

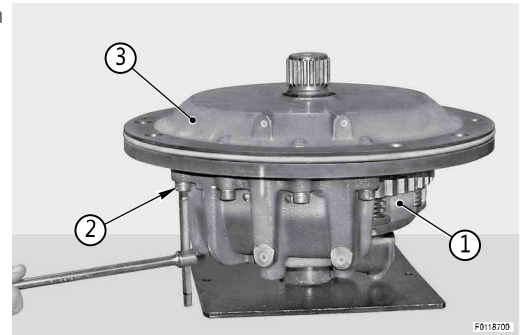


Disassembly of shuttle assembly

Disassembly

Position shuttle assembly (1) on a suitable stand and remove the seven screws (2).

- Mark flange (3) and the support to facilitate assembly operations.



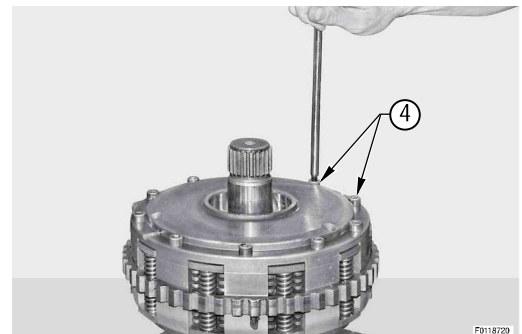
1.

Remove flange assembly (3).



2.

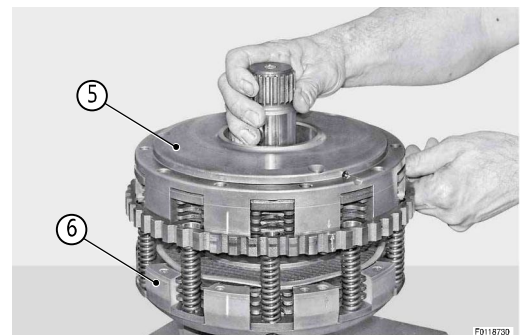
Remove screws (4) (no. 10).



3.

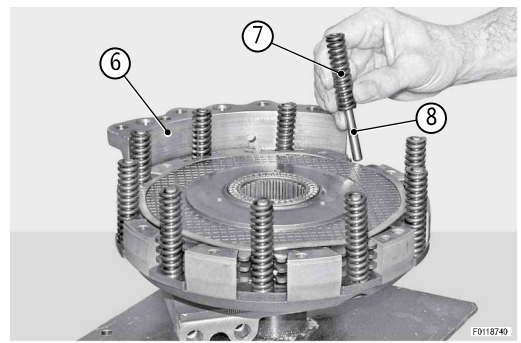
Remove clutch assembly (5) of the forward gear.

- Mark clutch assemblies (5) and (6) to facilitate reassembly.



4.

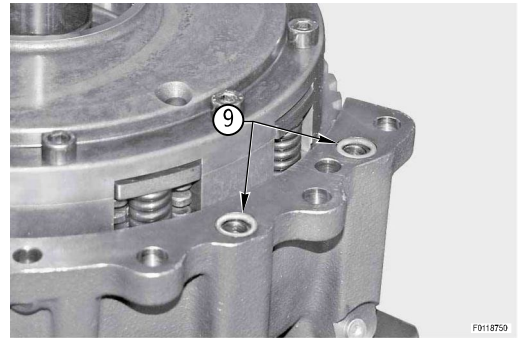
Recover springs (7) and pins (8) from clutch assembly (6) of the reverse gear.



5.

Remove O-rings (9).

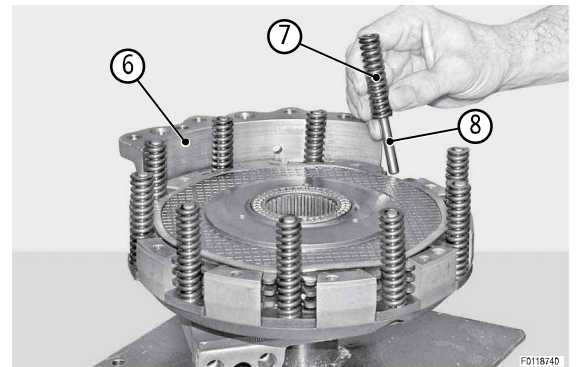
- Renew the O-rings on reassembly.



