

Install the bevel pinion and the adjustment shim just found (Item S, Fig. B.III/6) then torque tighten the nut (Item C.) to the specified value.

3. Setting the bevel gear tapered roller bearings and finding the total shim stack (Item Sc) thickness.

Install the differential and bevel gear as an assembly with the bearings properly lubricated, install a stack of shims (Item Sa, Fig. B.III/13) about 1 mm. thick and the bearing housing bracket securing the latter with only three nuts (Item C.) tightened to a torque value of 41.5-45.5 ft.-lbs. (56-62 N•m) and, finally, install the left side bearing housing bracket with no shims and also with three nuts (Item D), well lubricated with thin crankcase oil and arranged at 120° from each other (Fig. B.III/14).

Gradually cross-tighten the three nuts (Item D) with a torque wrench and with torque increments of 0.7 ft.-lbs. (.9 N•m) up to the final value of 4.3 ft.-lbs. (6N•m) per nut, simultaneously, turn the bevel gear a few turns by hand to ensure correct roller seating.

Measure the clearance (Item L, Fig. B.III/13) between transmission housing side and left side bearing housing bracket with a feel gauge at three points 120° from each other and symmetrical with respect to the adjusting nuts (Item D, Fig. B.III/15).

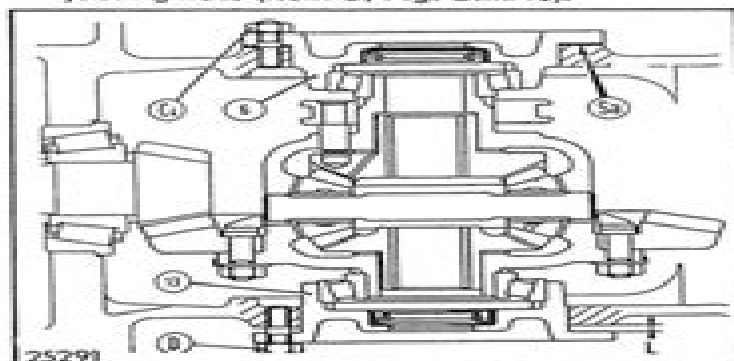


FIG. B.III/13 ADJUSTING THE DIFFERENTIAL-BEVEL GEAR TAPERED ROLLER BEARING
C.. Bearing housing bracket (6) stud nuts; D. Setting check nuts; L. Assembly clearance between transmission housing and left hand bearing housing (13); Sa. 0.040" (1 mm.). Shim stack thickness to be inserted on the right bearing housing; 6. Right side bearing housing bracket; 13. Left side bearing housing bracket

Find the average of the readings then add 0.002 in. (0.05 mm.).

Therefore, the total thickness (Item Sc) of shims to be installed is:

$$Sc = Sa + L + 0.05 \text{ mm. (.002")}$$

where:

Sa = shim thickness inserted at the right bearing housing bracket.

L = Clearance measure previously.

0.05 mm. = play required to take up the end float caused by tightening the nuts (Item D).

EXAMPLE

Thickness of shim stack inserted at the right side housing bracket 0.0374 in. (0.95 mm.)

Clearance (L) measures 0.1062 - .1062 - .1043 in. (2.70 - 2.70 - 2.65 mm.)

L = average clearance

$$= \frac{0.1062 + 0.1062 + 0.1043}{3} = 0.1055 \text{ in.}$$

$$= \frac{2.70 + 2.70 + 2.65}{3} = 2.683 \text{ mm.}$$

$$Sc = Sa + 0.05 = 0.0374 + 0.1055 + 0.0019 = 0.1448, \text{ rounded in excess of } 0.145 \text{ in.}$$

$$Sc = Sa + L + 0.05 = 0.95 + 2.683 + 0.05 = 3.683, \text{ rounded in excess to } 3.70 \text{ mm.}$$

NOTE: Always round the result in excess to the second decimal figure, with 0.002" (0.05 mm.) intervals.

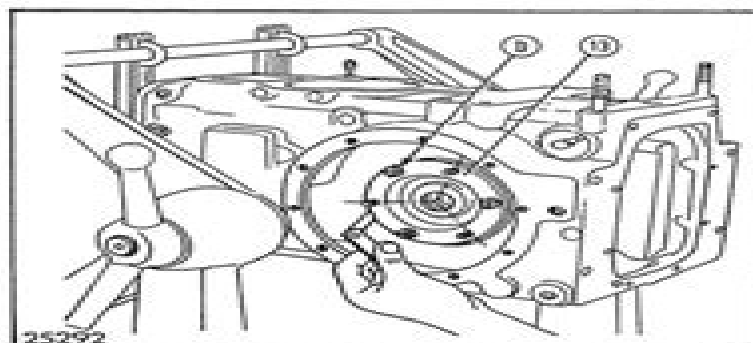


FIG. B.III/14 TIGHTENING THE NUTS (D) WITH A TORQUE WRENCH TO CHECK THE BEARING SETTING
13. Left bearing bracket

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 - The Rise of Digital Reading Long Tractor Service Manual 3 Cyc
 - Advantages of eBooks Over Traditional Books
2. Identifying Long Tractor Service Manual 3 Cyc
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Long Tractor Service Manual 3 Cyc
 - User-Friendly Interface

4. Exploring eBook Recommendations from Long Tractor Service Manual 3 Cyc
 - Personalized Recommendations
 - Long Tractor Service Manual 3 Cyc User Reviews and Ratings
 - Long Tractor Service Manual 3 Cyc and Bestseller Lists
5. Accessing Long Tractor Service Manual 3 Cyc Free and Paid eBooks
 - Long Tractor Service Manual 3 Cyc Public Domain eBooks
 - Long Tractor Service Manual 3 Cyc eBook Subscription Services
 - Long Tractor Service Manual 3 Cyc Budget-Friendly Options
6. Navigating Long Tractor Service Manual 3 Cyc eBook Formats
 - ePub, PDF, MOBI, and More
 - Long Tractor Service Manual 3 Cyc Compatibility with Devices
 - Long Tractor Service Manual 3 Cyc Enhanced eBook Features
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 - Adjustable Fonts and Text Sizes of Long Tractor Service Manual 3 Cyc
 - Highlighting and Note-Taking Long Tractor Service Manual 3 Cyc
 - Interactive Elements Long Tractor Service Manual 3 Cyc
8. Staying Engaged with Long Tractor Service Manual 3 Cyc
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Long Tractor Service Manual 3 Cyc
9. Balancing eBooks and Physical Books Long Tractor Service Manual 3 Cyc
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Long Tractor Service Manual 3 Cyc
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Long Tractor Service Manual 3 Cyc
 - Setting Reading Goals Long Tractor Service Manual 3 Cyc
 - Carving Out Dedicated Reading Time

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 - Fact-Checking eBook Content of Long Tractor Service Manual 3 Cyc
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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