
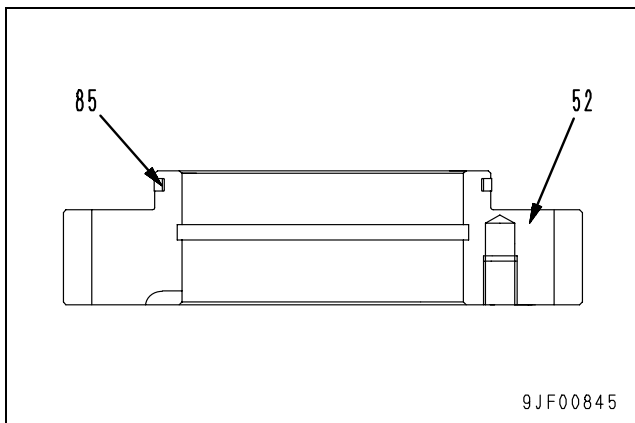


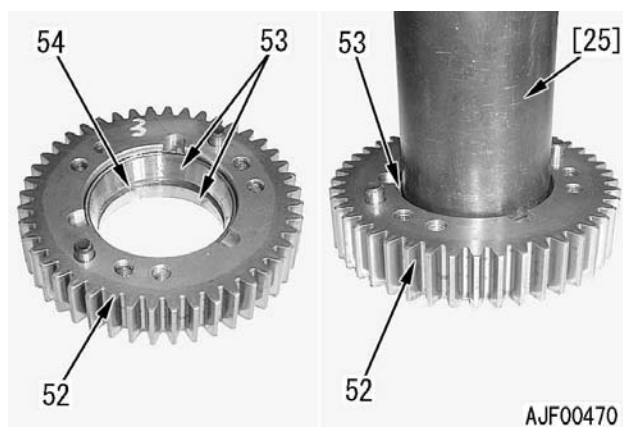
## 6. Assembly of HST motor 1 gear and outer races

- 1) Install seal ring (85) to HST motor 1 gear (52).

 Seal ring: **Grease (G2-LI)**



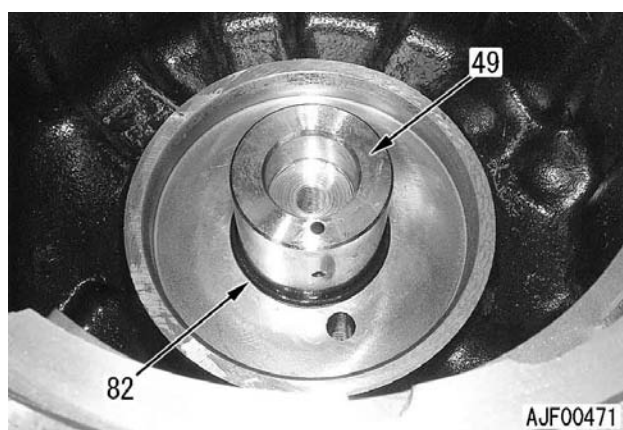
- 2) Install spacer (54) to HST motor 1 gear (52).
- 3) Using push tool [25], press fit 2 outer races (53) to HST motor 1 gear (52).



## 7. Installation of motor 1 gear and outer races

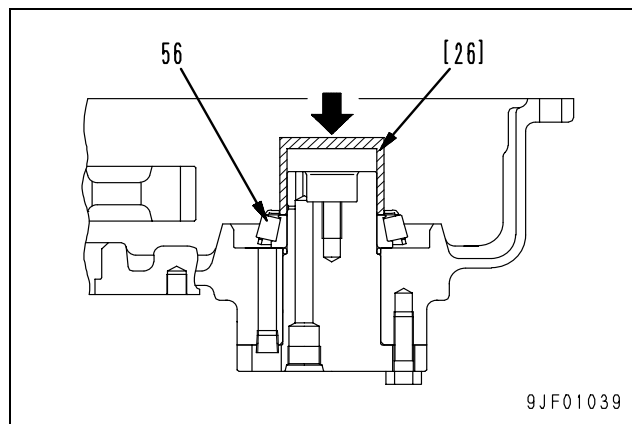
- 1) Install O-ring (82) to shaft (49).

 O-ring: **Grease (G2-LI)**



## 8. Bearing and HST motor 1 gear

- 1) Using push tool [26] and the press, press fit bearing (56).



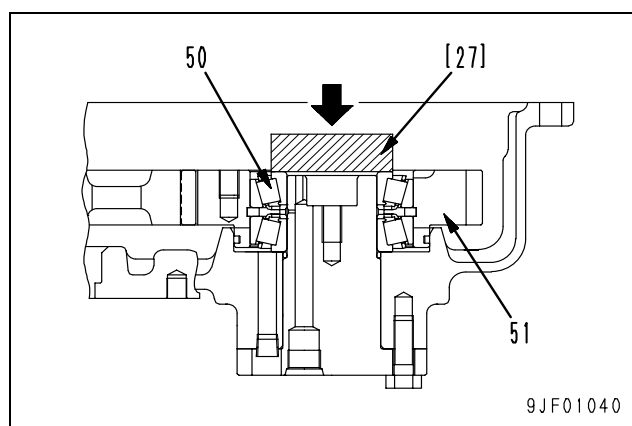
- 2) Install spacer (55).



