Paragraphs 19-20

prior to installing final drive shaft goar

Position final drive shaft with wheel stude down and block under shaft so wheel stude are not touching. Place housing (28) over final drive shaft. Beat gear (7) to about 100 degrees F., start gear on splines of final drive shaft. then press or drive gear and bossing on final drive shaft. Install lockwasher (8) and not (9) and tighten nut securely. Distance from nut to end of shaft should be the same as that recorded prior to disassembly, about 3 mm (1/8-in.) of final drive shaft thread should be exposed with nut tightened. Retain aut by beading take of lockwasher into slots in nut and gear.

Refer to paragraph 20 for information to join bousing to carrier.

19. AXLE SHAFT. To remove asie shaft from carrier, support carrier and axle shaft and drive bearing cone (13-Fig. 8) into carrier far enough to allow removal of split bushing (12). Use a soft faced hammer and drive axle shaft out of bearing and carrier. Seal (14) and bearing cup (13) can now be removed from carrier. Outbeard bearing assembly (2) cannot be removed orders final drive shaft gear (7-Fig. 7) has been removed. Spacer (3) should have been retrieved when housing and carrier were separated.

NOTE: The axie universal joint can be disassembled as follows: Remove anap rings (8-Fig. 8) and pull needle bearings (9). Tip cross pieces (6) out of center yoke (10), remove set screws (5), then remove pins (1) and separate axie halves from cross pieces.

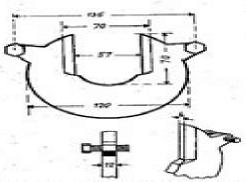


Fig. 15—A holding clamp can be inhelicated lecally to prevent ania movement during ex-

Glean and inspect all parts and renew as necessary. Install axis shaft in carrier as follows: Coat outside diameter of seal (24) with scalant and install in carrier (18) with lip toward inside. Grease lip of seal. Drive bearing cup into carrier with taper facing in, then insert gear end of axis through oil seal and bearing cup. Hold axis in position and drive bearing come on axis shaft until the split bushing can be installed with flat side up. Use a soft faced hammer and hump end of axis shaft until axis shaft gear seats on split bushing.

NOTE: Care should be taken after axis is installed to prevent damage to oil seal (14-Fig. 8) by movement of axis shart during subsequent assembly. Use of a clamp, shown in Fig. 11, is recommended by the manufacturer and clamp is installed between carrier and universal joint. Clamp must be tabricated locally and note that dimensions are in millimeters.

20. ASSEMBLY. Before joining carrier (18-Fig. 8) and housing (28-Fig. 7) the preload for axie shaft must be determined. The axie spectrum with a 0.25 mm preload and preload is controlled by spacer (3-Fig. 8). Spacer is available in thicknesses from 1.60 mm through 2.70 mm in increments of 0.05 mm.

Determine correct spacer thickness as follows:

1. Measure from inner race of bear-

J I CASE (DAVID BROWN)

ing (2-Fig. 8) to mating face of bousing (26-Fig. 7). For the example, assume it to be 72.5 mm.

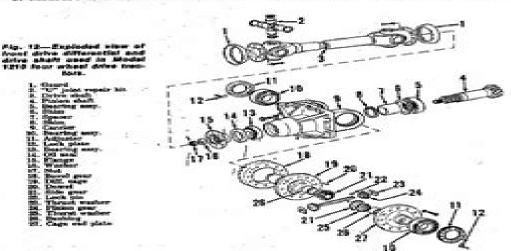
 Measure from inner end of axle shaft gear (4-Fig. 8) to upper face of carrier (18). For the example, assume it to be 70.5 mm.

 Subtract measurement 2 from measurement 1 which, for the example, is 2.0 mm.

 Add recommended axis preload of 0.25 mm to difference of measurements 1 and 2 which will give spacer thickness which, for the example, is 2.25 mm.

Existrapile:		70-72	
Measurement	1	72.5	
Milwood processes:	respent 2	- 70.5	
Equals differs	epop.	2.0	
Add profond		+0.20	TOTAL
Recognized spa-	cer thickness	2.25	GRACE

With thickness of spacer determined proceed as follows: Apply scalant to mating surfaces of housing (26-Fig. 7) and carrier (15), then position final drive shaft bousing on beach with wheel study down. Lower carrier and axle shaft assembly onto final drive shaft housing and be sure that axle shaft and final drive shaft enter their bearings (use hoist if necessary). Axle shaft is a push fit in the outboard bearing and can be seated in the bearing using a hammer and suitable drift. Install the carrier to housing cap screws and tighten securely. If clamp (Fig. 11) was used, remove clamp and



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- 1. Understanding the eBook Repair Manual For 995 Case Tractor
 - The Rise of Digital Reading Repair Manual For 995 Case Tractor
 - $\circ\,$ Advantages of eBooks Over Traditional Books
- 2. Identifying Repair Manual For 995 Case Tractor
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
- 3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Repair Manual For 995 Case Tractor
 - User-Friendly Interface
- 4. Exploring eBook Recommendations from Repair Manual For 995 Case Tractor
 - Personalized Recommendations
 - Repair Manual For 995 Case Tractor User Reviews and Ratings
 - Repair Manual For 995 Case Tractor and Bestseller Lists
- 5. Accessing Repair Manual For 995 Case Tractor Free and Paid eBooks
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 - Repair Manual For 995 Case Tractor Enhanced eBook Features
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 - Highlighting and Note-Taking Repair Manual For 995 Case Tractor
 - Interactive Elements Repair Manual For 995 Case Tractor
- 8. Staying Engaged with Repair Manual For 995 Case Tractor
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Repair Manual For 995 Case Tractor
- 9. Balancing eBooks and Physical Books Repair Manual For 995 Case Tractor
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Repair Manual For 995 Case Tractor
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Repair Manual For 995 Case Tractor
 - Setting Reading Goals Repair Manual For 995 Case Tractor
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Repair Manual For 995 Case Tractor
 - Fact-Checking eBook Content of Repair Manual For 995 Case Tractor
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends

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