

Fig 81. Output Shaft

Install Pre-assembled Drive Shaft and Clutches

- 1 Insert outer races for bearings being renewed into the relevant bearing bores of the housing cover.

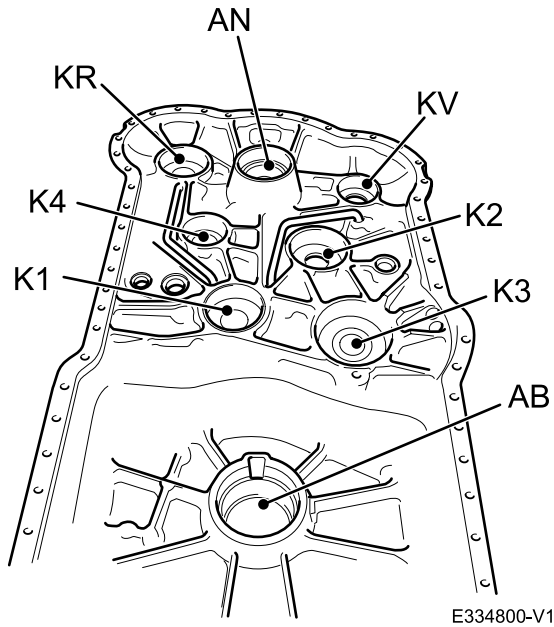


Fig 82.

Key ⇒ Fig 82. (□ F-74)

An	Input (driveshaft)
KV	Clutch - Forward
KR	Clutch - Reverse
K1	Clutch - 1st Speed
K2	Clutch - 2nd Speed
K3	Clutch - 3rd Speed
K4	Clutch - 4th Speed
AB	Output shaft

Note: Prior to the installation of the clutches and the drive shaft, grease the rectangular rings retaining the taper bearings and align them centrally. When installing refer to ⇒ Fig 83. (□ F-74) for the shaft position and orientation.

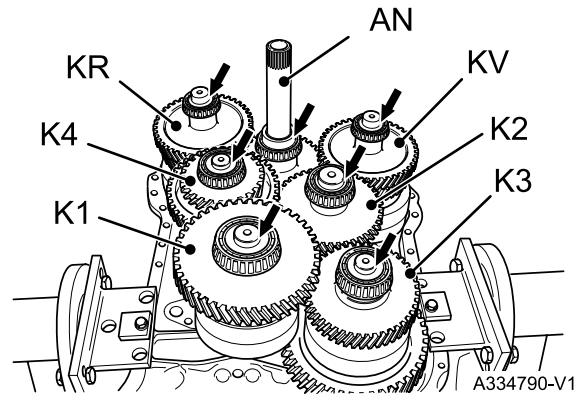


Fig 83.

- 2 Insert clutch **KR**, drive shaft **AN** and clutch **KV** together into the housing cover.
- 3 Raise drive shaft **AN** and install clutch **K4**.
- 4 Install clutch **K3** followed by clutch **K2**.
- 5 Raise clutch **K4** and install clutch **K1**.
- 6 Grease rectangular rings (arrowed) in and align them centrally ⇒ Fig 82. (□ F-74).
- 7 Attach retainers **A** to the threaded studs protruding through the housing cover from the six clutches. As an alternative to the retainers, fit washers and M10 nuts over each stud and tighten firmly.

Retainer 892/01014

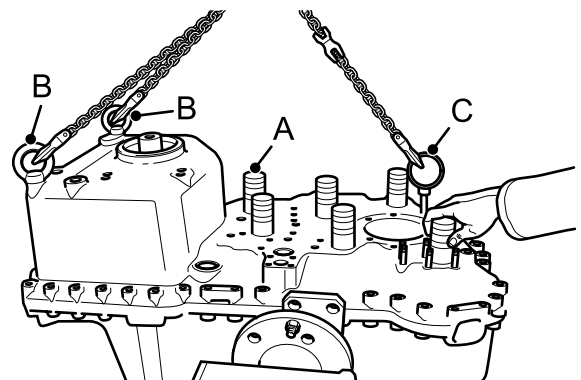


Fig 84.

