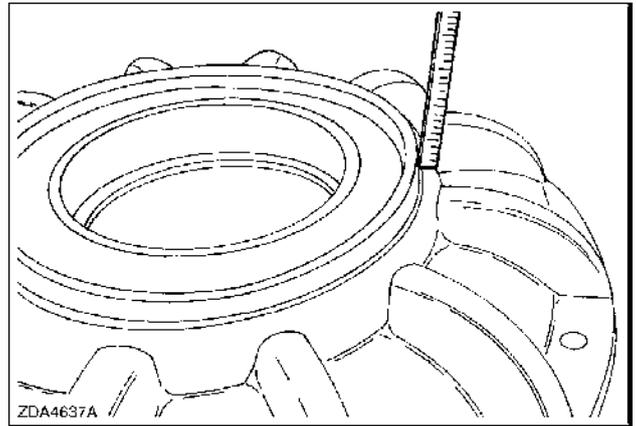


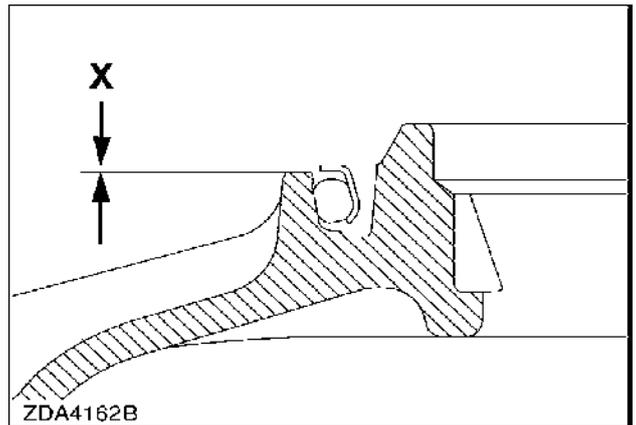
7. In case mud seals are installed, install the mud seal (1).

**NOTICE:** When installing the mud seal, take care the outer sides of the mud seal is free of dirt and oil.



ZDA4637A 4

8. Check the distance (X) (mud seal surface to gearbox housing) in at least four places, 90 ° apart. The difference in height around the ring must not be more than 1 mm.

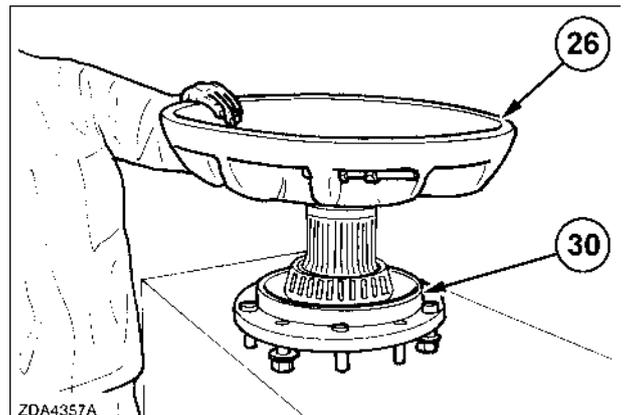


ZDA4162B 5

9. Apply oil to the seal and to the output shaft where the seal makes contact.

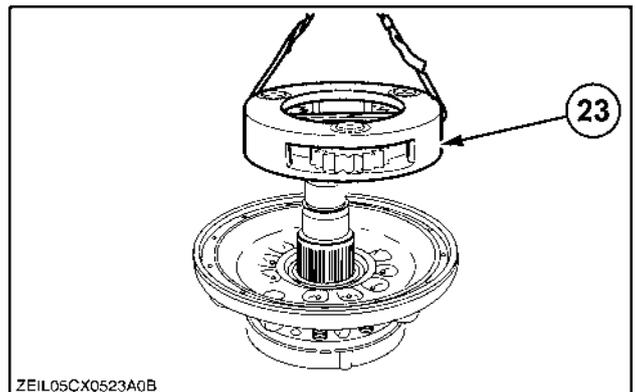
Install the gearbox housing half (26) on the pre-assembled output shaft (30).

