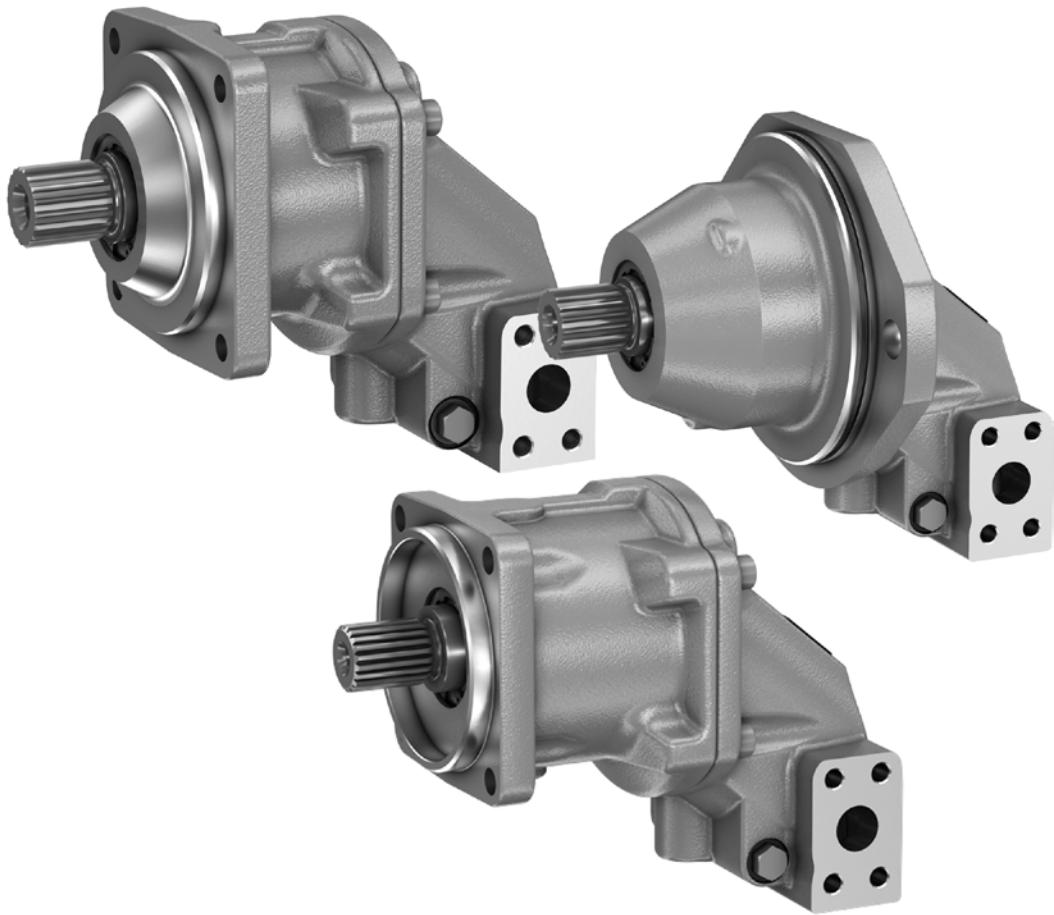


# Axial piston fixed motor A2FM/A2FE/ A2FMT

Series 70

**Instruction manual**  
**RE 91071-01-B/03.2019**





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# 1 About this documentation

## 1.1 Validity of the documentation

This documentation is valid for the following products:

- Axial piston fixed motor A2FM series 70 (standard version)
- Axial piston fixed motor A2FE series 70 (plug-in version)
- Axial piston fixed motor A2FMT series 70 (for drum drives)

This documentation is intended for machine/system manufacturers, assemblers and service engineers.

This documentation contains important information on the safe and proper transport, installation, commissioning, operation, maintenance, removal and simple troubleshooting of the axial piston unit.

- Read this documentation completely, in particular chapter 2 "Safety instructions" on page 8 and chapter 3 "General instructions on property damage and product damage" on page 14 before you start work with the axial piston unit.

## 1.2 Required and supplementary documentation

- Only commission the axial piston unit if the documentation marked with the book symbol  is available to you and you have understood and observed it.

**Table 1: Required and supplementary documentation**

Title	Document number	Document type
 <b>Order confirmation</b> Contains the order-related technical data of your A2FM, A2FE or A2FMT axial piston fixed motor.	-	Order confirmation
 <b>Installation drawing</b> Contains the outer dimensions, all connections and the hydraulic circuit diagram of your A2FM, A2FE or A2FMT axial piston fixed motor.	Please request the installation drawing from your contact at Bosch Rexroth.	Installation drawing
 <b>Axial piston fixed motor A2FM, axial piston plug-in motor A2FE series 70</b> Contains the permissible technical data, ports, main dimensions and circuit diagrams.	91071	Data sheet
 <b>Axial piston fixed motor A2FMT series 70</b> Contains the permissible technical data, ports, main dimensions and circuit diagrams.	91072	Data sheet
<b>DSM speed sensor series 10</b>	95132	Data sheet
<b>DSA speed sensor series 12</b>	95133	Data sheet
<b>Counterbalance valve BVD</b>	95522	Data sheet
 <b>Mineral oil-based hydraulic fluids and related hydrocarbons</b> Describes the requirements on a hydraulic fluid on mineral oil basis and related hydrocarbons for operation with Rexroth hydraulic components and assists you in selecting a hydraulic fluid for your hydraulic system.	90220	Data sheet
 <b>Environmentally acceptable hydraulic fluids</b> Describes the requirements on an environmentally acceptable hydraulic fluid for operation with Rexroth hydraulic components and assists you in selecting a hydraulic fluid for your hydraulic system.	90221	Data sheet
 <b>Bosch Rexroth Fluid Rating List for Rexroth hydraulic components (pumps and motors)</b> Contains the hydraulic fluids positively evaluated by Bosch Rexroth.	90245	Data sheet

**Table 1: Required and supplementary documentation**

Title	Document number	Document type
<b>Information on the use of hydrostatic drives at low temperatures</b> Contains additional information on the use of Rexroth axial piston units at low temperatures.	90300-03-B	Manual
<b>Storage and preservation of axial piston units</b> Contains additional information on storage and preservation.	90312	Data sheet

### 1.3 Representation of information

Uniform safety instructions, symbols, terms and abbreviations are used throughout this documentation to ensure safe and proper use of the product. For clarification, they are explained in the sections below.

#### 1.3.1 Safety instructions

This documentation contains safety instructions in chapter 2.6 "Product-specific safety instructions" on page 11 and in chapter 3 "General instructions on property damage and product damage" on page 14, as well as before a sequence of actions or an instruction for action involving a risk of personal injury or property damage. Always follow the measures for danger prevention associated with the use of this product.

Safety instructions are set out as follows:

<b>⚠ SIGNAL WORD</b>	
<b>Type and source of danger</b>	
Consequences of noncompliance	
▶ Danger prevention measures	

- **Warning sign:** draws attention to the danger
- **Signal word:** identifies the degree of the danger
- **Type and source of danger:** indicates the type and source of the danger
- **Consequences:** describes what occurs if safety instructions are disregarded
- **Precautions:** states how the danger can be avoided

**Table 2: Hazard classes as defined in ANSI Z535.6**

Warning sign, signal word	Meaning
<b>⚠ DANGER</b>	Identifies a dangerous situation that will result in death or serious injury if it is not avoided.
<b>⚠ WARNING</b>	Identifies a dangerous situation that may result in death or serious injury if it is not avoided.
<b>⚠ CAUTION</b>	Identifies a dangerous situation that may result in minor to moderate injury if it is not avoided.
<b>NOTICE</b>	Property damage: The product or surrounding area may be damaged.

### 1.3.2 Symbols

The following symbols indicate notices that are not safety-relevant but increase understanding of the documentation.

**Table 3: Meaning of symbols**

Symbol	Meaning
	If this information is disregarded, the product cannot be used and/or operated to its full extent.
►	Single, independent action
1.	Numbered instruction:
2.	The numbers indicate that the actions must be completed in order.
3.	

### 1.3.3 Designations

This documentation uses the following designations:

**Table 4: Designations**

Designation	Meaning
A2FM	Axial piston fixed motor in standard version, open and closed circuit
A2FE	Axial piston fixed motor in plug-in version, open and closed circuit
A2FMT	Axial piston fixed motor, closed circuit, for use in concrete mixer trucks
Threaded plug	Metal screw, pressure-resistant
Protective plug	Made out of plastic, not pressure-resistant, only for transportation

As a generic term for the "axial piston fixed motor A2FM" and "axial piston plug-in motor A2FE" or "axial piston fixed motor A2FMT", the designation "axial piston unit" will be used in the following.

### 1.3.4 Abbreviations

This documentation uses the following abbreviations:

**Table 5: Abbreviations**

Abbreviation	Meaning
ATEX	EC directive on explosion protection ( <a href="#">Atmosphère explosive</a> )
DIN	Deutsches Institut für Normung (German Institute for Standardization)
ISO	International Organization for Standardization
JIS	Japan Industrial Standard
RE	Rexroth document in the English language
VDI 2230	Standard for systematically calculating heavy-duty threaded connections and cylindrical screwed connections from the VDI ( <a href="#">Verein Deutscher Ingenieure – Association of German Engineers</a> )

## 2 Safety instructions

### 2.1 About this chapter

The axial piston unit has been manufactured to generally accepted engineering standards. There is still, however, a risk of personal injury or property damage if this chapter and the safety instructions in this documentation are not observed.

- ▶ Read this documentation completely and thoroughly before working with the axial piston unit.
- ▶ Keep this documentation in a location where it is accessible to all users at all times.
- ▶ Always include the required documentation when you pass the axial piston unit on to third parties.

### 2.2 Intended use

Axial piston units are hydraulic components, meaning that in their application area they are classified neither as complete nor as partly completed machinery as defined in the EC Machinery Directive 2006/42/EC. The component is exclusively intended to form partly completed machinery or complete machinery together with other components. The component should only be commissioned after it has been installed in the machine/system for which it is intended and the safety of the entire system has been established in accordance with the Machinery Directive.

This product is intended for the following use:

The A2FM and A2FE axial piston units are only approved as hydraulic motors in hydrostatic drives.

The A2FMT axial piston unit is only approved as a hydraulic motor for hydrostatic drum drives in a closed circuit in concrete mixer trucks.

- ▶ Observe the technical data, the application and operating conditions, and the performance limits as specified in data sheet 91071 or 91072 and in the order confirmation. Information about approved hydraulic fluids can be found in data sheet 91071 and 91072.

The axial piston unit is only intended for commercial use and not for private use.

Intended use includes having fully read and understood this documentation, especially chapter 2 "Safety instructions" on page 8.

### 2.3 Improper use

Any use other than that described as intended use is considered improper.

Bosch Rexroth AG is not liable for damages resulting from improper use. The user is solely responsible for any risks arising from improper use.

The following foreseeable forms of faulty usage are also considered improper (this list is not exhaustive):

- Use outside the operating parameters approved in the data sheet or in the order confirmation (unless specifically approved by the customer)
- Use of non-approved fluids, e.g. water or polyurethane components
- Changes to factory settings by unauthorized persons.
- Use of assembled parts (e.g. control unit, valves) not in combination with the specified Rexroth components

- Use of the axial piston unit with assembled parts under water at a depth of more than 10 meters without the necessary additional measures, e.g. pressure equalization. Units with electrical components (e.g. sensors) generally cannot come into contact with water.
- Use of the axial piston unit under a continuous pressure differential between housing and ambient pressure greater than 2 bar, with the ambient pressure always lower than the case pressure. Momentary ( $t < 0.1$  s) pressure peaks of up to 10 bar are allowed. Beyond this, the maximum permissible case pressure specified in the data sheet should not be exceeded.
- Use of the axial piston unit in explosive environments unless the component or machine/system has been certified as compliant with the ATEX Directive 2014/34/EU
- Use of the axial piston unit in a corrosive atmosphere
- Use of the axial piston unit in aircraft or spacecraft

## 2.4 Personnel qualifications

The activities described in this documentation require a basic understanding of mechanics, electricity and hydraulics, as well as familiarity with associated technical terms. For transporting and handling the product, knowledge regarding the use of lifting devices and lifting accessories is required. In order to ensure safe use, these activities should only be performed by skilled personnel or an instructed person under the direction and supervision of skilled personnel.

