

chipped edges with a stone or burr grinder. Renew any parts which have sections of splines broken away. Inspect springs (3) for fractures, or other damage, and renew springs which do not have a free height of 2¼-2½ inches. Center cam in central driver (7) must be free to rotate within the limits of keys in central driver. Check the weld between driven clutch (5) and cam ring on clutch by tapping lightly on cams of cam ring. If cam ring rotates in driven clutch, weld is defective (failed). Inspect teeth on central driver and driven clutches. Small defects can be dressed with a stone. If central driver or driven clutch is renewed, also renew the part it mates with. A smooth wear pattern up to 50 percent of face width is acceptable for the cams on center cam and driven clutch.

29. The differential and carrier unit is assembled as follows: Place the inner (pilot) bearing on inner end of pinion shaft and stake in four places. Use a piece of pipe the size of inner race of pinion shaft bearing and press

the forward pinion shaft bearing (10—Fig. 17) on shaft with taper facing threaded end of pinion shaft. Place bearing spacer, and any shims which were present during disassembly over pinion shaft, then position the bearing cup over forward bearing. Press the rear pinion shaft bearing (7) on shaft with taper away from threaded end of pinion shaft. Check, and renew if necessary, the oil seal (4) in pinion shaft bearing retainer (5). Seal is installed with lip toward inside. Place gasket and bearing retainer over pinion shaft. Check, and renew if necessary, the dust shield (3) on companion flange. Position companion flange so it will not obstruct cotter pin hole in end of pinion shaft, slide bearing retainer oil seal on its land on companion flange, then press companion flange on pinion shaft. Install retaining nut, clamp companion flange in a vise and tighten nut to a torque of 300 ft.-lbs.

NOTE: Pressure of oil seal will generally hold bearing retainer away from bearing. If it does not, tie retainer to companion flange.

30. With pinion shaft assembled as outlined above, clamp the bearing cup in a soft jawed vise only tight enough to prevent rotation, then using an inch-pound torque wrench attached to companion flange retaining nut, check the rolling torque (bearing preload) of the pinion shaft. This rolling torque should be 13-23 in.-lbs.

If rolling torque is not as specified, it will be necessary to disassemble the shaft assembly and vary the spacer and/or shims as required. A spacer and shim kit is available under Oliver part number 155 342-A.

With pinion shaft assembled and the rolling torque of shaft determined, press pinion shaft assembly into carrier, install bearing retainer and tighten cap screws to a torque of 25 ft.-lbs. Install cotter pin to lock nut (1) in place.

31. Lubricate all parts and reassemble no-spin differential by reversing disassembly procedure. Be sure to position spring retainers so that spring seats inside cupped section of retainer. Be sure key in central

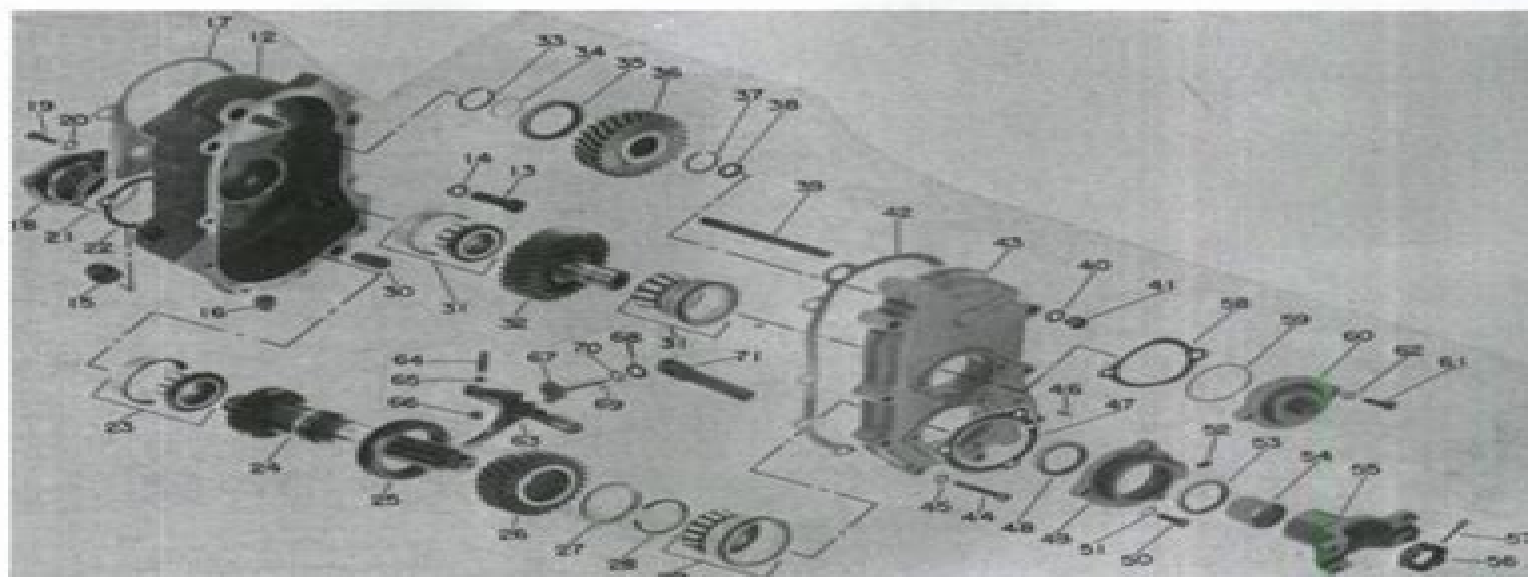


Fig. 19—Exploded view of the four-wheel drive transfer drive assembly. Breather filter element (not shown) should be renewed yearly, or after each 1000 hours of operation.

12. Case
13. Filler plug
14. Drive plug
15. Gasket
16. Bearing retainer
17. "O" ring
18. Shim (0.004, 0.0075, 0.015)
19. Bearing
20. Shaft

21. Coupling
22. Gear (27 teeth)
23. Washer
24. Gear
25. Bearing
26. Driveline
27. Bearing
28. Tiller gear
29. Snap ring

34. "O" ring
35. Oil seal
36. Gear
37. Snap ring
38. Seal
39. Steel bush
40. Gasket
41. Cover

47. Gasket
48. Seal
49. Retainer
50. Seal
51. Spacer
52. Companion flange
53. Gasket
54. Shim (0.004, 0.0075, 0.015)
55. "O" ring

60. Retainer
61. Shim bush & seal
62. Driveline spring
63. Driveline bush
64. Plug
65. Actuator
66. Woodruff key
67. Seal
68. Arm

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