

1. Install lip seals (32) and O-ring seal (33) in bearing cage (29).

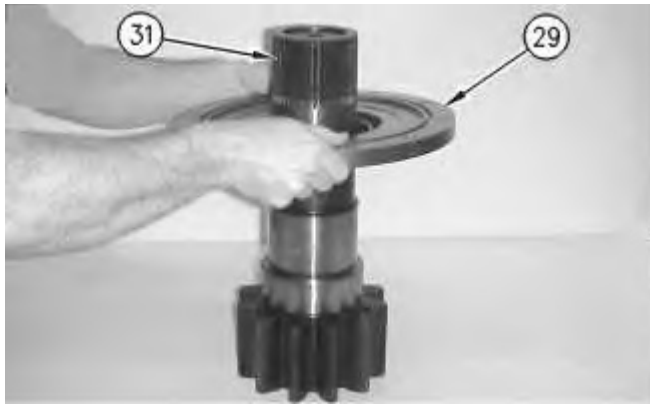


Illustration 2

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Note: Lubricate the seals and the seal surface of the shaft before you install the cage assembly.

2. Carefully install cage (29) on shaft (31).

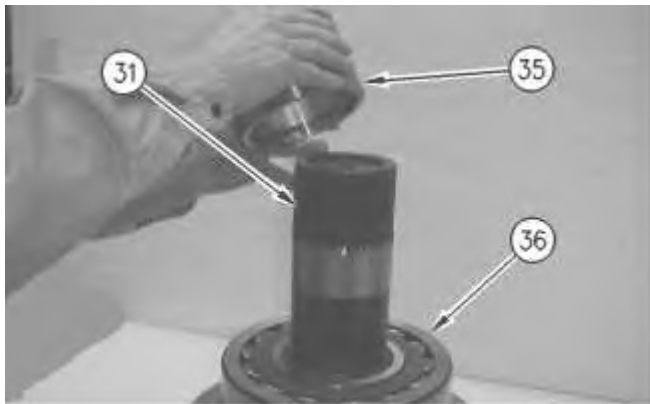


Illustration 3

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3. Raise the temperature of bearing (36) to 135 °C (275 °F) and use two people to install the bearing on shaft (31). The weight of bearing (36) is approximately 35 kg (77 lb).
 4. Install spacer (35) on shaft assembly (31). Install the spacer with relief against bearing (36).
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Illustration 4

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5. Raise the temperature of bearing (34) to 135 °C (275 °F). Install the bearing on shaft (31) and against spacer (35).

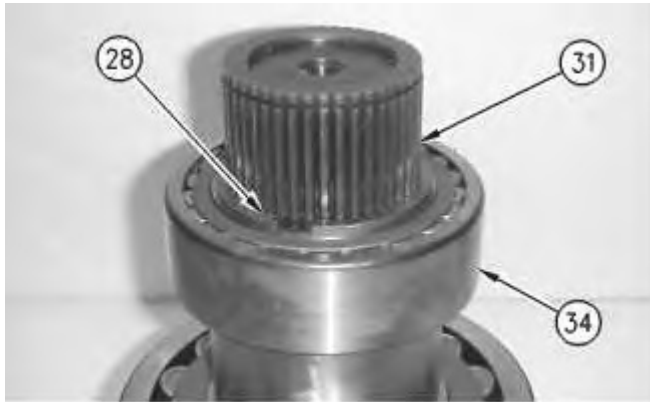


Illustration 5

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6. Use Tooling (A) to install retaining ring (28) on shaft (31) and against bearing (34).

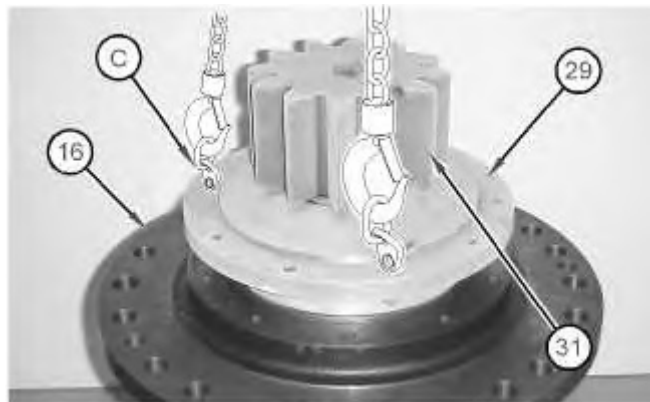


Illustration 6

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7. Install shaft assembly (31) in swing drive housing (16).

- a. Apply **5P-3931** Anti-Seize Compound on the inside diameter of swing drive housing (16).
- b. Lower the temperature of shaft assembly (31).
- c. Attach Tooling (C) and a suitable lifting device to the shaft assembly.
- d. Install the shaft assembly into swing drive housing (16). Bearing (34) must be within the bore of the swing drive housing.
- e. Remove Tooling (C) and the suitable lifting device from the shaft assembly. Attach Tooling (C) and the suitable lifting device to the swing drive housing.
- f. Lift the swing drive vertically. Use a hammer and a drift to align bearing (34) in the lower bore of the swing drive housing. When the bearing is properly aligned in the bore, shaft assembly (31) will drop into the proper position within the swing drive housing.

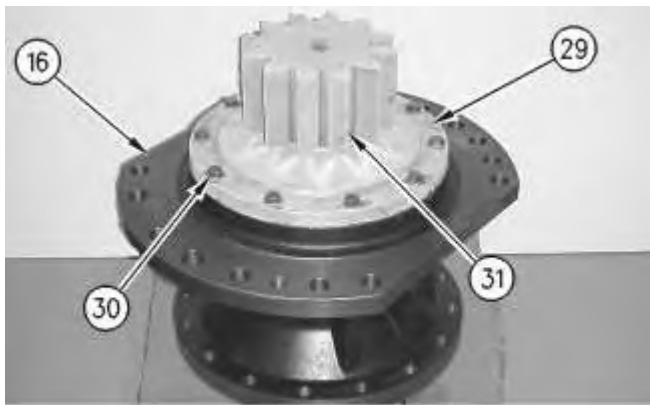


Illustration 7

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8. Apply **1U-8846** Sealant on the threads of bolts (30).
9. Install bolts (30) and washers in bearing cage (29) and swing drive housing (16).

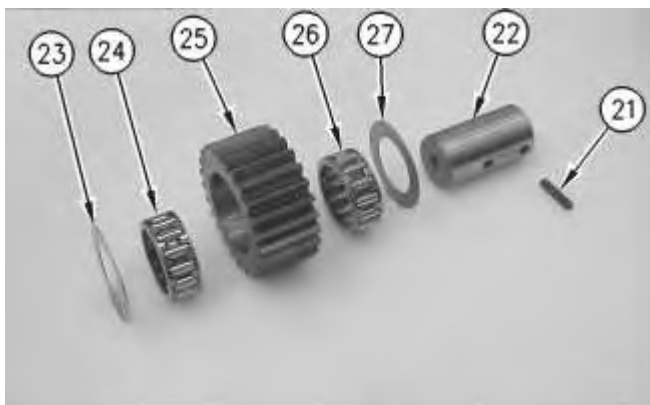


Illustration 8

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