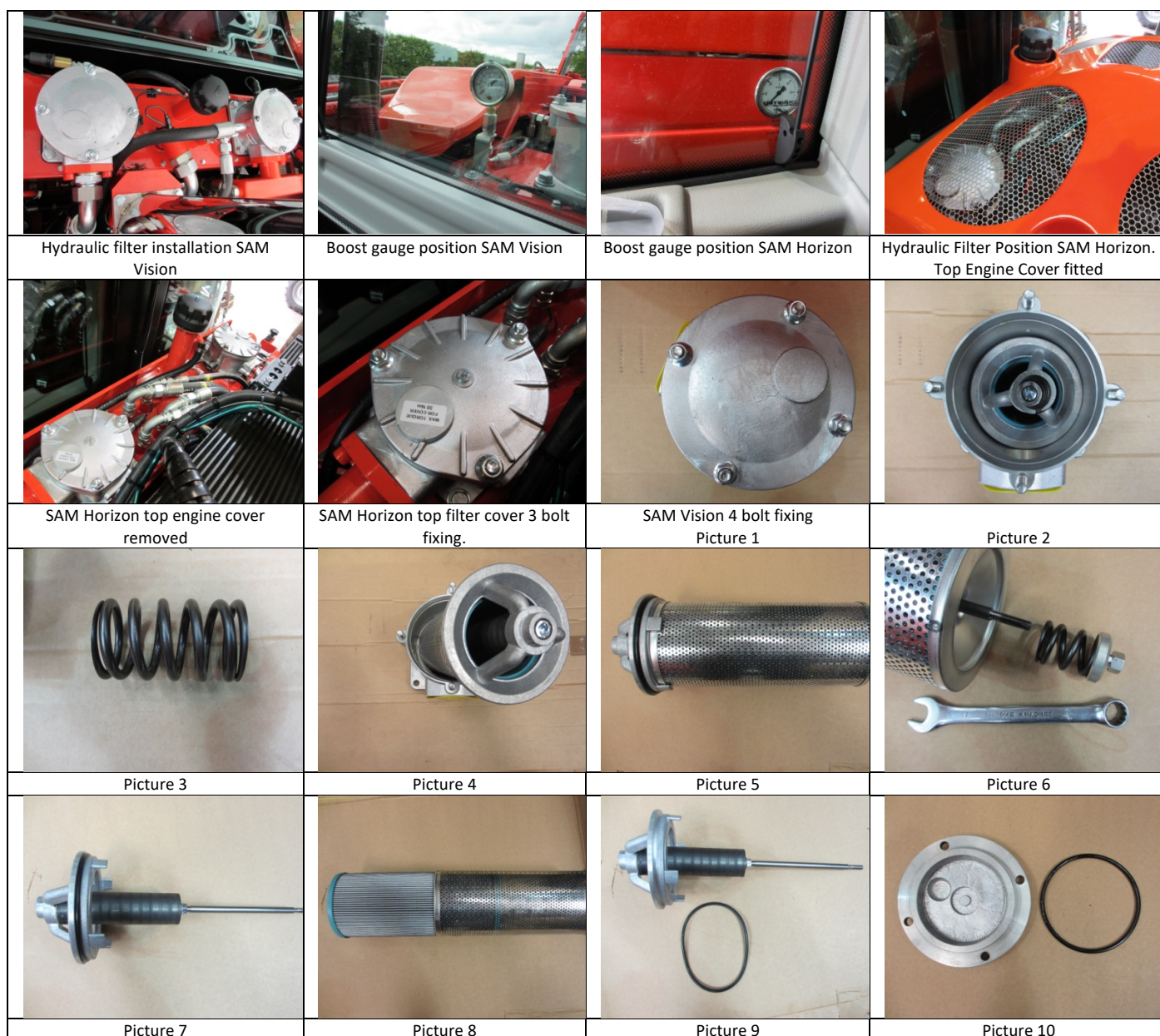




## Hydraulic Filter Change Procedure for SAM Horizon / Vision



1. Remove engine top cover on Horizon Machine. Replace return filter first
2. Clean dirt and debris around return filter housing cover. See photo 1
3. Undo bolts on filter housing cover and remove. See photo 2
4. Remove spring. See photo 3
5. Lift filter and allow excess oil to drain back to tank. See photo 4
6. Remove filter assembly to work bench. See photo 5
7. Undo bottom nut. See photo 6
8. Remove filter. See photo 7
9. Clean magnet stack. See photo 7
10. Replace filter housing. See photo 8  
NB: when replacing return filter element, be sure to refit outer filter screen
11. Fit new 'O' ring to filter assembly. See photo 9
12. Re-fit filter assembly
13. Re-fit spring
14. Replace filter housing cover 'O' ring
15. Refit filter housing cover. Tighten nuts to 30nm
16. Ensure cover is fitted correctly to filter housing
17. Repeat procedure for suction filter
18. Top up hydraulic oil
19. Start machine and watch boost pressure gauge. Gauge should raise to approx 28-30 bar within a few seconds.

**If no pressure, stop machine immediately and ring Sands Agricultural Machinery Service.**