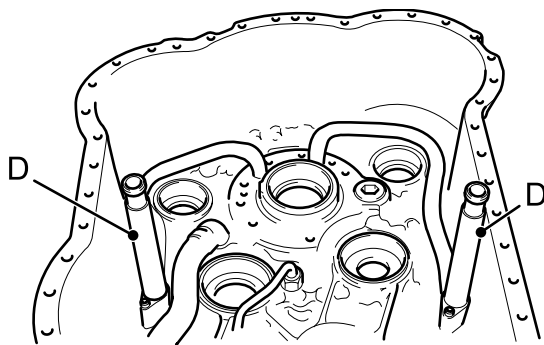
- 8 Rotate housing cover 180°. Attach two M20 eyebolts **B** and one M16 eyebolt **C** to the torque converter case half.

Lifting Eye (M20) 892/01015

Lifting Eye (M16) 892/01013

- 9 Grease O-rings of the two oil tubes **D** installed at step 4 → [Fig 85.](#) ([□ F-75](#))>.

Wet mounting face with JCB Multigasket sealing compound.



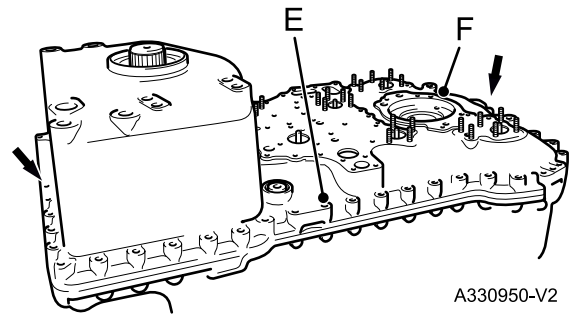
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Fig 85.

- 10 Position pre-assembled housing cover by means of lifting device carefully on the gearbox housing until contact is obtained.

Note: Pay attention to the alignment of the oil tubes **D** with the bores in the housing cover.

- 11 Remove the six clutch retainers fitted at step 7.
- 12 Install both cylindrical pins (arrowed) centrally to the housing face → [Fig 86.](#) ([□ F-75](#)).



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Fig 86.

Fasten housing cover by means of hexagonal head screws **E**.

Torque limit (M10/8.8)..... 46 Nm (34 lbf ft).

Note: Pay attention to the position of the lifting ring **F**.

Install Pump Shaft

- 1 Install ball bearing 7. Fit rectangular ring 6 and let it snap in.
- 2 Grease rectangular ring 6, align it centrally and introduce pump shaft 5 into the housing cover until contact is obtained.
- 3 Fix pump shaft 5 by means of circlip 4. Fit gasket 3 and retaining plate 2 and secure with screws 1.

