

Reference Exploded Assembly View

- Place Targator in a vice**
1. Place the Targator™ in a soft-jawed vice, with coupling shaft (1) centered down and the vice jaws clamping firmly on the sides of the housing (18) mounting flange or post (bore). Remove mandrel post (3) Rings (14) if applicable.
- WARNING:** If the TARGATOR™ is not FIRMLY HELD in the VICE, IT COULD BE DISLOADED DURING THE REFERENCE PROCEDURES, CAUSING INJURY.



Figure 1

- Scrub alignment mark & loose valve plugs**
1. Scrub an alignment mark down and across the Targator™ components from end cover (2) to housing (18) to facilitate reassembly operation where required. Loosen two shuttle or relief valve plugs (2) for disassembly later (included in end cover, 3/16 or 3/8 inch Allen wrench or 1 inch hex socket required. SEE FIGURE 3 & 4.



Figure 2



Figure 3

- Remove special bolts & inspect bolts**
1. Remove the fire, etc. or cover special ring head bolts (1, 1A, 1B, or 1C) using an appropriate 1/2 or 9/16 inch size socket. SEE FIGURE 5. Inspect bolts for damaged threads, or seating rings, under the ball head. Replace damaged bolts. SEE FIGURE 6.



Figure 4

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- Remove end cover & inspect bolts**
4. Remove end cover assembly (2) and seal ring (4). Discard seal ring. SEE FIGURE 7.



Figure 5

NOTE: Refer to the appropriate "alternate cover construction" on the exploded view to determine the end cover construction being serviced.

- Remove plugs and valves**
5. If the end cover (2) is equipped with shuttle valve or relief valve (2A) components, remove the two previously loosened plugs (2) and o-rings (22). SEE FIGURE 6.



Figure 6

CUTION: Be ready to catch the shuttle valve or relief valve components that will fall out of the end cover valve cavity when the plugs are removed.

NOTE: O-ring (22) is not included in seal kit but serviced separately if required.

NOTE: The insert and if included the orifice plug in the end cover (2) must not be removed as they are serviced as an integral part of the end cover.

- Wash & inspect end cover**
6. Thoroughly wash end cover (2) in proper solvent and allow dry. Be sure the end cover valve apertures, including the internal orifice plug, are free of contamination. Inspect end cover for cracks and the ball head recesses for good ball head seating surfaces. Replace end cover as necessary. SEE FIGURE 9.



Figure 7

NOTE: A polished pattern (not attached) on the cover from rotation of the commutator (5) is normal. Discoloration would indicate excess fluid temperature, thermal shock, or excessive speed and require system investigation for cause and stress inspection of end cover, commutator, manifold, and inlet seal.

- Remove & inspect commutator ring**
7. Remove commutator ring (5). SEE FIGURE 10. Inspect commutator ring for cracks, or burn.



Figure 8

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Torqmotor Service Manual

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1. Understanding the eBook Torqmotor Service Manual
 - The Rise of Digital Reading Torqmotor Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Torqmotor Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Torqmotor Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Torqmotor Service Manual
 - Personalized Recommendations

- Torqmotor Service Manual User Reviews and Ratings
- Torqmotor Service Manual and Bestseller Lists
- 5. Accessing Torqmotor Service Manual Free and Paid eBooks
 - Torqmotor Service Manual Public Domain eBooks
 - Torqmotor Service Manual eBook Subscription Services
 - Torqmotor Service Manual Budget-Friendly Options
- 6. Navigating Torqmotor Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Torqmotor Service Manual Compatibility with Devices
 - Torqmotor Service Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Torqmotor Service Manual
 - Highlighting and Note-Taking Torqmotor Service Manual
 - Interactive Elements Torqmotor Service Manual
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 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Torqmotor Service Manual
- 9. Balancing eBooks and Physical Books Torqmotor Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Torqmotor Service Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Torqmotor Service Manual
 - Setting Reading Goals Torqmotor Service Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Torqmotor Service Manual
 - Fact-Checking eBook Content of Torqmotor Service Manual

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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