

	3E-3882	Eyebolt	1
T	4C-4030	Loctite 242 Thread Locker	1

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## NOTICE

**Keep all parts clean from contaminants.**

**Contaminants may cause rapid wear and shortened component life.**

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**Note:** Cleanliness is an important factor. Before assembly, thoroughly clean all parts in cleaning fluid. Allow the parts to air dry. Do not use wiping cloths or rags to dry parts. Lint may be deposited on the parts which may cause trouble. Inspect all parts. If any parts are worn or damaged, use new parts for replacement. Dirt and other contaminants can damage the precision component. Perform assembly procedures on a clean work surface. Keep components covered and protected always.

**Note:** Lubricate all seal rings and O-ring seals prior to assembly.

**Note:** Check the O-ring seals, and the seals for wear or for damage. Replace the components, if necessary.

**Note:** Remove old anaerobic sealant from the bottom of the blind tapped holes in housing (237) before assembling.

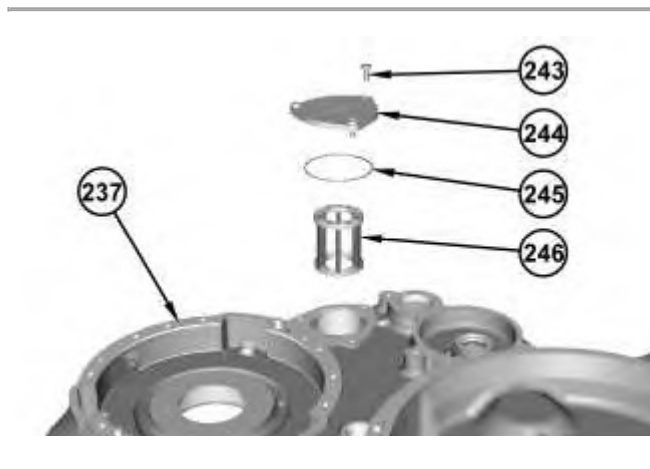
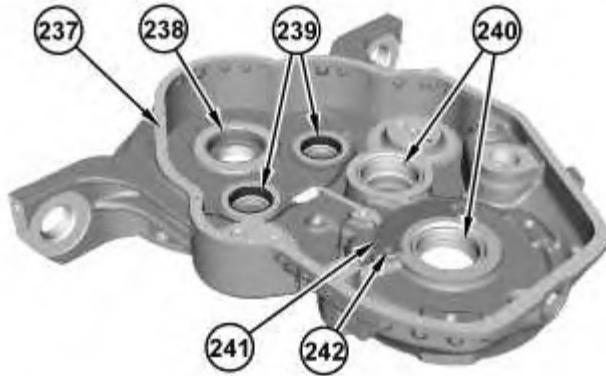


Illustration 1

g01389210

This Illustration is viewed from the bottom.

1. Install filter (246) and O-ring seal (245). Position cover (244) and install bolts (243). Tighten bolts (243) to a torque of  $28 \pm 7 \text{ N}\cdot\text{m}$  ( $21 \pm 5 \text{ lb ft}$ ).
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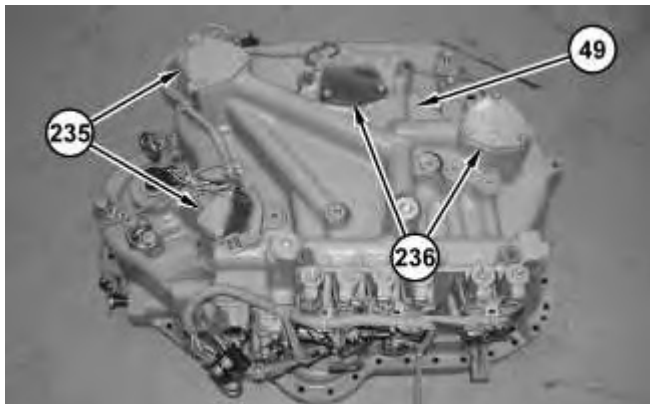


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Illustration 2

g01389019

2. Position plate (241) and install bolts (242). Tighten bolts (242) to a torque of  $12 \pm 3 \text{ N}\cdot\text{m}$  ( $106 \pm 27 \text{ lb in}$ ).
3. Lower the temperature of bearing outer races (240), (239), and (238). Install bearing outer races (240), (239), and (238) into housing (237).



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Illustration 3

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4. Install the O-ring seals and covers (236) onto housing (49). Tighten the bolts for covers (236) to a torque of  $28 \pm 7 \text{ N}\cdot\text{m}$  ( $21 \pm 5 \text{ lb ft}$ ). Install the O-ring seals and covers (235) onto housing (49). Tighten the bolts for covers (235) to a torque of  $28 \pm 7 \text{ N}\cdot\text{m}$  ( $21 \pm 5 \text{ lb ft}$ ).
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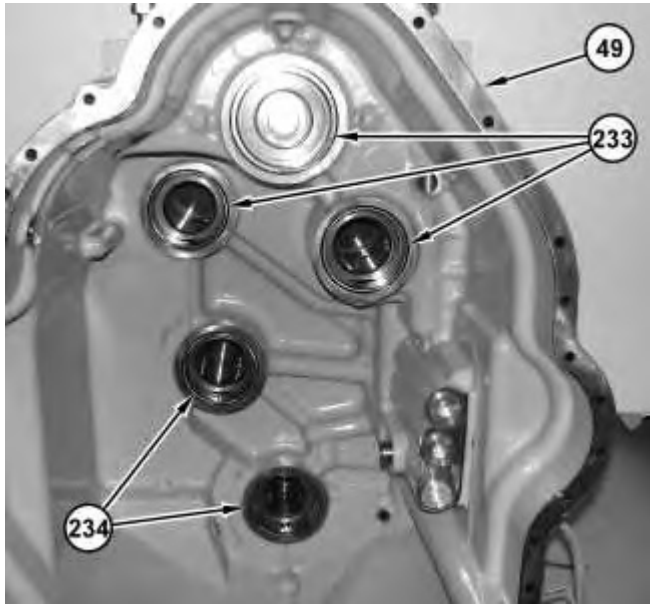


Illustration 4

g01394193

5. Lower the temperature of races (234) and races (233) . Install races (234) and races (233) into housing (49).

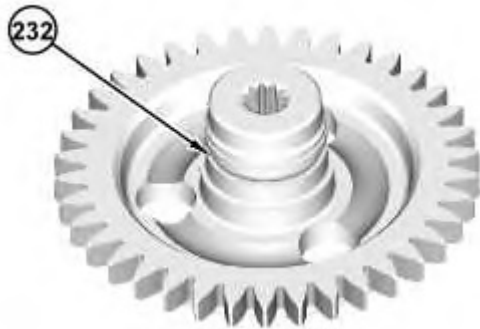
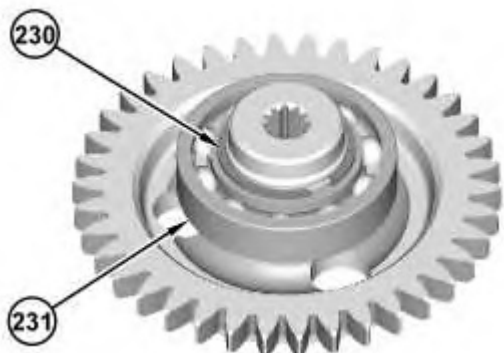


Illustration 5

g01394189

6. Install O-ring seal (232).



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