

Dis assembly and assembly eighth fast 16JS series gearbox

Fusite 16 gear box by a file is inserted into the front auxiliary box and a four forward gears of main gear box and composed of a high and low speed range of gear pair transmission box of, so in dismantling and introduced above the Fast gear box have bigger difference, focus on the following the 16 gear box and other boxes different dis assembly of the key, open the rest of the, installed can refer to the RT1509C type box.

One, 16JS series gearbox key parts of the demolition

(a) the removal of a shaft assembly



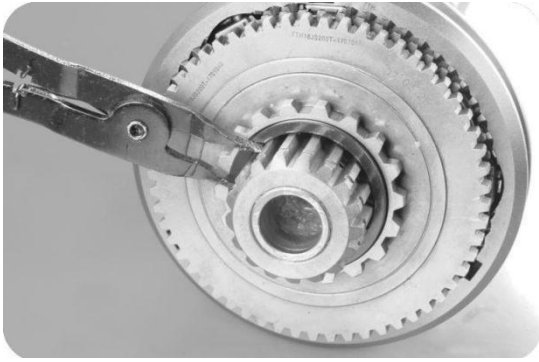
1, 16 gear transmission shaft gear assembly.



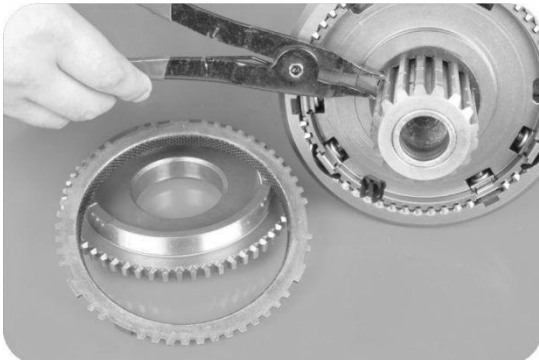
2, remove the stop ring in the inner hole of the shaft gear.



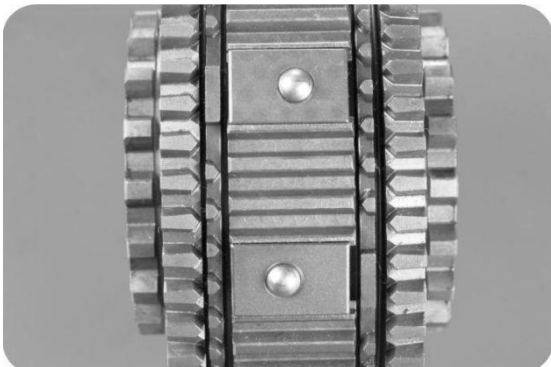
3, take off a shaft gear and its two side spline pad.



4, pull down the retaining ring in front of the gear mesh.



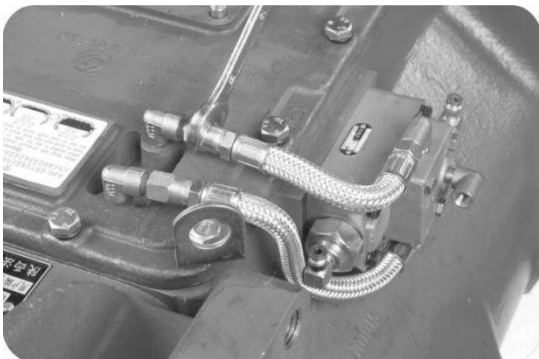
5, take off the side component of the odd and even gear synchronization device, remove the stop ring on one side of the synchronization device.



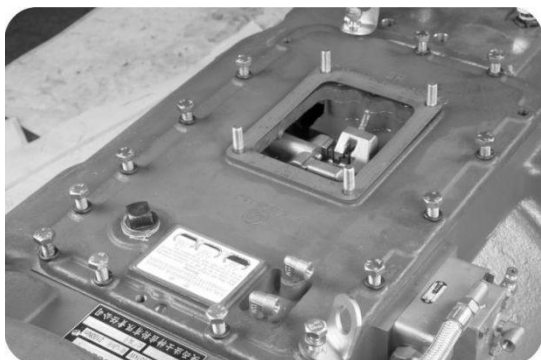
5, the direction of the slider and the cone ring on the sync.

Note: the two sides of the odd and even gear of the sixteen gear is not interchangeable with the cone ring and often engaged teeth

(two) the removal of the upper cover of the transmission box



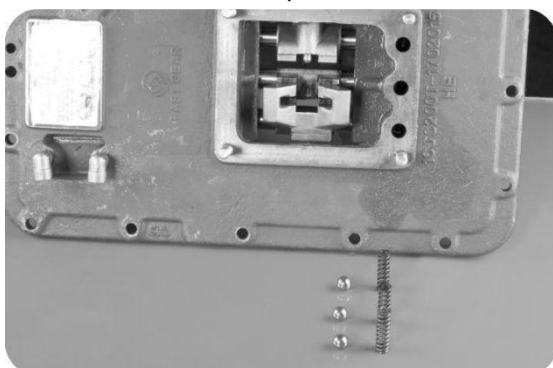
1, remove the valve and odd even number of cylinders of the air pipe.



