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7. Position gauge block on face of pinion and mount arbor and dial indicator assembly in side bearing cover bores in case with dial indicator plunger bearing against gauge block, **Fig. 19**.
8. Obtain measured pinion depth by adding dial indicator reading to gauge block height and record sum.
9. Factor recorded pinion depth modification number with nominal pinion depth to obtain desired pinion depth. **Modification number is expressed as 1/100 of a millimeter. If modification number is stamped with plus (+) sign add that value to nominal depth; if number is stamped with minus (-) sign subtract that value. Nominal pinion depths are as follows:**
 - a. 325: .355 inch.
 - b. Except 325: .453 inch.
10. Select shim to obtain desired pinion depth as follows:
 - a. If desired pinion depth is greater than measured pinion depth, subtract the difference between the values from the installed shim thickness, and select shim accordingly.
 - b. If desired pinion depth is less than measured pinion depth, add the difference between the two values to the installed shim thickness and select shim accordingly.
11. Remove pinion assembly, rear bearing race and shim.
12. Install selected pinion depth shim, then press rear bearing race into housing as outlined.
13. Lubricate pinion bearings, insert pinion assembly into housing, then install a collapsible spacer and front bearing on pinion shaft.
14. Seat front bearing on pinion shaft using forcing screw and spacer, **Fig. 18**, then install pinion flange seal.
15. Install pinion flange and nut along with pinion nut lock plate.
16. Hold pinion flange and **torque** pinion nut to 108 ft. lbs., rotating pinion to ensure bearings are properly seated, then check preload with a torque wrench, **Fig. 2**.
17. If pinion bearing preload is more than approximately 2 inch lbs. greater than value recorded during disassembly, or if specified pinion nut torque cannot be obtained without bottoming nut, replace collapsible spacer and repeat installation procedure.
18. When rotating torque value is properly established, secure pinion nut with lock plate.