- 3) Install HST motor 1 gear and outer races (51).
- 4) Using push tool [27] and the press, press fit bearing (50).


- Projection of bearing from shaft:

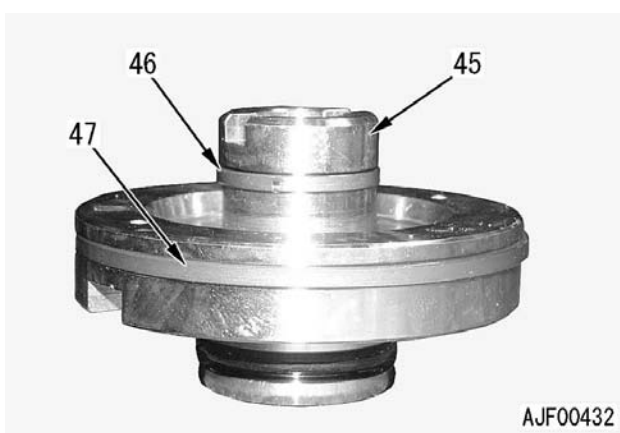
**1.71 – 3.35mm**



**9. Holder**


- 1) Install seal rings (46) and (47) to holder (45).

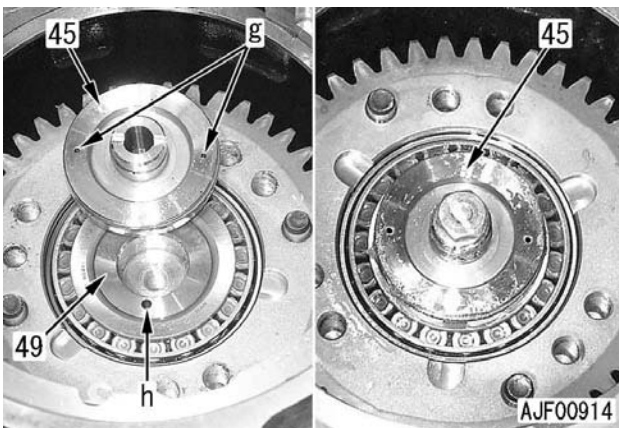
 Seal ring and O-ring: **Grease (G2-LI)**



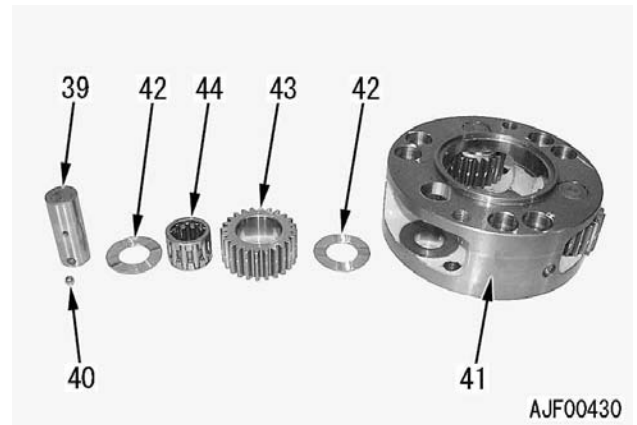
- 2) Install holder (45) and tighten the mounting bolts.

★ Set the hole 2 mm in diameter **g** on the top of the holder horizontally [Set it at 90° to the hole 4.5 mm in diameter **h** on shaft (49)].

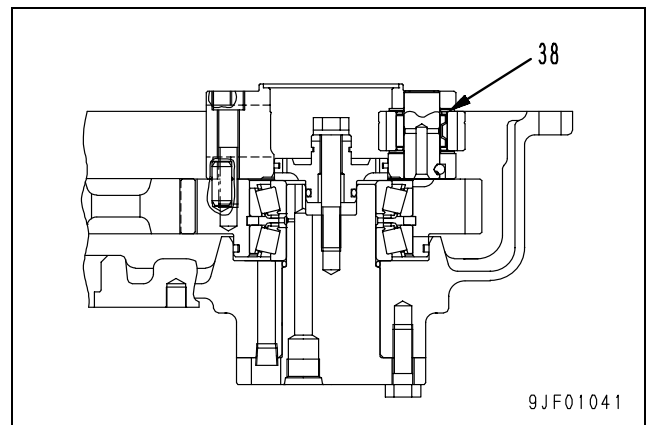
 Mounting bolt:  
**88.2 – 107.8 Nm {9 – 11 kgm}**

**10. Assembly of carrier assembly**

- 1) Set planetary gear (43), bearing (44), and 2 thrust washers (42) to carrier (41) (at 3 places).
- 2) Install pinion shaft (39) to carrier (41), matching their ball holes to each other, and then install ball (40).

**11. Installation of carrier assembly**

- 1) Install carrier assembly (38), matching it to the dowel pin of the HST motor 1 gear.

**12. Assembly of HST motor 1 shaft and ring gear assembly**

- 1) Install bearing (37) to ring gear (32), and then install snap ring (36).

