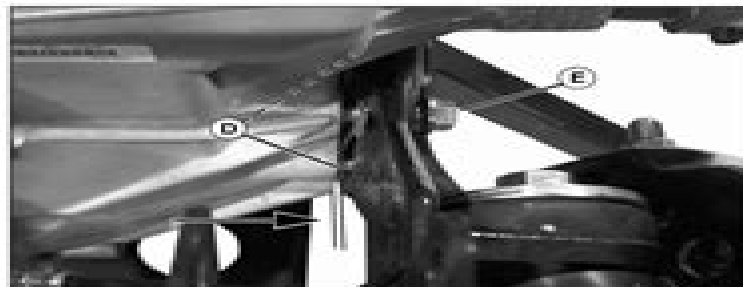


N•m (18 lb-ft).

- Install four outer bolts.

4. Remove old gasket material from transmission and inner axle bearing housing.
5. Check that alignment pins are in place in the transmission housing.



6. Carefully lower transmission into machine. Place new gasket on pins. Ensure that the gasket stays in place and the alignment pins (D) start to seat in right-hand bearing holder side plate.

7. Right-hand Side: Install two or more bolts (E) through side plate to transmission. Alternately tighten bolts to pull transmission to side plate.



8. Install remaining bolts (E). Tighten all bolts to **73 N•m (54 lb-ft)**.



9. Right-hand Side: Seat isolator (F) between side plate and frame. Install spacer through isolator to frame.



10. Install the second isolator, washer, bolt (G) and nut. Tighten to **109 N•m (80 lb-ft)**.

Note: Transmission may need to be rotated slightly up or down to insert center mount bolt. Do not install shim(s) at this time.



11. Install center mount bolt (O); start bolt into threads, do not tighten.

Xuv 825i Service Manual

M Lipman



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