

R0015254 Bench Assemble shafts, Bearings and Pinions

Bench assembly instructions for drive components

 Difficulty **Medium**

 Duration **2 hour(s)**

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Comments

Introduction

Tools Required

Compressed air line
180 grit emery tape
Fe10 solvent
Cleaning cloth
Standard Hex key set
Standard spanner set
Grease gun

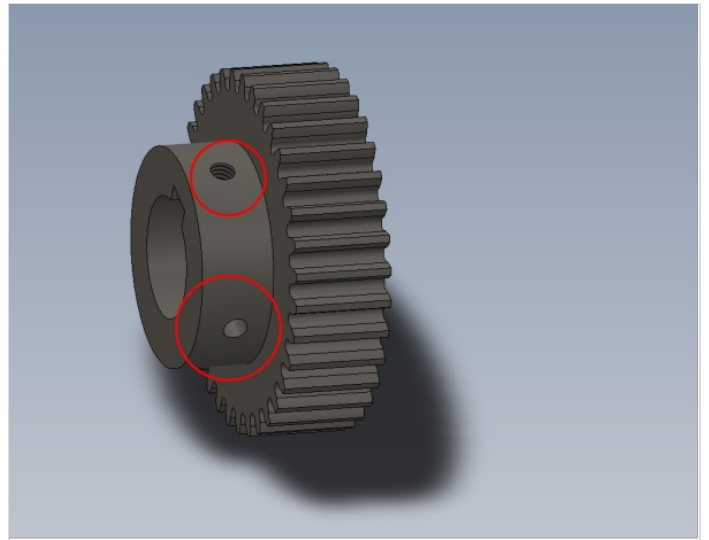
Parts Required

D0015556B x 2
D0015555Bx 2
B0001094 x 17
B0000228 x 18

Step 1 - Quality check

Check that 2 off M6 tapped holes in all B0001094 pinions are tapped thru. Check by winding grubscrew though each hole and make sure it travels all the way through

9 off



Step 2 - Clean shafts

Ensure shafts D0015556 2 off and D0015555 2 off are clean before trial fitting .

- 1 check for any burrs or damage to shafts . Remove with File/emery tape 180 grit if present
- 2 Use compressed air to clean debris from all keyways on shafts .
- 3 Use Fe10 solvent to remove contaminants on shafts



Step 3 - Clean and prepare bearings

Ensure bearings B0000228 18 off are clean before trial fitting

- 1 Check for any internal burrs especially around grubscrew point .
If present remove with emery tape 180 grit
- 2 Use compressed air to remove and debris
- 3 Use Fe10 solvent to remove any contamination



Step 4 - Clean and prepare Pinions

Ensure B0001094 Pinions 17 off are clean before trial fitting

- 1 Check for any internal burrs especially around grubscrew point .
If present remove with emery tape 180 grit
- 2 Use compressed air to remove and debris
- 3 Use Fe10 solvent to remove any contamination



Step 5 - Check fitment of prepared parts.


Check the following

1 Every B0000228 bearing passes freely over each shaft

2 Every B0001094 pinion passes freely over each shaft

If tight spots are found, these steps should be followed

- If all pinions/bearings pass freely on a shaft but one is tight, polish out individual pinion to achieve correct fitment
- If all pinions (Or most off) are tight , polish main shaft down with emery tape 180 to remove high spot

 ...When performing any adjustments using emery tape., parts must be thoroughly cleaned before trial fitting again as grit residue can caused components to bind together on assembly



Step 6 - Fit grease points

1 Attach supplied grease points and covers to B0000228 bearings (18 off)

2 Use grease gun to grease bearings to aid assembly

