

Fig. 6.18 Tighten casing bolts in the sequence shown (Set 3)

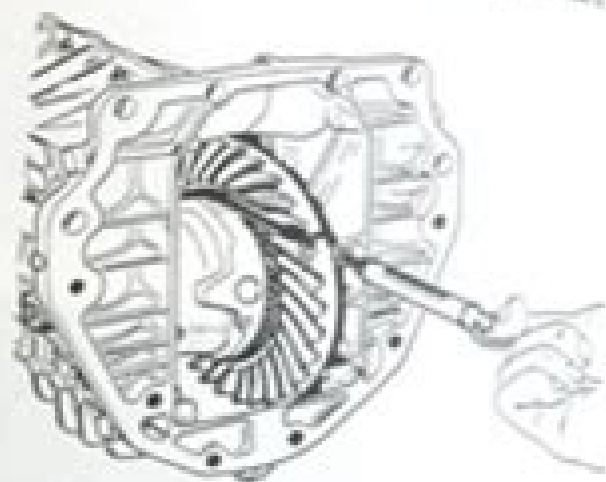
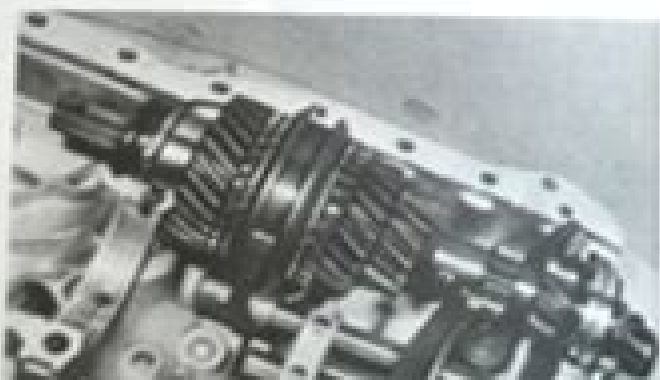


Fig. 6.19 Method of checking bearing preload adjustment (Set 3)



6.20 Engage the clutch shaft and sleeve and screw in a new roll pin to secure



6.21 Align the bearing slot and location pin for replacement

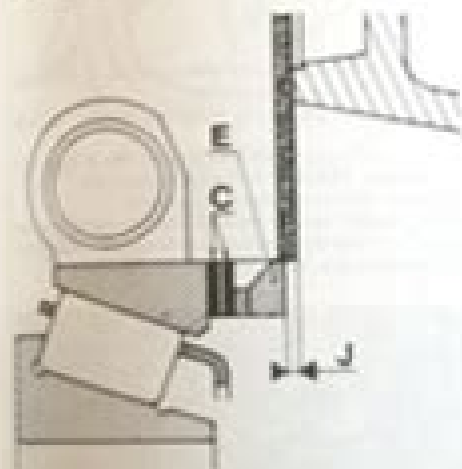


Fig. 6.22 Check the primary shaft endfloat (only 367 model). Clearance at J must be as specified (See 6)

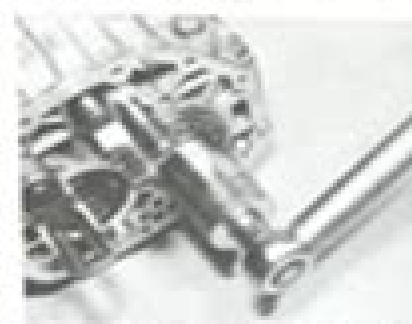
E Distance plate C Sleeve

Check the endfloat, which should be within the specified limits. If the clearance is incorrect, add or subtract shims as applicable.

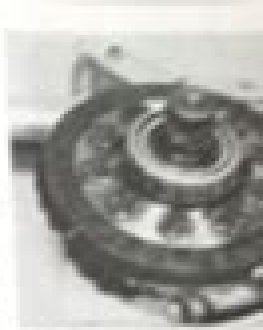
12 Tighten the bolt (torque) according to the specified torque and



6.23 Fit the clutch shaft guide sleeve with oil flutes (arrowed) downwards



6.24 Tighten the primary (where applicable) and secondary shaft nuts ...



6.25 Relocate the bearing slot plate



6.26 ... and gear over (arrowed)

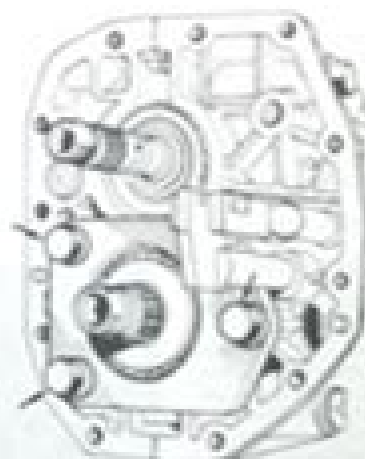


Fig. 6.27 Relocate the bearing slot plate onto the rear face of the 368 gearbox (See 6)

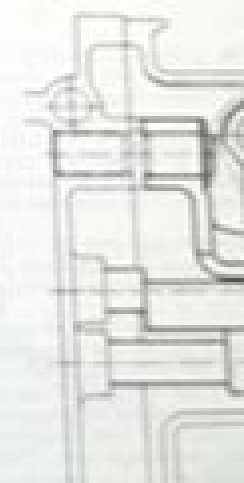


Fig. 6.28 Engage the clutch shaft

to the 5th gear. Fit washer and retaining nut. Assemble the flat washer, spacer roller, fit (arrowed) with grease and the 5th is

# Un1 Gearbox Service Manual

**H Kauffman**



## **Un1 Gearbox Service Manual:**

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