

Illustration 1

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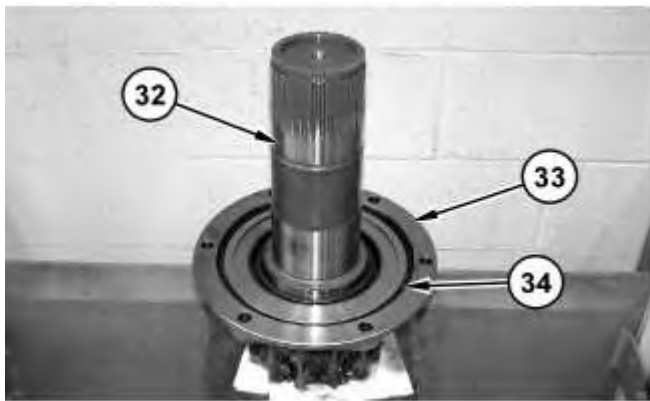


Illustration 2

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1. Use a suitable press and Tooling (G) in order to install lip seal (35) into cage (33).
2. Use two people to place shaft (32) in a suitable press. The weight of shaft (32) is approximately 30 kg (65 lb). Install cage (33). Install O-ring seal (34).

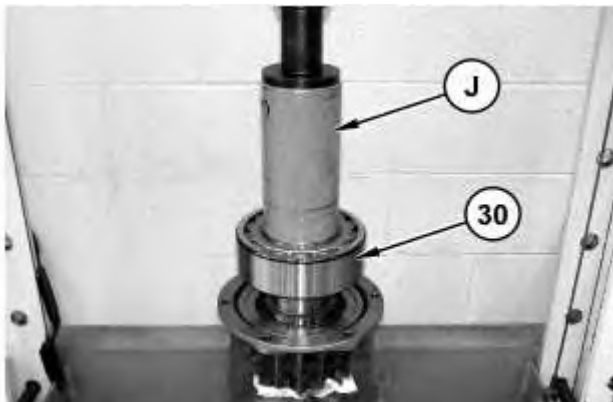


Illustration 3

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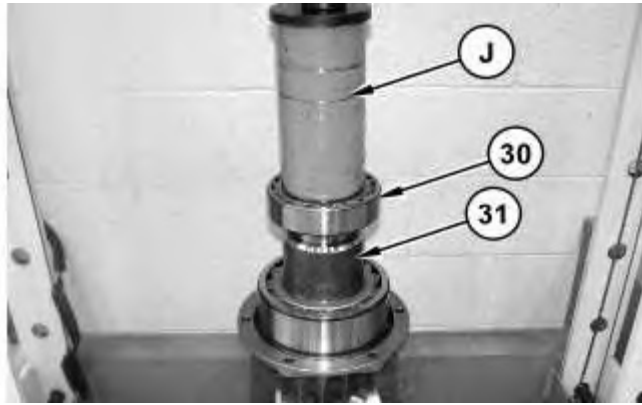


Illustration 4

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3. Apply Tooling (H) to inner diameter of the bearing and the shaft. Use a suitable press and Tooling (J) in order to install bearing (30). Install spacer (31). The bevel of the spacer must face upward.

4. Install bearing (30).



Illustration 5

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Illustration 6

g01339903

5. Attach a suitable lifting device to shaft assembly (29). Use Tooling (A) in order to install retaining ring (19). Install shaft assembly (29) onto Tooling (E). Remove the suitable lifting device.
6. Attach Tooling (B) and a suitable lifting device to housing (28). Install housing (28) on the shaft assembly. Position the shaft assembly to the side by 90 degrees. Remove tooling (E).

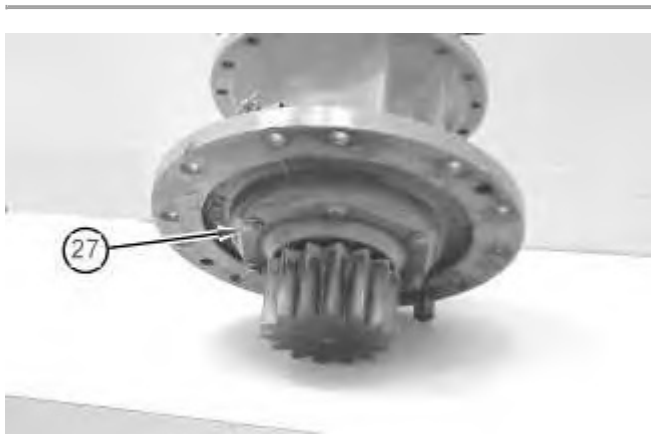


Illustration 7

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7. Install bolts (27).

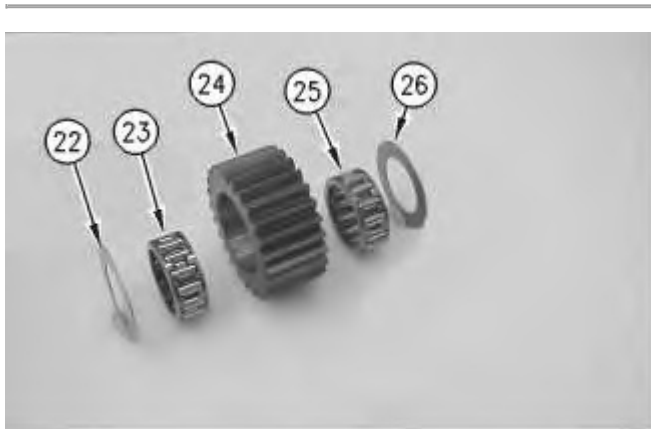
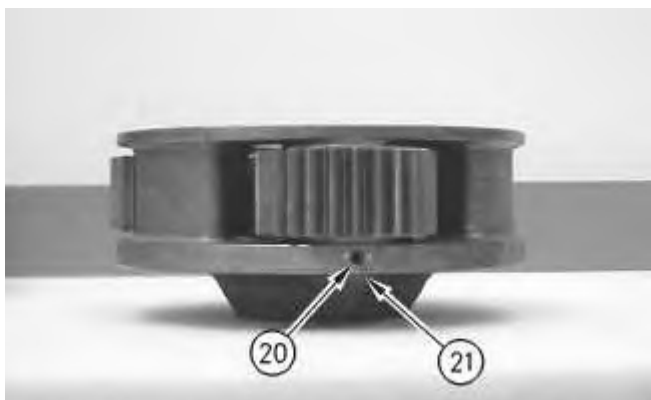


Illustration 8

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8. Assemble the gear assembly, as follows: washer (22), bearing (23), gear (24), bearing (25), and washer (26).



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