

00790989 (HD80)

**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

Scrapper

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:**

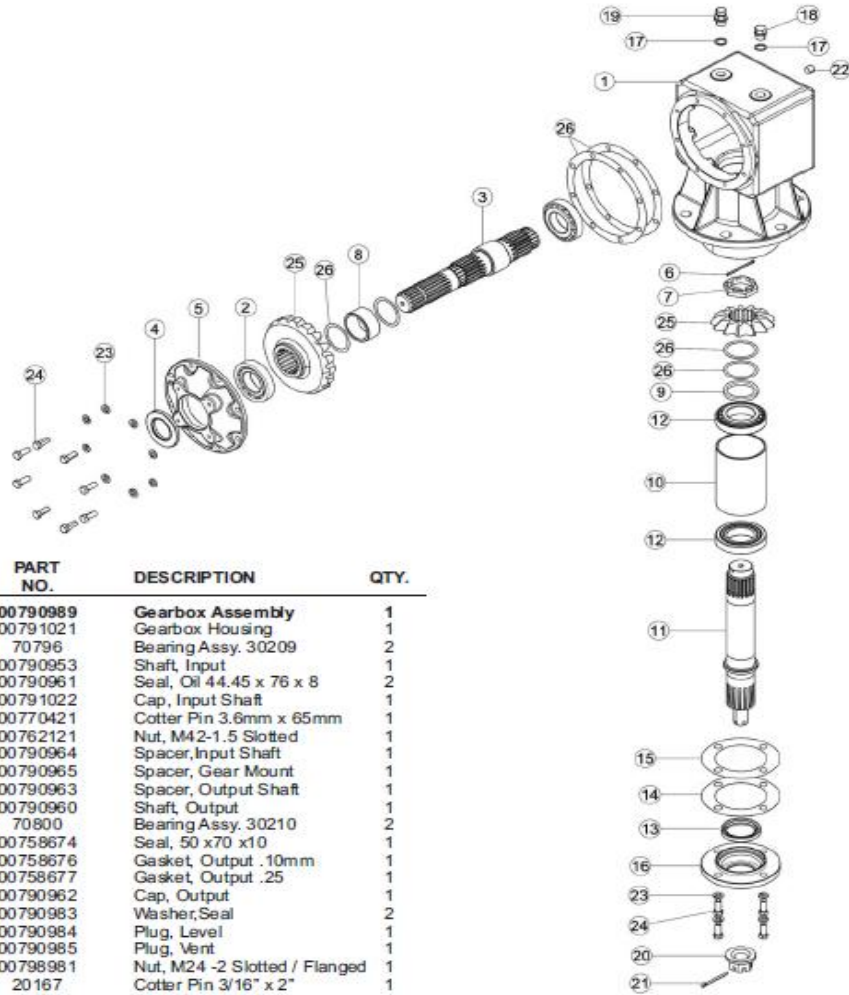
Output shaft bearing pre-load is 6-8 inch pounds without seal (rolling Torque).

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.
1	00790989	<b>Gearbox Assembly</b>	1
	00791021	Gearbox Housing	1
2	70796	Bearing Assy. 30209	2
3	00790953	Shaft, Input	1
4	00790961	Seal, Oil 44.45 x 76 x 8	2
5	00791022	Cap, Input Shaft	1
6	00770421	Cotter Pin 3.6mm x 65mm	1
7	00762121	Nut, M42-1.5 Slotted	1
8	00790964	Spacer, Input Shaft	1
9	00790965	Spacer, Gear Mount	1
10	00790963	Spacer, Output Shaft	1
11	00790960	Shaft, Output	1
12	70800	Bearing Assy. 30210	2
13	00758674	Seal, 50 x70 x10	1
14	00758676	Gasket, Output .10mm	1
15	00758677	Gasket, Output .25	1
16	00790962	Cap, Output	1
17	00790983	Washer, Seal	2
18	00790984	Plug, Level	1
19	00790985	Plug, Vent	1
20	00798981	Nut, M24 -2 Slotted / Flanged	1
21	20167	Cotter Pin 3/16" x 2"	1
22	13032	Plug, Socket Hd.	1
23	15812	Lockwasher 3/8"	12
24	20034	Capscrew 3/8" x 1" Gr.5	12
25	00790956	Gear Set Kit ( 19 & 13 T Gears)	1
26	00790959	Shim Kit	1

1 Remove bolts item # 24 from front cover item # 5



2 Use flat head screwdriver to work the cover item # 5 off of the shaft item # 3



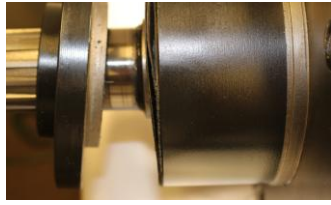
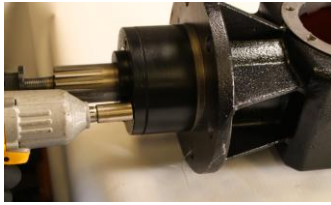
3 Remove gear item # 25 and bearing item # 2 from the shaft item # 3 then remove the shaft from the box



4 Gearbox item # 1 with input shaft item # 3 removed



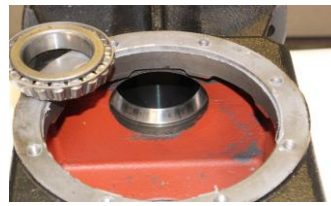
- 5 Remove bolts item # 24 from lower cap item # 16 on tail of gearbox be sure to protect shims item #14 & 15 to reuse for reinstallation



- 6 Remove cotter pin item # 6 and castle nut item # 7 from shaft item # 11 and remove gear item # 25



- 7 Remove output shaft item # 11 by driving out thru bottom of gear box item # 1



- 8 Remove race item # 12 to access inner sleeve item # 10 in the lower housing



- 9 Bottom of Gearbox item # 1 shown with sleeve item # 10 reinstalled



- 10 Reverse steps 1 - 8 for reinstallation