**How to Plumb Hydraulic Gear Motor Case Drain Port Back To Tank**

*Most all hydraulic motors, and sometimes pumps, have a case drain port which must be run separately to tank. This port is usually the smallest port at the back of the motor. The plumbing from these drain ports should be at least the same size as the drain port in order to keep back pressure low in the motor case. Excessive pressure build-up inside the case will blow out the shaft seal.*

**Caution Always Connect Case Drain!!!**

- Always connect the case drain circuit **BEFORE** operating the motor. **If this drain is not connected, blocked or sees pressures above 25 psi, the shaft seal will fail immediately or in minutes of running!!**

- The case drain line is a separate independent line to tank. Do not combine or connect to other circuit return to tank lines.

- The case drain circuit is designed for motor internal leakage only (minimal flow at low pressure).

- The motor case drain line at the tank should be above the fluid level so entrained air can escape on start-up. This will prevent air being introduced into the hydraulic system.

- The case drain line is a separate independent line to tank. Do not combine or connect to other circuit return to tank lines.

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