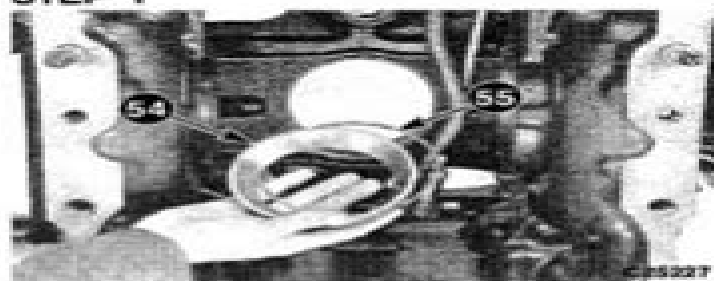


STEP 2

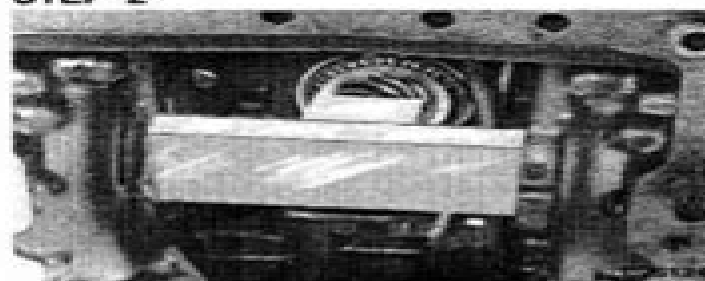
Set the pinion shaft bearing Preload. Refer to Pinion Bearing Preload Setting, see below.

IMPORTANT: When the pinion shaft bearing preload has been set, the pinion gear/ring gear tooth patterns **MUST** be checked, refer to Section 6012. If the tooth patterns are not correct pinion shaft and bearing cup must be removed and shims added or subtracted until the correct tooth pattern is obtained.

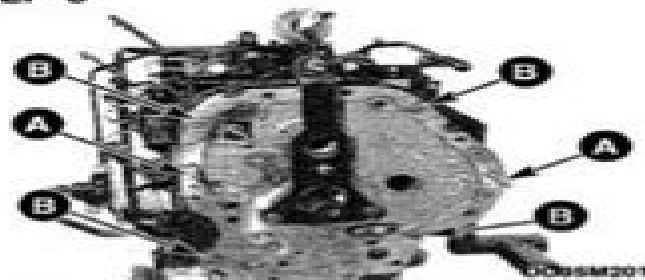
PINION BEARING PRELOAD SETTING**STEP 1**

Install the shims (55) determined during pinion shaft mounting distance setting. Use a suitable bearing driver and install the bearing cup (54). Make sure the bearing cup is installed evenly and the bearing cup and shims are against the shoulder in the transmission housing.

NOTE: If the pinion bearing has been replaced, install the old shims removed during the pinion shaft removal. If the old shims are damaged, measure the old shims and install new shims to the thickness of the old shims.

STEP 2

Lubricate the pinion bearing with clean transmission oil. Install and support the pinion shaft. Secure the pinion shaft in position with suitable blocks.

STEP 3

Install two alignment studs CAS1995 (A) into the transmission housing. Install the lifting bracket CAS1993 and suitable lifting equipment to the bearing carrier housing. Install the bearing carrier housing. Install and tighten four 16 x 100 mm temporary bolts (B) (minimum thread length of 40 mm) into the bearing carrier housing mounting holes as shown. Remove the lifting bracket CAS1995.

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Michael Hoelscher

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the author's name.

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