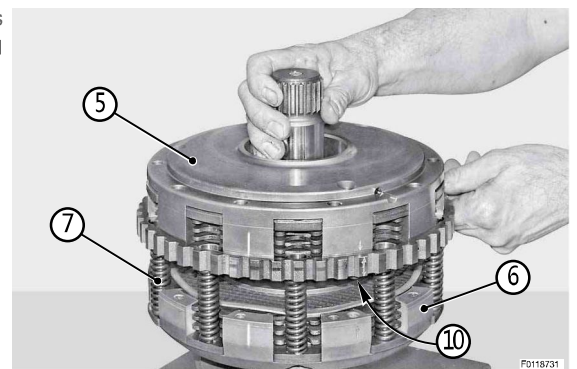
6.

Assembly

Locate springs (7) and pins (8) in clutch assembly (6).

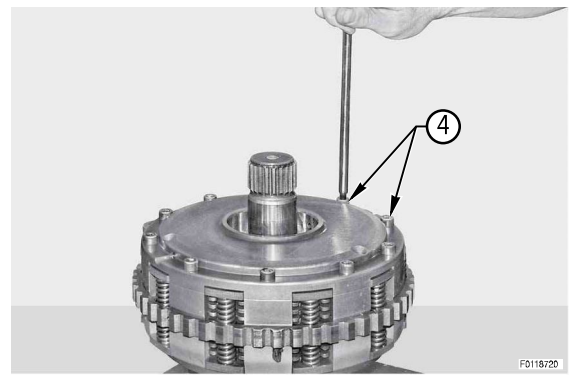


Locate clutch assembly (5), making sure that springs (7) are positioned in the holes and that centring pin (10) is aligned with the corresponding hole in clutch housing (6).

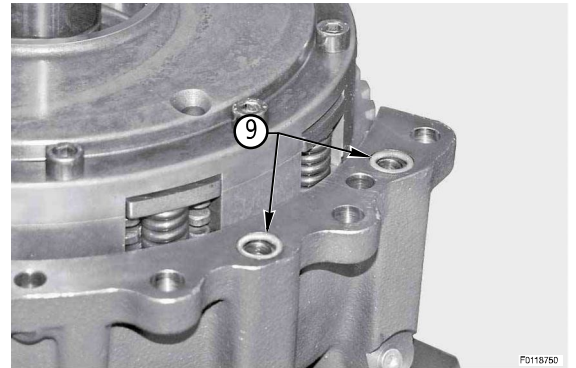


Tighten screws (4).

- Screws: 20 Nm (29.5 lb.ft.)
Screws: Loctite 242
 - Tighten the screws in an alternate crosswise sequence.

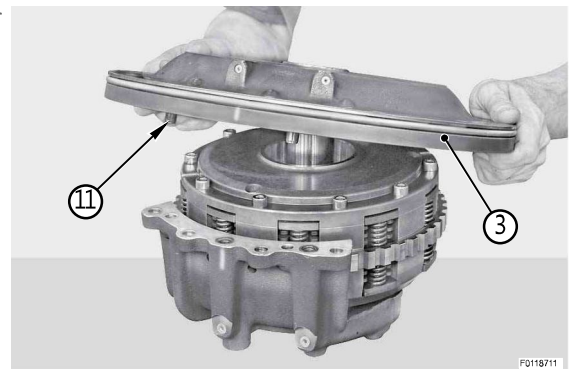


Fit new O-rings (9).



