

**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

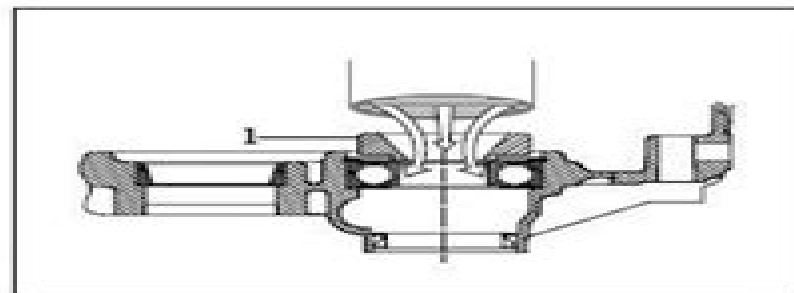
Articulated bolts for 3rd/4th gear (3) = approx 55.0 mm

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

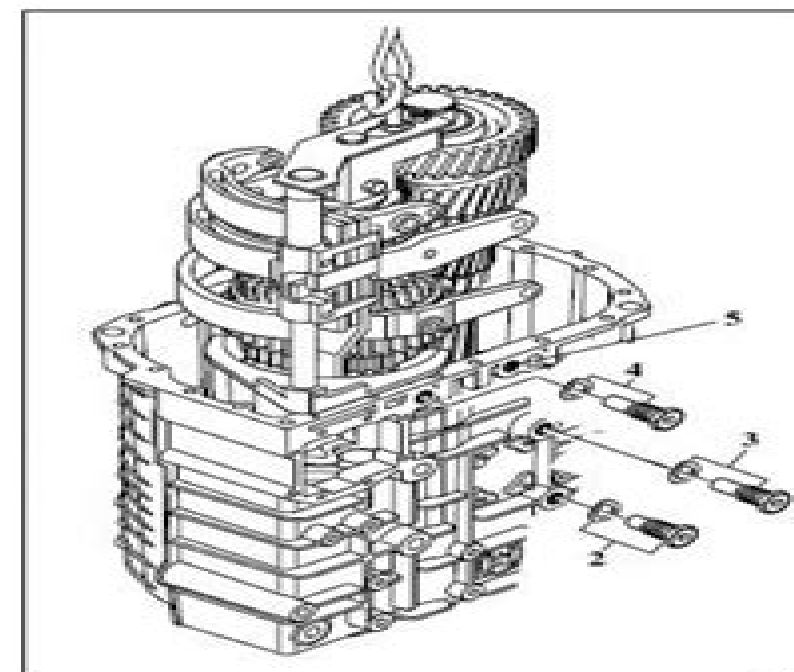
**NOTE**

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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# Manual Gearbox Man Repair Manual

**ML Morrison**



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## **Table of Contents Manual Gearbox Man Repair Manual**

1. Understanding the eBook Manual Gearbox Man Repair Manual
  - The Rise of Digital Reading Manual Gearbox Man Repair Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Manual Gearbox Man Repair 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 Manual Gearbox Man Repair Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Manual Gearbox Man Repair Manual
  - Personalized Recommendations
  - Manual Gearbox Man Repair Manual User Reviews and Ratings
  - Manual Gearbox Man Repair Manual and Bestseller Lists

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