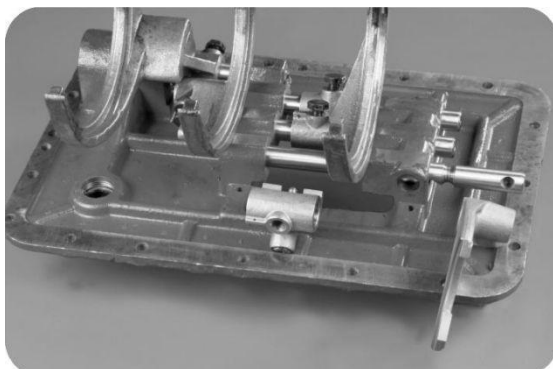
2, remove the cover bolts.



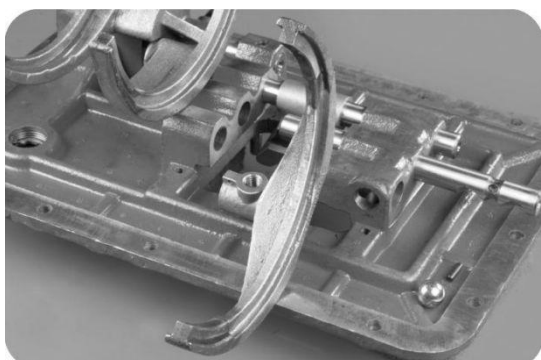
3, with the bolt on the top of the cover, take off the top cover assembly.



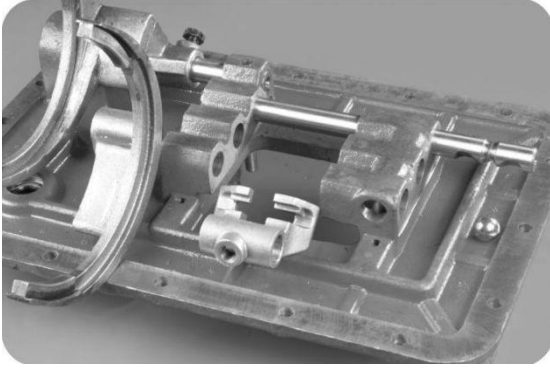
4, remove the shell hole in the three positioning springs and steel balls.



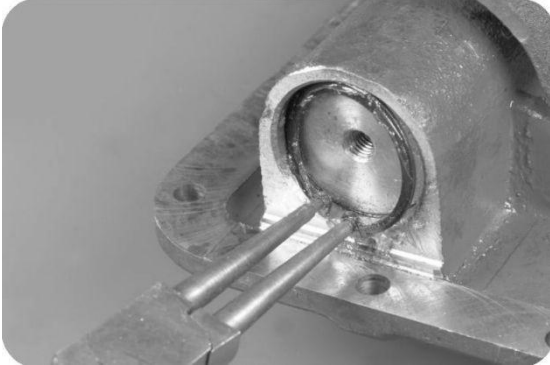
5, remove the reverse gear shifting fork shaft, the guide block and reverse gear shifting fork.



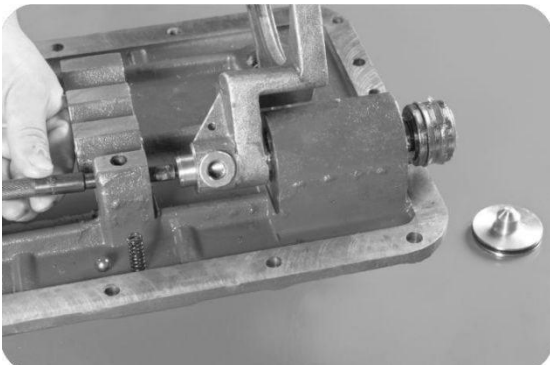
6, remove the 1/2 gear shifting fork shaft and fork, interlocking steel ball out shell. Note: 1/2 gear shifting fork shaft hole of each latch.



7, remove the 3/4 file shifting fork shaft, guide block and fork, take out the case of interlocking steel ball.



8, remove the check ring in the cylinder of the odd and even number of odd and even gear on the upper cover shell.