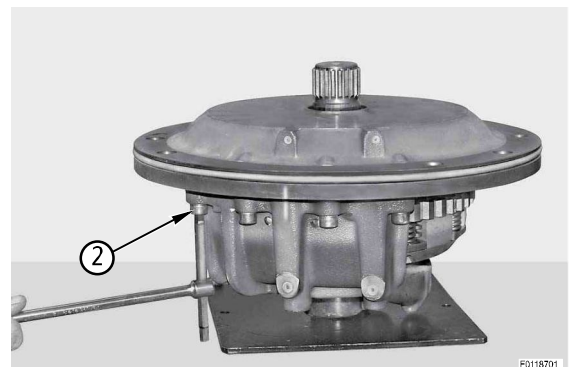
Locate flange (3), taking care to align the marks made during disassembly, or centring pin (11).

- Lubricate the lip of the oil seal with hydraulic oil.



Tighten screws (2).

- Screws: 40 Nm (29.5 lb.ft.)
Screws: Loctite 242

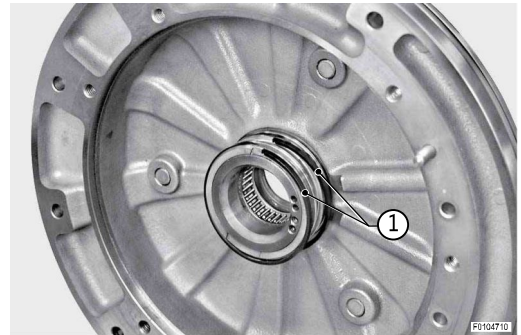




Cover assembly

Disassembly

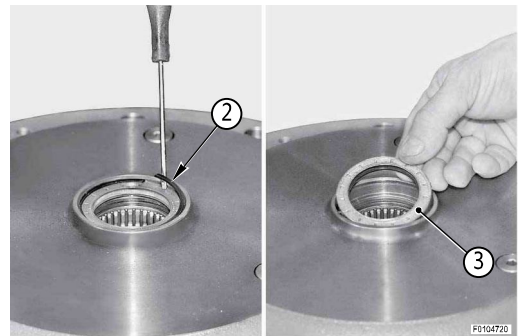
Remove rings (1).



1.

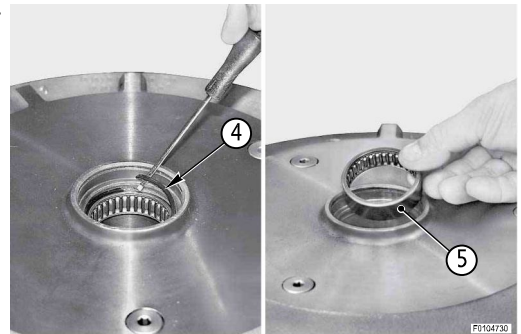
Remove oil seal (3) and remove circlip (2).

- Renew the oil seal on reassembly.



2.

Remove circlip (4) and, using a suitable puller or drift, remove needle roller bearing (5).



3.

