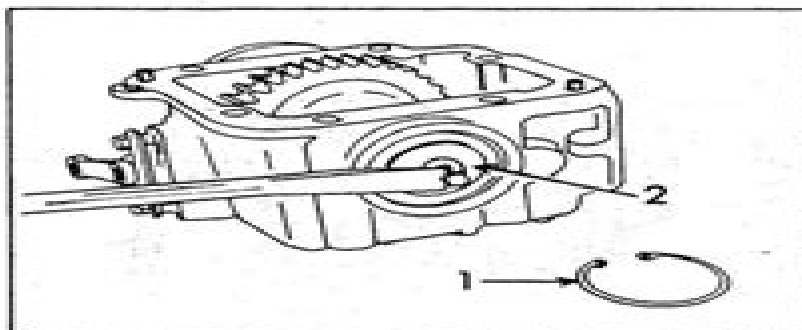
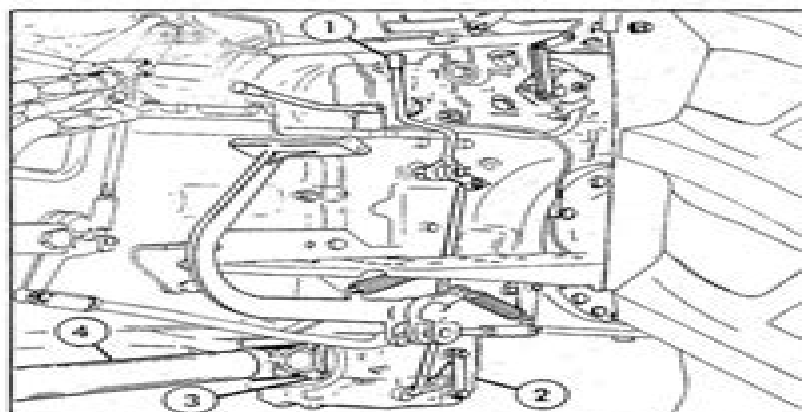




**FIG. B.X/19 REMOVE SHAFT**

1. Snap ring; 2. Cover



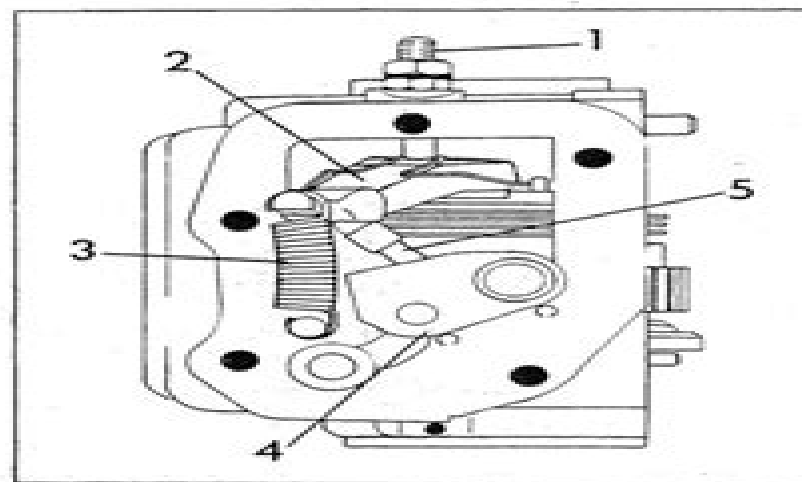
**FIG. B.X/20 REDUCTION GEARBOX INSTALLED**  
1. Control lever, shift forward to engage, rearward, disengage; 2. Reduction gearbox; 3. Cardan shaft screws; 4. Cardan shaft

Expand external snap ring and slide along shaft toward the rear of case. Make certain snap ring is out of groove and up on spline. Slide deflector up on shaft toward rear of case (Fig. B.X/22).

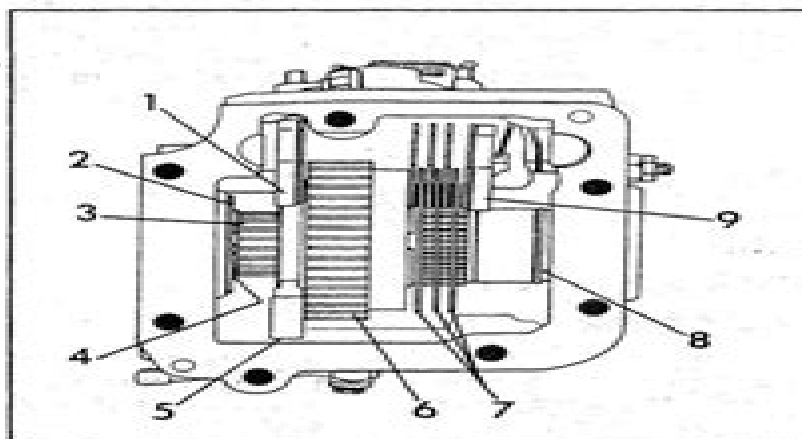
Using a drift, drive the drive shaft out of the casing. Remove the gear with brake disc, deflector, snap ring, brake disc and front brake plate.

Disconnect spring and remove brake fork, and cam assembly. Remove shifting arm retainer, detent ball and spring. Drive roll pin from detent shift arm and remove shaft (Fig. B.X/21).

If necessary, remove front bearing by pressing toward the rear of the case. Remove the snap ring and press the seal out of the front of the case. Press the rear bearing into the case to



**FIG. B.X/21 L.H. REDUCTION GEARBOX**  
1. Brake adjustment screw; 2. Brake fork; 3. Spring; 4. Brake cam; 5. Push rod



**FIG. B.X/22 TOP VIEW, REDUCTION GEARBOX**  
1. Front plate; 2. Deflector; 3. Sliding sleeve; 4. Snap ring; 5. Shifting pad; 6. Gear; 7. Friction disc; 8. Bevel ring

#### INSPECTION

Inspect front and rear bearings. Check front seal, cover O-ring, and replace if necessary. Check thickness of brake liner and brake disc. Brake liner should be 0.155 in. to 0.160 in. (3.930 to 4.070 mm) thick. Brake disc should be 0.98 in. to 0.104 in. (2.485 to 2.650 mm) thick. Replace if necessary. Check drive shaft, drive gear and engaging sleeve for wear.

# Long 610 Service Manual

**Lei Huang**

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the author's name.

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