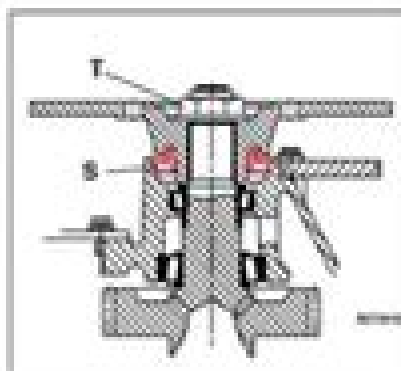


Assembly (cont'd)

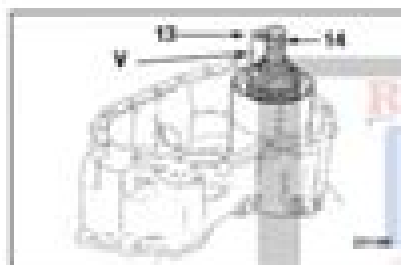
- 12 a. Remove nut B and sleeve A. Fit new oil seal S, grease between seal lip and fitting. Assemble roller shaft flange. (The flange may be a tight fit).
- b. Fit 1000 rotating nut T and progressively torque tighten to 300 Nm (217 lbf ft), provided the correct size spacer has been selected the rolling torque should not exceed a maximum of 7.0 Nm (5.1 lbf ft) when fully torque tightened.

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 nut T into slot.



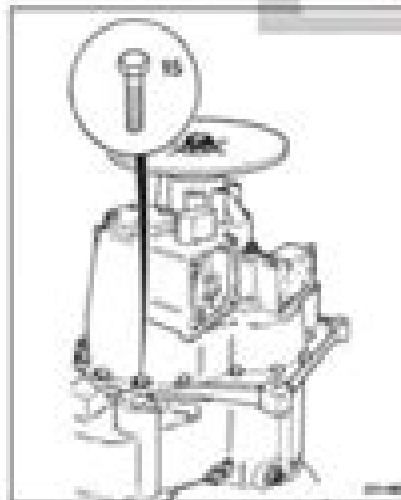
- 13 Press the gear spindle into casing. Ensure that its drive hole V points toward bottom of casing.
- 14 Grease piston ring seal and pack oilseal seal bearing with J30 100 Grease. Then carefully lower motor shaft into casing.



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

Note: Assembling the case halves at this stage is a temporary arrangement to enable measurement of the motor shaft and flut. DO NOT apply J30 Threadlocker B. (Refer to the bolts at this stage or final casing bore).

Note: To prevent damaging motor seal piston ring seals, it is preferable to remove the seals prior to assembling case halves. However this is applicable only whilst measuring motor shaft and flut. TEST THE SEALS BEFORE FINAL ASSEMBLY.



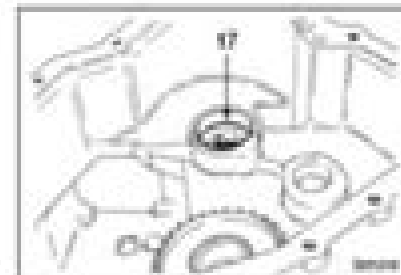
Assembly (cont'd)

- 16 Measure end flut of motor shaft which should be 0.00 to 0.03 mm (0.001 to 0.001 in).

Note: Rotate shaft whilst measuring to test bearings fully. Positive pointer of dial test indicator on the diameter of the shaft, not the end face. This will ensure a constant reading is given.



- 17 Separate two halves of casing and add or subtract shims (flat beneath the bearing outer race for the rear casing) in order to correct motor shaft end flut.



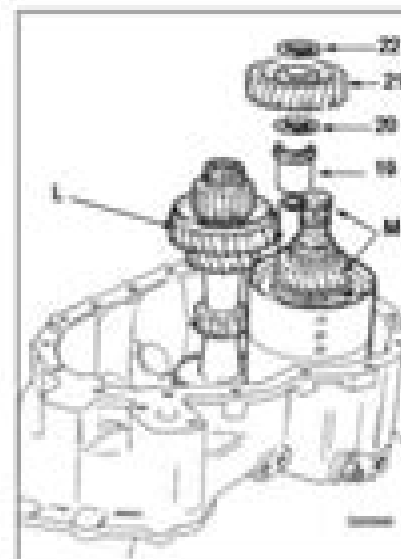
- 18 Grease motor shaft output seal bearing with J30 100 Grease and place motor shaft in position, followed by motor assembly M.

- 19 Fit after gear spacer.

- 20 Fit front motor.

- 21 Fit spacer cup to 3rd gear (provided L). Lubricate after gear spindle roller bearing and assemble to spindle while fitting motor shaft L to case side.

- 22 Fit front motor.



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Xiang Xie



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