Skilled personnel refers to persons who possess the professional training, knowledge and experience, as well as the understanding of the regulations relevant to the work to be done that are necessary to recognize possible dangers and take the appropriate safety measures. Skilled personnel must follow the rules relevant to their field and have the necessary hydraulic expert knowledge.

Hydraulic expert knowledge includes:

- Being able to read and fully understand hydraulic circuit diagrams
- In particular, fully understanding the relationships with regard to safety devices
- comprising of knowledge regarding the function and layout of hydraulic components.



Bosch Rexroth offers you measures supporting training in specific areas.  
You can find an overview of the training contents on the Internet

## 2.5 General safety instructions

- Observe applicable accident prevention and environmental protection regulations.
- Observe the safety regulations of the country in which the product is used/operated.
- Use Rexroth products only when they are in good working order.
- Observe all notices on the product.
- Do not install, operate, remove or maintain Rexroth products if under the influence of alcohol, drugs or medication that may affect your reaction time.
- Only use genuine Rexroth accessories and spare parts to ensure there is no hazard to persons from unsuitable spare parts.
- Observe the technical data and ambient conditions specified in the product documentation.
- If unsuitable products are installed or used in applications that are of relevance to safety, unexpected operating conditions may occur in the application, which could result in personal injury or property damage. For this reason, only use the product in safety-relevant applications if this use is expressly indicated and approved in the product documentation, e.g. in explosion protection applications or in safety-related parts of a control system (functional safety).
- Only commission the product if it has been determined that the end product (e.g. machinery or system) in which the Rexroth products are installed complies with the country-specific provisions, safety regulations and standards for the application.
- Use tools appropriate for the work being performed and wear appropriate protective clothing to prevent punctures and cuts (e.g. when removing protective covers, disassembly).
- There is a risk of entanglement when operating the axial piston unit with a bare shaft end. Check whether or not your machine requires additional safety measures for your application. If necessary, make sure these are properly implemented.

## 2.6 Product-specific safety instructions

The following safety instructions apply to chapters 6 to 14.

### **WARNING**

#### **Danger from excessive pressure!**

Danger to life, risk of injury or property damage!

Improperly changing the factory pressure settings can result in a pressure increase beyond the max. permissible pressure.

Operating the unit above the max. permissible pressure can cause components to burst and hydraulic fluid to escape under high pressure.

- ▶ Changes to the factory settings may only be made by Bosch Rexroth specialists.
- ▶ In addition, a pressure relief valve is required in the hydraulic system as a back-up. If the axial piston unit is equipped with a pressure cut-off and/or pressure controller, this is not an adequate safeguard against pressure overload.

#### **Danger due to suspended loads!**

Danger to life, risk of injury or property damage!

Improper transportation may cause the axial piston unit to fall down and lead to injury, e.g. crushing or fracture, or damage to the product.

- ▶ Make sure that the load bearing capacity of the lifting device is sufficient to safely bear the weight of the axial piston unit.
- ▶ Never step or grip under suspended loads.
- ▶ Ensure a stable transport position.
- ▶ Use your personal protective equipment (e.g. safety goggles, safety gloves, suitable working clothes, safety shoes).
- ▶ Use suitable lifting devices for transport.
- ▶ Observe the prescribed position of the lifting strap.
- ▶ Observe the national laws and specifications of occupational safety and health and transport.

#### **System/machine under pressure!**

Risk of death or serious injury when working on unsecured machines/systems!

Property damage!

- ▶ Switch off the entire system and secure it against reactivation according to the parameters provided by the machine/system manufacturer.
- ▶ Ensure that all relevant components of the hydraulic system are depressurized. For this purpose, observe the parameters indicated by the machine/system manufacturer.
- ▶ Please note that the hydraulic system might still be pressurized even after separation from the actual pressure supply.
- ▶ Do not disconnect any line connections, ports or components as long as the hydraulic system is under pressure.

## ⚠ WARNING

### **Escaping hydraulic fluid mist!**

Risk of explosion and fire hazard, health hazard, risk of environmental pollution!

- ▶ Depressurize the relevant machine/system component and repair the leak.
- ▶ Only perform welding work when the machine/system is depressurized.
- ▶ Keep open flames and ignition sources away from the axial piston unit.
- ▶ If axial piston units are located in the vicinity of ignition sources or powerful thermal radiators, a shield must be erected to ensure any escaping hydraulic fluid cannot be ignited, and to protect hose lines from premature aging.

### **Electrical voltage!**

Risk of injury from electric shock or risk of property damage!

- ▶ Always disconnect the voltage supply to the relevant machine/system part before installing the product and/or connecting or disconnecting the connector. Protect the machine/system against being re-energized.

### **Limitation of load-holding function in lifting winches!**

Risk of injury or property damage!

Moving parts in high-pressure relief valves may in certain circumstances become stuck in an undefined position due to contamination (e.g. impure hydraulic fluid).

This can result in restriction or loss of load-holding functions in lifting winches.

- ▶ Check whether the application on your machine requires additional safety measures in order to keep the load in a safe position.
- ▶ If necessary, make sure these are properly implemented.

## ⚠ CAUTION

### **High noise development during operation!**

Danger of hearing damage or hearing loss!

The noise emission of axial piston units depends on rotational speed, working pressure and installation conditions, among other factors. The sound pressure level may rise above 70 dB (A) in certain application conditions.

- ▶ Always wear hearing protection near a running axial piston unit.

### **Hot surfaces on axial piston unit!**

Risk of burning!

- ▶ Allow the axial piston unit to cool down sufficiently before touching it.
- ▶ Protect yourself with heat-resistant protective clothing, e.g. gloves.

## CAUTION

### **Inappropriate routing of cables and lines!**

Risk of stumbling and property damage! Improper routing of cables and lines can cause a risk of stumbling as well as damage to equipment and components, e.g. due to lines and connectors being torn off.

- ▶ Always install cables and lines in a way that nobody can fall over them, that they are not bend or twisted, do not chafe on edges and are not guided through ducts with sharp edges without sufficient protection.

### **Contact with hydraulic fluid!**

Danger to health / damage to health, e.g. eye injury, skin damage, intoxication in the event of inhalation!

- ▶ Avoid any contact with hydraulic fluids.
- ▶ When handling hydraulic fluids, the safety instructions of the lubricant manufacturer need to be observed at all times.
- ▶ Use your personal protective equipment (e.g. safety goggles, safety gloves, suitable working clothes, safety shoes).
- ▶ Immediately seek medical attention, however, if hydraulic fluid gets into your eyes or blood circuit or if you swallow it accidentally.

### **Escaping hydraulic fluid through leaking machine/system components!**

Risk of burning and injury due to escaping hydraulic fluid jet!

- ▶ Depressurize the relevant machine/system component and repair the leak.
- ▶ Never attempt to block or seal the leak or hydraulic fluid jet with a cloth.

### **Danger from improper handling!**

Slip hazard! Risk of slipping on wet surfaces when climbing on the axial piston unit.

- ▶ Never grab or climb onto the axial piston unit.
- ▶ Check how to safely get on top of the machine/system.

## **2.7 Personal protective equipment**

Personal protective equipment is the responsibility of the user of the axial piston unit. Observe the safety regulations in your country.

All pieces of personal protective equipment should be intact.

### 3 General instructions on property damage and product damage

The following instructions apply to chapters 6 to 14.

#### **NOTICE**

##### **Danger from improper handling!**

Product can be damaged!

- ▶ Do not subject the product to improper mechanical loads.
- ▶ Never use the product as handle or step.
- ▶ Do not put/place any objects on the product.
- ▶ Do not strike the drive shaft of the axial piston unit.
- ▶ Do not set/place the axial piston unit on the drive shaft or assembled parts.
- ▶ Do not strike assembled parts (e.g. sensors or valves).
- ▶ Do not hit sealing surfaces (e.g. on the work connections).
- ▶ Leave the protective covers on the axial piston unit until you connect the lines.
- ▶ Disconnect all electrical connectors before arc welding or painting.
- ▶ Ensure that the electronic components (e.g. sensors) are not electro-statically charged (e.g. during painting operations).

##### **Risk of property damage due to inadequate lubrication!**

Product can be damaged or destroyed!

- ▶ Never operate the axial piston unit with insufficient hydraulic fluid. Specifically, make sure that the rotary group has sufficient lubrication.
- ▶ When commissioning a machine/system, make sure that the housing area and the working lines of the axial piston unit are filled with hydraulic fluid and remain filled during operation. Avoid air inclusions in the forward drive shaft bearing, especially with the axial piston unit installed with the drive shaft up.
- ▶ Check the hydraulic fluid level in the housing area regularly and recommission, if necessary. For above-reservoir installation, the housing area may drain out through the drain line after prolonged standstill periods (air enters through the shaft seal) or through the working line (gap leakage). This means the bearings are insufficiently lubricated when the system is turned on.

##### **Mixing hydraulic fluids!**

Product can be damaged!

- ▶ Before installation, remove all fluids from the axial piston unit to prevent mixing with the hydraulic fluid used in the machine/system.
- ▶ Any mixture of hydraulic fluids of different manufacturers and/or different types of the same manufacturer is generally not permissible.

## **NOTICE**

### **Contamination of hydraulic fluid!**

The cleanliness of the hydraulic fluid impacts the service life of the axial piston unit. Contamination of the hydraulic fluid may lead to premature wear and malfunctions!

- ▶ Always ensure a work environment in the assembly location that is free from dust and foreign particles to prevent foreign particles, e.g. welding beads or metal cuttings, from entering the hydraulic lines and lead to wear and malfunctions in the product. The axial piston unit should be clean when installed.
- ▶ Only use clean ports, hydraulic lines and assembled parts (e.g. measuring devices).
- ▶ When plugging the ports, no contamination may ingress.
- ▶ Before commissioning, ensure that all hydraulic connections are tight and that all seals and plugs of the plug-in connection are correctly installed and undamaged to prevent fluids and foreign particles from entering the product.
- ▶ Use a suitable filter system to filter hydraulic fluid during filling to minimize solid particle contamination and water in the hydraulic system.

### **Improper cleaning**

Product can be damaged!

- ▶ Close all openings with appropriate protective covers in order to prevent cleaning agents from entering the hydraulic system.
- ▶ Never use solvents or aggressive cleaning agents. Use only water and, if necessary, a mild cleaning agent to clean the axial piston unit.
- ▶ Do not point a high-pressure cleaner at sensitive components, e.g. shaft seal, electrical connections and components.
- ▶ Use fiber-free cleaning cloths for cleaning.

### **Environmental pollution due to incorrect disposal!**

Careless disposal of the axial piston unit and its assembled parts, the hydraulic fluid and the packaging material can cause environmental pollution!

- ▶ Dispose of the axial piston unit, hydraulic fluid and packaging in accordance with the regulations in your country.
- ▶ Dispose of the hydraulic fluid in accordance with the applicable safety data sheet of the hydraulic fluid.

