

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

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Table of Contents Gearbox Maintenance Manual

1. Understanding the eBook Gearbox Maintenance Manual
 - The Rise of Digital Reading Gearbox Maintenance Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Gearbox Maintenance 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 Gearbox Maintenance Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Gearbox Maintenance Manual
 - Personalized Recommendations
 - Gearbox Maintenance Manual User Reviews and Ratings
 - Gearbox Maintenance Manual and Bestseller Lists
5. Accessing Gearbox Maintenance Manual Free and Paid eBooks
 - Gearbox Maintenance Manual Public Domain eBooks
 - Gearbox Maintenance Manual eBook Subscription Services
 - Gearbox Maintenance Manual Budget-Friendly Options

6. Navigating Gearbox Maintenance Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Gearbox Maintenance Manual Compatibility with Devices
 - Gearbox Maintenance Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Gearbox Maintenance Manual
 - Highlighting and Note-Taking Gearbox Maintenance Manual
 - Interactive Elements Gearbox Maintenance Manual
8. Staying Engaged with Gearbox Maintenance Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Gearbox Maintenance Manual
9. Balancing eBooks and Physical Books Gearbox Maintenance Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Gearbox Maintenance Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Gearbox Maintenance Manual
 - Setting Reading Goals Gearbox Maintenance Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Gearbox Maintenance Manual
 - Fact-Checking eBook Content of Gearbox Maintenance 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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