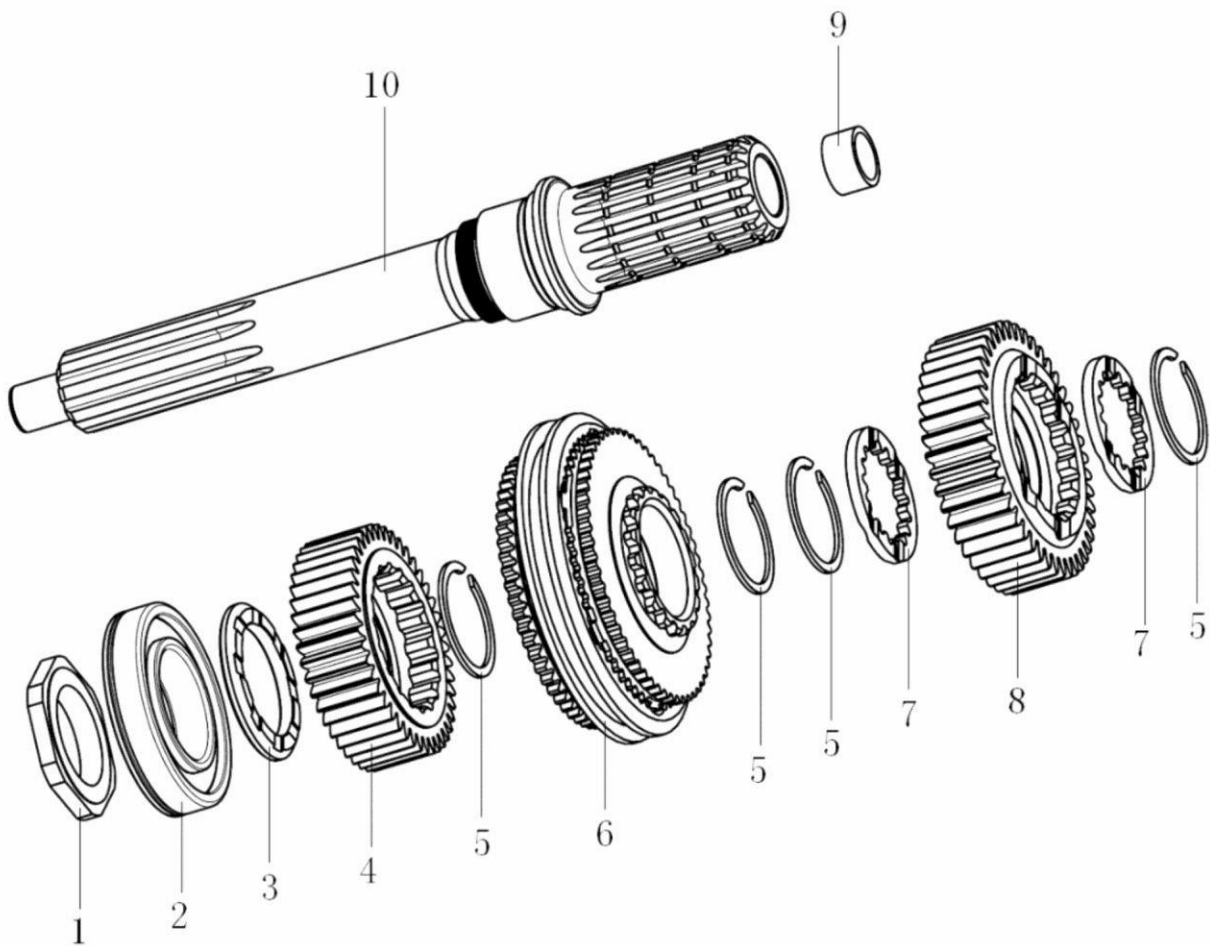
9, tap the piston and the fork shaft, remove the shell in the spring and the steel ball, remove the piston and the fork shaft.



10, the piston shifting fork shaft on the Y - shaped sealing ring and the side cover of the O - shaped sealing ring.