**NOTICE:** In case mud seals are installed, apply a thin film of oil on the entire seal face of both seals. Oil must not contact other surfaces than the sealing faces.



ZDA4357B 6

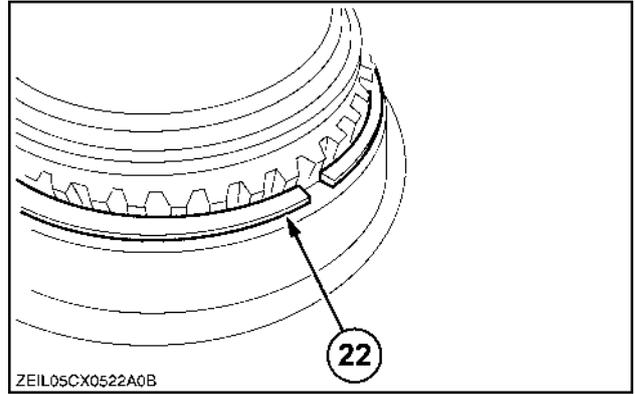
10. Install the pre-assembled planet gear carrier (23).



ZEIL05CX0523A0C 7

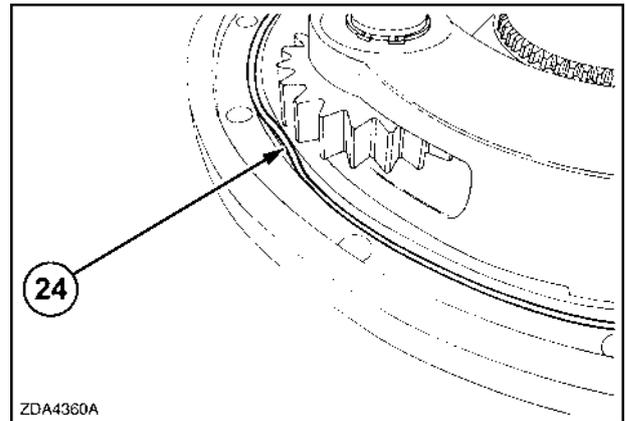
11. Install the retaining ring (22).

**NOTE:** Tap radially on the retaining ring to be sure it seats well in the groove.



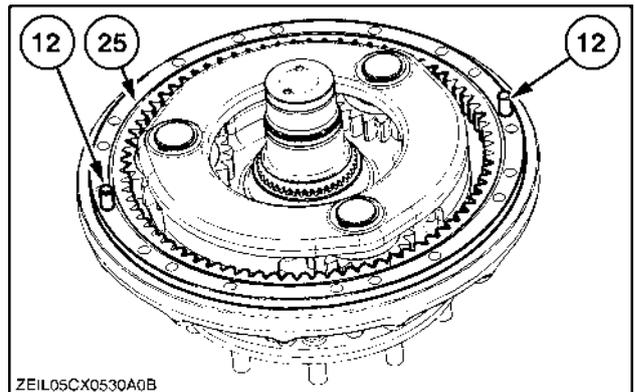
ZEIL05CX0522A0C 8

12. Apply a little grease on the O-ring (24) and install the O-ring (24) in the gearbox housing.



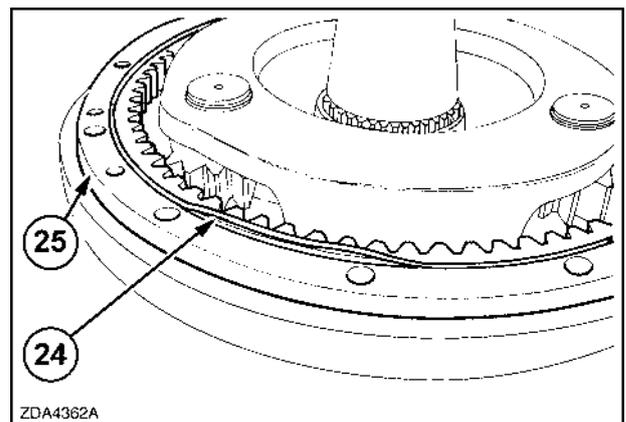
ZDA4360B 9

13. Insert two dowel pins (12) in the ring gear (25) and install the ring gear (25) with the seal groove at the upper side on the gearbox housing.