### **Danger due to chemical or aggressive environmental conditions!**

Product can be damaged! If the axial piston unit is exposed to chemical or corrosive environmental conditions, such as sea water, fertilizer or road salt, it can result in corrosion or, in extreme cases, malfunction. Leaks may lead to a leakage of hydraulic fluid.

- ▶ Take appropriate measures to protect the axial piston unit from chemical or corrosive environmental conditions.

## NOTICE

### **Leakage or spilling of hydraulic fluid!**

Environmental pollution and contamination of the ground water!

- ▶ Always place a drip tray under the axial piston unit when filling in and draining the hydraulic fluid.
- ▶ Use a suitable binding agent if hydraulic fluid is spilled.
- ▶ Observe the safety data sheet for the hydraulic fluid and the specifications provided by the system manufacturer.

### **Danger due to heat development in components!**

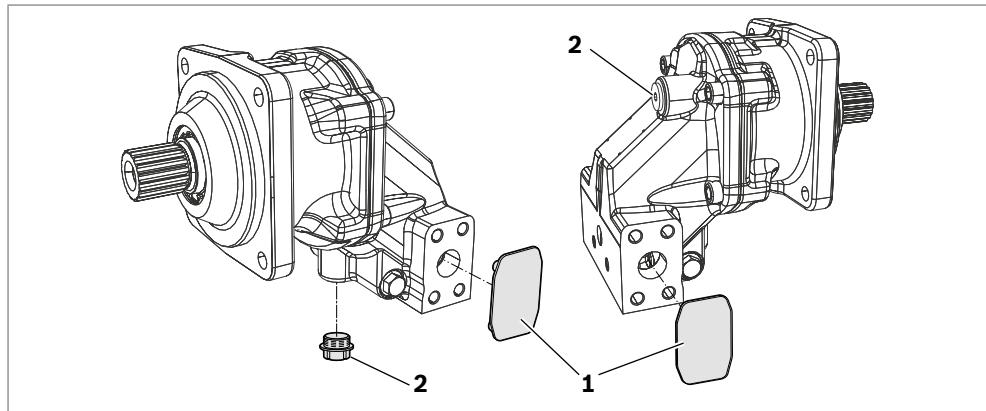
Adjacent products may be damaged! Due to a heat development in components (e.g. solenoids), adjacent products may be damaged during assembly if no sufficient safety distance is complied with.

- ▶ When installing the axial piston unit, check the safety distances to nearby products to ensure that they are not damaged.

The warranty exclusively applies to the delivered configuration.

The warranty will be voided if the product is incorrectly installed, commissioned or operated, or if it is used or handled improperly.

## 4 Scope of delivery



**Fig. 1: Axial piston unit**

Included in the scope of delivery:

- Axial piston unit as per order confirmation

The following parts come assembled on the unit:

- Protective covers (1)
- Protective plug/threaded plugs (2)

## 5 About this product

### 5.1 Performance description

An axial piston fixed motor converts hydrostatic flow into mechanical rotation.

It is designed for mobile and stationary applications.

Refer to data sheets 91071 and 91072, and the order confirmation for the technical data, operating conditions and operating limits of the axial piston unit.

### 5.2 Product description

The fixed motor is available in the A2FM standard version and the A2FE plug-in version. The A2FM/A2FE is a fixed motor with an axial tapered piston rotary group with a bent-axis design for hydrostatic drives in open and closed circuits. The A2FMT is a fixed motor with an axial tapered piston rotary group with a bent-axis design for closed-circuit hydrostatic drum drives in concrete mixer trucks. In axial piston units with a bent-axis design, the pistons (2) are arranged at an angle to the drive shaft (1). The pistons rest directly on the drive shaft where they generate torque depending on the pressure.

**Open circuit** In an open circuit, the hydraulic fluid flows from the reservoir to the hydraulic pump, where it is transported to the hydraulic motor. The hydraulic fluid flows from the hydraulic motor directly back to the reservoir. The output direction the hydraulic motor can be changed with a directional valve.

**Closed circuit** In the closed circuit, the hydraulic fluid flows from the hydraulic pump to the hydraulic motor, then directly back to the hydraulic pump. The output direction of rotation of the hydraulic motor is changed, e.g., by reversing the flow direction in the hydraulic pump.

#### 5.2.1 Axial piston unit layout

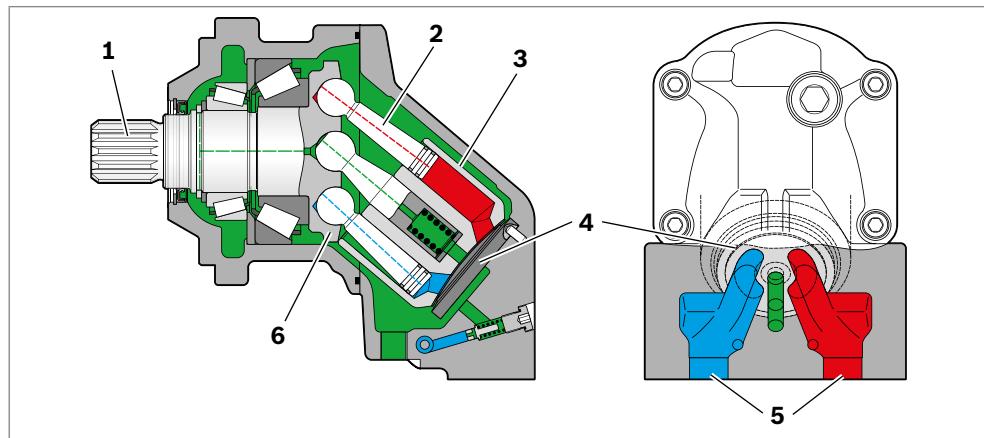


Fig. 2: Series 70 A2FM layout

**1** Drive shaft  
**2** Piston

**3** Cylinder  
**4** Control plate

**5** Working ports  
**6** Drive shaft flange

### 5.2.2 Functional description

#### Motor function

A hydraulic motor converts hydrostatic energy into mechanical energy. Hydraulic fluid is fed to the cylinder bores through the working ports (5) and the control plate (4). The pistons (2) in the cylinder bores complete a stroke that is converted into rotary movement by the pistons on the drive shaft flange (6). During this process, the pistons move the cylinder (3) and generate output torque on the drive shaft. This output torque increases with the pressure difference between the high-pressure and low-pressure sides. The output speed is proportional to the inward flow and inversely proportional to the displacement of the hydraulic motor.

### 5.3 Product identification

The axial piston unit can be identified by the name plate. The following example shows an A2FM name plate:

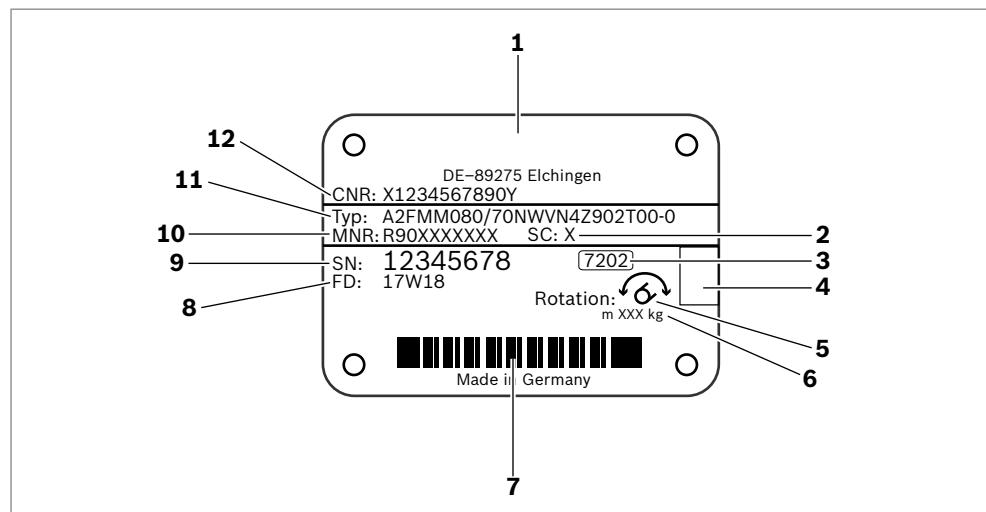


Fig. 3: Name plate A2FM

<b>1</b> Manufacturer	<b>7</b> Bar code
<b>2</b> Sample category (optional)	<b>8</b> Manufacturing date
<b>3</b> Internal plant designation	<b>9</b> Serial number
<b>4</b> Designated area for inspection stamp	<b>10</b> Material number of the axial
<b>5</b> Direction of rotation (viewed on	piston unit
drive shaft) – here: bi-directional	
<b>6</b> Weight (optional)	<b>11</b> Type code
	<b>12</b> Customer material number

## 6 Transport and storage

- Always observe the necessary ambient conditions for transport and storage; see chapter 6.2 "Storing the axial piston unit" on page 22.



Information on unpacking can be found in chapter 7.1 "Unpacking" on page 25.

### 6.1 Transporting the axial piston unit

The following transportation options are available depending on weight and duration of transport:

- Transport by hand
- Transporting with a lifting device (eye bolt or lifting strap)

#### Dimensions and weights

**Table 6: Dimensions and weights A2FMN/A2FEN**  
Nominal pressure 300 bar, maximum pressure 350 bar

Size	28	32	37	45	56	63	80	90	107
Weight	kg	10.8	10.8	10.8	10.8	17	17	17	23
Width	mm	Dimensions vary by equipment. The values applicable for your axial piston unit can be found in the installation drawing (request if necessary).							
Height	mm								
Depth	mm								

**Table 7: Dimensions and weights A2FMM/A2FEM**  
Nominal pressure 400 bar, maximum pressure 450 bar

Size	23	28	32	45	56	63	80	90	107	125
Weight	kg	10.8	10.8	10.8	17	17	17	23	23	33
Width	mm	Dimensions vary by equipment. The values applicable for your axial piston unit can be found in the installation drawing (request if necessary).								
Height	mm									
Depth	mm									

**Table 8: Dimensions and weights A2FMH/A2FEH**  
Nominal pressure 450 bar, maximum pressure 500 bar

Size	45	56	63	80	90	107	125
Weight	kg	17	17	17	23	23	33
Width	mm	Dimensions vary by equipment. The values applicable for your axial piston unit can be found in the installation drawing (request if necessary).					
Height	mm						
Depth	mm						

**Table 9: Dimensions and weights A2FMT**  
Maximum pressure 420 bar

Size	56	63	80	90	107
Weight	kg	17	17	17	23
Width	mm	Dimensions vary by equipment. The values applicable for your axial piston unit can be found in the installation drawing (request if necessary).			
Height	mm				
Depth	mm				

Weight may vary by equipment.

### 6.1.1 Transport by hand

Up to a specific maximum weight, axial piston units can be transported by hand for a short distance. Observe the national regulations in your country. To prevent health damage, we recommend renouncing any transport by hand.

**CAUTION!** Risk of injury due to heavy loads!

Health hazard from carrying axial piston units.

- ▶ Only manually transport the axial piston unit for a short period of time. Observe the national regulations in your country for manual transport.
- ▶ Always use appropriate lifting, lowering and moving techniques.
- ▶ Use your personal protective equipment (e.g. safety goggles, safety gloves, suitable working clothes, safety shoes).
- ▶ Do not transport the axial piston unit by sensitive assembled parts (e.g. sensors or valves).
- ▶ Carefully place the axial piston unit on the seating to prevent it from being damaged.

### 6.1.2 Transport with lifting devices

For transporting, the axial piston unit can be connected to a lifting device via an eye bolt or a lifting strap.

#### Transporting with eye bolt

The axial piston unit can be transported suspended from an eye bolt screwed into the drive shaft as long as only outward (pulling) axial forces are applied.

