#### Inestalliation

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.

#### A 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 boilt.

- 04 Remove fixtures and auxiliary strip
- 05 Coat thread of articulated bolts with scaling compound. First screw in articulated bolts of 1st/2nd gear with spring washer.

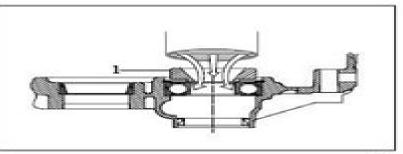
#### NOTE

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

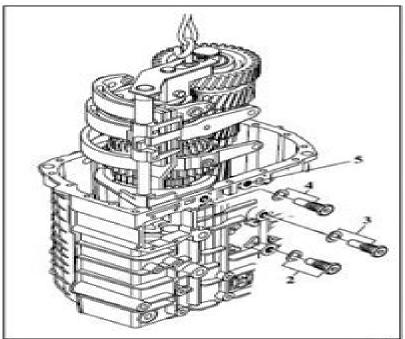
#### NOTE

Overdrive version (4), direct drive version (5).

O6 Screw in and tighten the remaining articulated bolts and spring washers as previously described. Tightening torque = 160 Nm.



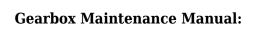
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Puja Mehta



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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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