

Installation

- 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.

**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 bolt.

- 04 Remove fixtures and auxiliary strip
- 05 Coat thread of articulated bolts with sealing 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).

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



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Transmission Repair Manual Pagers

**United States. Congress. Senate.
Committee on the Judiciary.
Subcommittee on Antitrust and
Monopoly**

Transmission Repair Manual Pagers:

Technical Manual United States Department of the Army,1983 **Automotive Repair Industry: Appendix (Pages 3007 to 4081)** United States. Congress. Senate. Committee on the Judiciary. Subcommittee on Antitrust and Monopoly,1969

Monthly Catalog of United States Government Publications ,1995 Monthly Catalogue, United States Public Documents ,1993-03 Technical Abstract Bulletin ,1982 **Performance & Style Scootermatic, english** , *Report on the Manuals and Handbooks Project* ,1977 **Directory of Existing Natural Resource Agency Manuals and Handbooks** ,1977 The Commercial Car Journal ,1963-03 Beginning with 1937 the April issue of each vol is the Fleet reference annual **Popular Mechanics** ,1958-03 Popular Mechanics inspires instructs and influences readers to help them master the modern world Whether it s practical DIY home improvement tips gadgets and digital technology information on the newest cars or the latest breakthroughs in science PM is the ultimate guide to our high tech lifestyle **The Popular Science Monthly** ,1950 **Popular Science** ,1954-07 Popular Science gives our readers the information and tools to improve their technology and their world The core belief that Popular Science and our readers share The future is going to be better and science and technology are the driving forces that will help make it better School Shop ,1972 *Popular Science* ,1961-01 Popular Science gives our readers the information and tools to improve their technology and their world The core belief that Popular Science and our readers share The future is going to be better and science and technology are the driving forces that will help make it better **Automotive Repair Industry: Appendix (Pages 1819 to 3006)** United States. Congress. Senate. Committee on the Judiciary. Subcommittee on Antitrust and Monopoly,1969 *Walk Behind Lawn Mower Service Manual* ,1987 **Popular Science** ,1964-08 Popular Science gives our readers the information and tools to improve their technology and their world The core belief that Popular Science and our readers share The future is going to be better and science and technology are the driving forces that will help make it better **Catalog of Copyright Entries. Third Series** Library of Congress. Copyright Office,1974 *Popular Mechanics* ,1984-09 Popular Mechanics inspires instructs and influences readers to help them master the modern world Whether it s practical DIY home improvement tips gadgets and digital technology information on the newest cars or the latest breakthroughs in science PM is the ultimate guide to our high tech lifestyle *Motor Age* ,1909

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