ZEIL05CX0530A0B 10

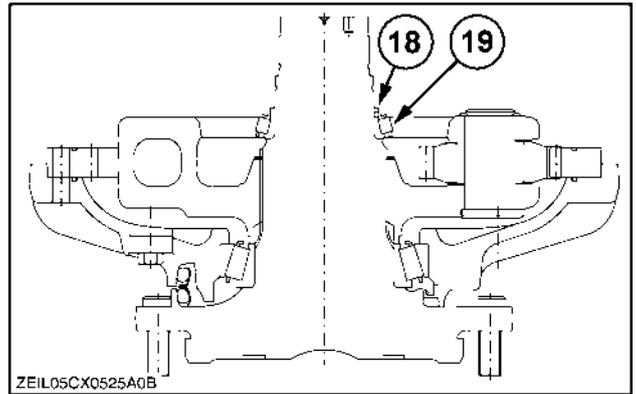
14. Apply a little grease on the O-ring (24) and install the O-ring (24) in the ring gear (25).



ZDA4362B 11

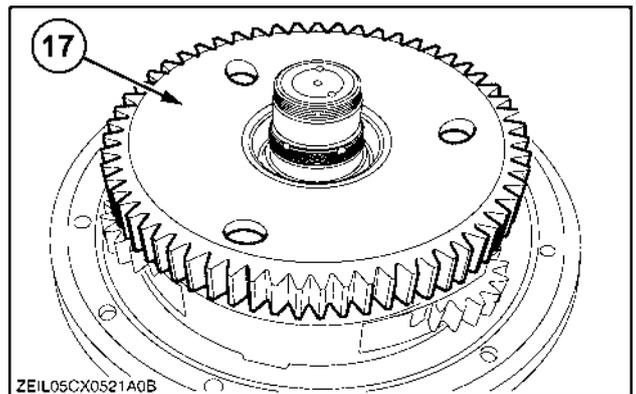
15. Install the inner ring of bearing (19) and the two rings (18) with overall thickness **Z mm**.

