

6. Install cap (14) and tighten mount bolts (13).

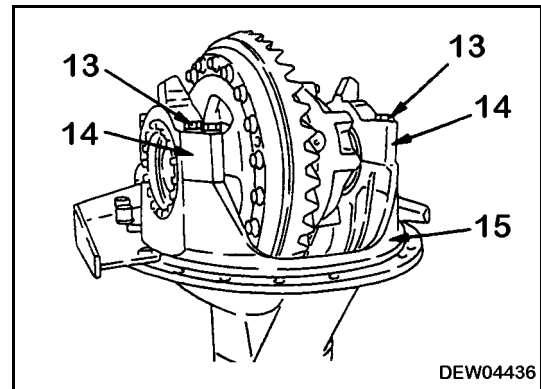


Mount bolt: Adhesive (LT-2)



Mount bolt:  $932 \pm 98$  Nm ( $687.40 \pm 72.28$  lbf ft)

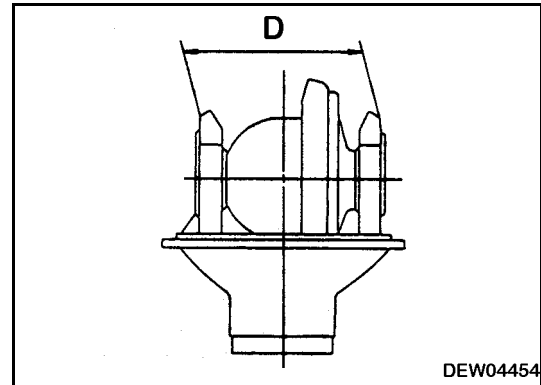
- ★ Check the match mark on the bearing cap when installing.
- ★ When tightening the bolts, rotate the bevel gear 20 - 30 times to settle the bearing before tightening.



7. Adjust the preload of the bevel gear as follows.

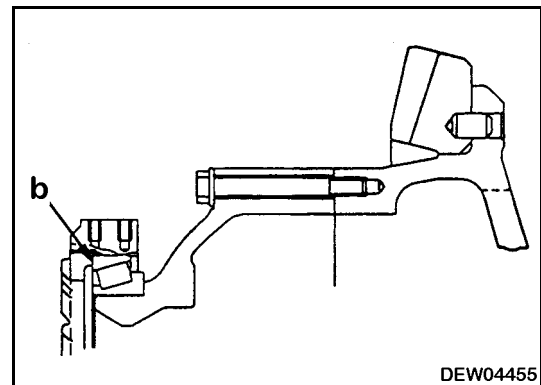
- A. Using tool **D7**, measure distance **D**.
- B. Adjust with the nut so that the increase in distance **D** is  $0.39 \pm 0.15$  mm.

- ★ The increase becomes the amount of deflection of the case from before giving preload to after giving preload.



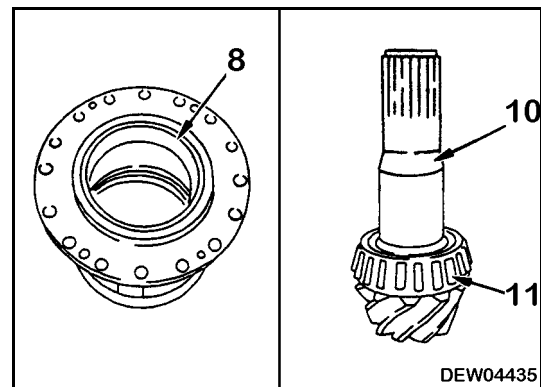
- ★ If the increase deflection is greater than the standard distance, return to the position before adjusting with the adjustment nut.

When returning the adjustment nut, rotate the bevel gear, and tap the bearing cap and bevel gear with a plastic hammer to check that there is no clearance at "b". Then adjust again.

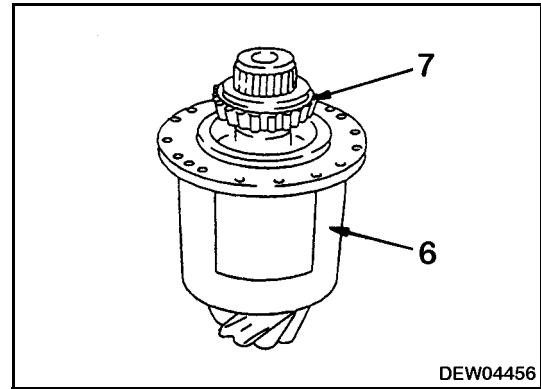


8. Assemble pinion and cage assembly as follows.

- A. Install bearing (11) to pinion shaft (10).
  - ★ Check that there is no clearance between the bearing inner race and the pinion.
- B. Install outer race (8) to cage.

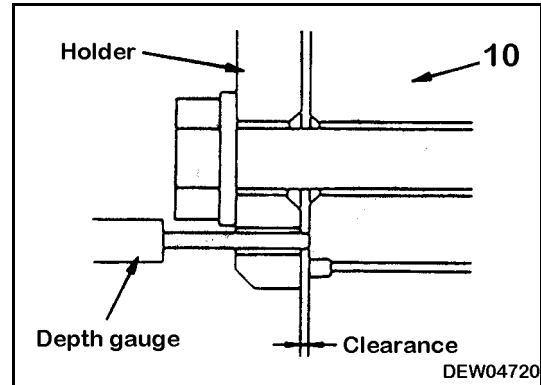


- C. Install pinion shaft to cage (6).
- D. Install bearing (7).



- E. Install coupling (4), and tighten holder with mount bolts to  $323.6 \pm 19.6$  Nm ( $238.67 \pm 14.45$  lbf ft) temporarily, then measure clearance between holder and pinion.

★ Add 0.11 mm to the measured value for the clearance to decide the shim thickness.



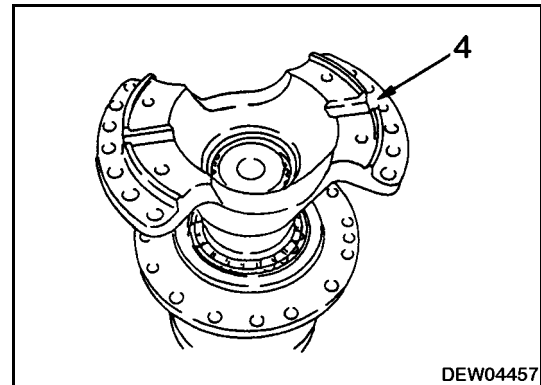
- F. Insert shim and rotate cage while tightening holder mount bolts to specified tightening torque.



Mount bolt: Adhesive (LT-2)



Mount bolt:  $2750 \pm 290$  Nm ( $2028.29 \pm 213.89$  lbf ft)



- ★ Rotate the cage 20 - 30 times, then using push-pull scale ①, check the starting torque.



Starting torque:  $22.6 \pm 6.9$  Nm ( $16.66 \pm 5.08$  lbf ft)