- ▶ For all female threads, use a stud end from the same system of units and of the correct size.
- ▶ To do this, screw an eye bolt completely into the female thread on the drive shaft. The thread size is indicated in the installation drawing.
- ▶ Make sure that the eye bolt can bear the total weight of the axial piston unit plus 20%.

You can lift the axial piston unit as shown in Fig. 4 with the eye bolt screwed into the drive shaft.

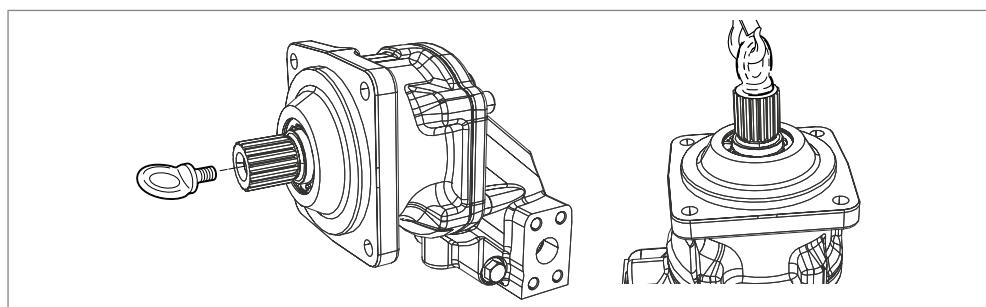


Fig. 4: Mounting the eye bolt

**Transport with lifting strap****WARNING!** Danger due to suspended loads!

During transport with a lifting device, the axial piston unit can topple out of the lifting strap and cause injury.

- ▶ Use the widest possible lifting strap.
- ▶ Make sure that the axial piston unit is securely fixed with the lifting strap.
- ▶ Only guide the axial piston unit by hand for fine positioning and to avoid swinging.
- ▶ Never step or grip under suspended loads.
- ▶ Place the lifting strap around the axial piston unit in such a way that it does not pass over assembled parts (e.g. valves, piping) and that the axial piston unit is not suspended from assembled parts (see Fig. 5).

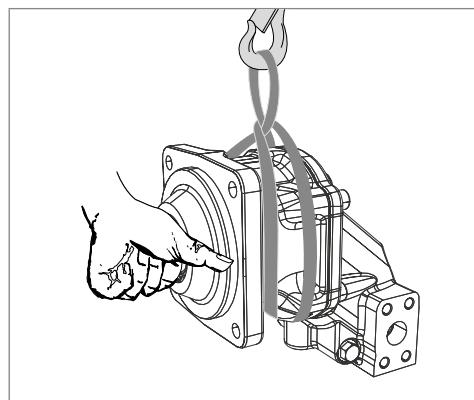


Fig. 5: Transport with lifting strap

## 6.2 Storing the axial piston unit

**Requirement**

- Storage areas should be free of corrosive materials and gases.
- To prevent damage to the seals, do not operate ozone-forming equipment (e.g. mercury-vapor lamps, high-voltage equipment, electric motors, sources of electrical sparks or electrical discharge) in storage areas.
- Storage areas should be dry.  
Recommended relative humidity  $\leq 60\%$ .
- Ideal bearing temperature:  $+5\text{ }^{\circ}\text{C}$  to  $+20\text{ }^{\circ}\text{C}$ .
- Minimum storage temperature:  $-50\text{ }^{\circ}\text{C}$ .
- Maximum storage temperature:  $+60\text{ }^{\circ}\text{C}$ .
- Keep out of direct sunlight.
- Do not stack axial piston units and store them in a shock-proof manner.
- Do not store the axial piston unit on the drive shaft or assembled parts, e.g. sensors or valves.
- For further storage conditions, see Table 10.
- ▶ Check the axial piston unit monthly to ensure proper storage.

**After delivery** The axial piston units come in corrosion protection packaging (corrosion protection film). Table 10 lists the max. permissible storage times for an unpackaged axial piston unit as per data sheet 90312.

**Table 10: Storage time with factory corrosion protection**

Storage conditions	Standard corrosion protection	Long-term corrosion protection (optional)
Closed, dry room, uniform temperature between +5 °C and +20 °C. Undamaged and closed corrosion protection film.	Max. 12 months	Max. 24 months



The warranty will be voided if the requirements and storage conditions are not observed or after expiration of the max. storage time (see Table 10).

What to do once the max. storage time elapses:

1. Check the entire axial piston unit for damage and corrosion prior to installation.
2. Perform a test run to check the axial piston unit for proper function and leaks.
3. If storage time exceeds 24 months, replace the shaft seal.



Once the max. storage time has elapsed, we recommend that you have the axial piston unit inspected by your Bosch Rexroth service partner.

For questions regarding repair and spare parts, contact your proper Bosch Rexroth service partner or the service department of the plant that manufactured the axial piston unit, see chapter 10.5 "Spare parts" on page 46.

**After removal** An uninstalled axial piston unit must be preserved with corrosion protection for the duration of storage.



The following instructions only refer to axial piston units operated with hydraulic fluid on a mineral oil basis. Other hydraulic fluids require other specific preservation measures. In such a case, consult your local contact person; you can find their contact information at [www.boschrexroth.com/addresses](http://www.boschrexroth.com/addresses)

Bosch Rexroth recommends the following procedure:

1. Clean the axial piston unit; see chapter 10.1 "Cleaning and care" on page 44.
2. Drain the axial piston unit.
3. For storage times up to 12 months: Moisten the inside of the axial piston unit with mineral oil and fill with approx. 100 ml mineral oil.  
For storage times up to 24 months: Fill the axial piston unit with VCI 329 corrosion protection (20 ml).  
Filling is done through the drain port **T<sub>1</sub>** or **T<sub>2</sub>**, see chapter 7.4 "Installing the axial piston unit", Fig. 12 to Fig. 15 on page 35.
4. Plug all ports so they are airproof.
5. Coat unpainted areas of the axial piston unit with mineral oil or suitable, easily removable corrosion protection, e.g. acid-free grease.
6. Package the axial piston unit with desiccant in corrosion protection film so it is airproof.
7. Store the axial piston unit in a shock-proof manner; see "Requirement" on page 22 in this chapter.

## 7 Installation

Prior to installation, the following documents should be to hand:

- Installation drawing for the axial piston unit (can be obtained from your contact person at Bosch Rexroth)
- Hydraulic circuit diagram for the axial piston unit (in the installation drawing)
- Hydraulic circuit diagram for the machine/system (available from the machine/system manufacturer)
- Order confirmation (contains the order-related technical data for your axial piston unit)
- Data sheet for the axial piston unit (contains the permissible technical data)

### 7.1 Unpacking

The axial piston unit comes in a polyethylene material (PE) corrosion protection film.

**CAUTION!** Danger due to falling parts!

If the packaging is not opened correctly, parts may fall out and damage the parts or even result in injury.

- ▶ Place the packaging on a level surface with sufficient load-bearing capacity.
- ▶ Only open the packaging from the top.
- ▶ Remove the packaging from the axial piston unit.
- ▶ Check the axial piston unit for transport damage and completeness; see chapter 4 "Scope of delivery" on page 17.
- ▶ Dispose of the packaging in accordance with the regulations in your country.

### 7.2 Installation conditions

The installation position and location of the axial piston unit essentially determine how it is installed and commissioned (such as when filling and air bleeding the axial piston unit).

- ▶ Install the axial piston unit so that the expected forces and torque can be transferred without any danger. The machine/system manufacturer is responsible for sizing the fasteners.
- ▶ Observe the permissible radial forces on the drive shaft when transferring output drive with radial force loading (belt drives). If necessary, store the belt pulley separately.
- ▶ Make sure the axial piston unit is always filled with hydraulic fluid during commissioning and operation. Also do this also after relatively long standstill periods, since the axial piston unit may drain out through the hydraulic lines.
- ▶ Direct the leakage in the housing area to the reservoir through the highest drain port. Use a line size that matches the port.

- ▶ Avoid using a check valve in the drain line.  
Exception: Above-reservoir installation, drive shaft upward.  
A check valve in the drain line (cracking pressure 0.5 bar) can prevent the system from draining through the drain line. Please note the correct flow direction.
- ▶ To keep noise values low, use elastic elements to isolate all connecting lines from all vibration-capable components (e.g. reservoir).
- ▶ Make sure that the drain line and return line flow into the reservoir below the minimum fluid level in all operating conditions. This prevents foaming.
- ▶ Make sure that the working environment at the installation site is completely free of dust and foreign substances. The axial piston unit should be clean when installed. Contamination of the hydraulic fluid can considerably affect the function and service life of the axial piston unit.
- ▶ Use fiber-free cleaning cloths for cleaning.
- ▶ Use suitable, mild cleaning agents to remove lubricants and other heavy contamination. Do not allow cleaning agents to enter into the hydraulic system.

### 7.3 Installation position

The axial piston unit can be installed in the following positions. The pipeline routing shown illustrates the basic layout.

#### 7.3.1 Below-reservoir installation (standard)

Below-reservoir installation is when the axial piston unit is installed outside of the reservoir below the minimum fluid level.



Recommended installation position: 1 and 2.

Also be sure to bleed air through air bleed port **R** when installing with the drive shaft up (special version).

Do not install the A2FE and A2FMT with the drive shaft up.

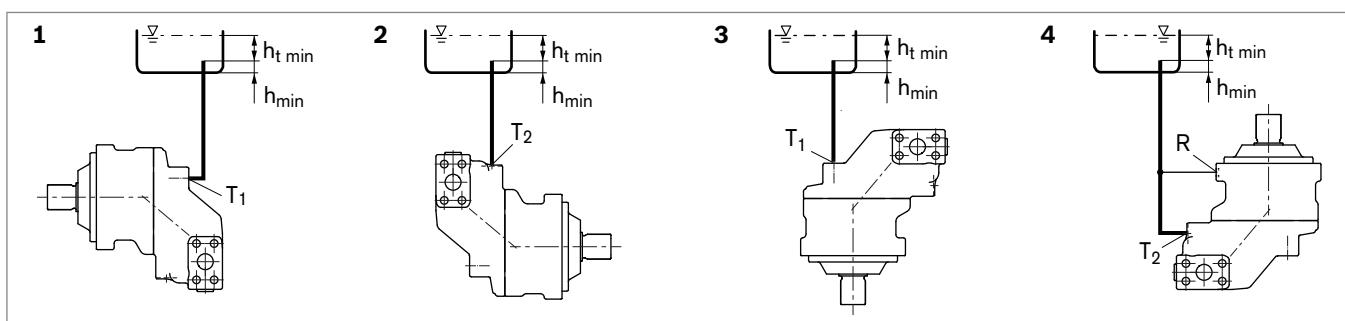


Fig. 6: A2FM below-reservoir installation with installation positions 1–4

**T<sub>1</sub>, T<sub>2</sub>** Highest drain port

**h<sub>t min</sub>** Minimum required immersion depth (200 mm)

**h<sub>min</sub>** Minimum required distance to reservoir bottom (100 mm)

**Table 11: Below-reservoir installation**

Installation position	Air bleed	Filling
1 (drive shaft horizontal)	–	T <sub>1</sub>
2 (drive shaft horizontal)	–	T <sub>2</sub>
3 (drive shaft vertically down)	–	T <sub>1</sub>
4 (drive shaft vertically up)	R	T <sub>2</sub>

**7.3.2 Above-reservoir installation**

Above-reservoir installation means that the axial piston unit is installed above the minimum fluid level of the reservoir.