**NOTE:** Refer to instruction 1.



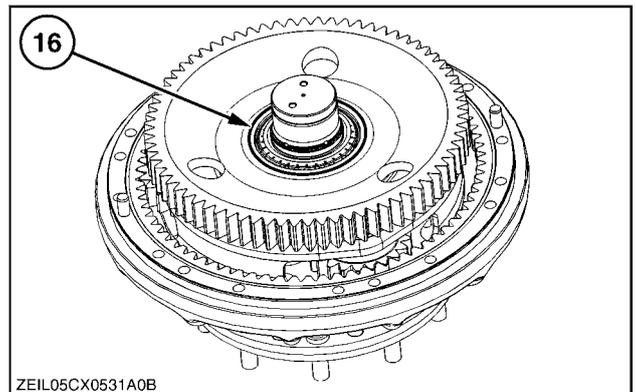
ZEIL05CX0525A0C 12

16. Install the sun gear assembly (17).



ZEIL05CX0521A0C 13

17. Install the bearing (16).



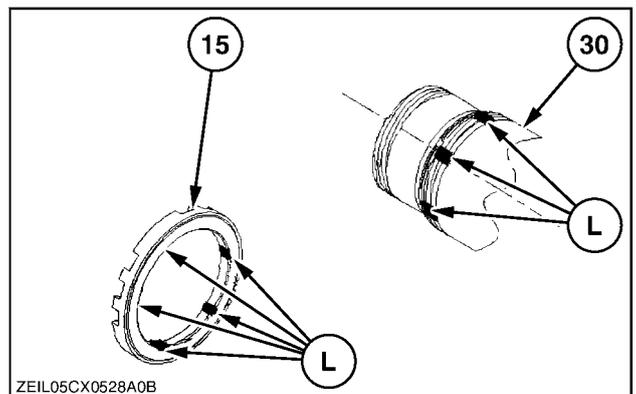
ZEIL05CX0531A0B 14

18. Remove remaining old thread locking compound from and de-grease the thread well of the nut (15) and the corresponding thread on the output shaft (30) using de-greasing compound (Loctite 7063).

Apply thread locking compound (type Loctite 273) to the thread of the nut (15) and the corresponding thread on the output shaft (30) as shown (5 spots on the thread of the nut and 5 spots on the thread of the output shaft).

**NOTE:** De-greasing is successful when a white dull layer appears on the thread.

**NOTE:** Apply enough thread locking compound so that all clearance is filled up when installing the nut.



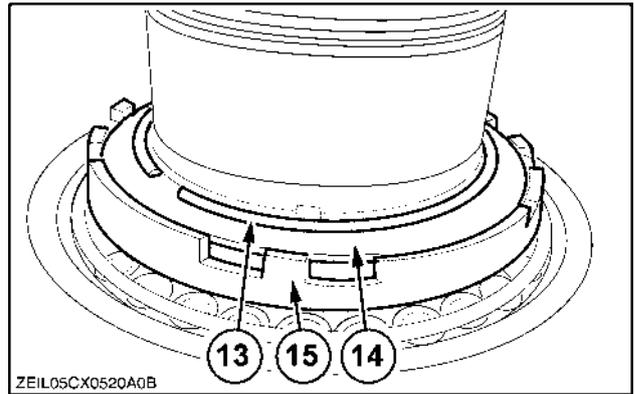
ZEIL05CX0528A0B 15

19. Install the nut (15) and torque the nut (15) to **1300 Nm** using special tool **380002596**.

Install the lock plate (14) so that there are always 2 lips lying in the cams of the nut (15) without rotating the nut.

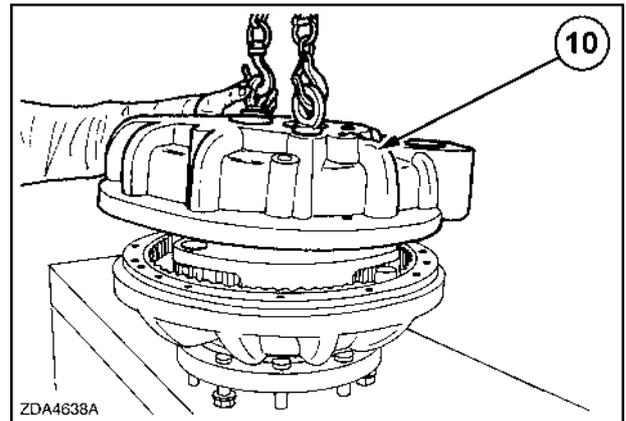
Install the retaining ring (13).