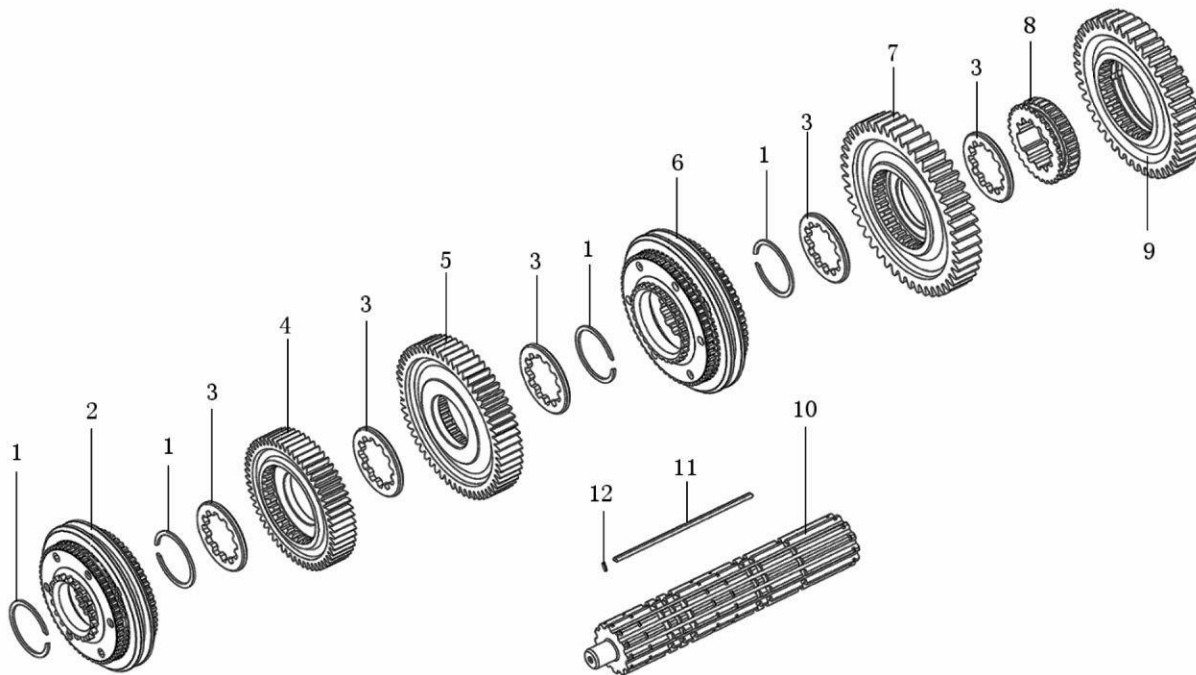
Two, 16JS series gearbox assembly

16JS series of gear box and a conventional twin counter shaft transmission main difference is more a file is inserted into the front auxiliary box. Figure 8-1, figure 8-2 and 8-3 were given a shaft, shaft and the second shaft parts decomposition diagram, rest and conventional twin counter shaft transmission exactly the same.



1 one shaft nut 2 one shaft bearing 3 separate ring 4 one shaft low half gear 5 clip ring 6 front side gear 7 one shaft gear spline pad.8 shaft high gear two 9 shaft guide sleeve 10 one shaft

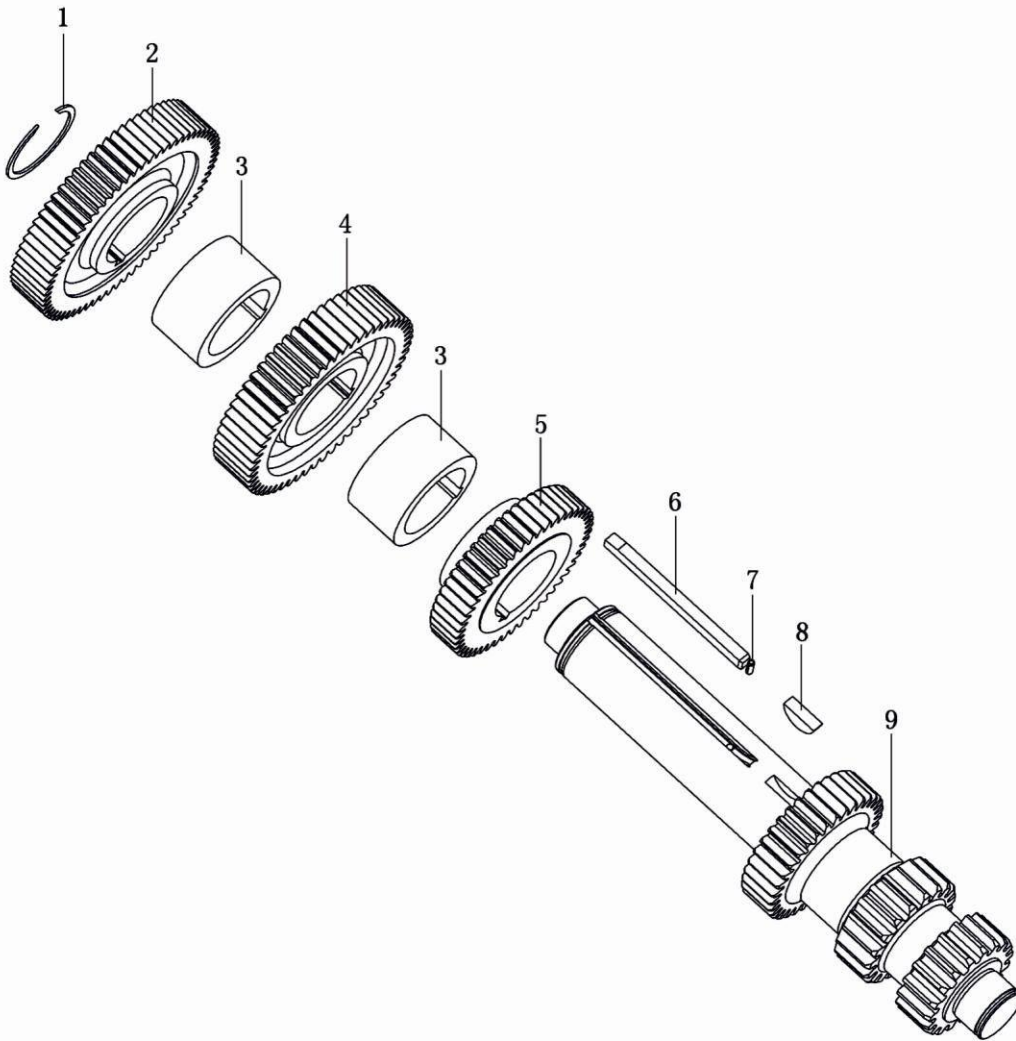
Figure 16JS 8-1 series gearbox one shaft parts breakdown



1. The snap ring is to be effected (made) during March / file synchronizer assembly set. The second shaft reverse gear. A reverse synchronous device. Second shaft gear septum. The second shaft gear box 5. The second shaft second gear 6.1/2

file. The second shaft first gear meshing slippery. Second shaft 11. Two axes of the six party Chang jian 12. Elastic cylindrical pin

Figure 16JS 8-2 series gearbox two shaft parts breakdown



1 clasp 2 counter shaft gear 3 low half sleeve 4 counter shaft gear semi high 5 counter shaft third gear 6 four long key 7 elastic circular shaft. Pin 8 key 9 counter shaft

Figure 8-3 16JS series gearbox main box counter shaft parts diagram

Here we introduce these parts of the assembly.

