

DISASSEMBLY OF THE GEARBOX

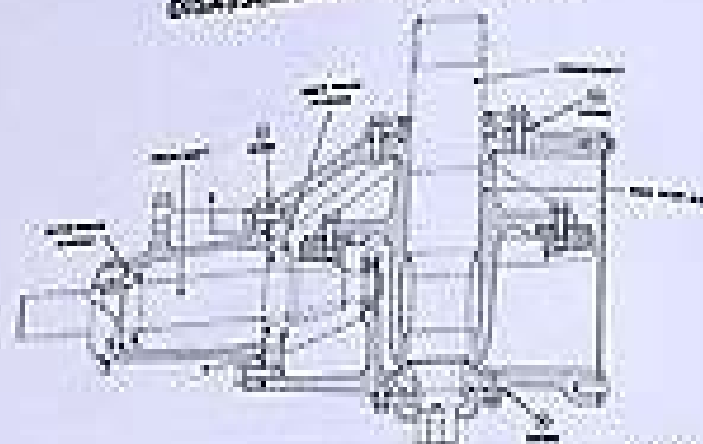


FIGURE 2-1

Remove the gearbox lock assembly from the rear portion assembly by removing four (4) 1/4" x 1" cap screws. Save the pins used at C, Figure 2-2.

Parts are to be identified by the numbers in Figure 2-2 and corresponding parts for the main gearbox should be maintained as shown.

1. Remove gearbox cover assembly by removing two (2) 1/4" x 1" cap screws.
2. Remove bearing retainer, (A) from the left side of the gearbox (small end of the crankshaft) by removing four (4) 1/4" x 1" cap screws and (2) 1/4" x 1" cap screws. After removing the bearing retainer, use care to avoid damaging the shaft.
3. Remove the shaft which was installed between the bearing retainer and the gear, (see Figure 2-2). Save these shafts for later assembly of the gearbox.
4. Remove lock nut, (B) by tapping the end of lock washer, (C), which is locking it in place.
5. Remove lock nut lock washer and bearing, (B). It is at the end of the shaft.
6. Remove the bearing retainer on the opposite side of the gearbox (large end of crankshaft) by removing six (6) 1/4" x 1" cap screws and (2) 1/4" x 1" cap screws. After removing the bearing retainer use care to avoid damaging the shaft.
7. Remove pins located at A, Figure 2-2 and save them for reassembly of the gearbox. Remove bearing, (D) at this time. A is key.
8. Insert the 5/16" x 1 1/4" cap screw and the washer at the small end of the crankshaft. This is the same cap screw and washer originally installed in the small end of the crankshaft.
9. Support the inner race of the bearing, (E) at the large end of the crankshaft on a section of 3/4" (3/8" max) diameter pipe approximately 12" (24" max) long. **NOTE:** It is important that the OD of the pipe be turned down slightly on the ends so the outside diameter does not interfere with the outer race of the bearing and result in damage. A section of pipe which has been threaded has been found to be correct in size. If a threaded section of pipe is not readily available, the OD of standard 3/4" (33 mm) pipe may be turned down 2/32".
10. Press the crankshaft out of the ring gear hub using a 24/32 ton hydraulic press.
11. Remove the crankshaft, the ring gear, and ring gear hub, and the bearings from the gearbox if they have not been removed before.

DISASSEMBLY OF THE GEARBOX HUB

1. Remove pin (G), (F) by removing four (4) 5/16" x 1/4" hex head cap screws.

2. Unhook the rope, (H) by tapping the top of lock washer, (I), which is locking the rope into place.
3. Remove lock nut.
4. Insert the original 1/4" x 1" cap screw in the front end of the pinion shaft and turn clockwise. Remove pinion shaft retainer from end of shaft (J, Figure 2-2), and remove pinion shaft by pressing down through the pinion shaft using 2" hydraulic press.

5. Remove bearings from pinion shaft. **NOTE:** When replacing any one ring gear and pinion or the ring gear hub, but not when pinion bearing, (K) it is not necessary to replace the new pinion bearing race from the pinion shaft to fit it over the shaft and, Figure 2-2, do not have to be placed. However, when replacing the inner pinion bearing, it is necessary to replace the inner pinion bearing race and change the number of shims located at L, Figure 2-2.

ASSEMBLY



FIGURE 2-2

Examine the gear assembly for cracks or any other damage. If any damage or questionable quality is apparent, use a new gear/hub. Wash all parts very thoroughly. Inspect all parts for wear or damage, especially the ring gear and pinion. If any questionable parts are noted, replace them.

NOTE: If either the ring gear or the pinion is replaced, replace both of these parts so they are supplied only in matched sets and must be used as matched sets. Numbers are staked on the circumference of the ring gear and the top-end of the pinion shaft. Do not use the set unless the numbers are the same. Replace any one of damaged bearings. Replace any oil seals which do not appear to be in good condition.

When the inner pinion bearing, (K) is being replaced, determine the correct number of shims to be installed at C, Figure 2-2. This is necessary so the pinion is properly located with respect to the center of the ring gear.

Proper location means lining the top of the ring gear and inner hub A hub, usually between Land (L) is staked on the machined surface of the top of the main gear/hub as indicated in Figure 2-2. Actual number is staked on the machined surface of the front mounting lug of the gearbox neck, see Figure 2-2.

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Table of Contents 73 Nh Square Baler Service Manual

1. Understanding the eBook 73 Nh Square Baler Service Manual
 - The Rise of Digital Reading 73 Nh Square Baler Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying 73 Nh Square Baler Service Manual
 - 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 73 Nh Square Baler Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from 73 Nh Square Baler Service Manual
 - Personalized Recommendations

- 73 Nh Square Baler Service Manual User Reviews and Ratings
- 73 Nh Square Baler Service Manual and Bestseller Lists
- 5. Accessing 73 Nh Square Baler Service Manual Free and Paid eBooks
 - 73 Nh Square Baler Service Manual Public Domain eBooks
 - 73 Nh Square Baler Service Manual eBook Subscription Services
 - 73 Nh Square Baler Service Manual Budget-Friendly Options
- 6. Navigating 73 Nh Square Baler Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - 73 Nh Square Baler Service Manual Compatibility with Devices
 - 73 Nh Square Baler Service Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of 73 Nh Square Baler Service Manual
 - Highlighting and Note-Taking 73 Nh Square Baler Service Manual
 - Interactive Elements 73 Nh Square Baler Service Manual
- 8. Staying Engaged with 73 Nh Square Baler Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers 73 Nh Square Baler Service Manual
- 9. Balancing eBooks and Physical Books 73 Nh Square Baler Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection 73 Nh Square Baler Service Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine 73 Nh Square Baler Service Manual
 - Setting Reading Goals 73 Nh Square Baler Service Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of 73 Nh Square Baler Service Manual
 - Fact-Checking eBook Content of 73 Nh Square Baler Service Manual

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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