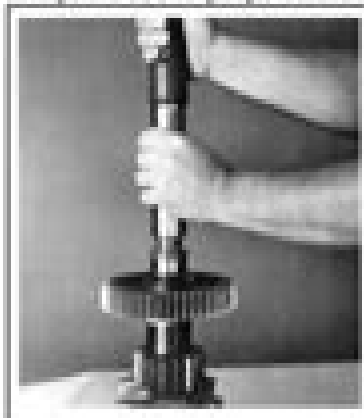




5. Install the synchronizer assembly on splines of range mainshaft, line range ring towards rear.

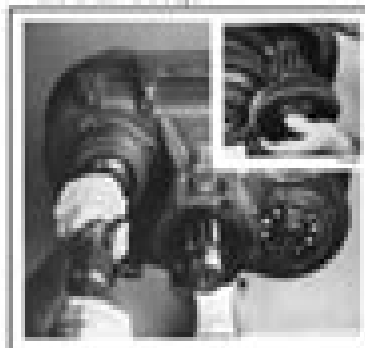


Timing And Installation Of Auxiliary Countershaft Assembly

1. If previously removed, install the bearing cover over rear on front of each countershaft.

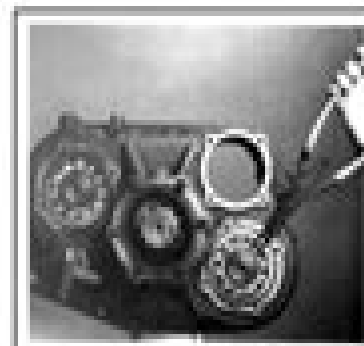


2. On the low range gear of each auxiliary countershaft assembly locate the "Q" stamped on one tooth. Align tooth with "Q", with smaller (deep reduction gear tooth and mark with high visible color of lubrication dye.



3. Place one countershaft into position in housing, matching the marked tooth of countershaft gear with either set of two marked teeth of mainshaft (deep reduction gear (front). Center rear of countershaft in bearing bore, slide rear bearing in bore and complete installation with a tapered-and driver and mallet. Repeat the procedure with other auxiliary countershaft assembly making sure the deep reduction gear set remains in line during bearing installation.

Note: Check synchronizer assembly for springs that may be released during bearing installation.

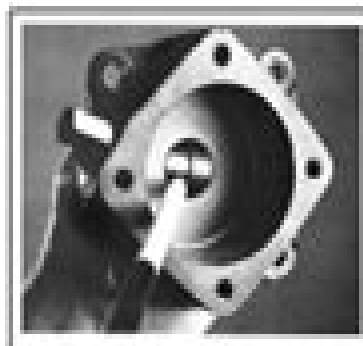


4. Install the range ring in groove at rear of each countershaft.



5. Position the corresponding new gasket on cover mounting surface and install both rear bearing covers. Tighten cap screws to secure covers to auxiliary housing.

Note: For reassembly and installation of models equipped with an Auxiliary Oil Pump Assembly on rear of countershaft, see **OPTIONAL**.



Reassembly And Installation Of Range Cylinder Assembly

1. If previously removed, install the spring in bore of range cylinder housing.



2. Position the corresponding new gasket on housing mounting surface and install the cylinder housing in rear bore of auxiliary housing, as fitting to the upper left. Tighten cap screws to secure cylinder housing to auxiliary housing.

Htc Kaier Service Manual User Guide

Scott C. Dulebohn



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