**NOTE:** The lock plate (14) has 2 sides with 5 positions.

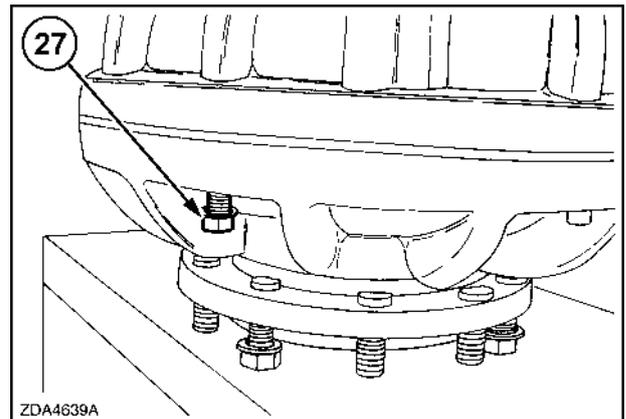


20. Install the outer ring of the bearing (11) in the inner housing (10) (refer to instruction 22).

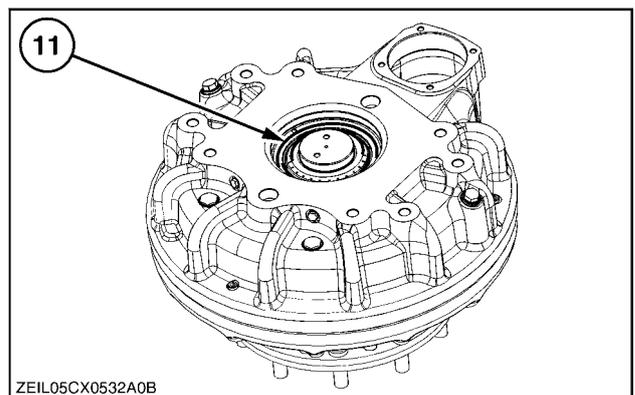
Install the inner housing (10).



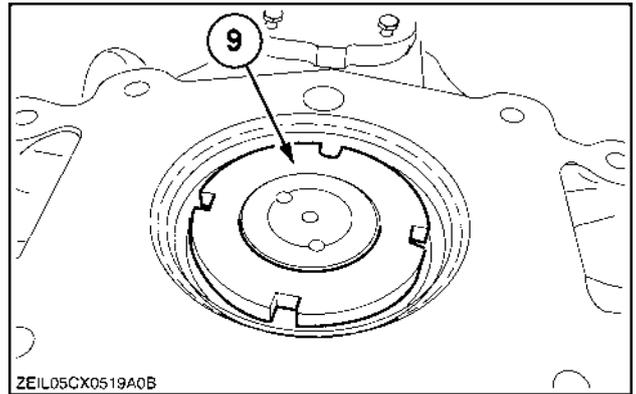
21. Apply thread locking compound (type Loctite 242) to the bolts (27). Screw in the twelve bolts (27) and tighten them to a torque of **320 Nm (236 ft.lbs)**.



22. Install the bearing (11).



23. Install the nut (9) and tighten the nut to **300 Nm**. Turn the final drive housing 1 turn and remove the nut (9).

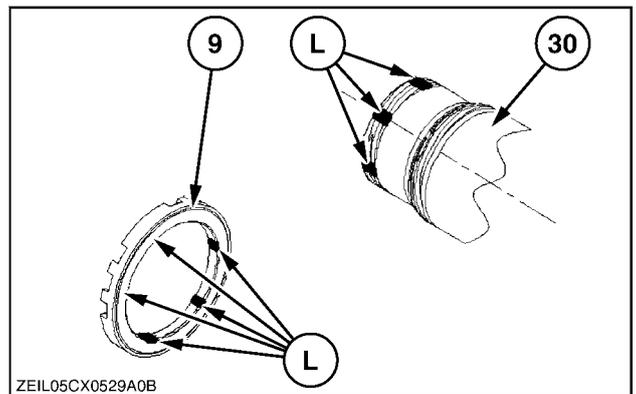


ZEIL05CX0519A0C 20

24. Remove remaining old thread locking compound from and de-grease the thread of the nut (9) and the corresponding thread on the output shaft using de-greasing compound (Loctite 7063). Apply thread locking compound (Loctite 273) to the thread of the nut (9) and the corresponding thread on the output shaft as shown (5 spots on the thread of the nut and 5 spots on the thread of the output shaft).

**NOTE:** De-greasing is successful when a white dull layer appears on the thread.

**NOTE:** Apply enough thread locking compound so that all clearance is filled up when installing the nut.



ZEIL05CX0529A0B 21

25. Install the nut (9).

Tighten the nut to **20 Nm**.

