

## Appendix for Truck Master 4 assembly tutorial

Use this step-by-step task list in parallel while following the assembly tutorial. The Pos column refers to the corresponding spare part position number, which is also listed in the spare parts list. The Drive End / Non-Drive End column indicates which end of the pump the work is carried out on, while any specified torque values (Nm) are stated in the Specification column.



Step	Pos	Description	Drive end / non drive end	Specification
1	-	Mount the guide bushings in NDE pump housing only	NDE	-
2	-	Mount the water connection swivel nut in both pump housings	DE/NDE	-
3	-	Mount the pump housing paper gasket in both pump housings	DE/NDE	-
4	21/20	Mount the flow plates in both pump housings	DE/NDE	-
5	-	Prepare a fundament for NDE pump housing	-	-
6	-	Mount the pump housing rubber gasket	NDE	-
7	9	Mount the shell	-	-
8	-	Mount the shell bottom paper gasket	NDE	-
9	-	Tighten the shell softly	-	75Nm
10	-	Mount the water connection pipe softly	NDE	-
11	50	Pre-mount the axel nut for protection	-	-
12	-	Mount the rotor	-	-
13	-	Mount the shell top paper gasket	-	-
14	-	Mount the guide bushings in the shell	-	-
15	-	Mount the shell top rubber gasket	-	-
16	3	Mount the DE pump housing on shell	DE	75Nm
17	-	Turn the pump to horizontal position NDE	-	-
18	-	Tighten the shell	-	75Nm
19	-	Measure the rotor clearance	-	-
20	-	Tighten the water connection	-	-
21	39	Mount mechanical shaft seal	DE	-
22	15	Prepare and mount retainer flange	DE	50Nm
23	16	Prepare and mount adjusting flange in bearing house	DE	-
24	12	Mount bearing housing	DE	50Nm
25	2	Mount mechanical shaft seal	NDE	-
26	16	Mount adjusting flange	NDE	50Nm
27	12	Mount bearing housing	NDE	50Nm
28	48	Mount roller bearing	DE	-
29	49	Mount ball bearing	NDE	-
30	50	Mount axle nut	NDE	85Nm
31	14	Mount bearing cap	NDE	30Nm
32	13	Mount bearing cap	DE	30Nm
33	-	Adjust and lock the rotor	-	30Nm
34	-	Greasing	DE/NDE	100/100g
35	-	Mount feet	DE/NDE	130Nm