

Remove drain plug and allow oil to drain. Remove the two socket head cap screws (14), then remove planetary carrier (12). Withdraw sun gear (11). Remove the three cap screws (10), retaining plate (9) and shaft (8). Then lift off ring gear (21). Remove wheel hub (4). Remove bearing cone (6) from ring gear (21). Remove oil seal (1), inner bearing cone (2), "O" ring (7) and, if necessary, bearing cups (3 and 5) from wheel hub (4).

Remove retaining rings (20), spacers (16) and planetary gears (18) with needle rollers (17) and spacers (18). Clean and inspect all parts and renew as necessary. Needle rollers (17) are available in a set of 276 and planetary gears (18) are available in a set of four.

Install first spacer plate (18) over pin in planetary carrier (12). Use petroleum jelly to hold needle rollers in place and install two rows of needle rollers in gear (18) with spacer (19) between the two rows. Install planetary gear and needle roller assembly over pin in planetary carrier. When all four planetary gears and needle rollers are installed, install second spacer plate (18) and secure with retaining rings (20).

If removed, install bearing caps (3 and 5) in both. Heat bearing caps (6) in a bearing oven to a temperature of 250° F (120° C) and install on ring gear (21) until seated.

WARNING: Always wear heat protective gloves when handling heated parts.

Install bearing cone (2), but do not install oil seal (1) at this time. Install Hub (2) on pivot bearing and install ring gear (21) and retaining plate (9) without shim(s) (8). Tighten pin screws (10) evenly to a torque

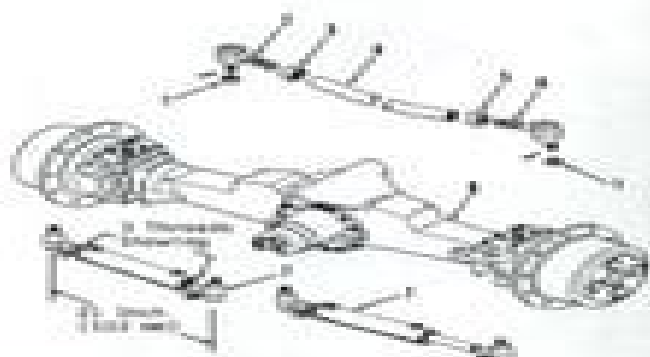


Fig. 5—Front drive axle, the roof and steering cylinders removed from tractor.

1. Blasted test
2. The red end (LR) channel
3. Jam test
4. The red tube
5. Jam test
6. The red end (SR) channel
7. Blasting cylinders
8. Drive side note

of 20 ft.-lbs. (27 N-m). Use a torque wrench and special tool CAA-1768 as shown in Fig. 7, to check rilling torque of hub. Tighten or loosen cap screws (10—Fig. 6) until rilling torque is 50-60 in.-lbs. (6-10 N-m). Then, using a depth micrometer through hole in retaining plate (9), measure distance from outer face of plate to end of pivot housing. See Fig. 8. Record this measurement. Remove retaining plate and measure thickness of the plate. Subtract this measurement from the first measurement. The difference will be the correct thickness of shim pack (8—Fig. 6) to be installed. Shims are available in thicknesses of 0.002, 0.002, 0.010, 0.020 and 0.030 inch (0.0254, 0.0508, 0.127, 0.254, 0.508 and 0.762 mm). Remove sun gear (11), ring gear (21) and hub (4). Install new oil seal (1) in hub with lip facing away from bearing (2). Reinstall hub, ring gear, correct shim pack and retaining plate. Install cap screws (10) and tighten to a torque of 65-75 ft.-lbs. (88-102 N-m). Install sun gear (11) and new "O" ring (7). Align holes for socket head screws (14) and install planetary carrier (12). Install socket head screws (14) and tighten securely. Rotate hub until oil level screw points downward. Remove shim (13) and fill planetary unit to level oil

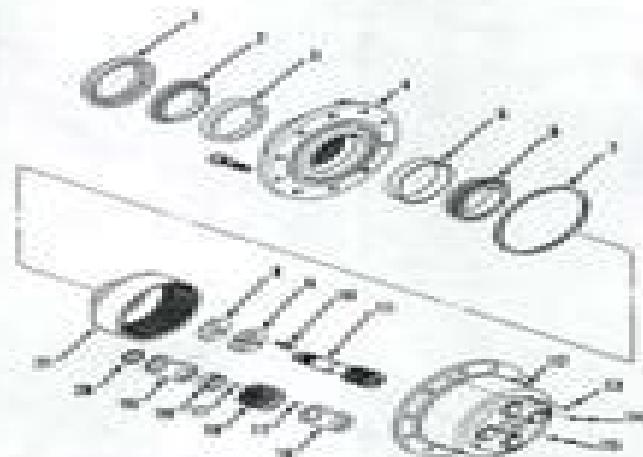


Fig. 8—Exploded view of exhaust bush and planetary unit
used on front drive axle.

- | | |
|---------------------------|-----------------------------|
| 1. Oak seed | 32. Transitory nurser |
| 2. Bearing cone (seaweed) | 33. Ping |
| 3. Bearing root | 34. Root-based screw (fish) |
| 4. Root | 35. Sprout |
| 5. Bearing trap | 36. Ping |
| 6. Bearing cone (seaweed) | 37. Sprout |
| 7. "CV" Ring | 38. Nuclei culture |
| 8. Root | 39. Transitory gear |
| 9. Retaining plate | 40. Sprout |
| 10. Cap screw (2) | 41. Retaining ring |
| 11. Root gear | 42. Root gear |

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Minjie Lin

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1. Understanding the eBook Case Ih 7110 Repair Manual
 - The Rise of Digital Reading Case Ih 7110 Repair Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Case Ih 7110 Repair Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Case Ih 7110 Repair Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Case Ih 7110 Repair Manual
 - Personalized Recommendations
 - Case Ih 7110 Repair Manual User Reviews and Ratings
 - Case Ih 7110 Repair Manual and Bestseller Lists
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- Case Ih 7110 Repair Manual Public Domain eBooks
- Case Ih 7110 Repair Manual eBook Subscription Services
- Case Ih 7110 Repair Manual Budget-Friendly Options
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 - ePub, PDF, MOBI, and More
 - Case Ih 7110 Repair Manual Compatibility with Devices
 - Case Ih 7110 Repair Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Case Ih 7110 Repair Manual
 - Highlighting and Note-Taking Case Ih 7110 Repair Manual
 - Interactive Elements Case Ih 7110 Repair Manual
- 8. Staying Engaged with Case Ih 7110 Repair Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Case Ih 7110 Repair Manual
- 9. Balancing eBooks and Physical Books Case Ih 7110 Repair Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Case Ih 7110 Repair Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Case Ih 7110 Repair Manual
 - Setting Reading Goals Case Ih 7110 Repair Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Case Ih 7110 Repair Manual
 - Fact-Checking eBook Content of Case Ih 7110 Repair Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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