(a) assembly of a shaft assembly



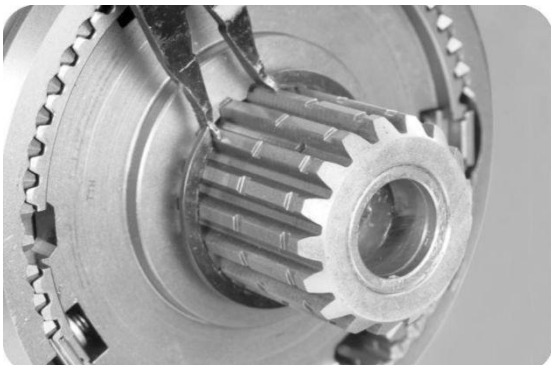
1, a vertical shaft, a shaft sleeve into high gear half shaft gear assembly, a spacer, convex downward.



2, load a shaft bearing.



3, a shaft horizontally, side components into odd and even gear synchronizer assembly, a stop ring.



4, a synchronizer gear hub, the installation of a stop ring.



5, load the other side of the device components, the installation of a stop ring.



6, install a spline on a shaft pad.



7, the assembly of a low gear and spline shaft gear, the installation of a stop ring.



8, in a shaft nut threads coated with anaerobic adhesive, assembly shaft nut and riveting die. On the one axis differential gear direction of 180 DEG arbitrary two groups of teeth on the tooth marks.



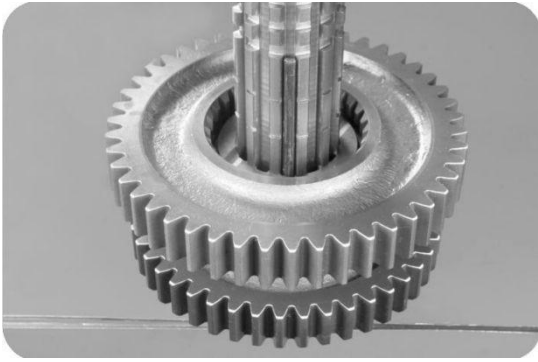
1, two axis vertically arranged on the workbench, a reverse gear gasket, turned a pitch and then penetrates the long bond.



2, two axis reverse gear up into the two combined tooth shaft into reverse sliding sleeve, lack of cogging towards the two axis with keyways.



3, load the two shaft gear spacer, turn a tooth pitch to push up the long key.



Two, the 4 shaft gear with a gear combined with the teeth into the two shaft, into the two shaft gear flower pad, turned a tooth pitch up to push the long key.



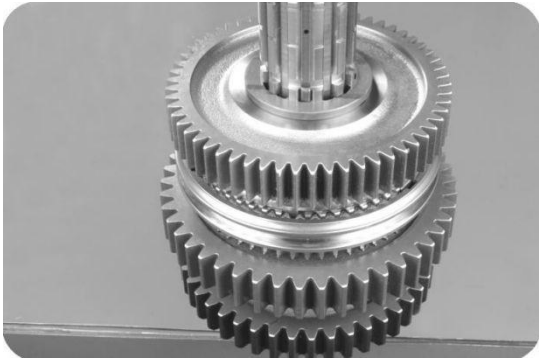
5, load the 1/2 gear of the side of the gear components, into a stop ring.



6, 1/2 gear synchronizer gear hub assembly, into a stop ring.



7, load the 1/2 gear of the other side of the gear assembly, into the two shaft gear flower pad, turned a tooth pitch up to push the long key.



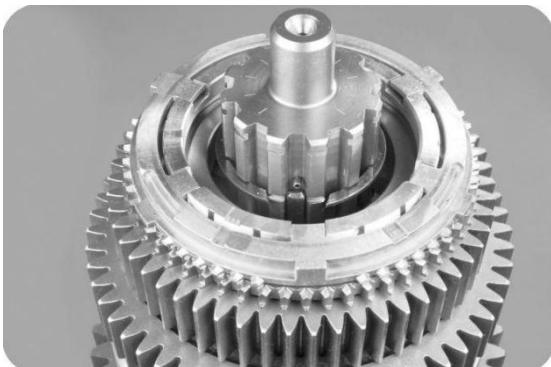
8, two axis gear tooth with gear down into two axis, two axis gear loading pad, turned a pitch to push the long key.



9, two axis combined tooth to third gear into two axis, two axis gear into flower pad, turned a pitch to push the long key.



10, assemble the elastic pin on the two axle.