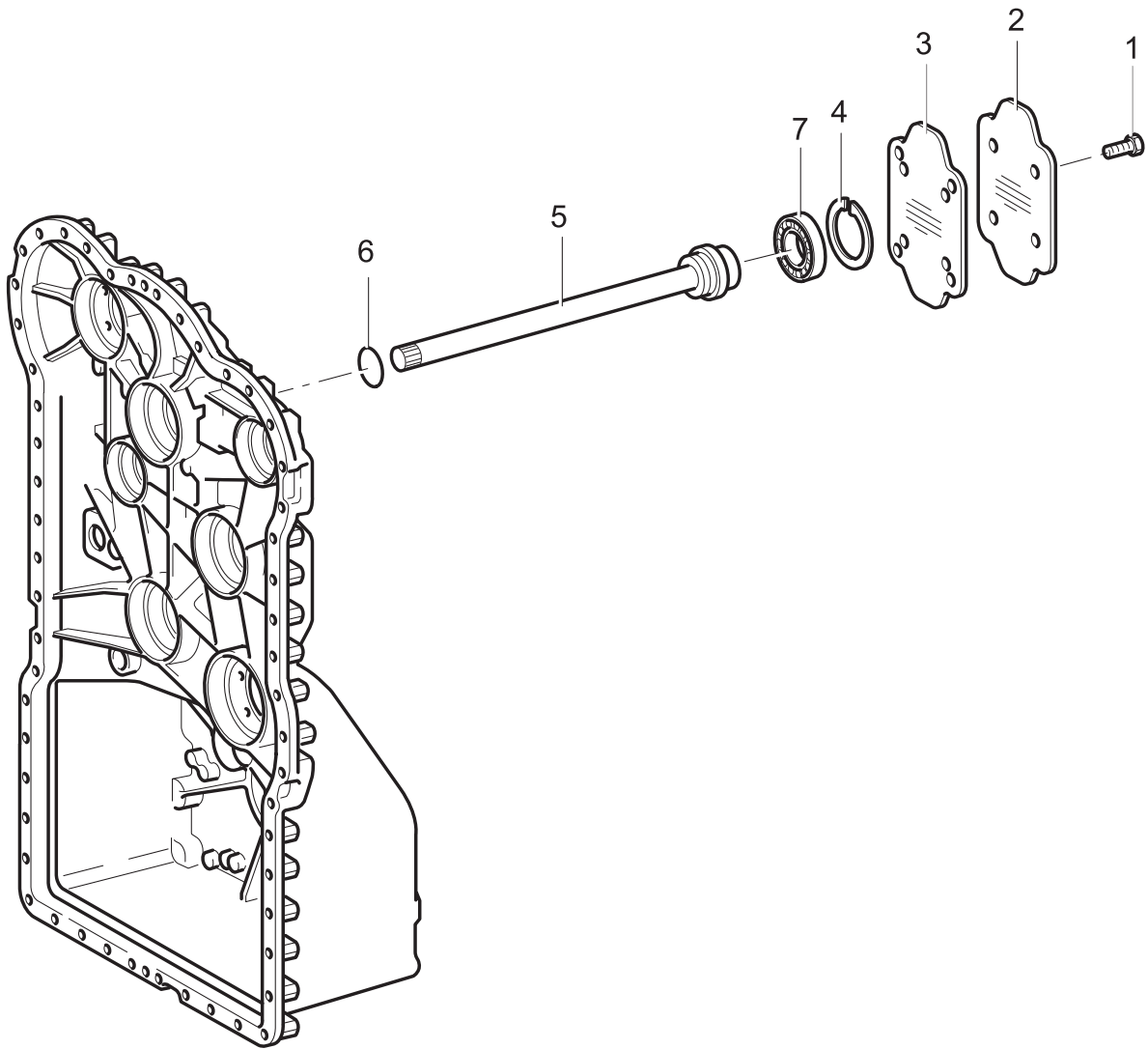


Fig 87.

Install Oil Seal Covers

- 1 Insert O-rings **16** and **21** into the annular groove of the oil feed covers **15** and **20** respectively.
- 2 Fasten covers **15** and **20** by means of nuts/plain washers **13/14** and **18/19** respectively.

Torque limit..... 23 Nm (17 lbf ft).

Install Output Flanges

- 1 Install shaft seal **12** with the sealing lip facing the oil chamber.

Wet rubber coated outer diameter with spirit. Grease sealing lip.

- 2 Fit output flange **11**. Insert O-ring **10** into the gap between drive flange and shaft.

- 3 Secure output flange **11** by means of disc **9** and screws **8**.

Torque limit..... 46 Nm (34 lbf ft).

- 4 Secure screws by means of lock plate **7**.

- 5 Repeat steps 1 - 4 for the opposite drive flange assembly **1,2, 3, 4, 5** and **6**.