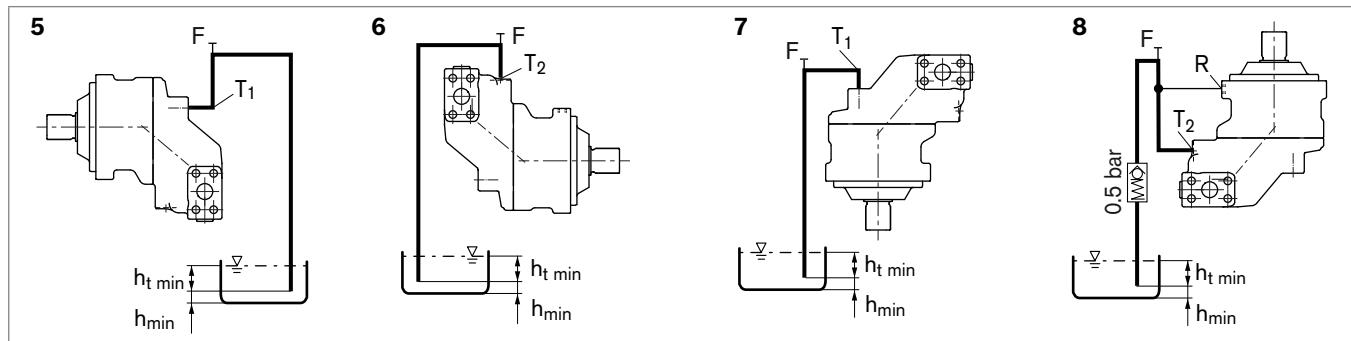


Also be sure to bleed air through air bleed port **R** when installing with the drive shaft up (special version).

Do not install the A2FE and A2FMT with the drive shaft up.



Recommendation for installation position **8** (drive shaft up): A check valve in the drain line (cracking pressure 0.5 bar) can prevent the housing area from draining.

**Fig. 7: A2FM above-reservoir installation with installation positions 5-8**

**T<sub>1</sub>, T<sub>2</sub>** Highest drain port

**h<sub>t min</sub>** Minimum required immersion depth (200 mm)

**F** Filling/air bleeding

**h<sub>min</sub>** Minimum required distance to reservoir bottom (100 mm)



Port **F** is part of the external piping and must be provided on the customer side to make filling and air bleeding easier.

**Table 12: Above-reservoir installation**

Installation position	Air bleed	Filling
5 (drive shaft horizontal)	–	T <sub>1</sub> ( <b>F</b> )
6 (drive shaft horizontal)	–	T <sub>2</sub> ( <b>F</b> )
7 (drive shaft vertically down)	–	T <sub>1</sub> ( <b>F</b> )
8 (drive shaft vertically up)	R	T <sub>2</sub> ( <b>F</b> )

## 7.4 Installing the axial piston unit

### 7.4.1 Preparation

1. Check the specifications on the name plate to see you have the correct axial piston unit.
2. Compare the material number and designation (type code) with the details in the order confirmation.



If the material number for the axial piston unit does not match the one in the order confirmation, contact your local contact person for clarification. You can find their contact information at [www.boschrexroth.com/addresses](http://www.boschrexroth.com/addresses)

3. Before installing, completely drain the axial piston unit to prevent mixing with the hydraulic fluid used in the machine/system.
4. Check the permissible direction of rotation of the axial piston unit (on the name plate) and make sure that this corresponds to the direction of rotation of the intended motor function.

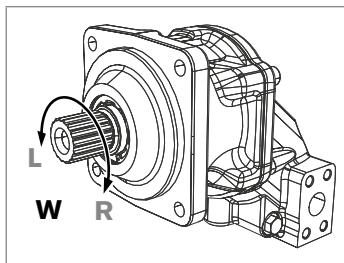


Fig. 8: Direction of rotation

**W** Bi-directional (can rotate counterclockwise and clockwise)

**L** Counter-clockwise

**R** Clockwise



The direction of rotation as indicated on the name plate determines the direction of rotation of the axial piston unit as viewed on the drive shaft; see chapter 5.3 "Product identification" on page 19. For information on the direction of rotation of the drive motor, please refer to the drive motor manufacturer's instruction manual.

### 7.4.2 Dimensions

For standard versions, the data sheet 91071 and 91072 contains all required installation dimensions as well as the position and dimensions of the connections. If necessary, an installation drawing can be requested. Also observe the manuals provided by the manufacturers of the other hydraulic components when selecting the required tools.

### 7.4.3 General instructions

Follow these general instructions when installing the axial piston unit:

- If a shared drain line is used for several units, make sure that the respective case pressure in each unit is not exceeded. The shared drain line must be dimensioned to ensure that the maximum permissible case pressure of all connected units is not exceeded in any operating conditions, particularly at cold start. If this is not possible, separate drain line must be laid, if necessary.

How the axial piston unit is installed depends on the connecting elements to the output side. The following descriptions explain the installation of the axial piston unit:

- With a coupling
- On a gearbox

### 7.4.4 Installation with a coupling

The following describes how to install the axial piston unit with a coupling:

**NOTICE!** Danger from improper handling!

Product can be damaged!

- ▶ Do not install the coupling hub on the drive shaft of the axial piston unit by striking it.

1. Install the specified coupling half on the drive shaft of the axial piston unit according to the instructions of the coupling manufacturer.



The drive shaft of the axial piston unit is equipped with a female thread. Use this female thread to pull the coupling element onto the drive shaft. The size of the female thread can be seen in the installation drawing.

2. Clamp the coupling hub onto the drive shaft or ensure permanent lubrication of the drive shaft. This prevents the formation of frictional corrosion and the associated wear.
3. Transport the axial piston unit to the installation location.
4. Remove dirt and foreign particles from the installation location.
5. Install the clutch on the drive shaft of the machine in accordance with the specifications provided by the coupling manufacturer.



Do not fasten down the axial piston unit until the coupling has been correctly installed.

6. Fasten the axial piston unit at the installation location.
7. Align the drive shaft of the axial piston unit and the drive shaft of the machine so that there is no angular deviation.
8. Make sure no excessive axial and radial forces are acting on the drive shaft.
9. Details on the required tools and tightening torques for the mounting bolts are available from the machine/system manufacturer.
10. When using elastic couplings, check that the drive does not resonate after completing the installation.

#### 7.4.5 Installation on a gearbox

The following describes how to install the axial piston unit on a gearbox.

After installing on a gearbox, the axial piston unit is covered and is difficult to access:

- ▶ Before installing, make sure that the spigot diameter centers the axial piston unit (observe tolerances) and that no excessive axial or radial forces are acting on the drive shaft of the axial piston unit (installation length).
- ▶ Protect the drive shaft against frictional corrosion by providing permanent lubrication.
- ▶ Fasten the axial piston unit at the installation location.

#### For attachment via gear wheel or helical gear shaft

No gearing forces higher than the permissible axial and radial forces should act on the shaft; if necessary, support the gear wheel at the gearbox output separately.

#### 7.4.6 Completion of assembly

1. Remove any installed transport screws.

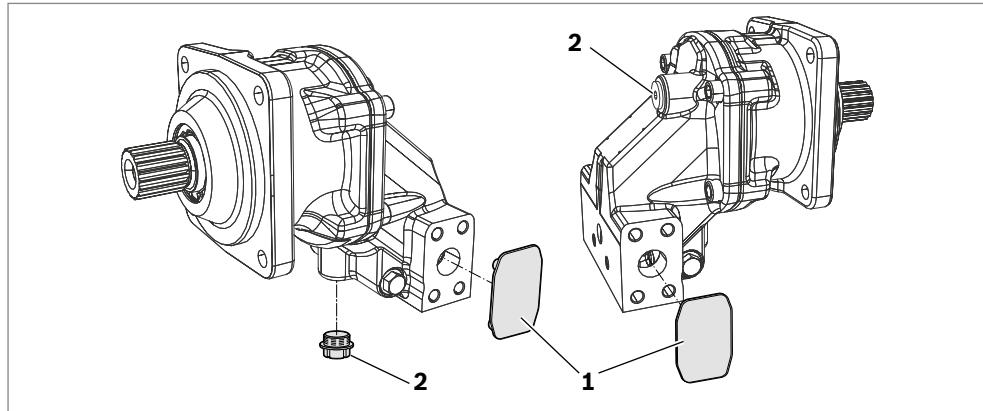
##### **CAUTION!** Operation with protective plugs!

Operating the axial piston unit with protective plugs may result in injury or damage to the axial piston unit.

- ▶ Before commissioning, remove all protective plugs and replace them with suitable, pressure-resistant, metal threaded plugs or connect the appropriate lines.

2. Remove the transport protection.

The axial piston unit is delivered with protective covers (1) and protective plugs (2). They are not pressure-resistant and have to be removed prior to connection. Use a suitable tool for this to prevent damage to the sealing and functional surfaces. If sealing or functional surfaces are damaged, contact your Bosch Rexroth service partner or the service department of the factory that manufactured the axial piston unit.



**Fig. 9: Removing transport protection**

**1** Protective covers

**2** Protective plugs/threaded plugs



Ports intended for connecting lines come with protective plugs or threaded plugs, which serve as transport protection. Connect all ports required for functional operation (see Table 15 "Ports A2FM/A2FE/A2FMT Series 70" on page 36). Failure to do so could lead to malfunctions or damage. If a port is not being used, plug it with a threaded plug since the protective plugs are not pressure-resistant.

The following information only applies to fixed motors with pressure relief valves.



Setting screws are protected against unauthorized adjustment by tamper-proof caps. Removal of the tamper-proof caps will void the warranty. If you need to change the settings, please contact your local contact person. You can find their contact information under [www.boschrexroth.com/addresses](http://www.boschrexroth.com/addresses)

#### 7.4.7 Hydraulically connecting the axial piston unit

The machine/system manufacturer is responsible for dimensioning of the lines. Connect the axial piston unit to the rest of the hydraulic system in accordance with the hydraulic circuit diagram of the machine/system manufacturer.

The ports and fastening threads are designed for the maximum permissible pressures  $p_{max}$ , see Table 15 "Ports A2FM/A2FE/A2FMT Series 70" on page 36. The machine/system manufacturer is required to ensure that the connecting elements and lines correspond to the specified application conditions (pressure, flow, hydraulic fluid, temperature) with the necessary safety factors.



Connect only hydraulic lines that are match the axial piston unit port (pressure level, size, system of units).

**Information on routing of lines**

Observe the following information when routing the pressure and drain lines.

- Lines and hoses should be installed without pre-charge pressure so no further mechanical forces are applied during operation that will reduce the service life of the axial piston unit and, possibly, the entire machine/system.
- Use suitable seals as sealing material.
- Pressure line
  - For the pressure lines, use only pipes, hoses and connecting elements that are rated for the working pressure range specified in data sheets 91071 and 91072 (see Table 15).
- Drain line
  - Always route the drain lines so that the housing is constantly filled with hydraulic fluid and to ensure no air gets through the shaft seal, even during extended standstill periods.
  - The case pressure must never exceed the limit values specified for the axial piston unit in the data sheet.
  - The drain line inflow in the reservoir should always be below the minimum fluid level (see chapter 7.3 "Installation position" on page 26).
- If the axial piston unit is equipped with installed screw fittings, do not remove them. Screw the stud end of the fitting directly into the installed fitting.

**Risk of confusion with threaded connections**

Axial piston units are used in application areas that use the metric system as well as the Anglo-American (imperial) and the Japanese measuring system (JIS – Japan Industrial Standard). Various kinds of seals are also used.

The system of units, the kind of seal and the size of female thread and stud ends (e.g. threaded plug) must all match.

There is a risk of confusion due to the limited ways of visually telling them apart.

