

b. Turn drive pinion bearing cage over so flange is facing upward. Insert inner bearing into inner bearing cup and position outer bearing in cage in opposite direction of the inner bearing so the two bearings are back-to-back. Place the outer bearing cup over opening in bearing cage. Using replacer 5120-708-3252 and handle 5120-708-3241, drive bearing cup even with the bottom of bearing cage (fig. 95).

83. Assembly of Carrier Through Shaft

To assemble the carrier through shaft assembly, reverse the disassembly procedures. (Refer to par. 87.)

84. Assembly of Through Shaft Front and Rear Bearing Covers

a. Place the bearing cover on a solid block. Place the oil seal over the opening in the cover.

b. Using replacer 5120-708-3256 with handle 5120-708-3241, drive the seal even with top of bearing cover (fig. 96).



Figure 95. Installation of outer bearing cup



Figure 96. Installing front and rear bearing cover oil seals

85. Assembly of Front Axle Carrier

a. Installation of Bevel Gear Inner Bearing Sleeve (Fig. 79). Align notch in bevel gear inner bearing sleeve with setscrew hole in carrier and drive into place, using remover and replacer 5120-708-3246 and screw 5120-708-3216. Install bearing sleeve setscrew.

b. Bevel Pinion Bearing Preload Test (Fig. 97).

- (1) Install through shaft assembly temporarily to conduct bearing preload test. Refer to § below for installation procedures.
- (2) Wrap cable of preload tester 6670-347-5922 around through shaft.
- (3) Pull and note reading on scale while shaft is rotating. If original bearing cones and cups are used, reading should be between 4 to 8 inch-pounds. If new bearing cones and cups are used, reading should be between 12 to 18 inch-pounds. An equal amount of shims must be added under through-shaft bearing covers to decrease preload or removed to increase preload.

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H Kauffman



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