5

PREASSEMBLING THE GROUPS AND ASSEMBLING THE TRANSFER GEAR BOX

5.1 Preassembling the central flange

Picture 94

Picture 95

Insert the ball on the top of flange by means of hammer and drift (pic.95).

Picture 96

Fix 2 pcs. bushing by means of 2pcs.of countersink screw (use thread sealant, see pic.96)

Picture 97

Press 2 pcs. rubber cushions by means of pressing machine. (pic.97).

5.2 Preassembling the rear case

Picture 98

Picture 99

Insert the ball on the top side case by means of hammer and drift (pic.99)

Picture 100

Insert the pin with up side of radius (pic.100).

Picture 101

Screw 6 pcs. studs (pic.101)

Picture 102

Mount the internal gear rim in to the case; check the joint with the case (pic.102).

Picture 103

Screw the 6pcs. nuts and tight it by prescribed torque (pic.103).

Picture 104

Insert the position ring near the pin in the upper side of the case (pic.104)

5.3 Preassembling the front case

Picture 105

Picture 106

Insert 2 pcs. pins (pic.106)

Picture 107

Insert the 2 pcs. O rings into the shafting lines (pic.107, 108)

Picture 108

5.4 Preassembling the rear support

Picture 109

Picture 110

Mount the rubber cushion by means of hydraulic press (pic.110)

5.5 Preassembling the upper front shaft

Picture 111

Picture 112

Mount the lip seal into the shaft cover (pic.112)

Picture 113

Use the Drift 3080A183 to install the lip seal into the correct position (pic.113)

Picture 114

Apply inside surface of lip seal with water repellent grease (Use Persian Oil-Sintegrease) and seat the flange inside of cover (pic.114, 115)

Picture 115

Picture 116

Insert the bearing into the shaft cover (pic.116)

Picture 117

Insert the shaft (pic.117)

Picture 118

For tighting the flange, use the Support 3080A180 griped into the vice (pic.118)

Picture 119

Insert the O ring (pic.119) and washer (pic.120)

Picture 120

Picture 121

Screw the nut by means of special Socked wrench M20x1 30803014 (pic.121) and tight it by prescribed torque (pic.122)

Picture 122

Picture 123

Insert the distance ring (pic.123)

5.6 Preassembling the lower front shaft

Picture 124

Picture 125

Mount the lip seal into the shaft cover (pic.125)

Figure 126

Use the Drift 3080A183 to install the lip seal into the correct position (pic.126)

Picture 127

Apply inside surface of lip seal with water repellent grease (Use Persian Oil-Sintegrease) and seat the flange inside of cover (pic.127, 128).

Picture 128

Picture 129

Insert the bearing into the shaft cover (pic.129).

Picture 130

Insert the shaft (pic.130).

Picture 131

For tight the flange use the Support 3080A180 griped into the vice (pic.131)

Picture 132

Insert the O ring (pic.132) and washer (pic.133)

Picture 133

Picture 134

Screw the nut by means of special Socked wrench M20x1 30803014 (pic.134) and tight it by prescribed torque (pic.135)

Picture 135

Picture 136

Insert the spacer (pic.136).

5.7 Preassembling the lower rear shaft

Picture 137

Picture 138

Mount the lip seal into the shaft cover (pic.138).

Picture 139

Use the Drift 3080A183 to install the lip seal into the correct position (pic.139).

Picture 140

Apply inside surface of lip seal with water repellent grease (Use Persian Oil-Sintegrease , pic.140).

Picture 141

Attention: this shaft cover has a tapped hole on the side for speed sensor (pic.141).

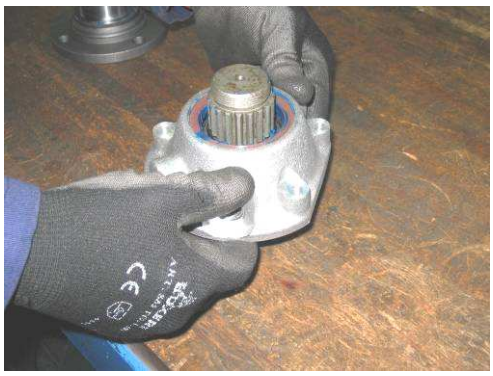
Picture 142

Fit the bearing and spread wheel on the spline shaft and perform pressing by means of hydraulic press (fig.142)

Picture 143

Install the O ring on the assembled spline shaft (pic.143, 144)

Picture 144



Picture 145

Fit on the shaft assembled cover (pic.145) and flange (pic.146)

Picture 146

Picture 147

Screw a nut by means of special socket wrench 30803015: M35x1, 5 (pic.147) and tight with prescribed torque by using the Support 3080A180 (pic.148)

Picture 148

5.8 Preassembling the internel central shaft

Picture 149

Picture 150

Install the bearing with retaining ring down on the quill shaft by means of hydraulic press (pic.150).

Picture 151

Mount the1st.gear wheel (pic.151).

Picture 152

Install the retaining ring (pic.152)

Picture153

Mount the jaw clutch with synchronizer without upper part, (pic.153) then retaining ring (pic.154) and upper part of jaw clutch (pic.155).

Picture 154

Picture 155

Picture 156

Mount the 2nd.gear wheel (smaller diameter for high speed, used only for army version), (pic.156) or 2nd gear wheel (bigger diameter for low speed) (pic.157).

Picture 157

Picture 158

Fit the bearing with retaining ring in up position on the quill shaft and perform pressing by means of hydraulic press (pic.158)

Picture 159

Mount the Seeger ring (pic.159)

Picture 160

Mount the Seeger ring on the opposite shaft end (pic.160). If necessary use hydraulic press

5.9 Preassembling the upper rear shaft

Picture 161

Picture 162

Install the bearing with retaining ring with up position on the quill shaft by means of hydraulic press (pic162 and 163)

Picture 163

Picture 164

Mount the gear wheel and secure by Seeger ring. (pic164, 165).

Picture 165

Picture 166

Install the bearing with retaining ring up on the quill shaft by means of hydraulic press (pic.166)

Picture 167

Insert the assembled unit into the Support 3080A180 (pic.167) and mount the Seeger ring by means of plastic hammer.

5.10 Preassembling the intermediate shaft

Picture 168

Picture 169

Install the bearing on the spline shaft by means of hydraulic press (pic.169)

Picture 170

Mount 2 pcs. of helical gear (first smaller one only for army version) and spacer with shoulder in up position (pic.170)

Picture 171

Install the bearing on the spline shaft by means of hydraulic press (pic.171)