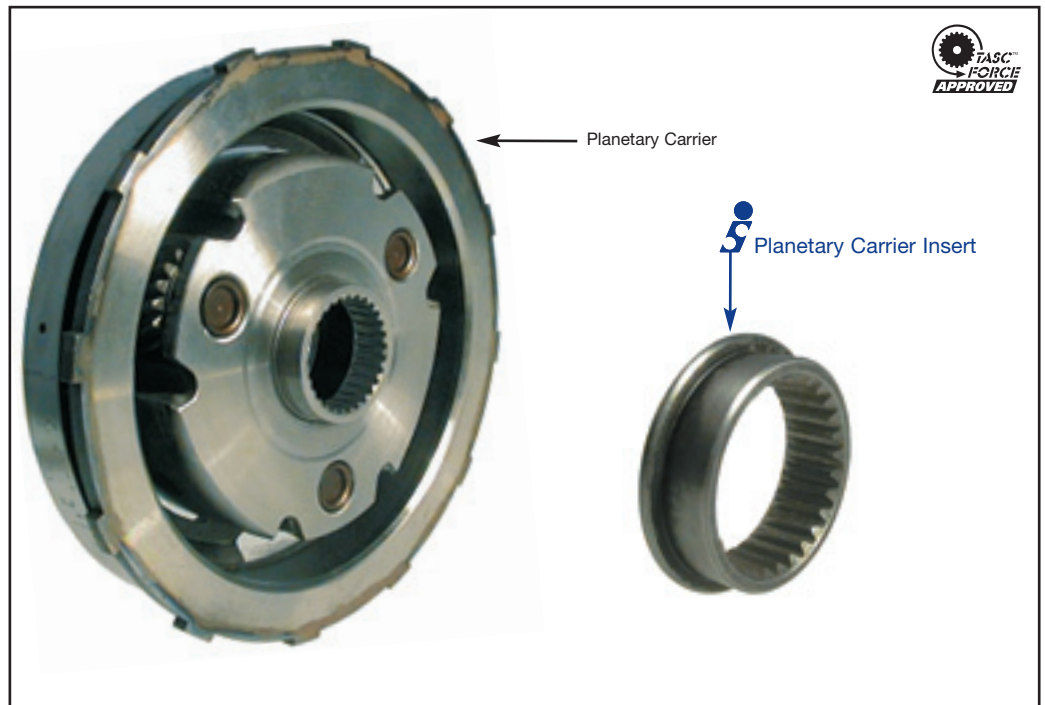


## Splined Repair Insert

### 93897S

1 Planetary Carrier Insert



### Installation Instructions

1. Chuck the carrier assembly in a lathe on the hardened race diameter. Ensure that chuck run-out does not exceed .002". Bore out the old internal spline. This bored diameter should yield a slip fit with the 35mm pilot diameter of the repair insert.
2. Now counter bore the outside surface of the carrier to clear the 40mm flange diameter of the repair insert. Counter bore depth requirement is 2mm to yield a flush surface between the insert flange and carrier.
3. Weld the joint around the flange O.D., then machine flush any weld protrusion.