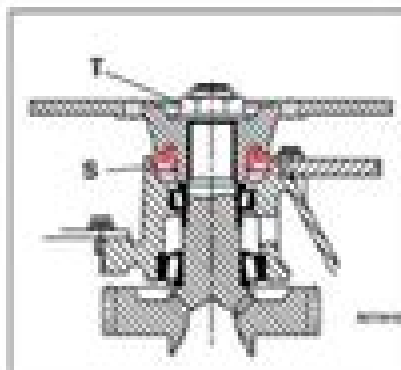


Assembly (cont'd)

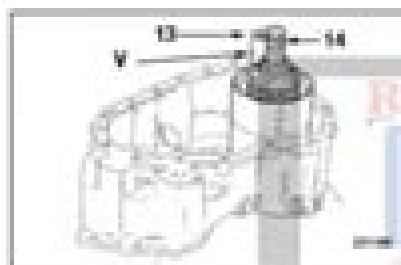
- 12 a. Remove nut B and sleeve A. Fit new oil seal S, grease between seal lip and fitting. Assemble roller shaft flange. (The flange may be a tight fit).
- b. Fit RTW retaining nut T and progressively torque tighten to 300 Nm (217 lbf ft), provided the correct size spacer has been selected. The rolling 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.



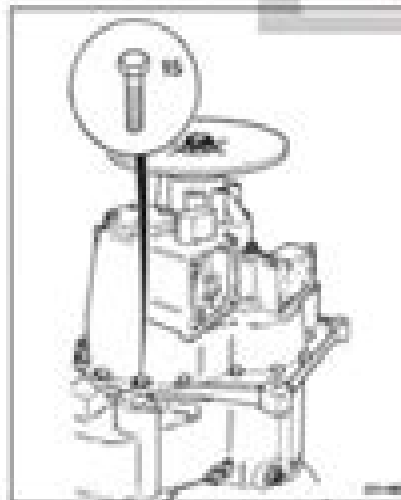
- 13 Press the gear spindle into casing. Ensure that its drive hole V points toward bottom of casing.
- 14 Grease piston ring seal and pack oilseal and bearing with J30 HP Grease. Then carefully lower motor shaft into casing.



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

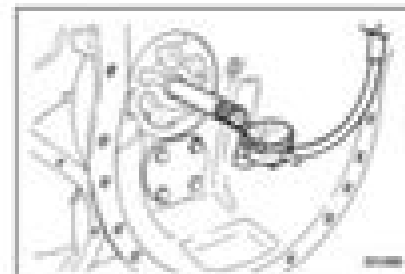
Note: Assembling the case halves at this stage is a temporary arrangement to enable measurement of the motor shaft and flut. DO NOT apply J30 Threadlocker B. (Refer to the bolts at this stage or final casing bore).

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

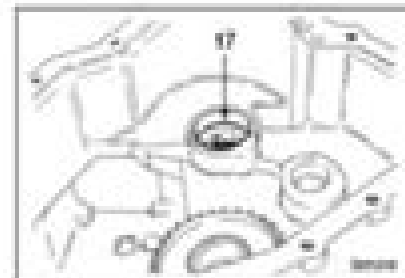
**Assembly (cont'd)**

- 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 shoulder 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.



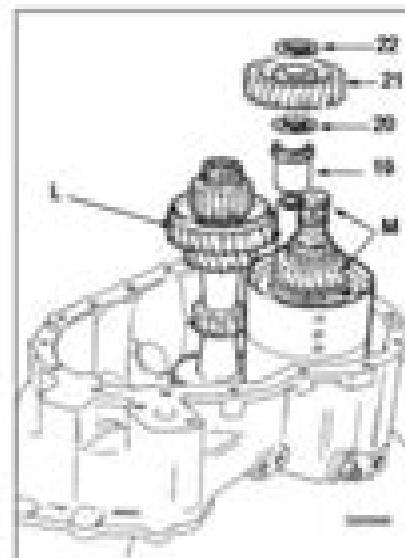
- 18 Grease motor shaft output seal and bearing with J30 HP Grease and place material L in position, followed by motor assembly M.

- 19 Fit after gear spacer.

- 20 Fit front motor.

- 21 Fit spacer cup to 3rd gear (optional L). Lubricate after gear spindle roller bearing and assemble to spindle while fitting material L to rear side.

- 22 Fit front motor.



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J Elliott



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Table of Contents Jcb 520 Loader Operators Manual

1. Understanding the eBook Jcb 520 Loader Operators Manual
 - The Rise of Digital Reading Jcb 520 Loader Operators Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Jcb 520 Loader Operators 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 Jcb 520 Loader Operators Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Jcb 520 Loader Operators Manual
 - Personalized Recommendations
 - Jcb 520 Loader Operators Manual User Reviews and Ratings

- Jcb 520 Loader Operators Manual and Bestseller Lists
- 5. Accessing Jcb 520 Loader Operators Manual Free and Paid eBooks
 - Jcb 520 Loader Operators Manual Public Domain eBooks
 - Jcb 520 Loader Operators Manual eBook Subscription Services
 - Jcb 520 Loader Operators Manual Budget-Friendly Options
- 6. Navigating Jcb 520 Loader Operators Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Jcb 520 Loader Operators Manual Compatibility with Devices
 - Jcb 520 Loader Operators Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Jcb 520 Loader Operators Manual
 - Highlighting and Note-Taking Jcb 520 Loader Operators Manual
 - Interactive Elements Jcb 520 Loader Operators Manual
- 8. Staying Engaged with Jcb 520 Loader Operators Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Jcb 520 Loader Operators Manual
- 9. Balancing eBooks and Physical Books Jcb 520 Loader Operators Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Jcb 520 Loader Operators Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Jcb 520 Loader Operators Manual
 - Setting Reading Goals Jcb 520 Loader Operators Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Jcb 520 Loader Operators Manual
 - Fact-Checking eBook Content of Jcb 520 Loader Operators 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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