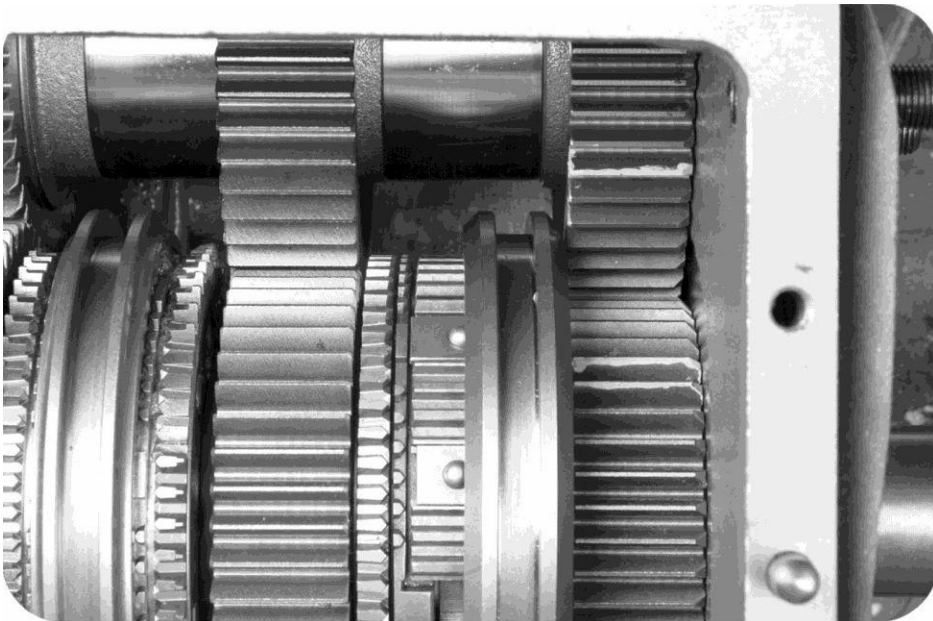
11, load the 3/4 gear synchronous device side of the component, into a stop ring. Note: the opening of the stop ring to the two axis hole.



12, 3/4 gear synchronizer gear hub assembly, into a stop ring. Note: stop ring opening to avoid the two shaft hole of the groove.

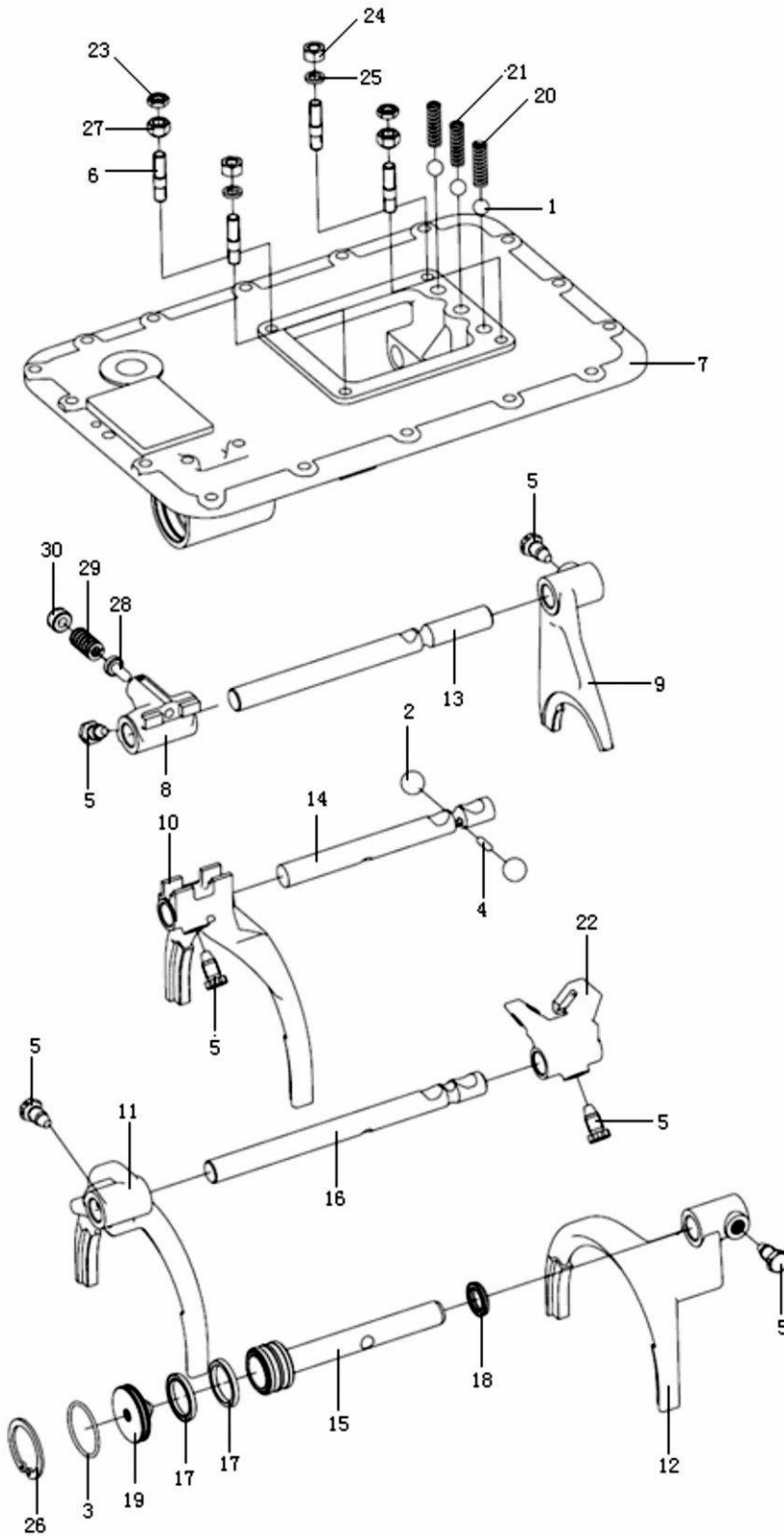


13, load the other side of the 3/4 file synchronization component.(three) main box assembly points



