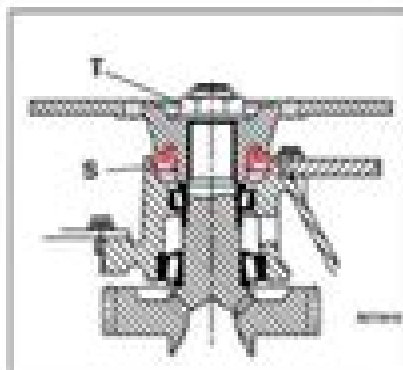


Assembly (cont'd)

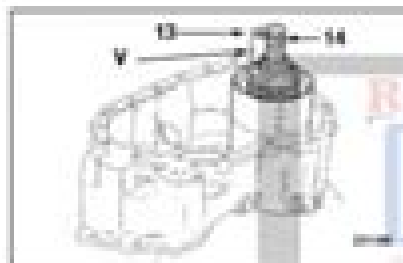
- 12 a. Remove nut B and sleeve A. Fit cone oil seal L, grease bearings and lip before fitting. Assemble leader shaft/flange. (The shaft/flange may be a tight fit.)
- b. Fit O-ring retaining nut T and progressively torque tighten to 300 Nm (217 ft-lb). Provided the correct size spacer has been selected the rolling torque should not exceed a maximum of 7.0 Nm (5.1 ft-lb) after fully torque adjustment.

Note: If the rolling torque measured is too high, fit the next larger size spacer. If the rolling torque is too low, fit the next smaller size spacer.

- c. Fully slide out T into slot.



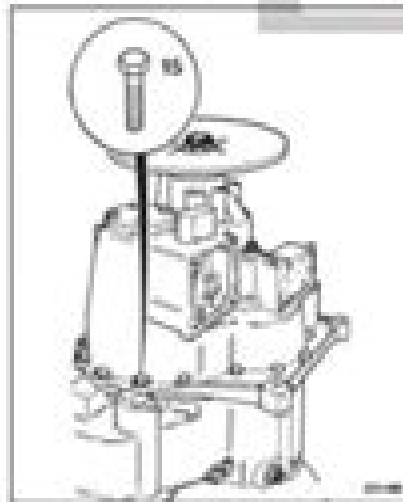
13. Press the gear spindle into casing. Ensure that oil drain hole V points toward bottom of casing.
14. Grease pinion dog and seal pack oilseal and bearing with XOL-10[®] Grease. Then carefully lower motor shaft into casing.



15. Assemble two halves of the casing together and tighten bolts to 50 Nm (37 ft-lb).

Note: Assembling the case halves at this stage is a temporary arrangement to enable measurement of the motor shaft and flut. DO NOT apply XOL-10[®] Grease & Sealant to the bolts at this stage or final casing close.

Note: To prevent damaging motor seal pinion dog seals, it is possible to remove the seal gear to assemble case halves. However this is applicable only whilst measuring motor shaft and flut. TEST THE SEAL BEFORE FINAL ASSEMBLY.

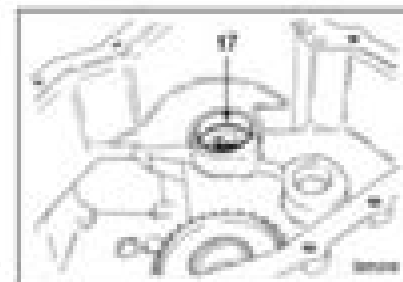
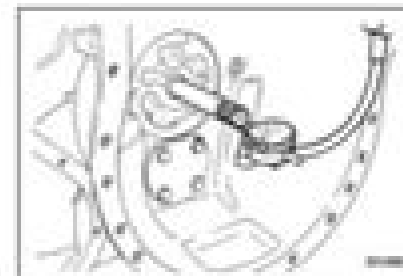


Assembly (cont'd)

16. Measure end flut of motor shaft which should be 0.07 to 0.08 mm (0.007 to 0.008 in).

Note: Rotate shaft whilst measuring to seat bearings fully. Positive position of oil seal indicates on the diameter of the shaft, not the seal face. This will ensure a consistent reading is given.

17. Separate two halves of casing and add or subtract shims (shown below) the bearing outer race in the case casing in order to correct motor shaft end flut.



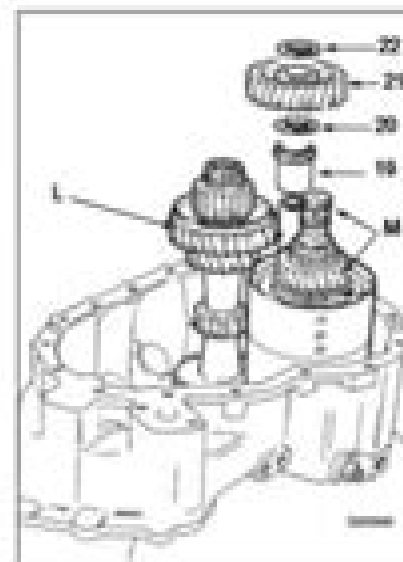
18. Grease motor shaft output seal bearing with XOL-10[®] Grease and place motor shaft in position. Tighten by motor assembly M.

19. Fit oiler gear spacer.

20. Fit final motor.

21. Fit spacer cup to fit gear (indicated L). Lubricate oiler gear spindle roller bearing and assemble to spindle while fitting motor shaft L to case side.

22. Fit final motor.



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