**WARNING!** Leaky or bursting stud ends!

For fittings, if a stud end that does not match the system of units, kind of seal and size of the female thread is pressurized, the stud end may loosen itself or even be ejected from the hole in a projectile-like manner. This can result in serious injury and property damage. Hydraulic fluid can escape from this leakage point.

- ▶ Use the drawings (installation drawing) to determine the required stud end for each fitting.
- ▶ Make sure the right fittings, mounting bolts and threaded plugs are installed.
- ▶ For all female threads, use a stud end from the same system of units and of the correct size.

**Connecting line to pressure relief valve with pressure sequencing stage (only for A2FM and A2FE)**

Observe the following information on versions with pressure relief valves.

- When screwing in and tightening the connection line to the port  $P_{st}$ , hold the nut (1) on the pressure relief valve with pressure sequencing stage (2) using an AF 24 wrench. Observe the manufacturer's specifications regarding tightening torques for the connection line used. Do not exceed the maximum permissible tightening torque on the female thread (40 Nm).

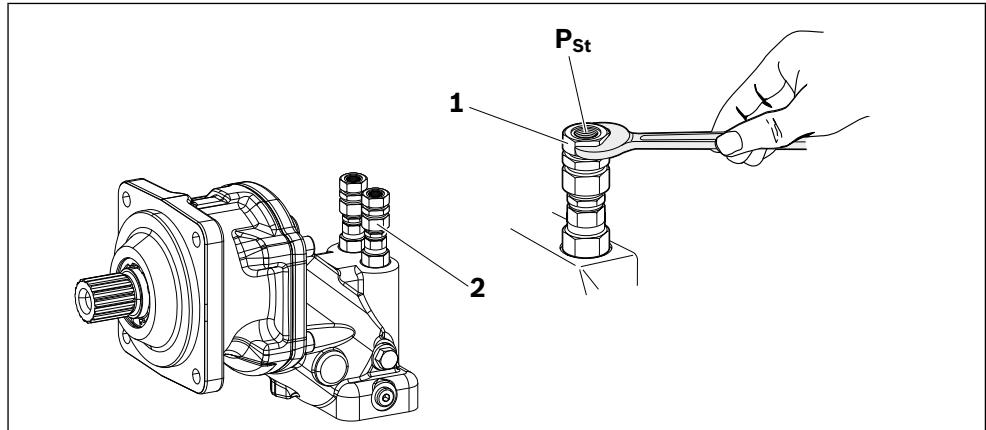


Fig. 10: Holding nut on pressure relief valve in place



Do not change the setting of the pressure relief valve. Adjusting the setting screw on the pressure relief valve will void the warranty.

**Mounting the counterbalance valve (only for A2FM and A2FE)**

Observe the following information on versions with counterbalance valves.

When delivered, the counterbalance valve is fastened to the motor with two tacking screws (transport lock). The tacking screws may not be removed while mounting the working lines! If the counterbalance valve and motor are delivered separately, the counterbalance valve must first be fastened to the motor housing using the tacking screws provided. The counterbalance valve is finally mounted on the motor by fitting the SAE flange with the following screws:

6 screws (1, 2, 3, 4, 5, 8) Length B1+B2+B3

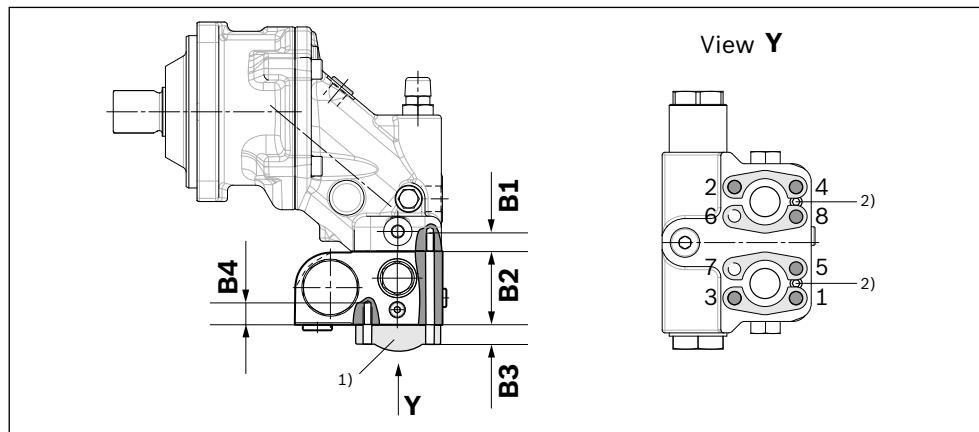
2 screws (6, 7) Length B3+B4

Tighten the screws in two steps in the specified order from 1 to 8 (see Fig. 11)!

- First, tighten the screws to half the tightening torque, then tighten to the max. tightening torque (see table Table 13).

Table 13: Mounting bolt tightening torques

Thread	Property class	Tightening torque
M6 x 1 (tacking screw)	10.9	15.5 Nm
M10 x 1.5	10.9	75 Nm
M12 x 1.75	10.9	130 Nm



<sup>1)</sup> SAE flange

<sup>2)</sup> Tacking screw (M6 x 1, length = B1 + B2, DIN 912)

**Fig. 11: Mounting the counterbalance valve**



The SAE flange and corresponding mounting bolts are not included in the scope of delivery.

**Table 14: Thread sizes and dimensions**

Size	56, 63	80, 90
Dimension B1 <sup>1)</sup>	M10 x 1.5 17 deep	M12 x 1.75 18 deep
Dimension B2	68 mm	68 mm
Dimension B3	customer-specific (flange-dependent)	
Dimension B4	M10 x 1.5 15 deep	M12 x 1.75 16 deep

Fastening thread according to DIN 13. For DIN 13 mounting bolts, we recommend checking the tightening torque on a case-by-case basis according to VDI 2230 Edition 2003.

<sup>1)</sup> Minimum required thread reach 1 x Ø thread

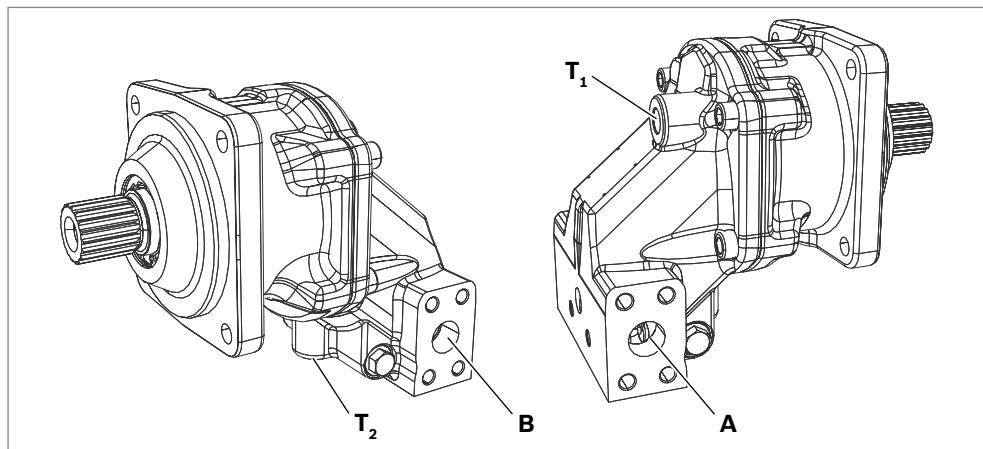
**Port overview**

Fig. 12: A2FM port overview, lateral SAE working ports

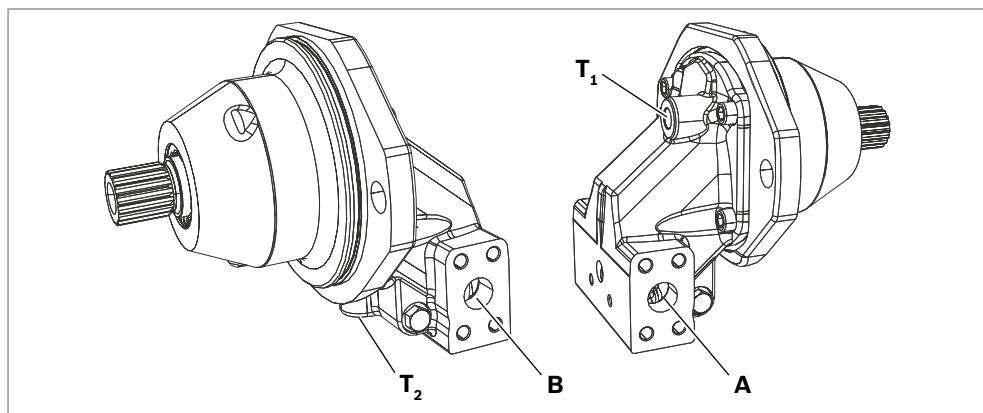


Fig. 13: A2FE port overview, lateral SAE working ports

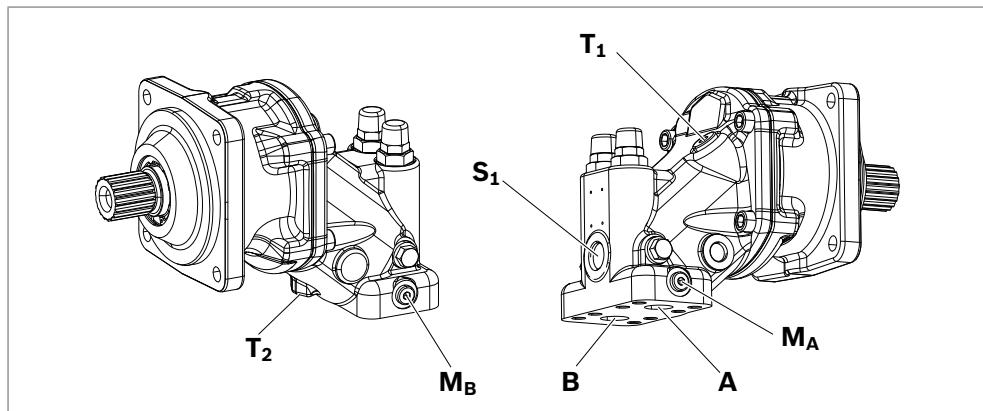


Fig. 14: A2FM Port overview, bottom SAE working ports and pressure relief valve

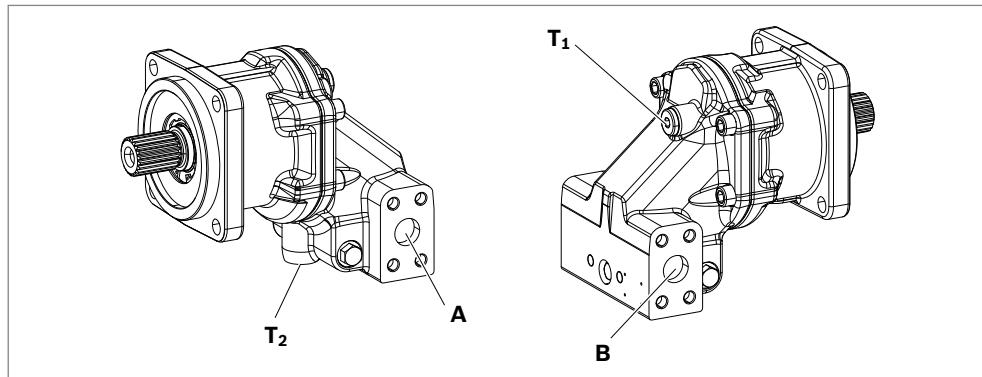


Fig. 15: A2FMT port overview, lateral SAE working ports and SAE mounting flange

Table 15: Ports A2FM/A2FE/A2FMT Series 70

Ports <sup>1)</sup>		$p_{\max}$ [bar] <sup>2)</sup>			State
		A2FMN/ A2FEN	A2FMM/ A2FEM	A2FMH/ A2FEH	
<b>A, B</b>	Working port	350	450	500	420 O
<b>T<sub>1</sub></b>	Drain port	3	3	3	3 X <sup>3)</sup>
<b>T<sub>2</sub></b>	Drain port	3	3	3	3 O <sup>3)</sup>
<b>S<sub>1</sub></b>	Boost port (only on version with pressure relief valve)	–	5	–	– O
<b>M<sub>A</sub>, M<sub>B</sub></b>	Measuring port pressure A/B (only on version with pressure relief valve)	–	420	–	– X
<b>P<sub>St</sub></b>	Pilot pressure port (only on version with pressure relief valve and pressure sequencing stage)	–	30	–	– O

<sup>1)</sup> The measuring system and thread size can be found in the installation drawing.

