Inestalliation:

01 Heat the output bearing's inner race to max. 110 °C. Place protection ring 1X56 138 187 (1) onto the output bearing to do this.

NOTE

The shafts must be assembled correctly ready for installation.

A DANGER

Only touch heated protective tool when wearing protective gloves.

- 02 Remove protection ring 1X56 138 187 and carefully insert the shafts fully into the transmission housing.
- 03 Pull the shafts into the correct axial position from the output end using a bushing (against the bearing inner race or speedometer worm) and a hex bolt (M12x1.5). Tightening torque = 120 Nm.

NOTE

Separate clutch housing version

Check the installation is correct by measuring distance "B", see section 10.1. Remove the bushing and hex boilt.

- 04 Remove fixtures and auxiliary strip
- 05 Coat thread of articulated bolts with scaling compound. First screw in articulated bolts of 1st/2nd gear with spring washer.

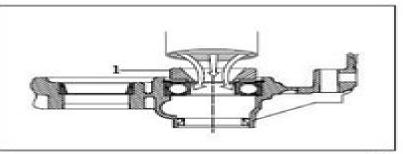
NOTE

Articulated bolts for 1st/2nd gear (2) = approx 48.5 mm Articulated bolts for 3rd/4th gear (3) = approx 55.0 mm Articulated bolts for 5th/6th gear (4) = approx 55.0 mm

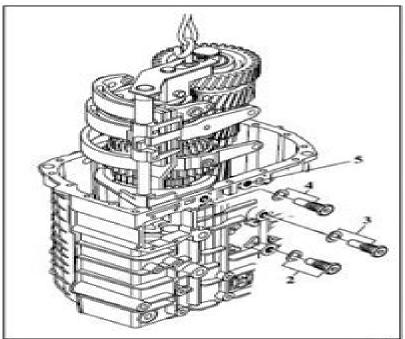
NOTE

Overdrive version (4), direct drive version (5).

O6 Screw in and tighten the remaining articulated bolts and spring washers as previously described. Tightening torque = 160 Nm.



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- 1. Understanding the eBook Zf Transmission Repair Manual 85 Iv
 - The Rise of Digital Reading Zf Transmission Repair Manual 85 Iv
 - $\circ\,$ Advantages of eBooks Over Traditional Books
- 2. Identifying Zf Transmission Repair Manual 85 Iv
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
- 3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - \circ Features to Look for in an Zf Transmission Repair Manual 85 Iv
 - User-Friendly Interface
- 4. Exploring eBook Recommendations from Zf Transmission Repair Manual 85 Iv
 - Personalized Recommendations
 - o Zf Transmission Repair Manual 85 Iv User Reviews and Ratings
 - Zf Transmission Repair Manual 85 Iv and Bestseller Lists
- 5. Accessing Zf Transmission Repair Manual 85 Iv Free and Paid eBooks
 - Zf Transmission Repair Manual 85 Iv Public Domain eBooks
 - Zf Transmission Repair Manual 85 Iv eBook Subscription Services

- Zf Transmission Repair Manual 85 Iv Budget-Friendly Options
- 6. Navigating Zf Transmission Repair Manual 85 Iv eBook Formats
 - o ePub, PDF, MOBI, and More
 - Zf Transmission Repair Manual 85 Iv Compatibility with Devices
 - Zf Transmission Repair Manual 85 Iv Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Zf Transmission Repair Manual 85 Iv
 - $\circ\,$ Highlighting and Note-Taking Zf Transmission Repair Manual 85 Iv
 - Interactive Elements Zf Transmission Repair Manual 85 Iv
- 8. Staying Engaged with Zf Transmission Repair Manual 85 Iv
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Zf Transmission Repair Manual 85 Iv
- 9. Balancing eBooks and Physical Books Zf Transmission Repair Manual 85 Iv
 - Benefits of a Digital Library
 - $\circ\,$ Creating a Diverse Reading Collection Zf Transmission Repair Manual 85 Iv
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Zf Transmission Repair Manual 85 Iv
 - Setting Reading Goals Zf Transmission Repair Manual 85 Iv
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Zf Transmission Repair Manual 85 Iv
 - Fact-Checking eBook Content of Zf Transmission Repair Manual 85 Iv
 - 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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