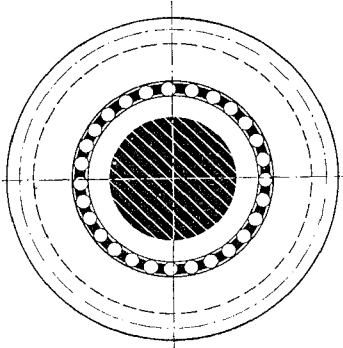
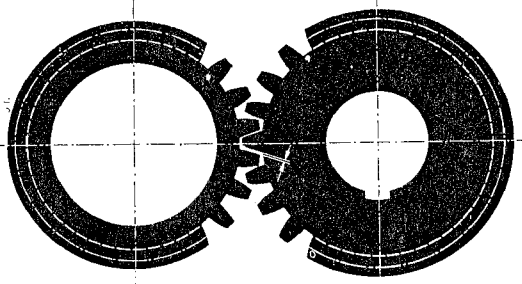



Table of Tolerances for Transmission 741

Measuring Point	Tolerance (new) mm	Wear limit mm	
<p>1. Clearance between sleeve, rollers or needles, and inner surface of gear</p> <p>1st and 2nd gear rollers 3×5 DIN 5402 available in standard and + 0.004 mm</p> <p>3rd and 4th gear needle bearings 2.5×19.8 mm are available in standard and + 0.004 mm</p>	By installing oversize roller or needle bearings, practically no clearance but turning freely.	By installing oversize roller or needle bearings, practically no clearance but turning freely.	
<p>2. Backlash between gears</p> <p>1st gear</p> <p>2nd gear</p> <p>3rd gear</p> <p>4th gear</p>	0.06—0.20	0.30	
<p>3. Backlash ring and pinion gears</p>	Between 0.12 and 0.18 as marked on ring gear. Measure at four different positions 90° apart.	Up to 0.05 mm in excess of clearance marked on gears	
<p>4. Gears on pinion shaft</p> <p>1st gear</p> <p>2nd gear lateral clearance</p> <p>3rd gear</p> <p>4th gear</p>	<p>0.25—0.35</p> <p>0.20—0.30</p> <p>0.20—0.30</p> <p>0.20—0.30</p>	<p>0.40</p> <p>0.40</p> <p>0.40</p> <p>0.40</p>	