<sup>2)</sup> Depending on the application, momentary pressure peaks can occur. Keep this in mind when selecting measuring devices and fittings.

<sup>3)</sup> Depending on the installation position, T<sub>1</sub> or T<sub>2</sub> must be connected (see chapter 7.3 "Installation position" on page 26)

O = Must be connected (comes plugged)

X = Plugged (in normal operation)

**Tightening torques** The following tightening torques apply:

- Fittings:

Observe the manufacturer's specifications regarding the tightening torques of the fittings used.

- Female threads in the axial piston unit:

The max. permissible tightening torques  $M_{G\max}$  are the maximum values for the female threads and should not be exceeded. For values, see Table 16.

- Threaded plugs:

For the metallic threaded plugs supplied with the axial piston unit, the required tightening torques of threaded plugs  $M_V$  apply. For values, see Table 16.

- Mounting bolts:

For mounting bolts with DIN 13 metric ISO threads or ASME B1.1 threads, we recommend checking the tightening torque in individual cases in accordance with VDI 2230.



In addition to the ports specified in Table 15 "Ports A2FM/A2FE/A2FMT Series 70" on page 36, axial piston units may have openings that are also closed with a threaded plug. These plugs must not be opened on the customer side! If you have opened the threaded plug accidentally, please contact your local contact person to ensure safe re-closing of the plug. You can find the address at [www.boschrexroth.com/addresses](http://www.boschrexroth.com/addresses)

**Table 16: Tightening torques for female threads and threaded plugs**

<b>Ports</b>		<b>Maximum permissible tightening torque of female threads <math>M_{G\ max}</math></b>	<b>Required tightening torque of threaded plugs <math>M_v</math></b>	<b>WAF hexagon socket of the threaded plug</b>
<b>Standard</b>	<b>Thread size</b>			
DIN 3852	M8 × 1	10 Nm	7 Nm <sup>1)</sup>	3 mm
	M10 × 1	30 Nm	15 Nm <sup>2)</sup>	5 mm
	M12 × 1.5	50 Nm	25 Nm <sup>2)</sup>	6 mm
	M14 × 1.5	80 Nm	35 Nm <sup>1)</sup>	6 mm
	M16 × 1.5	100 Nm	50 Nm <sup>1)</sup>	8 mm
	M18 × 1.5	140 Nm	60 Nm <sup>1)</sup>	8 mm
	M22 × 1.5	210 Nm	80 Nm <sup>1)</sup>	10 mm
	M26 × 1.5	230 Nm	120 Nm <sup>1)</sup>	12 mm
	M27 × 2	330 Nm	135 Nm <sup>1)</sup>	12 mm
	M33 × 2	540 Nm	225 Nm <sup>1)</sup>	17 mm
	M42 × 2	720 Nm	360 Nm <sup>1)</sup>	22 mm
	M48 × 2	900 Nm	400 Nm <sup>1)</sup>	24 mm
ISO 11926	5/16-24 UNF-2B	10 Nm	7 Nm	1/8 in
	3/8-24 UNF-2B	20 Nm	10 Nm	5/32 in
	7/16-20 UNF-2B	40 Nm	18 Nm	3/16 in
	9/16-18 UNF-2B	80 Nm	35 Nm	1/4 in
	3/4-16 UNF-2B	160 Nm	70 Nm	5/16 in
	7/8-14 UNF-2B	240 Nm	110 Nm	3/8 in
	1 1/16-12 UN-2B	360 Nm	170 Nm	9/16 in
	1 5/16-12 UN-2B	540 Nm	270 Nm	5/8 in
	1 5/8-12 UN-2B	960 Nm	320 Nm	3/4 in
	1 7/8-12 UN-2B	1200 Nm	390 Nm	3/4 in

<sup>1)</sup> The tightening torques for the threaded plugs are valid for the condition "dry" and "lightly oiled".

<sup>2)</sup> The tightening torques for the threaded plugs are valid for the condition "dry" – in the condition "lightly oiled", the tightening torques for M10 × 1 are reduced to 10 Nm and for M12 × 1.5 to 17 Nm.

**Procedure** To connect the axial piston unit to the hydraulic system:

1. Remove the protective plugs or threaded plugs from the ports where the connections should be made according to the hydraulic circuit diagram.
2. Make sure the sealing surfaces of the hydraulic ports and functional surfaces are not damaged.
3. Use only clean hydraulic lines or flush them before installation. (Observe chapter 7.5 "Performing flushing cycle" on page 38 when you flush out the entire system.)
4. Connect the lines in accordance with the installation drawing and the machine or system circuit diagram. Check that all ports are connected or plugged with threaded plugs.
5. Properly tighten the fittings (observe tightening torques!). Mark all properly tightened fittings, e.g. with a permanent marker.
6. Check all pipes and hose lines and every combination of connecting pieces, couplings or connecting points with hoses or pipes to ensure they are in safe working condition.



Relationship between direction of rotation and flow direction:

Clockwise rotation: **A to B**

Counter-clockwise rotation: **B to A**

## 7.5 Performing flushing cycle

In order to remove foreign particles from the system, Bosch Rexroth recommends a flushing cycle for the entire system prior to initial commissioning. To avoid internal contamination, do not include the axial piston unit in the flushing cycle.



Use an additional flushing unit to perform the flushing cycle. Follow the instructions of the flushing unit's manufacturer for the exact procedure during the flushing cycle.

## 8 Commissioning

### ⚠ WARNING

#### **Danger while working in the danger zone of a machine/system!**

Danger to life, risk of injury or serious injury!

- ▶ Pay attention to and eliminate potential danger sources before commissioning the axial piston unit.
- ▶ Make sure no one is in the danger zone of the machine/system.
- ▶ The emergency stop button for the machine/system should be within the operator's reach.
- ▶ Always follow the instructions of the machine/system manufacturer during commissioning.

### ⚠ CAUTION

#### **Commissioning an improperly installed product!**

Risk of injury and property damage!

- ▶ Make sure all electrical and hydraulic ports are connected or plugged.
- ▶ Commission only a fully installed, fully functioning product with original accessories from Bosch Rexroth.

### 8.1 Initial commissioning



During all commissioning work on the axial piston unit, observe the general safety instructions and intended use detailed in chapter 2 "Safety instructions" on page 8.

- ▶ Connect the pressure gauge for the working pressure and case pressure to the specified measuring points on the axial piston unit or in the hydraulic system to check the technical data during the first operation.
- ▶ During commissioning, monitor the temperature of the hydraulic fluid in the reservoir to ensure that it lies within permissible viscosity limits.

### 8.1.1 Filling the axial piston unit

Professional filling and air bleeding is necessary to prevent damage to the axial piston unit and to maintain proper function.



Usually, the cleanliness level of commercial hydraulic fluids is insufficient for our components. These hydraulic fluids must be filtered during filling using an appropriate filter system to minimize solid particle contamination and water in the system.

Use only a hydraulic fluid that conforms to the following requirements:

You can find details of the minimum requirements on hydraulic fluids in Bosch Rexroth data sheets 90220 and 90221. The titles of the data sheets can be found in Table 1 "Required and supplementary documentation" on page 5.



Bosch Rexroth evaluates hydraulic fluids on the basis of the Fluid Rating according to data sheet 90235. For hydraulic fluids which have been positively evaluated in the Fluid Rating, please refer to data sheet 90245 "Bosch Rexroth fluid rating list for Rexroth hydraulic components (pumps and motors)". The hydraulic fluid should be selected so that the operating viscosity in the operating temperature range is within the optimum range ( $\nu_{opt}$ ; see selection diagram in the data sheet 91071 and 91072).

To ensure the functional reliability of the axial piston unit, cleanliness level 20/18/15 according to at least ISO 4406 is necessary for the hydraulic fluid. At a hydraulic fluid viscosity of less than 10 mm<sup>2</sup>/s (e.g. due to high temperatures during short-term operation) at the drain port, a min. cleanliness level of 19/17/14 as defined in ISO 4406 is required. You can find details on the permissible and optimal viscosities and admissible temperatures in data sheet 91071 and 91072.

**Procedure** Proceed as follows to fill the axial piston unit:

1. Place a drip tray under the axial piston unit to collect any hydraulic fluid that may leak.

**NOTICE!** Contaminated hydraulic fluid!

The cleanliness levels of commercial hydraulic fluid are usually insufficient for our components.

- ▶ Use a suitable filter system to filter hydraulic fluids during filling to minimize solid particle contamination and water in the hydraulic system.

2. Fill and air bleed the axial piston unit via the appropriate ports; see chapter 7.3 "Installation position" on page 26. Also fill the hydraulic lines of the system.

### 8.1.2 Testing the hydraulic fluid supply

The axial piston unit should always have a sufficient supply of hydraulic fluid. For this reason, the supply of hydraulic fluid must be ensured at the start of the commissioning process.

When you test the hydraulic fluid supply, constantly monitor noise development and check the hydraulic fluid level in the reservoir. If the axial piston unit becomes louder (cavitation) or the drain fluid is discharged with bubbles, this is an indication that the axial piston unit is not being sufficiently supplied with hydraulic fluid.

For information on troubleshooting, see chapter 14 "Troubleshooting" on page 50.

To test the hydraulic fluid supply:

1. Allow the axial piston unit to run at low rotational speed and without load.  
Pay attention to leaks and noises.
2. Check the axial piston unit's drain line during the test. The drain fluid should be without bubbles.
3. Increase the load and check whether the working pressure rises as expected.
4. Perform a leak test to ensure the hydraulic system is sealed and can withstand the max. pressure.
5. At maximum working pressure, check the case pressure at port **T<sub>1</sub>** or **T<sub>2</sub>**. Refer to data sheet 91071 and 91072 for the permissible value.

### 8.1.3 Performing a functional test

#### **WARNING**

##### **Improperly connected axial piston unit!**

Mixing up the ports will cause malfunctions (e.g. lift instead of lower) and could endanger personnel and equipment!

- Before the functional test, check whether the piping specified in the hydraulic circuit diagram has been installed.

Once you have tested the hydraulic fluid supply, perform a functional test of the machine/system. The functional test should be performed according to the instructions of the machine/system manufacturer.

The axial piston unit is tested for functional capability and performance before delivery according to the technical data. During commissioning, make sure the axial piston unit was installed properly in the machine/system.

- After starting the drive motor, check in particular the specified pressures, e.g. working pressure, boost pressure and case pressure.
- Perform a leak test without and with load prior to normal operation.
- If necessary, disconnect the pressure gauge and plug the ports with the specified threaded plugs.

## 8.2 Running-in phase

### NOTICE

#### Property damage due to insufficient viscosity!

Elevated hydraulic fluid temperature may excessively reduce viscosity and damage the product!

- ▶ Monitor the operating temperature during the running-in phase, e.g. by measuring the leakage temperature.
- ▶ Reduce the loading (pressure, rotational speed) of the axial piston unit if unacceptable operating temperatures and/or viscosities occur.
- ▶ Excessively high operating temperatures indicate faults that have to be analyzed and eliminated.

