

S/N - TMF1-UP

S/N - WDJ1-UP

S/N - XAN1-UP

S/N - XBB1-UP

S/N - XCC1-UP

S/N - YEA1-UP

S/N - ZBD1-UP

S/N - ZCS1-UP

Assembly Procedure

Table 1

| Required Tools | | | |
|----------------|-------------|--|-----|
| Tool | Part Number | Part Description | Qty |
| A | 1P-2420 | Transmission Repair Stand | 1 |
| B | 439-3938 | Link Bracket | 2 |
| D | 439-3940 | Link Bracket | 2 |
| G | 126-3994 | Duo-Cone Seal Installer | 1 |
| H | - | Loctite C5-A Anti-Seize Lubricant | |
| F | - | Loctite High Flex From-In-Place Gasket | |

Note: Cleanliness is an important factor. Before assembly, all parts should be cleaned in cleaning fluid. Allow the parts to air dry. Wiping cloths or rags should not be used to dry parts. Lint may be deposited on the parts which may cause later trouble. Inspect all parts. If any parts are worn or damaged, use new parts for replacement. All disassembly and all assembly procedures must be performed on a clean work surface and in a clean hydraulic area. Keep cleaned parts covered and protected at all times.

Note: O-rings, gaskets, and seals should always be replaced. A used O-ring may not have the same sealing properties as a new O-ring. Use **1U-6396** O-Ring Assembly Compound during the assembly procedure.

Note: Apply a light film of hydraulic oil to all components before assembly.

1. Install the final drive sprocket if the sprocket was removed from the main housing.
 2. Refer to Disassembly and Assembly, "Final Drive Sprocket - Remove and Install".
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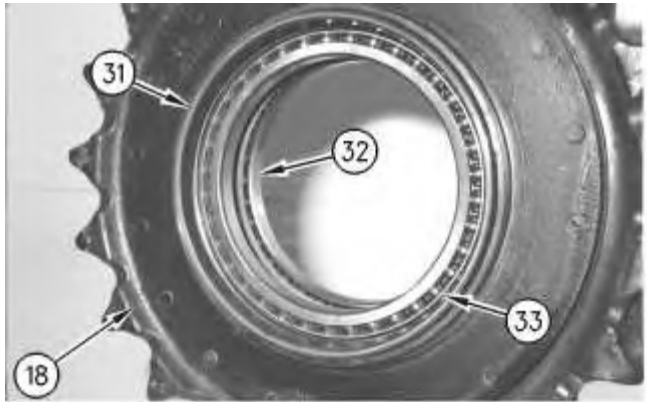


Illustration 1

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3. Apply Tooling (H) to the outer diameter of the bearings.
4. Install bearings (32) and (33) in main housing (18) with a suitable press.
5. Make sure that bearing (32) and bearing (33) contact the counter bore in the main housing.
6. Use the following procedure to preload the bearings and determine the correct thickness of shims.

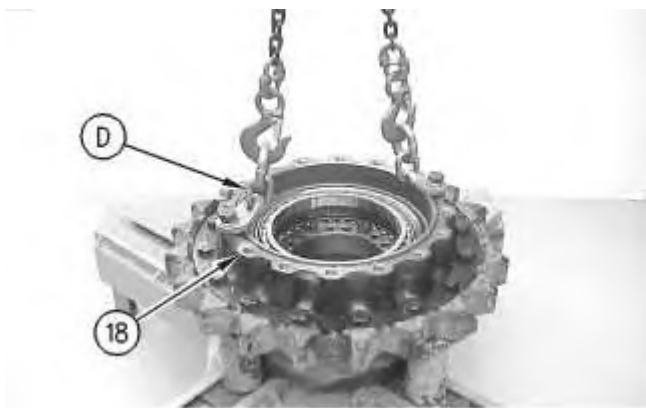


Illustration 2

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- a. Fasten Tooling (D) and a suitable lifting device to main housing (18). Install the main housing on the motor housing.
- b. Put the main housing and the motor housing in a suitable press.

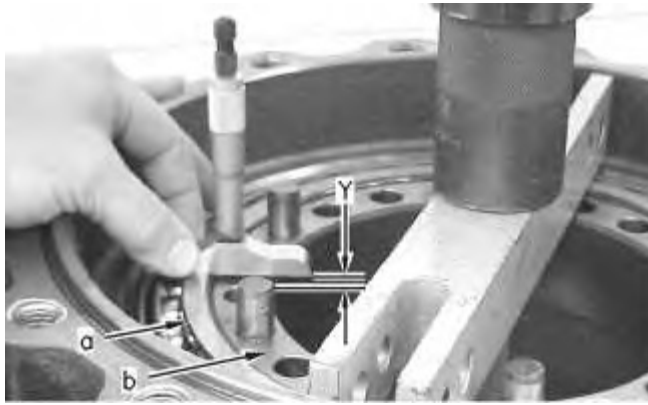


Illustration 3

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- (a) Bearing surface
- (b) Housing surface

- c. Use a suitable press and a spacer in order to apply a load of 4000 kg (8819 lb) on the bearings. Rotate the housing in order to seat the bearings.
- d. Reduce the load on the bearings to 1000 ± 100 kg (2205 ± 221 lb).
- e. Use a depth micrometer in order to measure the step length between the bearing surface and the housing surface. Take measurements at several different locations around the housing. Compute the average of the measured dimensions and record the number. Call this Dimension (Y).

