

Installation

- 01 Heat the output bearing's inner race to max. 110 °C. Place protection ring **1X56 138 187 (1)** onto the output bearing to do this.

NOTE

The shafts must be assembled correctly ready for installation.

**DANGER**

Only touch heated protective tool when wearing protective gloves.

- 02 Remove protection ring **1X56 138 187** and carefully insert the shafts fully into the transmission housing.
- 03 Pull the shafts into the correct axial position from the output end using a bushing (against the bearing inner race or speedometer worm) and a hex bolt (M12x1.5). Tightening torque = 120 Nm.

NOTE**Separate clutch housing version**

Check the installation is correct by measuring distance "B", see section 10.1. Remove the bushing and hex bolt.

- 04 Remove fixtures and auxiliary strip
- 05 Coat thread of articulated bolts with sealing compound. First screw in articulated bolts of 1st/2nd gear with spring washer.

NOTE

Articulated bolts for 1st/2nd gear (2) = approx 48.5 mm

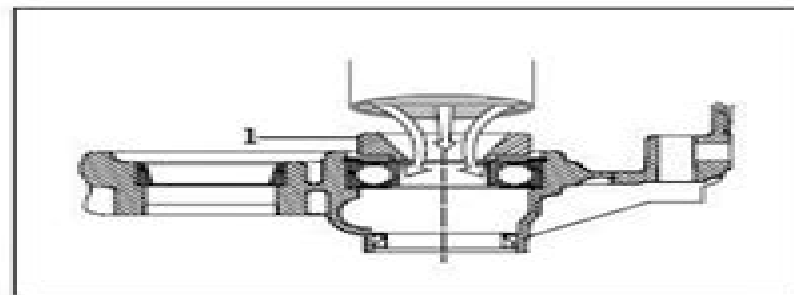
Articulated bolts for 3rd/4th gear (3) = approx 55.0 mm

Articulated bolts for 5th/6th gear (4) = approx 55.0 mm

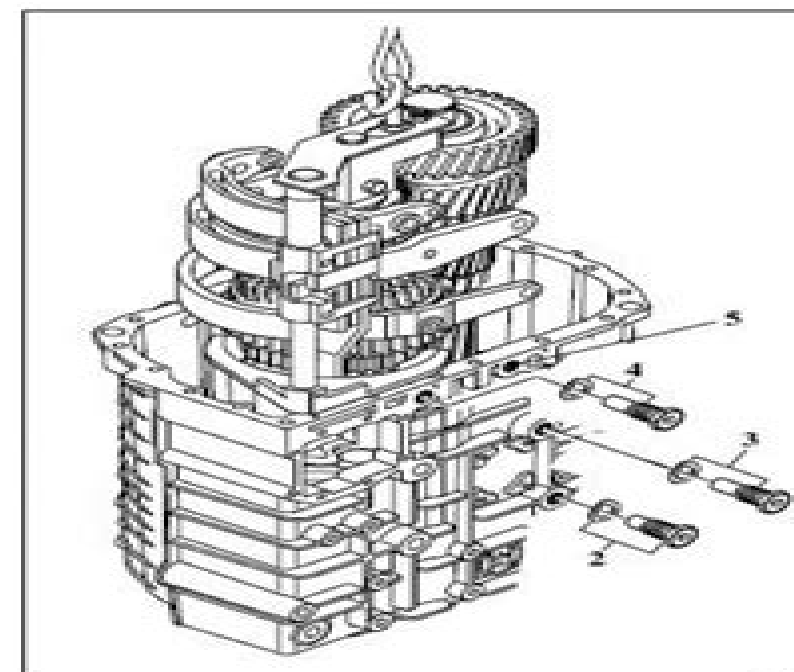
NOTE

Overdrive version (4),
direct drive version (5).

- 06 Screw in and tighten the remaining articulated bolts and spring washers as previously described. Tightening torque = 160 Nm.



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Gearbox Maintenance Manual

Yijin Wang



Gearbox Maintenance Manual:

AVUM and AVIM Maintenance Manual ,1988 **DS and GS Maintenance Manual** ,1992 *Manual Gearbox Design: A Practical Guide for Engineers* Pasquale De Marco,2025-08-10

Manual gearboxes are a vital part of many machines from cars and trucks to motorcycles and construction equipment They allow us to change the speed and torque of a rotating shaft which is essential for a wide variety of applications In this book we will cover the basics of manual gearbox design from the different types of gearboxes to the materials used in their construction We will also discuss the different types of gearbox tests and how to interpret the results Finally we will provide some tips on how to troubleshoot and repair gearbox problems Whether you are a student an engineer or a mechanic this book will provide you with the information you need to understand and work with manual gearboxes This book is divided into 10 chapters The first chapter provides an overview of manual gearboxes including their history benefits and challenges The second chapter covers the basics of manual gearbox design including the different types of gearboxes and their components The third chapter discusses gearbox design calculations including the mathematics of gearbox design and how to calculate the gear ratios torque and power requirements The fourth chapter covers gearbox manufacturing including the different methods of gearbox manufacturing the materials used and the quality control processes The fifth chapter covers gearbox testing including the different types of gearbox tests the purpose of each type of test and how to conduct and interpret gearbox tests The sixth chapter covers gearbox maintenance including the importance of gearbox maintenance the different types of gearbox maintenance and how to perform gearbox maintenance and troubleshoot gearbox problems The seventh chapter covers gearbox applications including the different applications of gearboxes the challenges of using gearboxes in different applications and how to select the right gearbox for a specific application The eighth chapter covers gearbox troubleshooting including the different types of gearbox problems the causes of gearbox problems and how to troubleshoot and repair gearbox problems The ninth chapter covers gearbox design trends including the latest trends in gearbox design the benefits of using new gearbox technologies and the challenges of using new gearbox technologies The tenth chapter covers gearbox resources including where to find information about gearboxes where to find gearbox suppliers and manufacturers and where to find gearbox repair services and training We hope that you find this book helpful and informative If you like this book write a review

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