

**Safety Precautions :**

Be certain to clamp or securely support the gearbox and sub-assemblies to prevent injuries to hands and feet due to inadvertent dropping or falling over.

Always wear safety glasses and gloves to prevent eye and hand injury when chiseling or hammering on metal components. Hardened metal will chip unexpectedly.

An assembled gearbox is quite heavy. Use a hoist or get help to handle them safely. Lift carefully and properly using legs to lift-not your back.

**Tools needed**

Set of Snap Ring pliers

Needle nose pliers

Scraper

Seal removal tool or flat head screwdriver

Ratchet or Air Ratchet with extension

5/8 socket and a 1 7/16 socket

Punch

Hammer

Seal Installation Tool

1/4 Allen wrench

**Assembly Notes:**

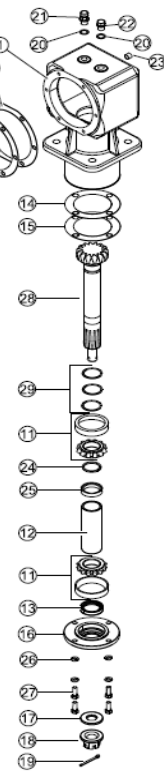
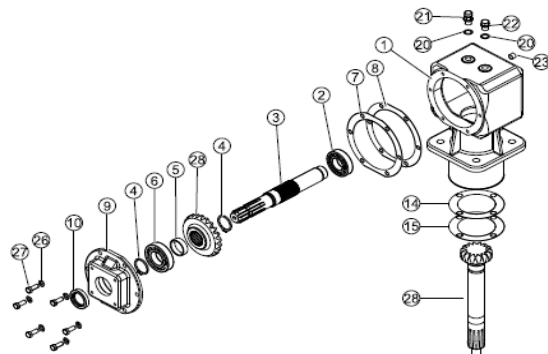
Output shaft bearing pre-load is 6-8 inch pounds without seal (rolling Torque).

The gearbox backlash is to be set at 6-8 thousands .

Replace any damaged components.

When assembling the bearings ,pay attention to not make any pressure on the rollers or cages in order to avoid damage.

When assembling oil seals, avoid contact with cutting parts in order to prevent any damage to the inner lip.



REF. NO.	PART NO.	DESCRIPTION	QTY.
	<b>00791015</b>	<b>Gearbox Assembly</b>	<b>1</b>
1	00791016	Gearbox Housing	1
2	71453	Bearing Assy. 6207	1
3	00791018	Shaft, Input	1
4	00790979	Retaining Ring	2
5	00790980	Spacer, Input Shaft	1
6	70256	Bearing Assy. 6208	1
7	00790975	Gasket, Input .13mm	1
8	00790976	Gasket, Input .30mm	1
9	00791017	Cap, Input Shaft	1
10	00790973	Seal, 54 x 34.925 x 10	1
11	70795	Bearing, Tapered 30208	2
12	00790982	Spacer, Output Shaft	1
13	00790974	Seal 54 x 39.7 x 9.5	1
14	00790977	Gasket, Output .13mm	1
15	00790978	Gasket, Output .30mm	1
16	00791025	Cap, Output	1
17	00791047	Washer, M24 x .5mm	1
18	00790981	Nut, M24-2 Slotted/Flange	1
19	20167	Cotter Pin 3/16 x 2	1
20	00790983	Washer Seal	2
21	00790985	Plug, Vent	1
22	00790984	Plug, Level	1
23	13032	Plug, Socket Hd.	1
24	00790997	Retainer Ring 40mm	1
25	00790912	Spacer	1
26	15812	Lockwasher 3/8"	10
27	20034	Capscrew 3/8" x 1" Gr.5	10
28	00790986	Gear Set Kit	1
29	00790969	Shim Kit	1

1 Remove the six(6) bolts item # 27 on front cover item # 9



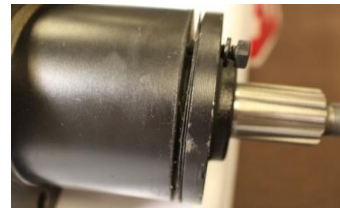
2 Remove front cover item # 9 by prying loose with a screwdriver



3 Remove input shaft item # 3 from gearbox housing item # 1



4 Remove bolts item # 27 from cap item # 16 on tail of gearbox and remove cap be sure to protect shims item # 14 & 15 from damage



5 Remove output shaft item # 28 by driving out the bottom of gearbox housing item # 1



6 View of retaining rings item # 24 installed and removed



7 Be sure to note the orientation of the spacer item # 25 so that the groove sits over the two retaining rings item # 24 to hold them in place



8 Repeat these steps in reverse order to reassemble the gear box