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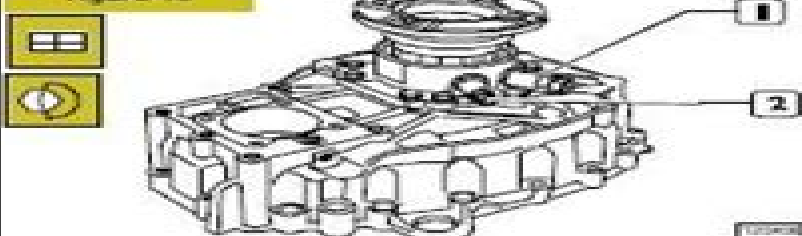
Output flange assembly

Figure 39



Heat the output flange (1) at max. 160 °C temperature and push it onto the satellite holder shaft teeth to the axial contact.
 Assemble the disc (2) and tighten the screws (3) according to the set torque.
 Tightening torque = 79 Nm

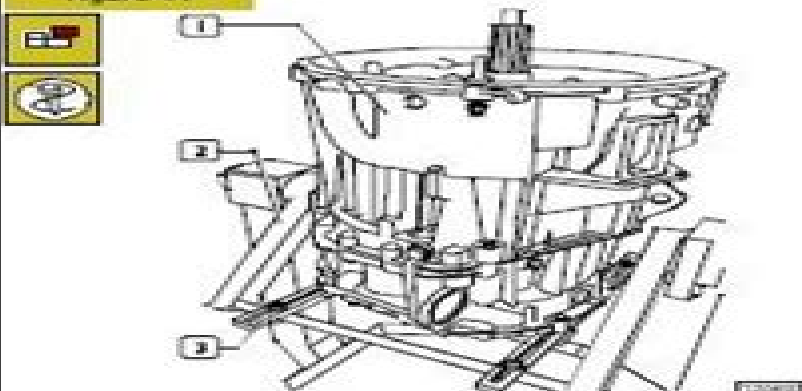
Figure 40



Screw the transmitters (1 and 2) according to the set torque.
 Tightening torque = 45 Nm

CLUTCH CASING

Figure 41

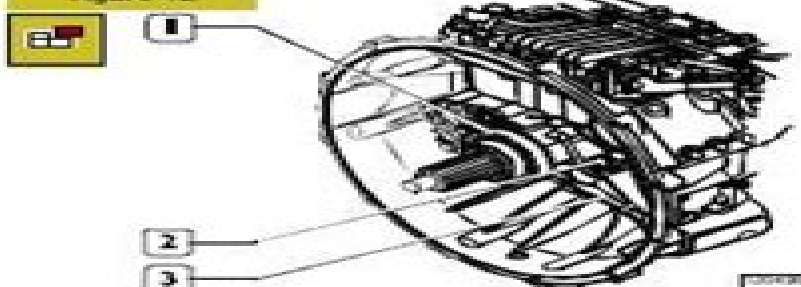


Fasten the gear transmission (1) to the support brackets 99322.225 (3), which are arranged on the rotary stand 99322.205 (2).

DISCONNECTING FORK

Disassembly

Figure 42



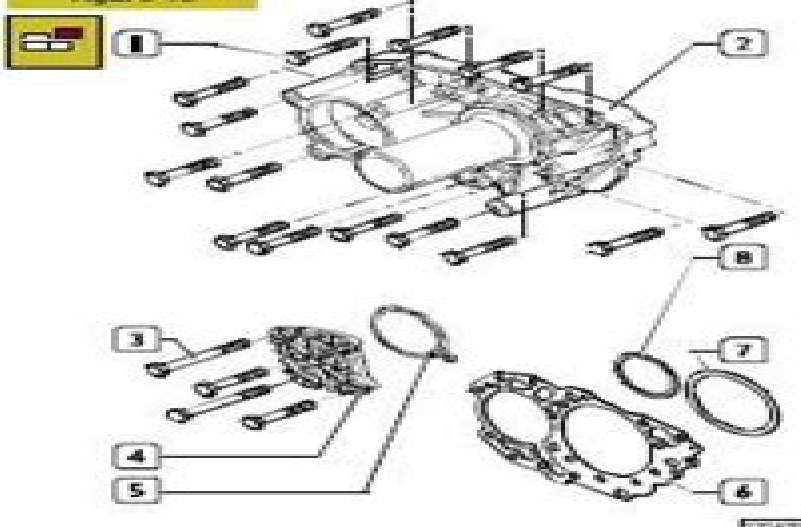
Remove the two hexagon head screws (2).
 Remove the disconnecting bearing (1) and the disconnecting fork (3) from the motion input shaft.

Assembly

Grease the bearing surfaces of the disconnecting bearing (1).
 Assemble the bearing (1) and the disconnecting fork (3) so that it meshes the bearing.
 Torque-tighten the screws (2).
 Tightening torque = 115 Nm

Disassembly of the front cover

Figure 43



Remove the fastening screws (1 and 3) and remove the front cover (2), the cover (4) and the diaphragm (5).
 Remove the adjusting rings (7, 8) and the gasket (6).

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