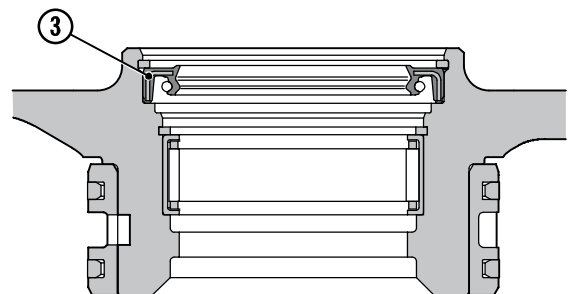
Assembly

Procedure 1

- Rings: hydraulic oil

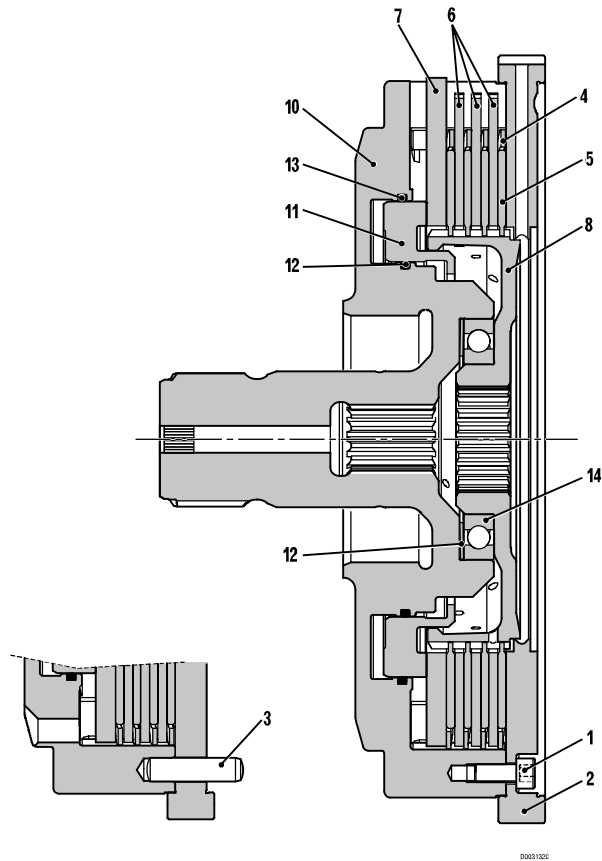
Procedure 2

- Make sure that oil seal (3) is installed the right way round.





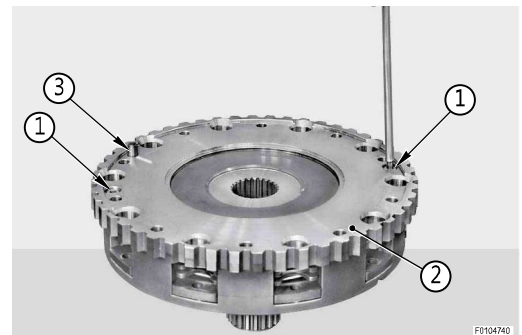
Forward gear clutches assembly



Disassembly

Remove screws (1) (qty. 2) and remove disc (2).

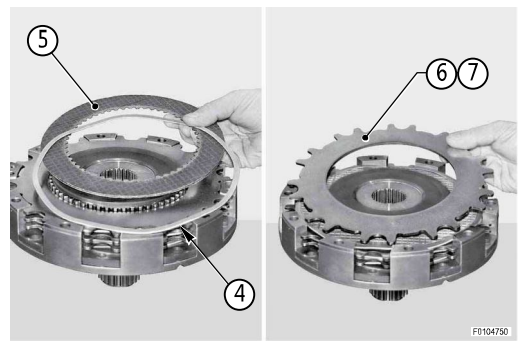
- o Mark the hole for fitting pin (3).



1.

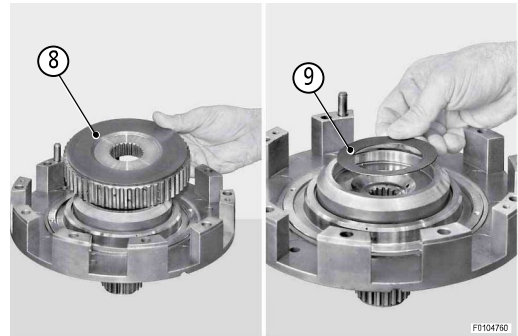
Remove the clutch pack assembly, composed of four corrugated springs (4), four friction discs (5), three steel discs (6) 3 mm thick and one steel disc (7) 6.5 mm thick.

- o Take care not to alter the assembly sequence of the friction and steel discs.



2.

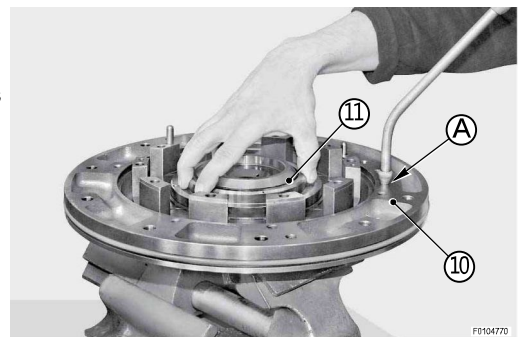
Remove hub (8) and recover Belleville spring (9).



