

26. Install reverse gear III on pinion shaft and tighten castle nut using torque wrench P 42 and socket P 46 to 20 mkg (145 ft. lb.) torque.

27. Loosen castle nut and re-tighten to 10 mkg (70 ft. lb.) torque.

28. With selector forks free on shafts check locking of selector rods. As soon as a gear is engaged, the other rods must be locked in position, i. e. after selecting 1st or 2nd gear the other selector rods must be locked in position.

29. In cases where the intermediate plate, the transmission housing or pinion have been exchanged, the ring and pinion adjustment must be performed (10 and 11 RA).

30. Remove intermediate plate with main and pinion shafts from transmission housing and secure in vise using soft jaws.

31. Install gear II of reverse gear in selector fork.

32. Insert shaft for reverse idler through reverse idler into intermediate plate. This will provide a proper guide for the reverse gear selector rod and assure the proper position for adjusting selector forks for forward speeds (Fig. 48).

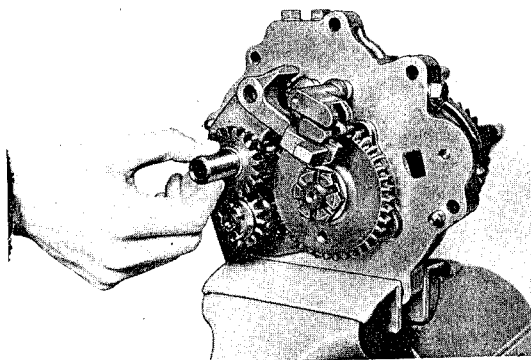


Fig. 48

33. Install selector rod guide P 68.

34. The selector forks should be so adjusted that the sliding sleeve in a neutral position is exactly centered between the synchronizing rings. This adjustment must be exact to insure proper gear synchronization.

35. After completion of fork adjustment, tighten clamping bolts to 2.5 mkg (18 ft. lb.) torque. Insure that the selector rod heads are in the proper position, i. e. parallel to each other.

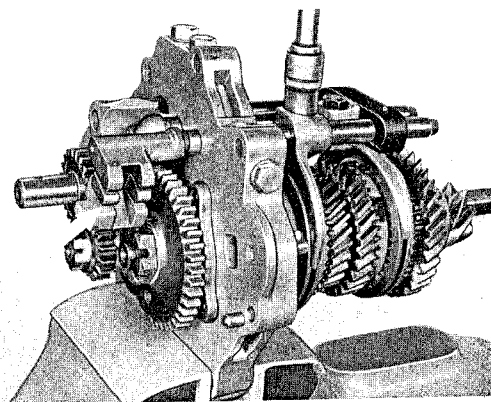


Fig. 49

36. After the proper shims for ring and pinion clearance have been determined, install intermediate plate in transmission housing.

37. Secure pinion and drive shaft castle nuts with cotter keys.