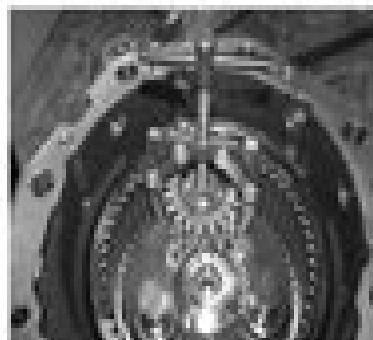


Disassembly (Cont'd)

DISASSEMBLY OF THE RING GEAR (18) AND OF THE DRIVE AXLE HUB (1)

1. In order to pull out the pinion gear (22) and their bearings (23), remove the retaining ring (24) and use a special extractor.



2. To unscrew the bearing nut (25) a special service tool is required; this tool is described on page 52/46.
To remove the drive axle hub (1) slide a pipe (diameter = 32 mm (1.26 in) and diameter = 40 mm (1.57 in) on the centre of the M80 thread of the hub, and carefully press it out. At this point slip off the pinion gear (18).

3. Unscrew the 10 bolts (17) and pull out the ring gear (18).



Assembly

After the wheel end parts have been replaced, to assemble the unit again follow the disassembling process steps in reverse order.

ASSEMBLY OF THE SECOND REDUCTION GEAR (26)

1. Place snap ring (28) on shaft of reduction gear (26). Place bearing (29) onto reduction gear shaft (26). Install snap ring (30).
2. Place the gear cover (31) on a press and press the second reduction gear (26) into the coast.
3. Locate the snap ring (28) through the slots in the second reduction gear (26) and install to retain the bearing.



ASSEMBLING THE RING GEAR (18) AND THE DRIVE AXLE HUB (1)

1. Insert the top (outer ring) of the taper roller bearings (8) in their front and rear housings on the gear carrier (17). Insert the outer (inner ring) of bearing (8) onto the hub (1) -preheating it up to 100°C (212°F)-. Insert the dual seal (3) into its housing in the hub.
Insert the bearing (8) in its coast side in the hub (1).

2. Introduce the dual cover (5) in its rear housing on the gear carrier (17) the wheel side.
Introduce the pre-assembled hub into the casing, insert the spacer (13) into the shaft and then place the cone of the bearing (8), preheating it in.

CAUTION

- In order to respect the max. axial play 0.04 mm (0.0016 in) it is possible to ask for a kit with calibrated shims including 3 bearings (8), spacer (13) and all the required spacers.
- When handling parts for assembly use care when handling parts to avoid getting burned.

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