

DISASSEMBLY OF THE GEARBOX

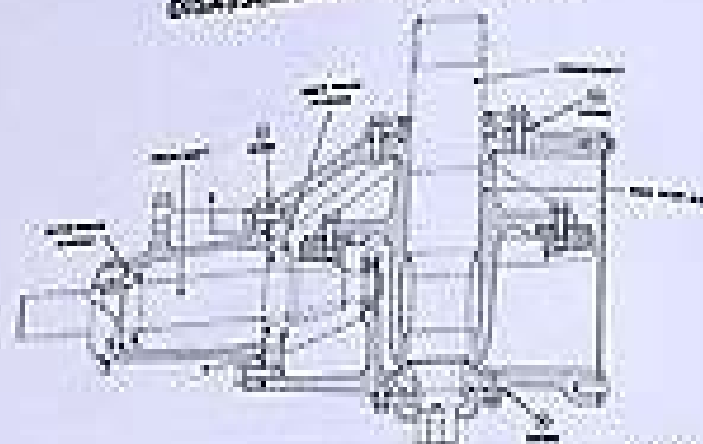


FIGURE 2-1

Remove the gearbox lock assembly from the main gearbox assembly by removing four 1/2" x 1/4" cap screws. Save the pins used at C, Figure 2-2.

Parts are to be identified by the numbers in Figure 2-2 and corresponding parts for the main gearbox should be maintained as shown.

1. Remove gearbox cover assembly by removing two 1/2" x 1/4" cap screws.
2. Remove bearing retainer, 14, from the left side of the gearbox (small end of the crankshaft) by removing four 1/2" x 1" cap screws and O-4 LockTite. After removing the bearing retainer, use care to avoid damaging the shaft.
3. Remove the shaft which was installed between the bearing retainer and the gear, four 1/2" x 1" cap screws. Save these shafts for later assembly of the gearbox.
4. Remove lock nut, 15, by tapping the end of lock washer, 14, which is facing it secure.
5. Remove lock nut lock washer and bearing, 15, if it is free of this unit.
6. Remove the bearing retainer on the opposite side of the gearbox (large end of crankshaft) by removing six 1/2" x 1/4" cap screws and O-4 LockTite. After disassembly remove the bearing retainer and inspect for any damage.
7. Remove pins located at A, Figure 2-2, and save them for reassembly of the gearbox. Remove bearing, 16, at this time. A is free.
8. Insert the 5/16" x 1/4" cap screw and tie washer at the small end of the crankshaft. This is the same cap screw and washer originally installed in the small end of the crankshaft.
9. Support the inner race of the bearing, 16, at the large end of the crankshaft on a section of 3/4" (36 mm) diameter pipe approximately 12" (30 cm) long. **NOTE:** It is important that the OD of the pipe be turned down slightly on the ends so the outside diameter does not interfere with the outer race of the bearing and result in damage. A section of pipe which has been threaded has been found to be correct in size. If a threaded section of pipe is not readily available, the OD of standard 1/2" (38 mm) pipe may be turned down 2/32".
10. Press the crankshaft out of the ring gear hub using a 20/32 ton hydraulic press.
11. Remove the crankshaft, the ring gear, and ring gear hub, and the bearings from the gearbox if they have not been removed before.

DISASSEMBLY OF THE GEARBOX HUB

1. Remove pin cap, 1, by removing four 5/16" x 1/4" hex head cap screws.

2. Unhook one end of the retaining the top of lock washer, 14, which hold the lock nut.
3. Remove lock nut.
4. Insert the original 1/2" x 1/4" cap screw in the third end of the lock washer and turn locknut tight. Remove pin cap and lock nut.

5. Remove bearings from pinion shaft. **NOTE:** When replacing any one ring gear and pinion or the ring gear hub, but not when pinion bearing, A, it is not necessary to replace the new pinion bearing race from the pinion shaft to maintain the same set. Figure 2-3, do not have to be placed. However, when replacing the inner pinion bearing, it is necessary to replace the inner pinion bearing race and change the location of where located at B, Figure 2-3.

ASSEMBLY



FIGURE 2-2

Examine the gear assembly for cracks or any other damage. If any damage or questionable quality is apparent, use a new gear box. Wash all parts very thoroughly. Inspect all parts for wear or damage, especially the ring gear and pinion. If any questionable parts are noted, replace them.

NOTE: If either the ring gear or the pinion is replaced, replace both of these parts so they are matched only in matched sets and must be used as matched sets. Numbers are marked on the circumference of the ring gear and the top-end of the pinion shaft. Do not use the set unless the numbers are the same. Replace any set of damaged bearings. Replace any oil seals which do not appear to be in good condition.

When the inner pinion bearing, B, is being replaced, determine the correct number of pins to be installed at C, Figure 2-2. This is necessary so the pinion is properly located with respect to the center of the ring gear.

Proper location means lining the top of the ring gear and inner hub A together, usually between 1 and 10, is stamped on the machined surface of the top of the inner gear hub as indicated in Figure 2-3. Another number is stamped on the machined surface of the front mounting lug of the gearbox neck, see Figure 2-4.

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Judd E. Hollander



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