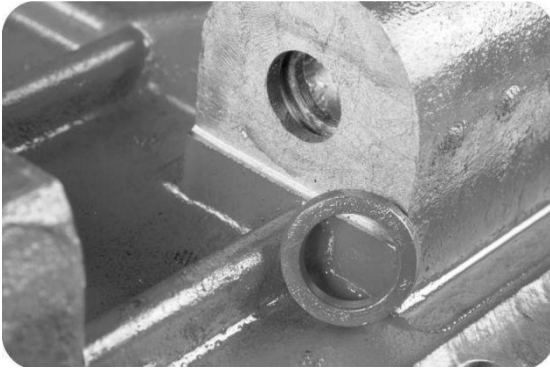
16JS series gearbox main box assembly process and conventional twin counter shaft transmission no what difference, only the gear assembly, available a high axial half gear on the tooth, can also be used a low axial semi file gear tooth(Figure) The auxiliary box assembly and double H shift mechanism assembly and conventional gearbox is similar, can refer to 12JS series gearbox.

(four) assembly of the main box cover Top cover assembly parts breakdown diagram see figure 8-4.



1.2. ball 3.O ring 4 fork fork shaft interlocking Shaw 5 locking screws 6 stud 7 cover 8 reverse guide block 9 reverse gear shifting.Fork 10.1/2 shift fork 11.3/4 gear shifting fork 12. Front side box fork 13. Reverse gear shifting fork shaft 14.1/2 gear shifting fork shaft dial fork shaft 17.18.Y type 15. Front side box shifting fork piston rod 16.3/4 file sealing ring 19. End cover 20. A compression spring 21. A compression spring 22.3/4.7/8 file guide block 23. Thin nuts 24.Z type nut 25. Spring washers 26. Hole spring file on lap 27. Nut 28. Reverse lock plunger 29. Reverse Lock spring 30 reverse gear locking plug

Figure 8-4 top cover assembly parts breakdown



1, the upper cover housing on the odd and even number of gear shift cylinder bore Y - shaped sealing ring.



2, the Y - shaped sealing ring of the piston shaft is covered with a layer of grease, and the shaft is mounted on the upper cover housing of the odd and even number of gear shift cylinders.

Note: the direction of the Y - shaped sealing ring.

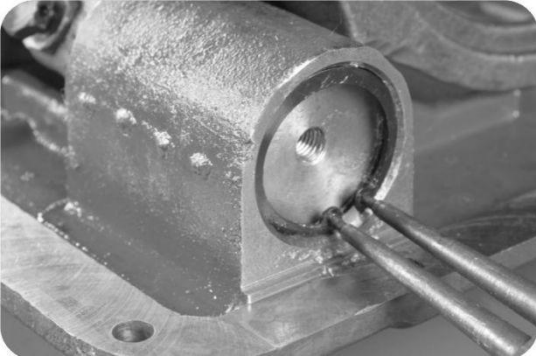


3, load the odd even number of files to change the positioning of the ball inside the cylinder bore.

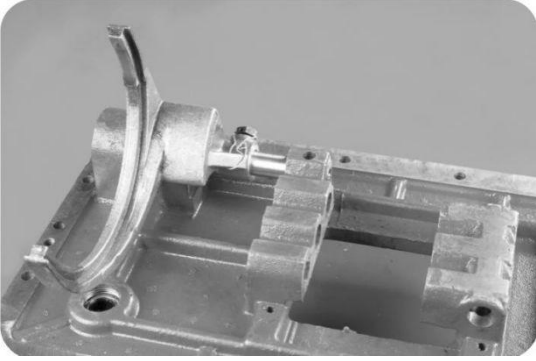
Note: the spring is down, the steel ball is on.



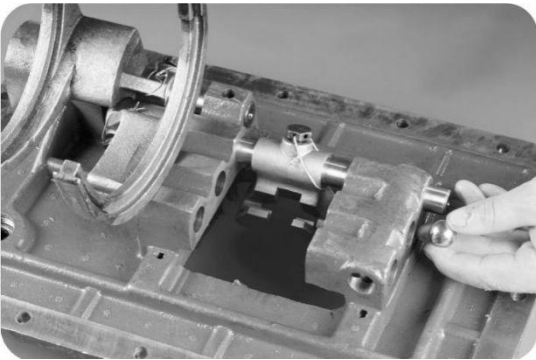
4, the out of plane with the side cover.