3.

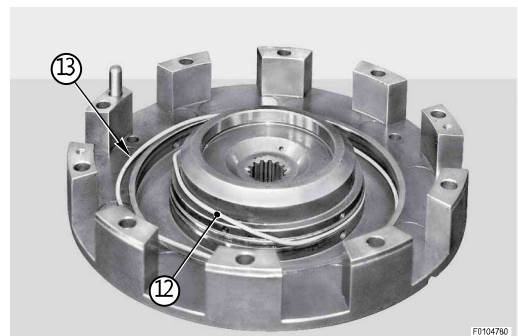
Blow compressed air at low pressure through the hole in the side of clutch housing (10) to expel piston (11).

- Restrain piston (11) as it could be expelled at high speed and thus damaged.



4.

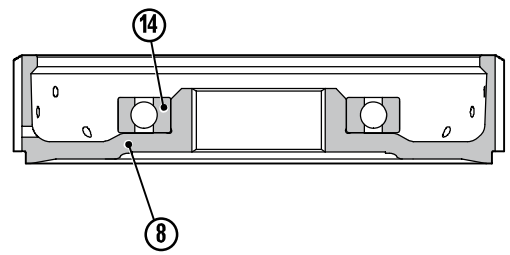
Check the condition of O-rings (12) and (13) and renew them if necessary.



5.

Only if necessary

Remove bearing (14) from hub (8).



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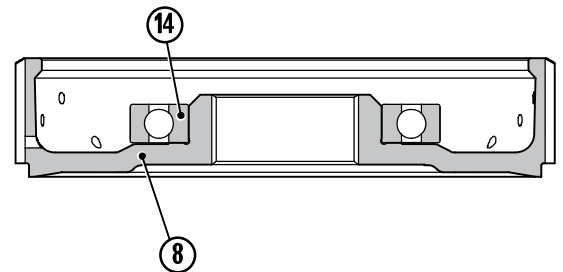


6.

Assembly

Only if removed

Using a suitable drift, fit bearing (14) on hub (8).

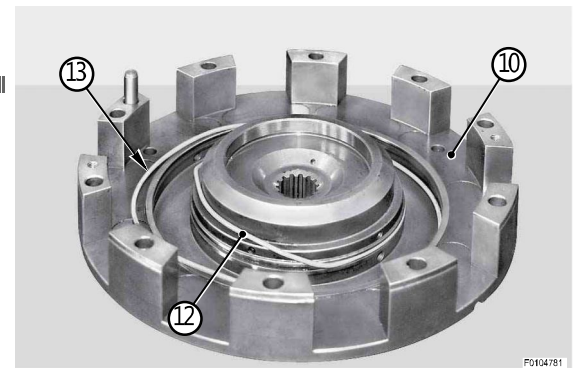


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Fit O-rings (12) and (13) in clutch housing (10).

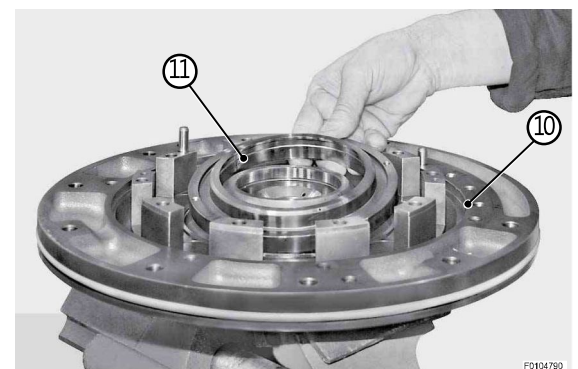
- To facilitate installation of O-ring (13), stretch it slightly at various points all around the circumference so that it is held in place in its seating.
 - O-ring: hydraulic oil



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Fit piston (11) in clutch housing (10) and make sure it is properly seated.

