



Illustration 1

g01021697

1. Place housing (27) on Tooling (A) .
2. Use Tooling (G) in order to clean the Duo-cone seal gp prior to installation. Use Tooling (D) in order to install Duo-cone seal gp (28) into housing (27) .



Illustration 2

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3. Install bearings (30) into housing (26). Use Tooling (D) in order to install Duo-cone seal gp (29) into housing (26).
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Illustration 3

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4. Install Tooling (C) to housing (26). Use Tooling (C) and a suitable lifting device in order to install housing (26) onto housing (27) .

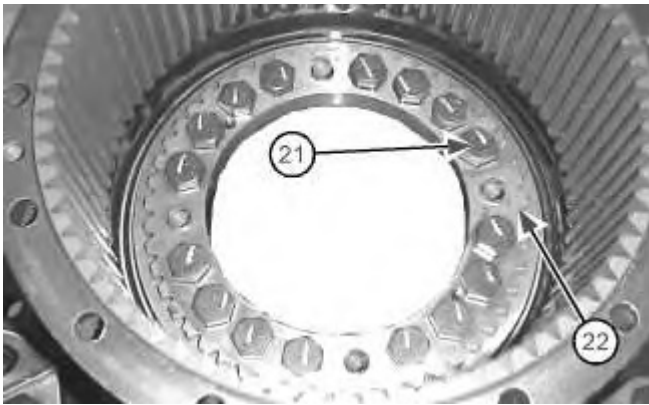


Illustration 4

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5. Install gear (22). Install bolts (21) in order to hold the two housings together. This is necessary in order to transport the housings to the press.

Note: The following steps are necessary in order to determine the proper shim or shims needed to set the rolling torque.

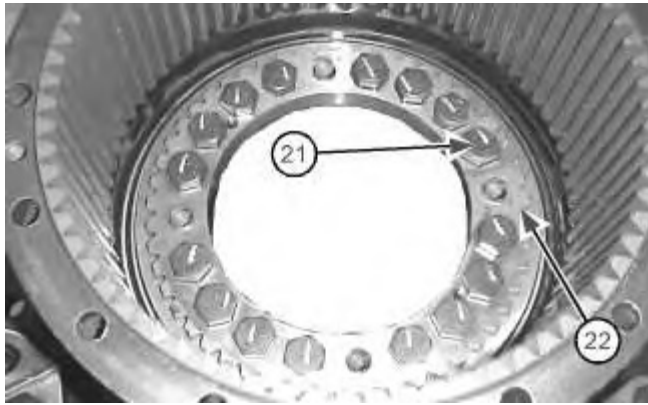


Illustration 5

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- a. Set the main housing assembly in a suitable press. Remove bolts (21). Remove gear (22) .

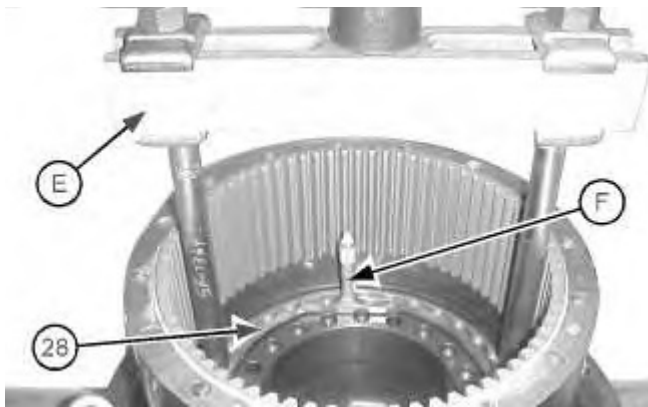


Illustration 6

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- b. Install Tooling (E). Use a suitable press in order to apply the load of 4000 kg (8818 lb). Rotate the housing in order to seat bearings (30). Reduce the load to 1000 ± 100 kg (2204 ± 220 lb).

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