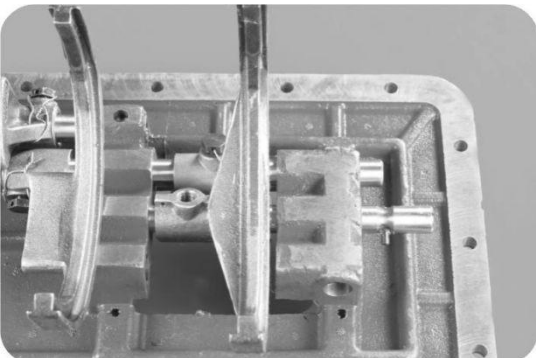
5, the assembly of the cylinder on the stop ring.



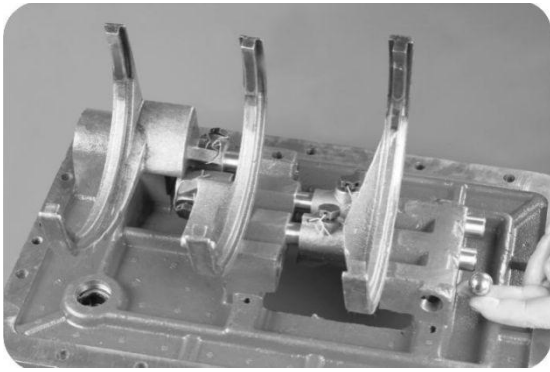
6, the assembly of odd and even number of files to change the cylinder shift fork on the bolt, and with wire fastening.



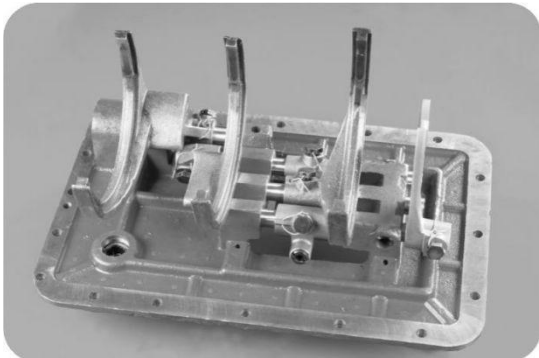
7, load 3/4 file shifting fork shaft, guide block and fork, fastening bolts, into an interlocking steel ball.



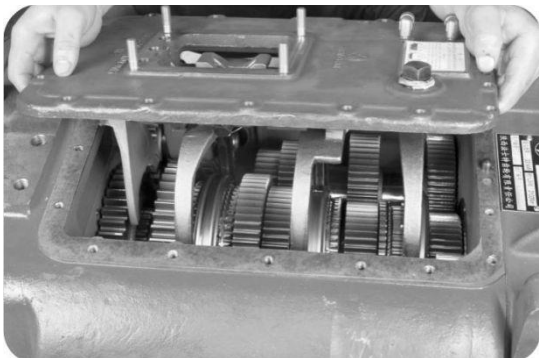
In 8, 1/2 gear shifting fork shaft and fork, install the interlocking pin.



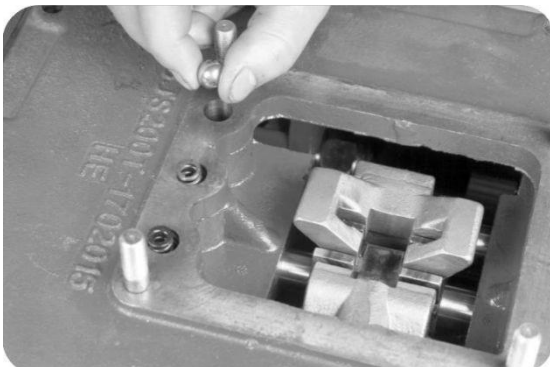
9, fasten the 1/2 shift fork and the guide block on the bolt, with wire binding.



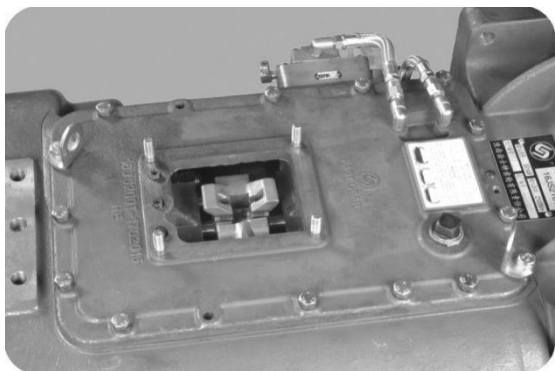
10, a reverse gear shifting fork shaft, the guide block and reverse gear shifting fork, fastening bolts.



11, assembly cover assembly.



12, the three positioning steel ball and spring plate within the assembly. Note: 3/4 gear shifting fork shaft hole spring thick.



13, tighten the bolts on the cover, connecting the shift device and the upper cover of the trachea.

16JS series gearbox rear auxiliary box and shift mechanism and conventional twin counter shaft gearbox no different, and the assembly procedure can participate according to 12JS series gearbox. It just has a larger difference in the shift control of gas on the way and transmission in the re assembly. Should be paid attention to.