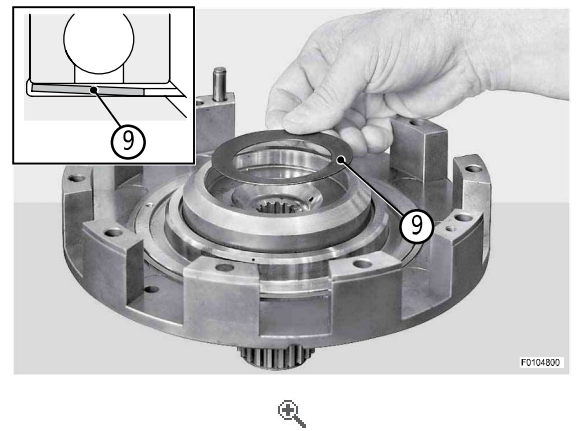


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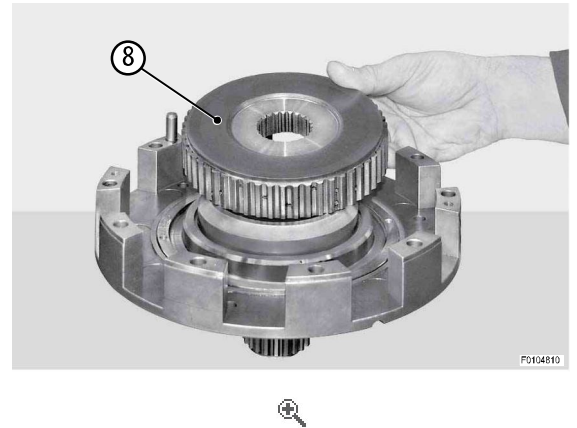


Position Belleville spring (9) in the clutch housing.

- Take care to install Belleville spring (9) the right way round.

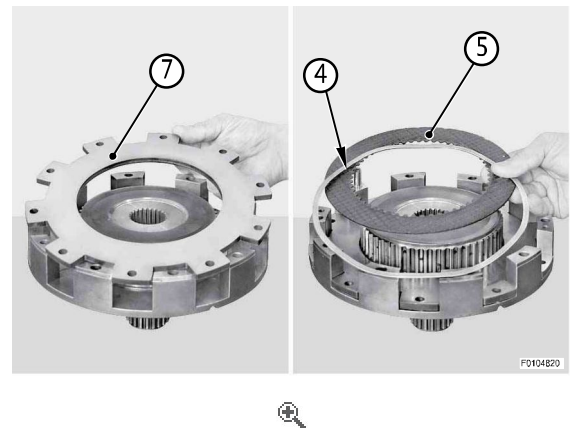


Fit hub (8) and make sure bearing (14) is firmly seated in Belleville spring (9).



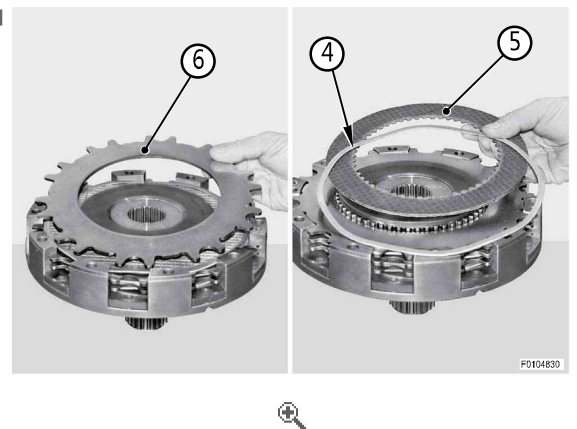
Fit first steel disc (7), friction disc (5) and corrugated spring (4).

- Make sure that steel disc (7) is 6.5 mm thick.
 - Friction disc: hydraulic fluid



Complete the clutch pack by fitting steel disc (6), friction disc (5) and corrugated spring (4) in sequence.

- Friction discs: hydraulic oil



Fit disc (2) and secure it in position with screws (1).

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