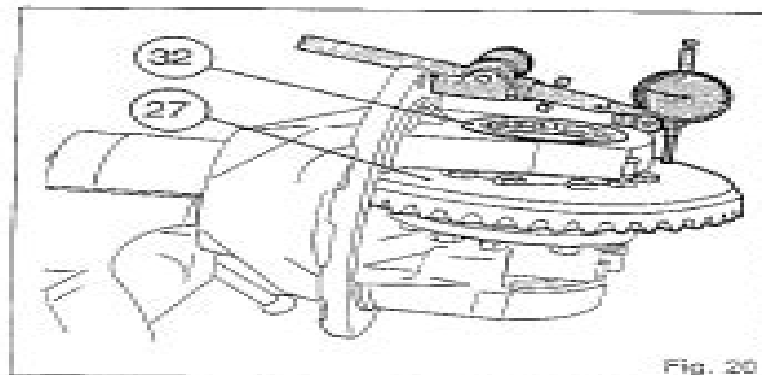


**Front axle Cat. 3.5 - Differential**

64. Fit the other bearing cone (33) (if removed) on the cover (24).
65. Assemble the housing half (25) in the cover (24) (with claw teeth) observing the marking made at the time of dismantling.
66. Position the washer (35) on the axle gear (11). Place the assembly in the housing half (25), putting the tab of the washer in one of the holes of the housing half.
67. Place the four planetary pinions (36) and the four spherical washers (37) on the two pins (36), then place the assemblies in the housing half (25), putting the tabs of the spherical washers (37) in the holes of the housing half (25) (Fig. 9).
68. Place the other washer (35) on the other gear (11). Place the assembly in the housing half (26), taking care to ensure that the position of the tab of the washer (35) is correct.
69. Position the housing half (26) assembly on the housing half (25) maintaining the assembly position marked at the time of dismantling.
70. Position the crownwheel (27) on the housing half (26). Fasten together the housing halves (25) and (26), the cover (24) and the crownwheel. Fit the bolts (23) and smear them with Loctite 270. Tighten the nuts (28) to a torque of 79 - 87 Nm.
71. Position the cups (29) on their cones (33).
72. Place the crownwheel assembly in the casing (7) (Fig. 8).
73. Check that the centering bushes (44) are present. Fit the shims (22). Position the bearing halves (43). Moderately tighten the bolts (42) so that the cups (29) move freely.
74. Put the housing in a horizontal position in a soft-jawed vice, the crown uppermost (Fig. 20).
75. Put a dial gauge in place. Tighten the nut (32) (Fig. 20) and turn the crownwheel a few times to seat the bearing cones properly in the cups. Tighten the nut again to eliminate the axial play.
76. Tighten the nut (32) a further 3 notches to obtain the correct preload.
77. Check the backlash between the crownwheel and the pinion with a dial gauge (Fig. 21). Take three readings at three equidistant points. Determine the average of the three readings to obtain backlash of 0.30 - 0.41 mm.
If the reading is too high, reduce the thickness of the shims (22). If it is too low, increase the thickness until a correct backlash is obtained.



78. Remove the bearing bolts (42) one by one. Smear them with Loctite 270 and tighten them to a torque of 136 - 150 Nm.
79. Refit the locking plate (31) with the bolt (30) smeared with Loctite 270 and tighten to a torque of 16 - 26 Nm. Lock the nut (32), bending the tab of the locking plate in the appropriate groove.

1. Piston leak test

80. Connect a pressure gauge equipped with a valve to the supply connector of the differential lock.
81. Supply the circuit with compressed air at a pressure of approx. 5 bar and check the movement of the piston (14).
Reduce the pressure to 0.3 bar and close the valve. The pressure gauge should not show any drop in pressure for 1 minute.
82. Remove the pressure gauge and valve assembly.

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Massey-Ferguson (Aust.) Ltd



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