



- **SECTION 3 TECHNICAL DATA FOR MAINTENANCE AND ASSEMBLY**
- I . For assembling and adjustment data, refer to Figs. 5-8 and 5-9 below:

| S/N | Contents | Standard value |
|-----|---------------------------------------------------------------------|----------------|
| 1 | Pre-tightening force for the conical roller bearing of input shaft | 0.05~1.0Nm |
| 2 | Axial clearance of conical roller bearing of intermediate shaft | 0.3~ 0.5mm |
| 3 | Pre-tightening force for the conical roller bearing of output shaft | 0.05~1.0Nm |



- **II. Refer to Table below and Figs. 5-8 and 5-9 for the tightening force of main bolts and nuts.**

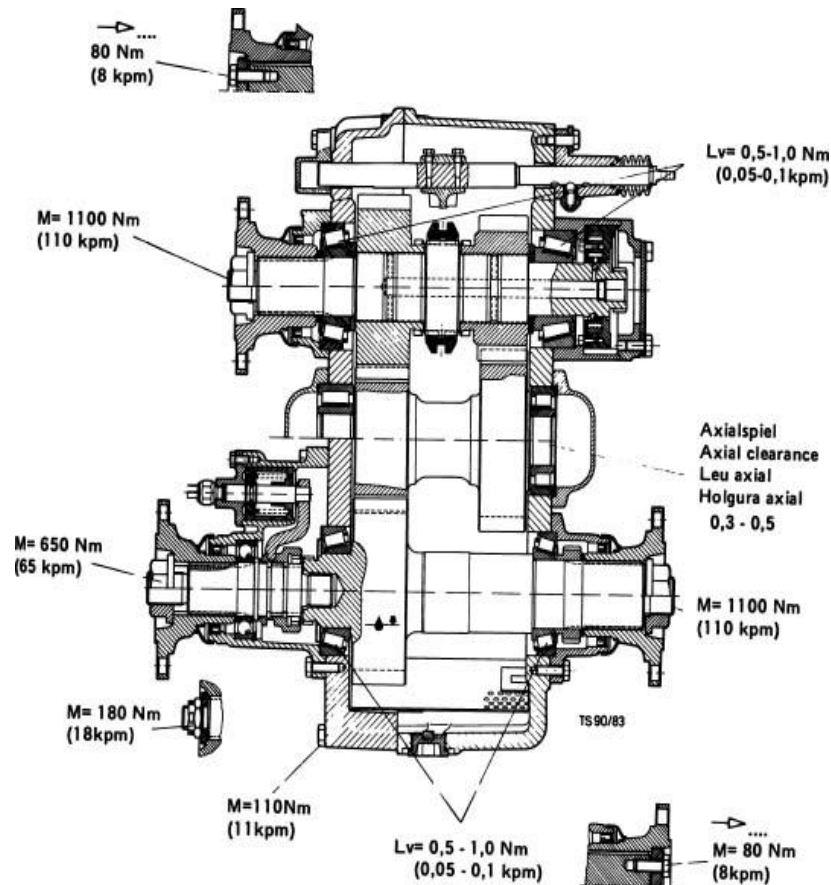
| S/N | Contents | Standard value |
|-----|-------------------------------------------------------|-----------------------------------------------|
| 1 | Connecting bolts of front and rear covers of transfer | 110Nm |
| 2 | locking nut for input shaft flange | 1,100Nm |
| 3 | locking nut for rear driving output flange | 1,100Nm |
| 4 | locking nut for front driving output flange | 650NM |
| 5 | Bolts for cover plate of plant carrier | $80 \sim 85\text{Nm} + 120^\circ \pm 5^\circ$ |



- **III. Assembling gluing and technique**
- ① During assembling, the Loctite brand plane sealing compound should be applied to the plane joint. Loctite 242 sealing compound should be applied to the locking nut of input and output flanges.
- ② After it is heated to 80°C, the bearing will be fitted onto shaft.
- ③ After it is heated to 100°C, the input and output flanges will be fitted onto shaft and at once tighten the locking nuts.
- ④ First of all, screw down to 80~85Nm for locking bolt of planet carrier cover plate, then tighten $120^{\circ} \pm 5^{\circ}$ further to locking direction.
- ⑤ Refer to TRANSMISSION section for lubrication, operation, maintenance and common troubles.



- Fig. 5-8 Tightening torques for different positions (without interaxle differential)





- Fig. 5-9 Tightening moments for different positions (with interaxle differential)