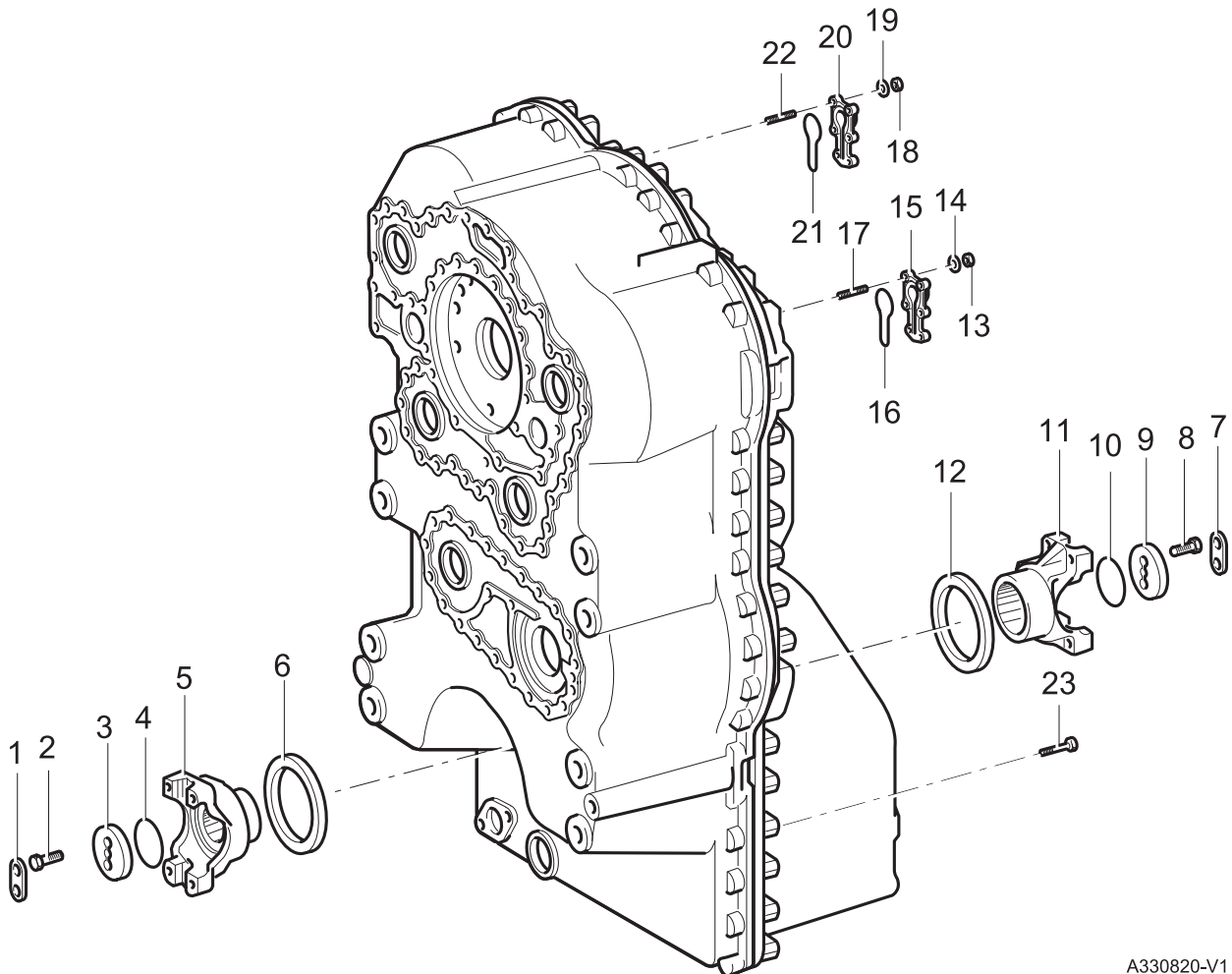


Fig 88.

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