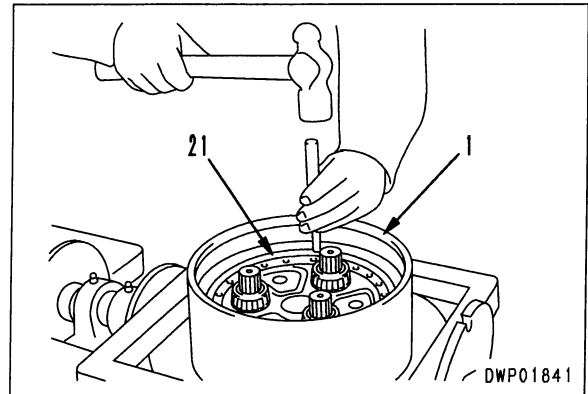
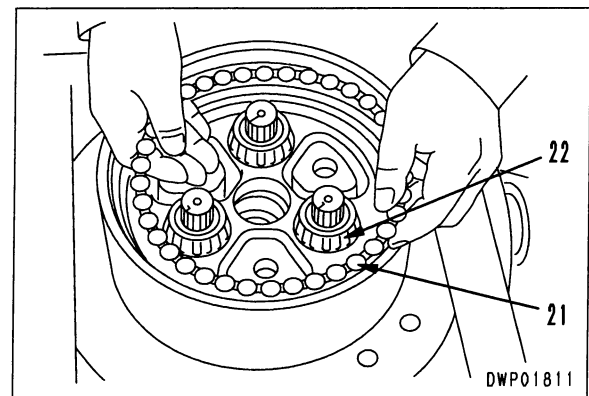


## 6. Installation of bearing

- 1) Install the outer race of bearing (21) into hub (1) with a steel rod and a hammer.

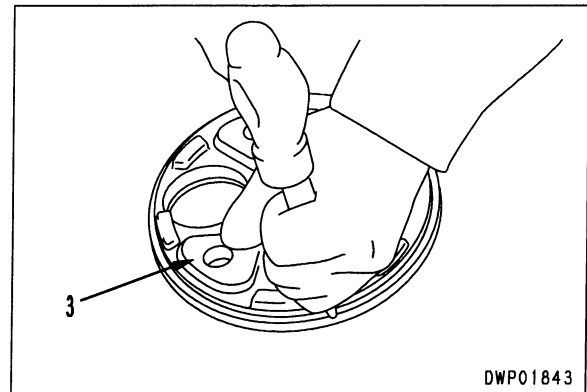


- 2) Place the steel balls and retainer assembly of bearing (21) on the outer race of bearing (21).



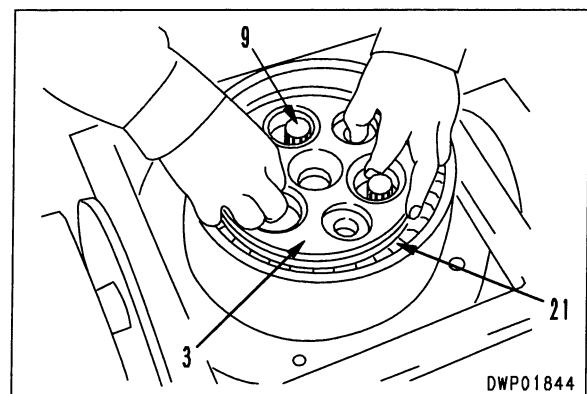
## 7. Installation of hold flange

- 1) Fit the inner race of bearing (21) to hold flange (3) with a steel rod and a hammer.



- 2) Fit hold flange (3) to bearing (21), setting the match marks on spindle (2) and crankshaft (9) to the positions before disassembly.

- ⚠ Since hold flange (3) is press fitted to bearing (21), if it is fitted offset, it may be scuffed and can cause malfunction. Take care extremely.
- ⚠ Apply molybdenum disulfide lubricant to the fitting parts of the hold flange and bearing.




## 8. Tightening of reamer bolts

- 1) Turn the travel motor by 90 degrees.
- 2) Apply anti-seizure lubricating oil to the reaming parts of reamer bolts (19) and apply adhesive to the threaded parts of the reamer bolts.
- 3) Tighten reamer bolts (19) (3 pieces) until hold flange (3) is press fitted to bearing (22) perfectly.

**!** If reamer bolts (19) are stained with oil or grease, degrease, clean, and dry in air for 10 minutes and then apply adhesive to their threaded parts.

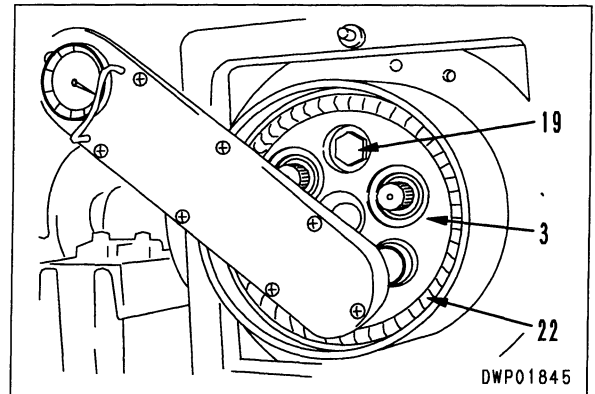
- 4) Tighten reamer bolts (19) (3 pieces) to the specified torque.

 Reamer bolts (19):  
**188.3 ± 29.4 Nm {19.2 ± 3 kgm}**

**!** Tighten 3 reamer bolts (19) evenly little by little. If only 1 or 2 of them are tightened first, hold flange (3) will slant and bearing (21) will not be fitted accurately in hold flange (3) and can cause seizure of reamer bolts (19).

**!** If the seats of 3 reamer bolts (19) are not fitted accurately to the surface of the hold flange, inspect and remove the cause.

- 5) Fit the outer race of tapered roller bearing (22) to hold flange (3).



## 9. Fitting of snap rings

- 1) Check that any of hub (1), spindle (2), hold flange (3), RV gear assembly, and snap rings (20) has not been replaced with new one.

**!** If any of the above parts has not been replaced, go to the next step.

**!** If any of the above parts has been replaced, adjust the axial clearance of tapered roller bearing (22) before going to the next step.

**!** When replacing only snap rings (20), select the same ones as the used ones or similar ones from 12 types.

- 2) Fit snap rings (20) to the snap ring holes in hold flange (3).

**!** Fit 3 snap rings (20) to the positions before disassembly, matching them to the match marks on hold flange (3). When using new snap rings (20), select ones having the thickness selected in the previous process.