The bearings and sliding surfaces are subject to a running-in phase. The increased friction at the start of the running-in phase results in increased heat development which decreases over time. Volumetric and mechanical-hydraulic efficiency is also greater until the running-in phase of about 10 operating hours is concluded.

To ensure that contamination in the hydraulic system does not damage the axial piston unit, Bosch Rexroth recommends the following after the running-in phase:

- ▶ After the running-in phase, have a hydraulic fluid sample analyzed for the required cleanliness level.
- ▶ Change the hydraulic fluid if the required cleanliness level is not reached. If a laboratory test is not carried out after the running-in phase, it is recommended to change the hydraulic fluid.

## 8.3 Recommissioning after standstill

Depending on the installation conditions and ambient conditions, changes may occur in the hydraulic system which make recommissioning necessary.

The following criteria may make recommissioning necessary:

- Air and/or water in the hydraulic system
- Old hydraulic fluid
- Other contamination

- ▶ Before recommissioning, proceed as described in chapter 8.1 "Initial commissioning" on page 39.

## 9 Operation

This product is a component which requires no settings or changes during operation. For this reason, this chapter of the manual does not contain any information on adjustment options. Use the product only within the performance range specified in the technical data. The machine/system manufacturer is responsible for proper project planning of the hydraulic system and its control.

## 10 Maintenance and repair

### **NOTICE**

#### **Overdue inspection and maintenance work!**

Property damage!

- ▶ Perform the specified inspection and maintenance work at the intervals described in this manual.

### **10.1 Cleaning and care**

### **NOTICE**

#### **Damage to seals and electrical system due to mechanical effects!**

The jet of a high-pressure cleaner may damage the seals and electrical system of the axial piston unit!

- ▶ Do not point a high-pressure cleaner at sensitive components, e.g. shaft seal, electrical connections and components.

For cleaning and care of the axial piston unit, observe the following:

- ▶ Check whether all seals and plug-in connections are securely seated to ensure no moisture can penetrate into the axial piston unit during cleaning.
- ▶ Use only water and, if necessary, a mild cleaning agent to clean the axial piston unit. Never use solvents or aggressive cleaning agents.
- ▶ Remove major external contamination and keep clean sensitive and important components, such as solenoids, valves, indicators and sensors.

## 10.2 Inspection

In order for the axial piston unit to be reliable and long-lasting, Bosch Rexroth recommends inspecting the hydraulic system and axial piston unit on a regular basis, and documenting and archiving the following operating conditions:

**Table 17: Inspection schedule**

Tasks to be performed	Interval
Hydraulic system	Check hydraulic fluid level in the reservoir. daily
	Check the operating temperature under comparable load condition at the drain port and in the reservoir. weekly
	Conduct hydraulic fluid analysis: Viscosity, aging and contamination Yearly or every 2000 operating hours (whichever occurs first)
Check filter. The replacement interval may vary depending on the cleanliness of the hydraulic fluid. We recommend using a contamination indicator.	Yearly or every 1000 operating hours (whichever occurs first)
Axial piston unit	Check axial piston unit for leakage. Early detection of hydraulic fluid loss can help to find faults on the machine/system and rectify them. This is why Bosch Rexroth recommends always keeping the axial piston unit and system clean. daily
	Check axial piston unit for unusual noise development. daily
	Check mounting elements for tight seating. All fasteners have to be checked when the hydraulic system is switched off, depressurized and cooled down. Monthly

## 10.3 Maintenance

The axial piston unit is low-maintenance when used as intended.

The service life of the axial piston unit is heavily dependent on the quality of the hydraulic fluid. This is why we recommend changing the hydraulic fluid at least once per year or every 2000 operating hours (whichever occurs first), or having it analyzed by the hydraulic fluid manufacturer or a laboratory to determine its suitability for further use.

The service life of the axial piston unit is limited to the service life of the bearings used. You can ask your local contact person about service life based on load cycle. You can find their contact information at [www.boschrexroth.com/addresses](http://www.boschrexroth.com/addresses)

Based on these details, a maintenance interval should be determined by the system manufacturer for the replacement of the bearings and included in the maintenance schedule of the hydraulic system.

## 10.4 Repair

Bosch Rexroth offers a comprehensive range of services for the repair of Rexroth axial piston units.

Repairs on the axial piston unit and its assembled parts should only be performed by service centers certified by Bosch Rexroth.

- ▶ Only use original spare parts from Rexroth to repair the Rexroth axial piston units, otherwise the functional reliability of the axial piston unit cannot be guaranteed and the warranty will be voided.

For questions regarding repairs, contact your proper Bosch Rexroth service partner or the service department of the plant that manufactured the axial piston unit; see chapter 10.5 "Spare parts" on page 46.

## 10.5 Spare parts

### CAUTION

#### **Use of unsuitable spare parts!**

Spare parts that do not meet the technical requirements specified by Bosch Rexroth can cause injury and property damage!

- ▶ Only use original spare parts from Rexroth to repair the Rexroth axial piston units, otherwise the functional reliability of the axial piston unit cannot be guaranteed and the warranty will be voided.

The spare parts lists for axial piston units are order-specific. When ordering spare parts, specify the material and serial number of the axial piston unit as well as the material numbers of the spare parts.

Address all questions regarding spare parts to your proper Service partner or the service department of the factory that manufactured the axial piston unit.

# 11 Removal and replacement

## 11.1 Required tools

Removal can be performed using standard tools. No special tools are necessary.

## 11.2 Preparing for removal

1. Decommission the entire system as described in the instruction manual for the machine or system.
  - Relieve pressure in the hydraulic system according to the instructions of the machine or system manufacturer.
  - Make sure the relevant system components are depressurized and de-energized.
2. Secure the entire system against being re-energized.

## 11.3 Performing the disassembly

Proceed as follows to remove the axial piston unit:

1. Make sure you have the appropriate tools and wear personal protective equipment.
2. Allow the axial piston unit to cool down until it can be removed without danger.
3. For below-reservoir installation, before removing the axial piston unit from the entire system, seal the connection to the reservoir or drain the reservoir.
4. Place a drip tray under the axial piston unit to collect any hydraulic fluid that may leak.
5. Disconnect the lines and collect the escaping hydraulic fluid in the drip tray.
6. Remove the axial piston unit. Use a suitable lifting device.
7. Completely drain the axial piston unit.
8. Plug all openings.

## 11.4 Preparing the components for storage or further use

- Proceed as described in chapter 6.2 "Storing the axial piston unit" on page 22.

## 12 Disposal

Careless disposal of the axial piston unit, the hydraulic fluid and the packaging material can result in environmental pollution.

Observe the following when disposing of the axial piston unit:

1. Completely drain the axial piston unit.
2. Dispose of the axial piston unit and packaging material in accordance with the regulations in your country.
3. Dispose of the hydraulic fluid in accordance with the regulations of your country.  
Also observe the applicable safety data sheet for the hydraulic fluid.
4. Disassemble the axial piston unit into its constituent parts for proper recycling.
5. For example, separate the parts into:
  - Castings
  - Steel
  - Aluminum
  - Non-ferrous metal
  - Electronic waste
  - Plastic
  - Seals

## 13 Extension and conversion

Do not modify the axial piston unit or its assembled parts.



The warranty from Bosch Rexroth only applies to the product as delivered.  
The warranty will be voided if the unit is modified or extended.

## 14 Troubleshooting

Table 18 is intended to support troubleshooting. This table is not exhaustive. Issues may occur in practice that are not listed here.

Only authorized personnel may perform troubleshooting inside a safety area designated by the machine manufacturer.

### 14.1 How to proceed for troubleshooting

- ▶ Troubleshoot with reduced operating parameters when possible.
- ▶ Use a systematic and targeted approach, even when pressed for time. Random, indiscriminate removal could make it impossible to determine the original cause of a fault.
- ▶ First get a general idea of how your product works in conjunction with the entire system.
- ▶ Try to find out whether or not the product was working properly in conjunction with the entire system before the fault occurred.
- ▶ Try to determine any changes to the entire system in which the product is installed:
  - Have there been any changes to the application conditions or operating range of the product?
  - Has maintenance work recently been carried out? Is there an inspection or maintenance log?
  - Have any changes (e.g. upgrades) or repairs been made to the overall system (machine/system, electrics, control) or to the product? If yes: What changes?
  - Has the hydraulic fluid been changed?
  - Has the product or machine been used as intended?
  - How does the malfunction appear?
- ▶ Try to get a clear idea of the cause of the fault. Directly ask the (machine) operator.
- ▶ Document the work carried out.
- ▶ If the fault cannot be corrected, please refer to one of the contract addresses

## 14.2 Malfunction table

**Table 18: Axial piston unit malfunction table**

Malfunction	Possible cause	Remedy
Unusual noises	Insufficient air bleeding of the hydraulic system	Fill the axial piston unit, suction line for the hydraulic pump and the reservoir Completely air bleed the axial piston unit and hydraulic system Check correct installation position
	Output speed too high	Machine/system manufacturer: Reduce output speed
	Improper mounting of the axial piston unit	Check the mounting of the axial piston unit according to the specifications of the machine/system manufacturer – observe tightening torques
	Improper mounting of assembled parts, hydraulic lines or improper installation of the coupling	Mount assembled parts according to the information provided by the coupling fitting manufacturer
	Mechanical damage to the axial piston unit (e.g. bearing damage)	Replace axial piston unit Contact Bosch Rexroth Service
Increased, unusual vibration	Bearings worn	Contact Bosch Rexroth Service
No or insufficient pressure	Insufficient air bleeding of the hydraulic system	Fill the axial piston unit, suction line for the hydraulic pump and the reservoir Check correct installation position
	Faulty mechanical output drive (e.g., defective coupling)	Contact machine/system manufacturer
	Drive power too low	Contact machine/system manufacturer
	Wear or mechanical damage to the axial piston unit	Replace axial piston unit Contact Bosch Rexroth Service
	Drive unit defective (e.g., hydraulic pump)	Contact machine/system manufacturer
Pressure/flow fluctuations/instabilities	Insufficient air bleeding of the hydraulic system	Fill the axial piston unit, suction line for the hydraulic pump and the reservoir Completely air bleed the axial piston unit and hydraulic system Check correct installation position
Rotational speed or torque cannot be reached	Insufficient flow in hydraulic pump	Check function of the hydraulic pump
	Hydraulic fluid not in optimal viscosity range	Machine/system manufacturer: Check temperature range and use suitable hydraulic fluid
	Wear or mechanical damage to the axial piston motor	Replace axial piston unit Contact Bosch Rexroth Service
	Wear or mechanical damage to the hydraulic pump	Replace hydraulic pump Contact Bosch Rexroth Service
	Wrong direction of rotation	Check function of the hydraulic pump Machine/system manufacturer: Check correct direction of rotation, see chapter 7.4.1 "Preparation" on page 28

**Table 18: Axial piston unit malfunction table**

Malfunction	Possible cause	Remedy
Excessively high temperature of hydraulic fluid and housing	Excessively high inlet temperature at the axial piston unit	Machine/system manufacturer: Inspect system, e.g. malfunction in the cooler, insufficient hydraulic fluid in the reservoir
	Incorrect setting or malfunction of the pressure relief valves	Optimize the adjustment of the axial piston unit pressure relief valves and the pressure limitation in the hydraulic system Contact Bosch Rexroth Service
		Contact machine/system manufacturer
	Output speed too high	Contact machine/system manufacturer
	Flushing flow of the flushing valve too low	Contact Service
	Axial piston unit worn	Replace axial piston unit; contact Service



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