

Remove pinion gear then measure the distance between mesh surface and bearing surface. This is measure "E".



Subtract measure "E" from measure "D". Note the result "F".
 $F = D - E$

The difference between result "F" and result "C" is the pinion shim thickness.

$F - C = \text{Pinion shim thickness}$

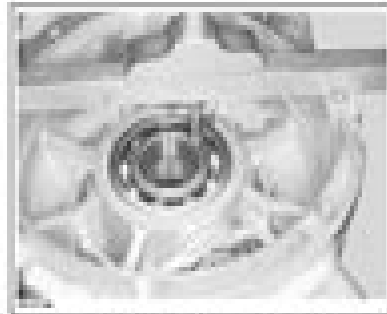
Determine the appropriate pinion shim using the following pinion gear shims for (P/N) 703 500 040.

THICKNESS	NOTCHES
0.25 mm (.010 in)	0
0.38 mm (.015 in)	1
0.51 mm (.020 in)	2
0.64 mm (.025 in)	3

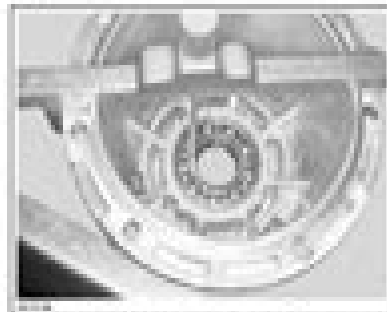
Install pinion, shims, bearing and pinion nut. Apply Loctite 243 to nut and torque to 56 Nm (71 ft-lb). Check if pinion gear teeth and ring gear teeth are equal.

After pinion installation, center ring gear carrier.

Take the half housing with pinion gear. Measure distance between housing edge and the inner ring of bearing. This is measure "H".



Measure the other half housing between housing edge and the inner ring of bearing. This is measure "H".



Measure the edge of half housing. This is measure "J".



Subtract the measure "J" from measure "H" then add this result to "G". Note the result "K".
 $G + (H - J) = K$ (housing inside length)

Measure ring gear carrier length. This is measure "L".



Measure the distance between the end of ring gear carrier and the bearing shoulder. Note the measure "M".



Take the same distance to the other end. This is measure "N".



Add measure "M" from measure "N". Subtract the result from measure "L". Note the result "P".

The result "P" is the length of ring gear carrier between bearings.

$L - (M + N) = P$

Subtract result "P" from "K". At this measure subtract the clearance 0.127 mm (.005 in). The result is the shim thickness.

$K - P = X - 0.127 \text{ mm (.005 in)} = \text{shim thickness}$

Determine the appropriate shim using the following ring gear carrier shims for (P/N) 703 500 040.

THICKNESS	NOTCHES
0.25 mm (.010 in)	0
0.38 mm (.015 in)	1
0.51 mm (.020 in)	2
0.64 mm (.025 in)	3
0.76 mm (.030 in)	4

Distribute total shim thickness between both end of ring gear carrier to obtain specified backlash between ring gear and pinion gear.

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