

6

ASSEMBLING THE TRANSFER GEAR BOX

6.1 Assembling the transfer gear box



Picture 207

For assembling the gear box use the 3080A018: Rotative stand (pic.207)



Picture 208

Insert and fix the central flange into the rotative stand. (pic.208, 209, 210)



Picture 209



Picture 210



Picture 211

Mount the temporary cover (pic.211, 212,) by means of 4 pcs socked-had screw for positioning the central shaft



Picture 212



Picture 213

Remove the retaining ring from the internal central shaft bearing (pic.213, 214, 215).



Picture 214



Picture 215



Picture 216

Heat all three calibrated bores for bearings (pic.216)



Picture 217

Mount all three pre-assembled shaft into the central flange (pic.217, 218, 219,)



Picture 218



Picture 219



Picture 220

Differential locking unit set (pic.220)



Picture 221

Before to install the all O rings, grease the ring grooves on the all flanges.



Picture 222



Picture 223



Picture 224



Picture 225

Install the all O-rings into the 3 pcs. of flanges (pic.222, 223, 224, 225) and grease again the O-rings (pic.226, 227, 228,)



Picture 226



Picture 227



Picture 228



Picture 229

Grease the both side central flange manhole surfaces (pic.229, 230,)



Picture 230



Picture 231

Mount the single flange (pic.231)



Picture 232

Mount the neck flange (pic.232)



Picture 233

Insert the pre-assembled shifting fork with the collar into the flange (pic.233, 234, 235, 236)



Picture 234



Picture 235



Picture 236



Picture 237

Insert helical spring (pic.237) and thrust ring (pic.238)



Picture 238



Picture 239

To insert and lock the Seeger ring on the shifting rod, press the inserted helical spring and thrust ring by means of the pliers 3080A188 (pic.239, 240)



Picture 240



Picture 241

To fix the position, grip the upper and lower shaft on the bottom side of central flange by means of supporting blade (pic. 241)

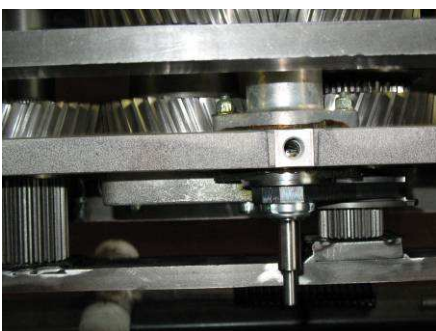


Picture 242

Fit the blank flange by means of two hexagon socket-head screw (pic.242, 243)

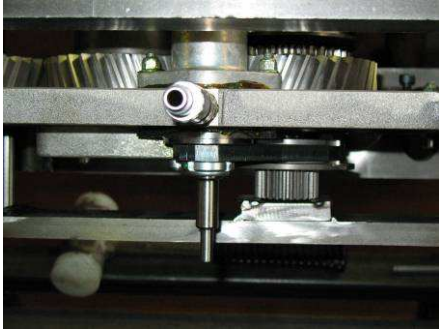


Picture 243



Picture 244

For checking the right function of deferential lock by air pressure, screw the inlet fitting. (pic.244, 245, 246).



Picture 245



Picture 246

Gear shift mechanism (pic.247)



Picture 247

Mount the speed change fork for normal and high speed on the selector rod (pic.248, 249)



Picture 248