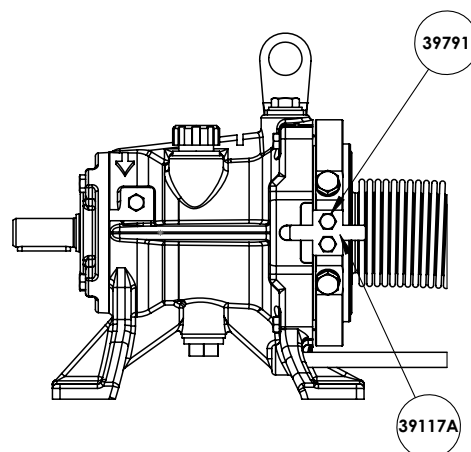
- FLO 40 .....28 ±2 N.m
- FLO 50 .....30,5 ±3 N.m
- FLO 65 .....64 ±6 N.m

## 2. PUMPS FLO 40 - 50 - 65 (continued)

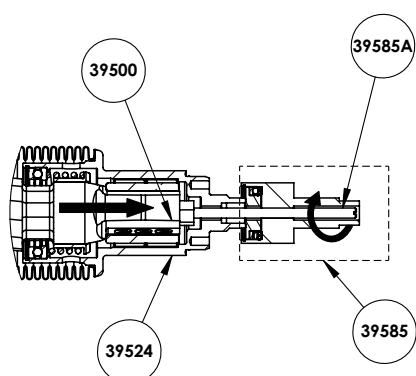
Flo 40



Position the indexer 39117A in its housing. Screw in screws 39791.

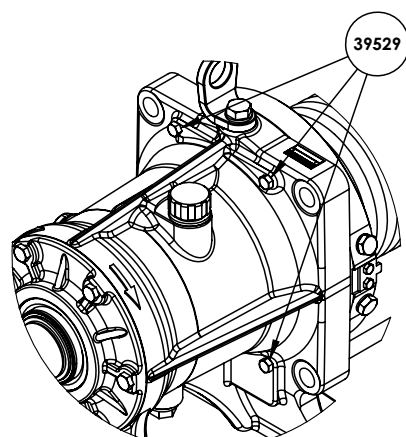


Flo 50

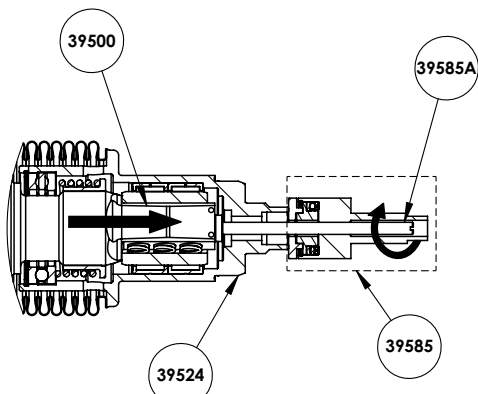


Tighten the 4 screws 39529. Tightening torque :

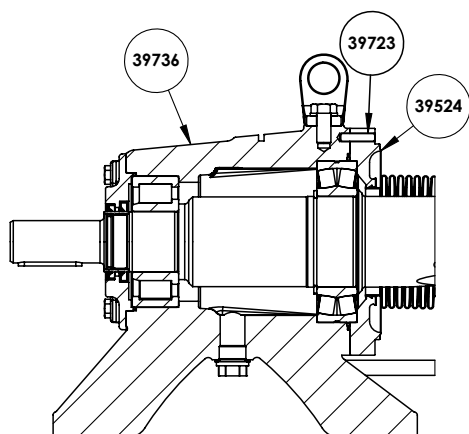
- FLO 40 - 50 .....  $10 \pm 1$  N.m
- FLO 65 .....  $13 \pm 1$  N.m



Flo 65



Fit the indexing pin 39723 onto flange of the bellows assembly 39524 and bearing housing 39736.



Screw grub screw 39533 into the hub of the bellows assembly 39524 and place disc 39548 on top.

