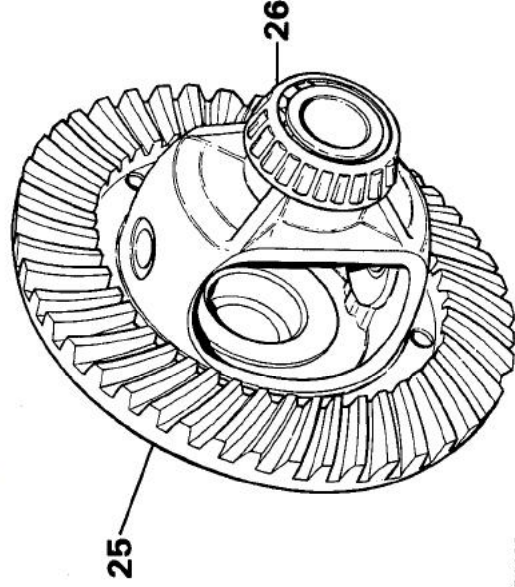


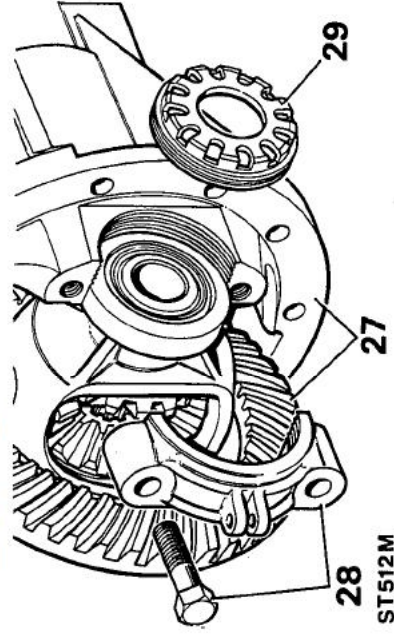


- 23. Check gear for freedom of rotation and backlash. Nominal backlash should be present. Excess backlash necessitates replacement of gears or differential housing.
- 24. Check serial number marked on pinion end face matches that on crown wheel.
- 25. Clean and fit crown wheel.
- 26. Fit carrier bearings and assemble tracks to bearings.



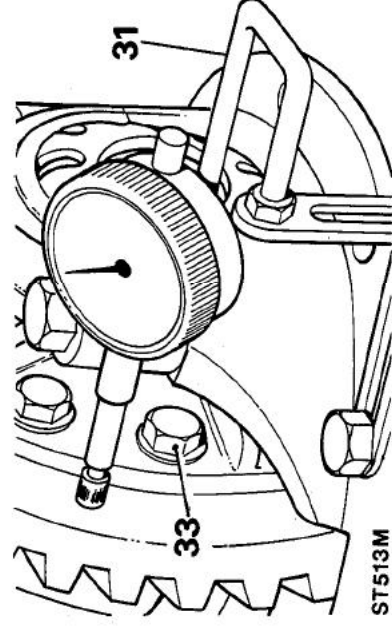
ST511M

- 27. Place differential housing with crown wheel and bearings in pinion housing.
- 28. Fit bearing caps and bolts. Do not tighten bolts.
- 29. Fit bearing adjusting nuts and adjust to obtain zero end float.



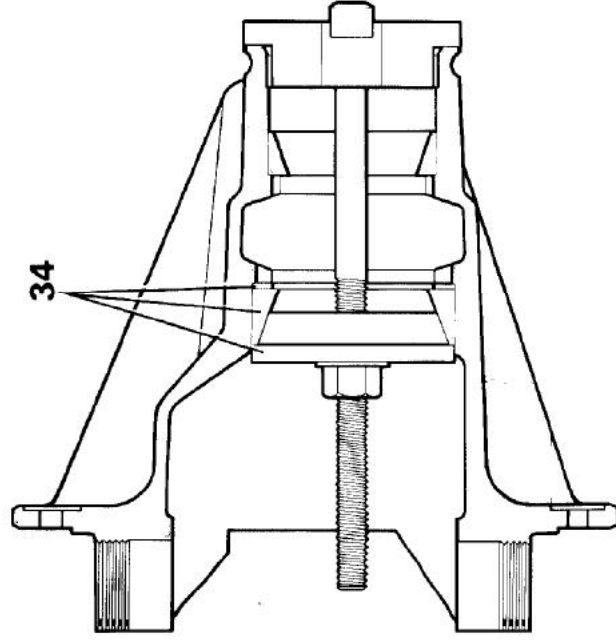
ST512M

- 30. Tighten bearing cap bolts to **90 Nm**.
- 31. Check crown wheel for run-out. This should not exceed 0,10 mm. If exceeded examine crown wheel and mounting flange for burrs, grit, etc. Refit and recheck. A buckled or damaged differential housing flange is corrected by replacing differential gear housing.
- 32. After checking run out remove differential housing from pinion housing.
- 33. Remove crown wheel bolts and refit using Loctite 'Studlock'. Tighten to **58 Nm**.



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- 34. Fit pinion head bearing track and original shim to pinion housing. Use service tools LRT-54-505 and LRT-54-506. If fitting a new shim use minimum 1.27 mm thickness.



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