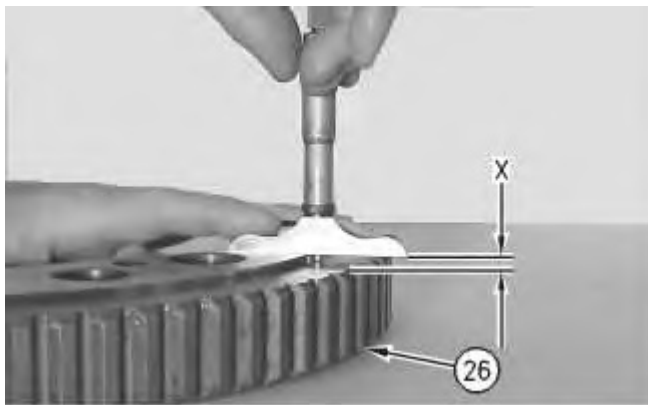


Illustration 4

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- f. Use a depth micrometer in order to measure the step length of gear (26). Take measurements at several different locations around the gear. Compute the average of the measured dimensions and record the number. Call this Dimension (X).
 - g. The thickness of the shims is equal to $(X - Y) \pm 0.05$ mm (0.002 inch).
- Note:** Use no more than two shims. If two shims are required, install the thinner shim next to the gear.
- h. Remove the main housing from the motor housing.

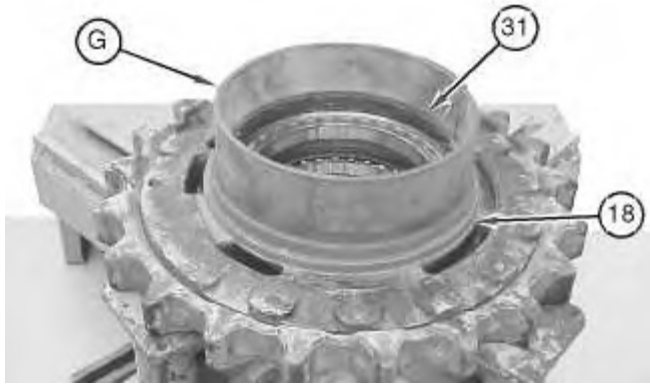


Illustration 5

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7. Use Tooling (G) in order to install Duo-Cone seal (31) in main housing (18). Refer to Disassembly and Assembly, "Duo-Cone Conventional Seals - Install".

Note: The rubber seals and all surfaces that contact the seals must be clean and dry. After installation of the seals, put clean SAE 30 oil on the contact surfaces of the metal seals.



Illustration 6

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8. Use Tooling (G) in order to install Duo-Cone seal (29) in motor housing (28).



Illustration 7

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9. Apply Tooling (H) to the surfaces that contact pins (30).

10. Install alignment pins (30).

Note: Do not damage the Duo-Cone seals in the main housing or in the motor housing during the assembly of the two components. After installation of the main housing on the motor housing, there will be a small gap between the components. The gap is caused by the Duo-Cone seals. This gap will be eliminated during installation of gear (26).

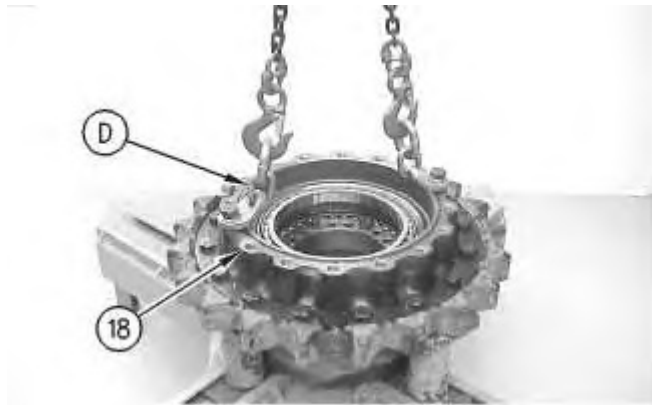


Illustration 8

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11. Fasten Tooling (D) and a suitable lifting device to main housing (18). Install the main housing on the motor housing.



Illustration 9

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12. Install shims (27) that were determined in Step 6.g in the main housing.

Note: If two shims are required, install the thinner shim next to the gear.



Illustration 10

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13. Install gear (26).
14. Install bolts (25) in gear (26). Install the bolts in an even pattern until the gear is seated against the bearing. Tighten bolts (25) in a crisscross pattern.

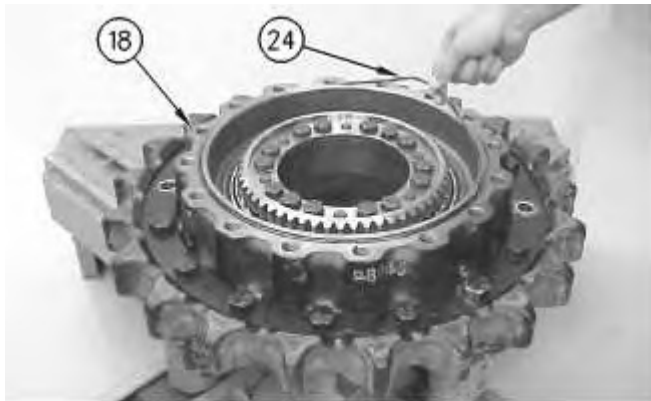


Illustration 11

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15. Install O-ring seal (24) to main housing (18).



Illustration 12

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16. Assemble carrier assembly (15), as follows.

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