Turn the final drive housing 1 turn.

Repeat the two previous steps until the nut (9) does not rotate anymore at **20 Nm**.

Additionally tighten the nut (9) with **73 - 77 °** over the shaft.

**NOTICE:** Be sure the 12 bolts (27) (fig. 18) are tightened to torque before performing the bearing preload adjustment.

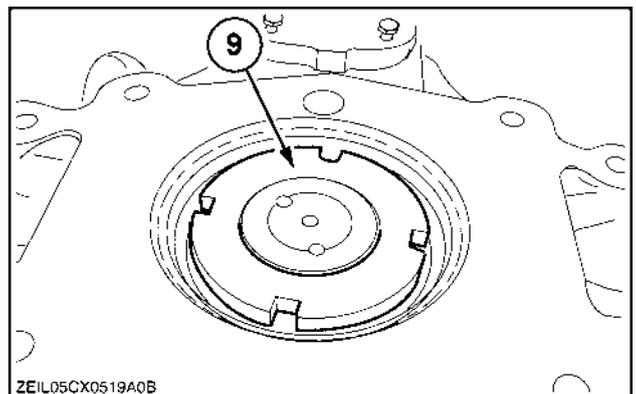
**NOTE:** Act rapidly when the thread locking component (Loctite 273) is applied, as the thread locking component harden out rapidly.

26. Install the lock plate (8), without rotating the nut (9), in such a way that 4 lips can be bended into the cams of the nut (9).

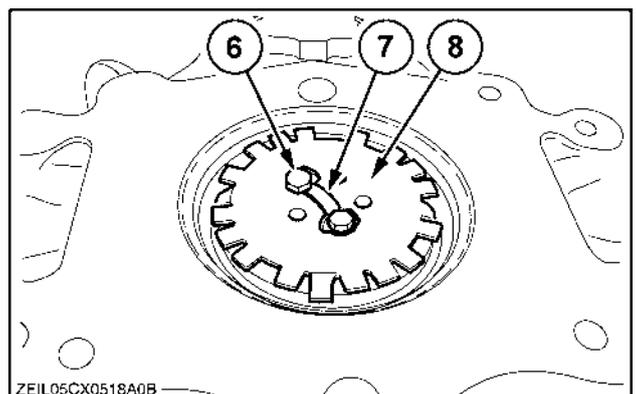
Install the lock plate (7) and the bolts (6). Tighten the bolts (6) to **45 - 55 Nm**. Bend 2 lips per bolt after assembly. Remove the by bending created burrs.

**NOTE:** The lock plate (8) has 5 installation positions on each side (5 x 2 = 10 position) and is designed in such a way that always 4 lips can be bend into the cams of the nut (9) no matter the position of the nut.

**NOTE:** Install the lock plate (7) with its bend to the middle as shown, otherwise interference with the cover (5) can occur.

