#### 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.

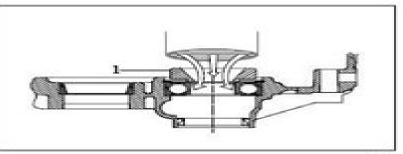
#### NOTE

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

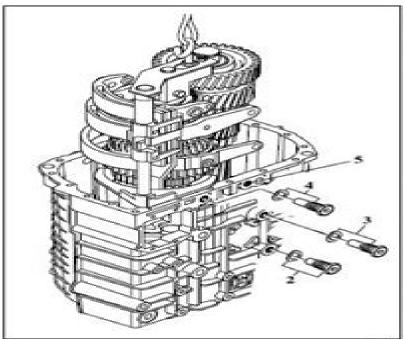
#### NOTE

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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or The

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