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Transmission housing assembly



WARNING

- All operations must be carried out with the utmost care to avoid injury to people.
- Specific tools are required for certain procedures. The use of these tools is essential to ensure safe operation.
- Follow the safety rules in force in the workshop. Specific warnings are provided in the Manual where specific precautions are required to prevent hazardous situations.
- When employing chemical products scrupulously follow the instructions shown on the safety data sheet that the supplier is required to hand over to the user.



CAUTION

- All operations must be carried out with the utmost care to avoid damage to components.
- During reassemble lubricate the required parts to prevent seizing during initial operation.
- During reassemble respect the tightening torques and the adjustment data.
- Replace gaskets, seals, snap rings, safety plates, self-locking nuts, caulked edge nuts and all other deteriorated parts during reassemble.
- During the reassemble use Locktite/Arexons 518 sealant.
- During the reassemble use Locktite/Arexons 52A42 medium thread stop where indicated.



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During reassemble operation, follow the removal procedure in reverse order, and in particular:

1. Install the gearbox-clutch housing assembly to the engine and tighten the mounting screws

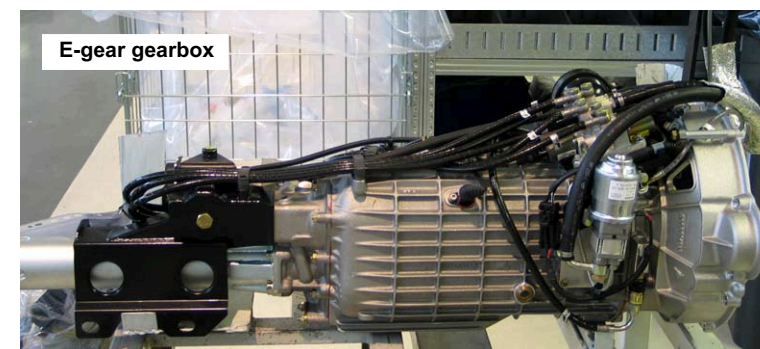


Fig.1



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1. Clean and degrease thoroughly the contact surfaces between the clutch housing and the gearbox.
2. Apply Locktite 518 on the contact surfaces between the clutch housing and the gearbox.

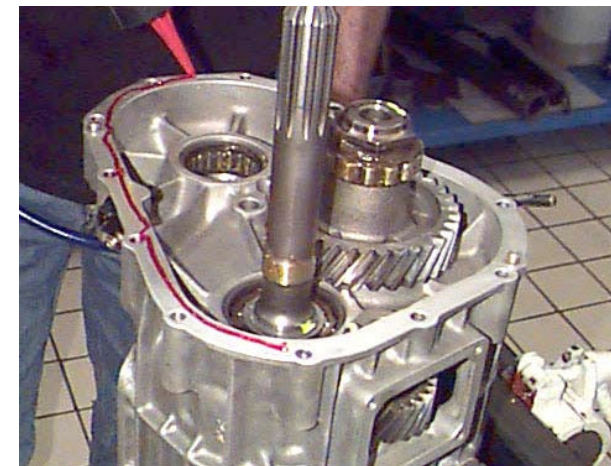


Fig.2

3. Introduce the clutch housing on the gearbox stud bolts paying attention that the countershaft transmission gear bearing rollers do not come out of their seats.
4. Tap the clutch housing with a rubber hammer to fit it into place; introduce the mounting nuts with corrugated washers and tighten to the prescribed torque:
Clutch housing mounting nuts; **tightening torque(000800-3d)**
Clutch housing screws; **tightening torque(000800-3d)**



Fig.3



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5. Clean and degrease thoroughly the contact surfaces between the cover and the gearbox.
6. Apply red paste to the cover and to the bearing surface on the gearbox.
7. Position the cover, fasten it by means of the screws (**A-Fig.4**) and tighten to the prescribed torque:
Cover mounting screws: **tightening torque (000800-4c)**
8. Install the cover shift control rod mounting pin to the shift lever device pin (Manual gearbox)
Tighten the mounting screw with Loctite medium-strength thread sealant (e-gear).
9. Grease the joint and position the guard.

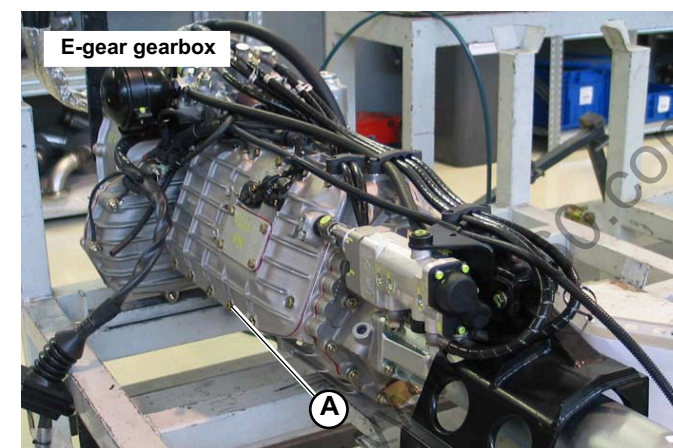
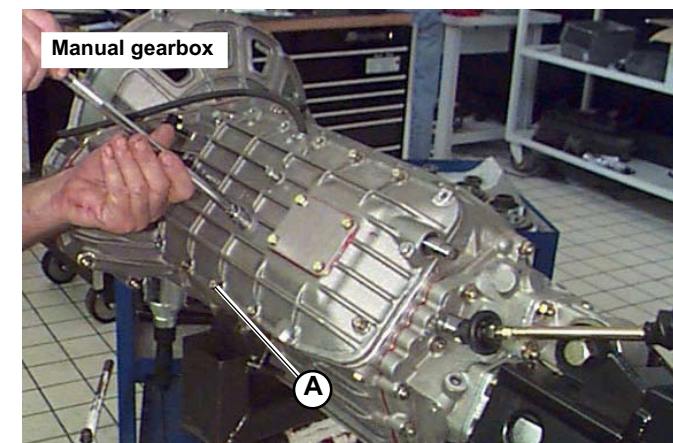
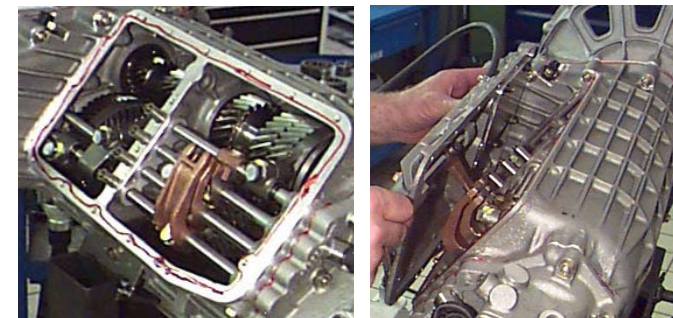


Fig.4