



Figure 3-133. Sprocket Shaft Bearing Assembly

- m. Verify that the tool assembly is square, so that the bearing inner race is not cocked during removal. See Figure 3-130.
- n. Using the Robinair Heat Gun (HD-25070), uniformly heat the bearing inner race for about 30 seconds using a circular motion.

NOTE

To facilitate removal without heat, apply a light penetrating oil to shaft and leading edge of bearing inner race.

- o. Turn forcing screw until bearing inner race is pulled free of sprocket shaft.
 - p. Remove thrust washer from sprocket shaft.
2. Discard thrust washer and bearing inner race.

Installation

1. Place **new** thrust washer over sprocket shaft with the ink stamp facing outside (and the chamfer on the ID inboard).
2. Place **new** bearing inner race on bench top. Using the Robinair Heat Gun (HD-25070), uniformly heat bearing inner race for about 60 seconds using a circular motion.
3. Wearing suitable gloves to protect hands from burns, place heated bearing inner race over sprocket shaft.

NOTE

To facilitate installation without heat, apply a light penetrating oil to shaft and leading edge of bearing inner race.

WARNING

Never use both heat and penetrating oil. Use only one or the other. Excessive heat can cause the penetrating oil to ignite resulting in flames or fire. Inadequate safety precautions can result in death or serious injury.

4. Obtain the SPROCKET SHAFT TIMKEN BEARING CONE INSTALLER (HD-97225-55B). See Figure 3-131. Assemble tool as described below.
 - a. Thread pilot onto sprocket shaft until contact is made with shoulder.
 - b. Sparingly apply graphite lubricant to threads of pilot shaft to prolong service life and ensure smooth operation.
 - c. Slide sleeve over pilot until it contacts bearing inner race.
 - d. Slide Nice bearing and large flat washer over pilot until contact is made with sleeve.
 - e. Thread handle onto pilot shaft. See upper frame of Figure 3-132.

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Table of Contents Harley Davidson Flhrs Service Manual

1. Understanding the eBook Harley Davidson Flhrs Service Manual
 - The Rise of Digital Reading Harley Davidson Flhrs Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Harley Davidson Flhrs 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 Harley Davidson Flhrs Service Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Harley Davidson Flhrs Service Manual
 - Personalized Recommendations
 - Harley Davidson Flhrs Service Manual User Reviews and Ratings
 - Harley Davidson Flhrs Service Manual and Bestseller Lists
5. Accessing Harley Davidson Flhrs Service Manual Free and Paid eBooks
 - Harley Davidson Flhrs Service Manual Public Domain eBooks
 - Harley Davidson Flhrs Service Manual eBook Subscription Services

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