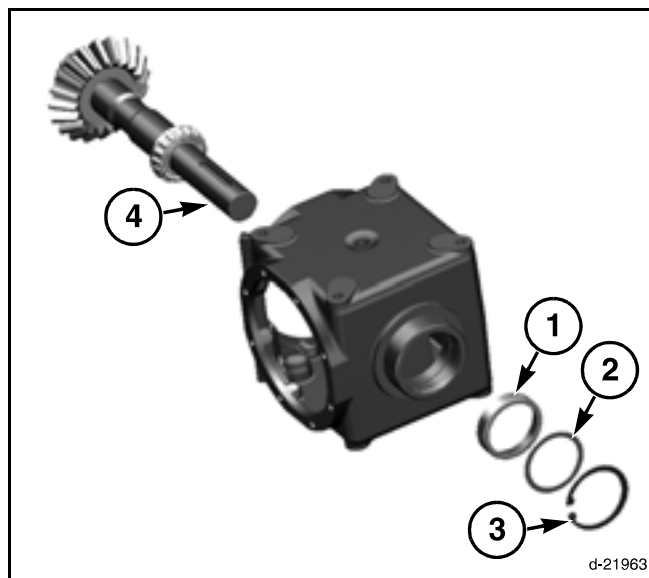


## Gearbox - 1366 Center Pull Gearboxes

**FIG. 24:** Assemble outer ring (1), shim (2) and snap ring (3) inside housing.

Assemble pre-mounted shaft (4).



**FIG. 24**

**FIG. 25:** Assemble shim (1) and outer ring (2) inside cover (3), using a pipe and hammer.

Assemble pre-mounted cover (3), bolts (4) and lock manually.

Hit the shaft (5) from both sides with a plastic hammer in order to set the axis.

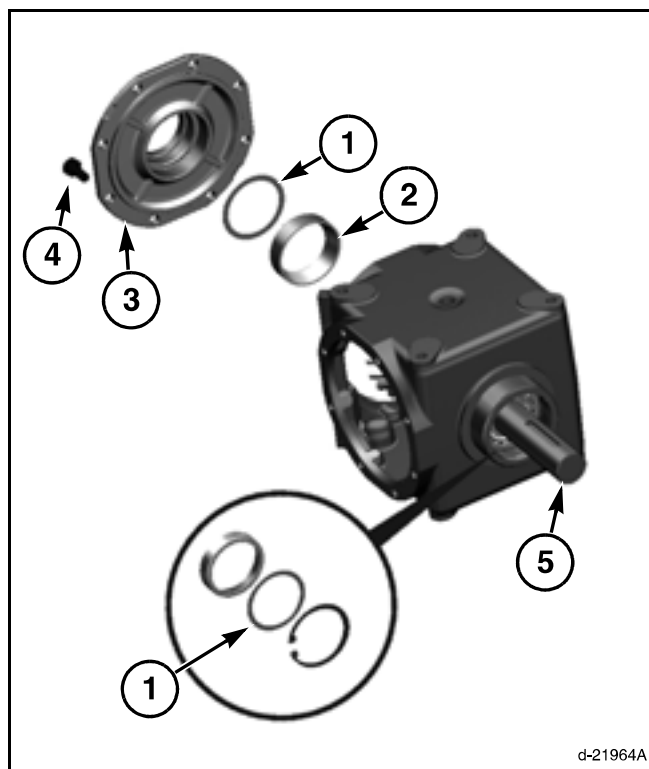
Check the assembled axis preload, using a torquemeter, the value must be below 0.3 Nm (2.6 lbf in).

If the value is not correct change the shim set (1).

Disassemble bolts and cover.

Put a Silicone film between housing and cover contact faces.

Assemble cover, bolts and tighten between 84 Nm (62 lbf ft) - 107 Nm (80 lbf ft).



**FIG. 25**

## Gearbox - 1366 Center Pull Gearboxes

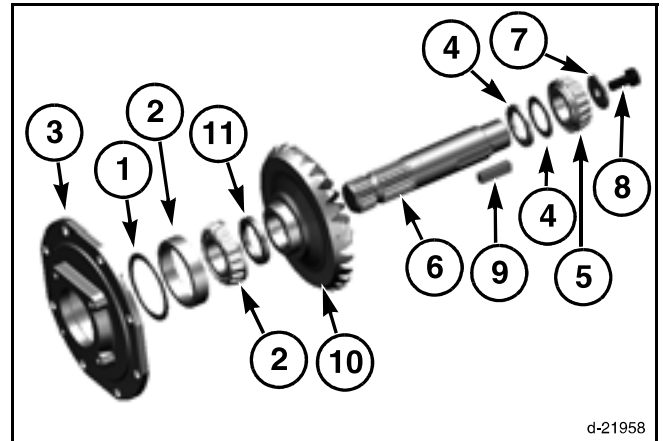
**FIG. 26:** Assemble shim (1), outer ring (2) inside cover (3), using pipe and hammer.

Assemble shims (4), inner ring (5), using pipe and hammer on shaft (6).

Assemble blank washer (7), bolt (8) and tighten between 50 Nm (36 lbf ft) - 64 Nm (47 lbf ft).

Assemble parallel key (9), gear (10).

Assemble spacer (11) and inner ring (2), using pipe and hammer.



**FIG. 26**