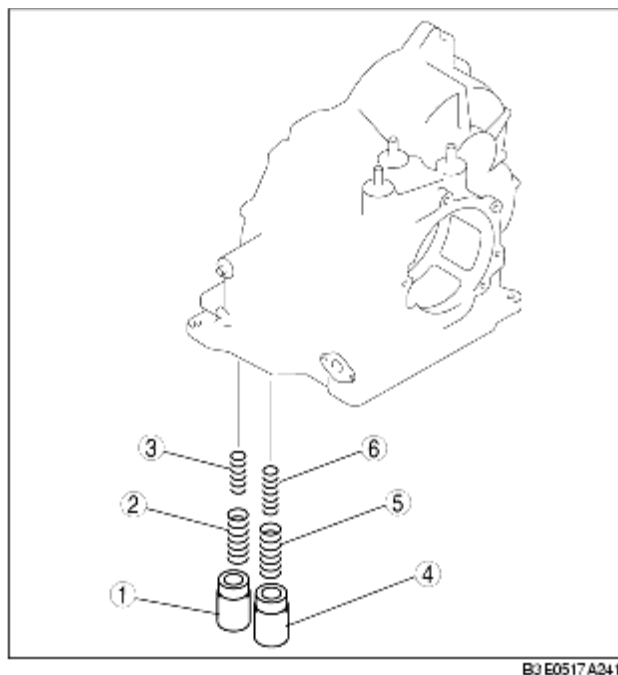


# ACCUMULATORS DISASSEMBLY/ASSEMBLY

B3E051719200A01

1. Disassemble in the order indicated in the table.
2. Assemble in the reverse order of disassembly.



1	Servo apply accumulator
2	Servo apply accumulator large spring
3	Servo apply accumulator small spring
4	Forward accumulator
5	Forward accumulator large spring
6	Forward accumulator small spring

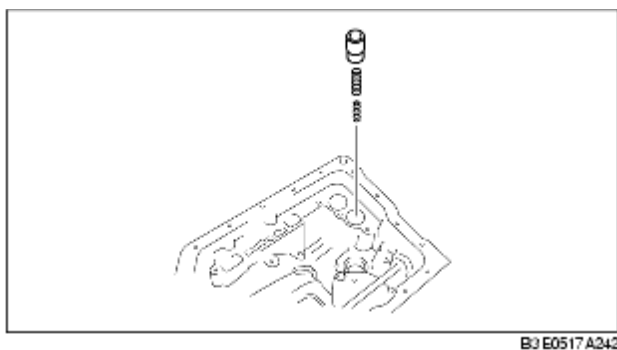
## Assembly Procedure

1. Measure the spring free length.

Spring	Outer diameter mm {in}	Free length mm {in}	No. of coils	Wire diameter mm {in}
Servo apply accumulator large spring	21.0 {0.827}	67.8 {2.669}	10.3	3.5 {0.138}
Servo apply accumulator small spring	13.0 {0.512}	67.8 {2.669}	17.1	2.2 {0.087}
Forward accumulator large spring	21.0 {0.827}	75.0 {2.953}	10.7	2.3 {0.091}
Forward accumulator small spring	15.6 {0.614}	49.0 {1.929}	7.7	2.4 {0.094}

- If not as specified, replace the spring.

2. Install the forward accumulator small spring, forward accumulator large spring and forward accumulator.



3. Install the servo apply accumulator small spring, servo apply accumulator large spring and servo apply accumulator.