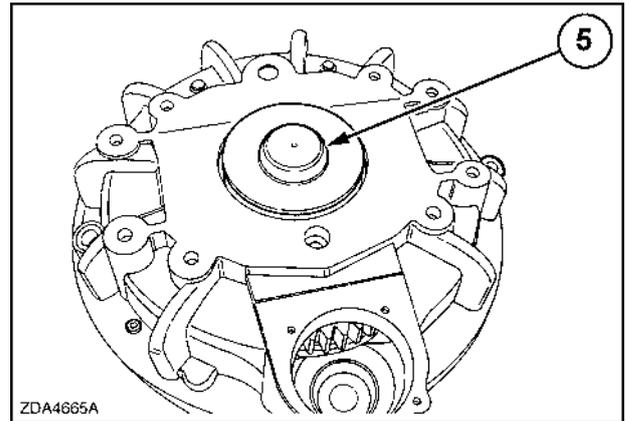


ZEIL05CX0519A0C 22



ZEIL05CX0518A0C 23

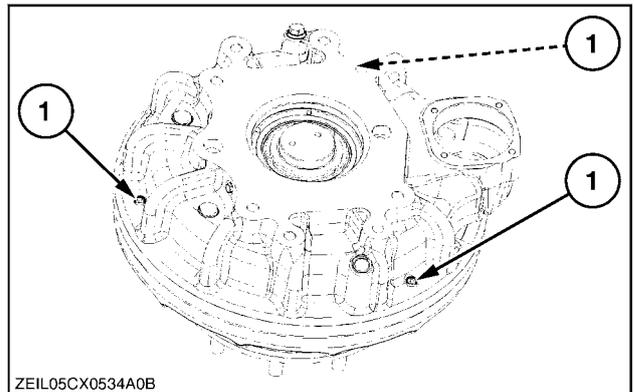
27. Apply sealing compound type 6 (Loctite 638) to the cover (5) and install the cover.



zda4665b 24

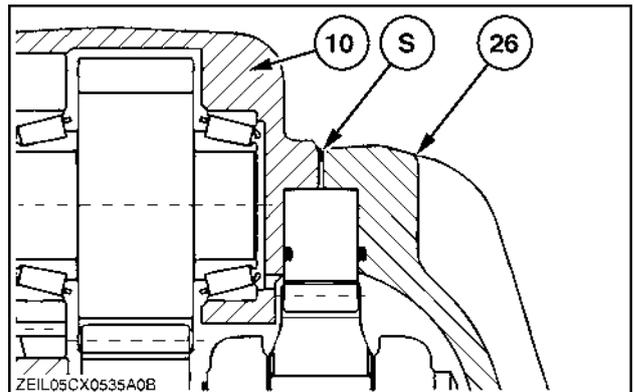
28. Apply sealing compound type 1 (Loctite 242) to the threaded studs (1).

Install the threaded studs (1) and tighten them to a torque of 15 - 25 Nm.



ZEIL05CX0534A0B 25

29. Apply sealing past (Loctite 5065) (S) between the inner housing (10) and the outer housing (26) all around.



ZEIL05CX0535A0B 26

**Next operation:**  
**Final drive Input shaft - Install (D.10.A).**

## Final drive - Install

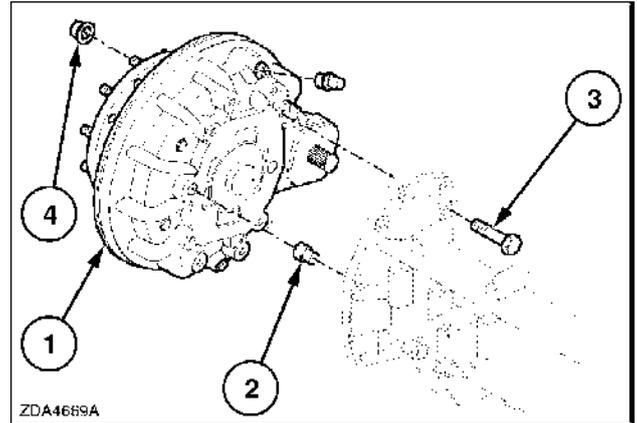
CX8070, CX8080, CX8090, CR9060 Elevation, CR9070 Elevation, CR9080, CR9080 Elevation, CR9090 Elevation

1. Insert two dowel pins (2) in the planetary final drive housing (1).  
Install the planetary final onto the traction axle of the combine.  
Apply some thread locking compound type 6 (Loctite 646) on bolts (3) to provide them from loosening.



**A final drive is heavy. Take extreme caution when handling the final drive! Use a supporting device which can handle this weight!**

Z001



ZDA4669A 1

2. Tighten bolts (3) to a torque of **670 Nm ( 495 ft.lbs)**
3. Fill the planetary final drive with oil ( Refer to the Operator's Manual, section 4 "Lubrication and Maintenance").
4. Install the traction wheel and tighten wheel nuts (4) to a torque of **610-730 Nm ( 450 - 540 ft.lbs)**.