

Illustration 1

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Illustration 2

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1. Lower the temperature of bearing cup (32) and install bearing cup (32) in housing (29). Check for full seating of the bearing cup with a Feeler Gauge.

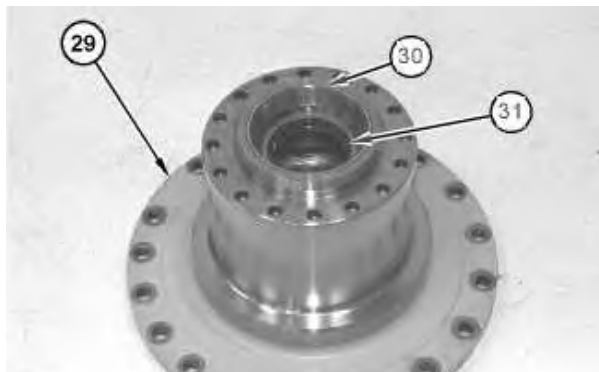


Illustration 3

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2. Place housing (29) in a vertical position with the flange downward.
3. Install lip seal (31) in housing (29). The lip of the seal must face outward. Lubricate the lip seal (31) with the lubricant which is being sealed.
4. Lower the temperature of bearing cup (30) and install bearing cup (30) in housing (29). Check for full seating of the bearing cup with a Feeler Gauge.

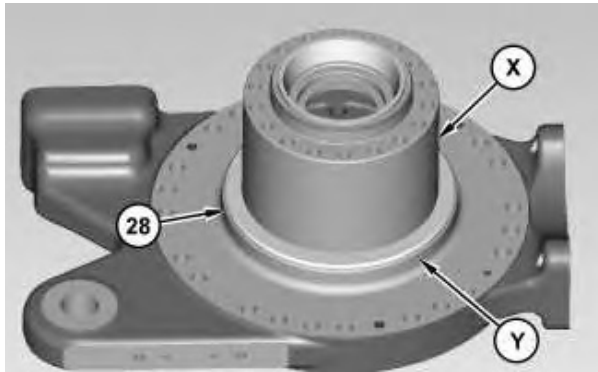


Illustration 4

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5. Apply Tooling (C) onto thrust washer (28). Apply Tooling (C) onto surface (X) and surface (Y). Install thrust washer (18).



Illustration 5

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6. Install lip seal (25) into housing (26).

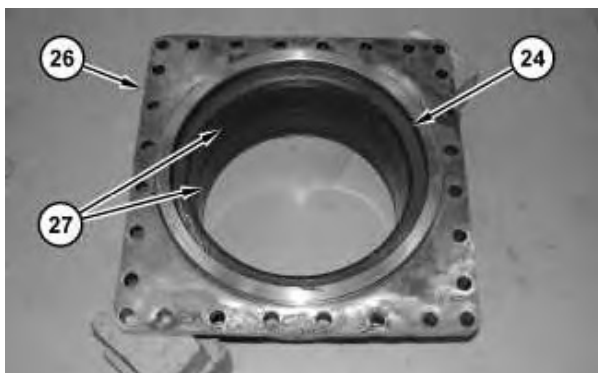


Illustration 6

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7. Turn over housing (26). Install wear sleeves (27). The diagonal cuts that are in wear sleeves (27) are separated by 90°. Apply Tooling (C) onto thrust washer (24). Install thrust washer (24).



Illustration 7

g02783245

8. Use Tooling (A) and a suitable lifting device to install housing (26). The weight of housing (26) is approximately 54 kg (120 lb). Install shims (23A). Use a suitable soft hammer to drive the wear sleeves into housing (26) until the sleeves are flush with the top of the bore surface. Do not install the shims at this time.

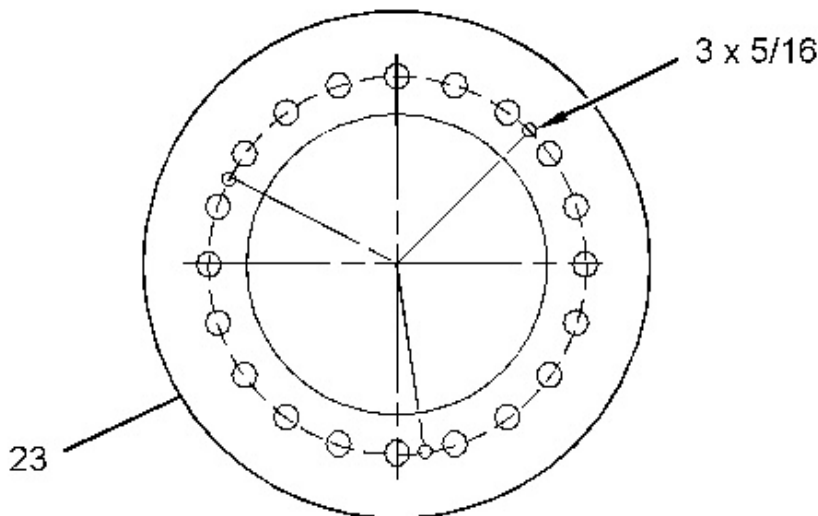


Illustration 8

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9. Drill three equally spaced 8 mm (5/16 inch) holes in retainer (23) if necessary. The holes must be centered on the existing bolt hole pattern and perpendicular to each surface.
 10. Measure the thickness of retainer (23) at the three hole locations. Average the three measurements and record the result as Dimension (A).
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