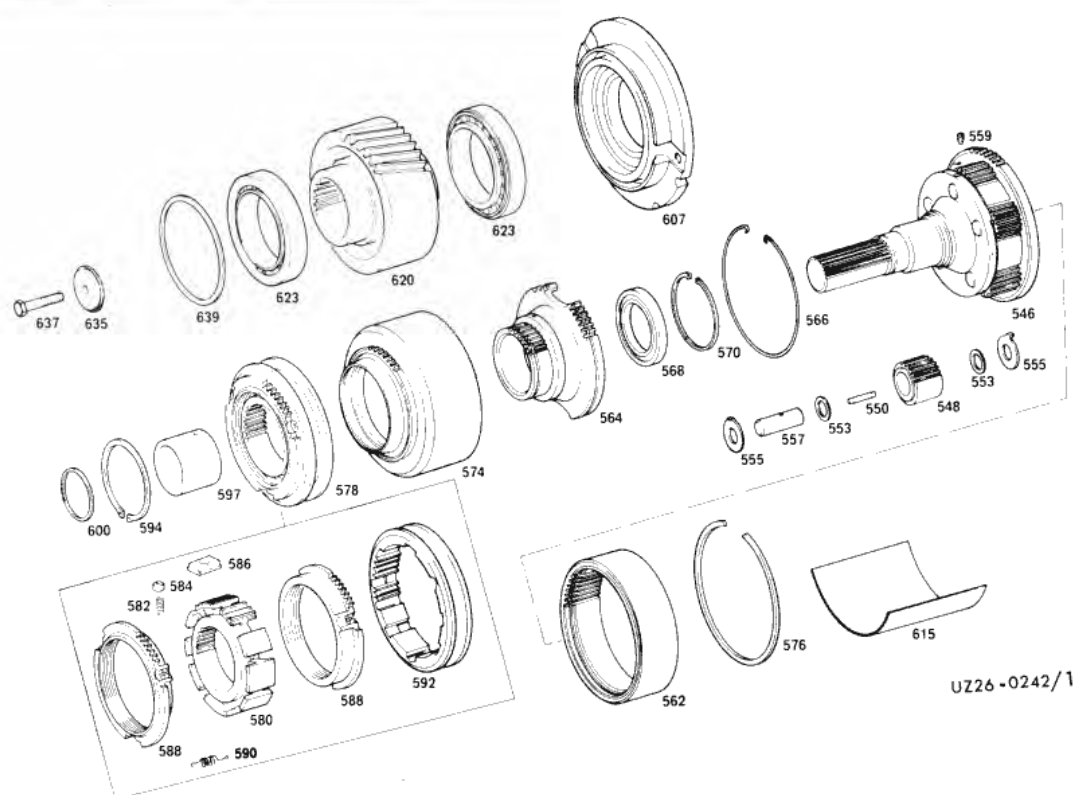


**Setting values**

Radial clearance of deep-groove ball bearing in planetary gear carrier	mm	0,4
permissible axial clearance of synchronizing body	mm	0
permissible synchromesh clearance min.	mm	$1,3 \pm 0,2$
max. wear travel	mm	2,0

**Expendable materials**

Cons. No.	Designation	Part Number
4	Adhesive: Ciba adhesive „Araldit“ AV 138 (bonding agent)	001 989 96 71
5	Adhesive: Ciba adhesive „Araldit“ 138 (hardener)	001 989 97 71
7	Lubricant: Roller bearing grease	commercially



## 26G26 Disassembly and assembly

26H259 **Note:** The description is based on the transmission ratio  $i = 9,35$  (with deep-groove ball bearing in the planetary gear carrier). The disassembly and assembly for the transmission ratio  $i = 13,01$  is in the same manner.

26/172 **1** Remove planetary gear train, see 6.1/1.

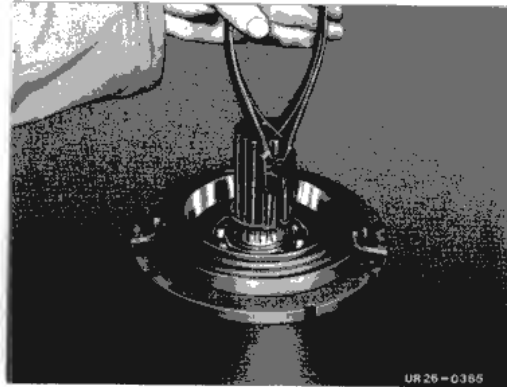
26/173 **2** Remove locking ring and shim ring.

26/174 **3** Remove synchronizing body with grooved ball bearing.

26/175 **4** Remove locking ring and remove grooved ball bearing in synchronizing body.

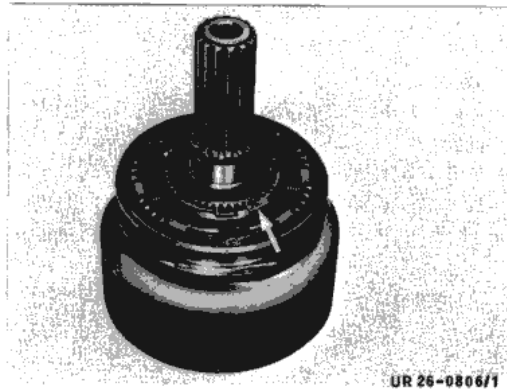
26/176 **5** Remove synchronizing body.

26H265 **Note:** Install oil bore so that it faces downward.



26/177 **6** Disassemble synchronizing body.

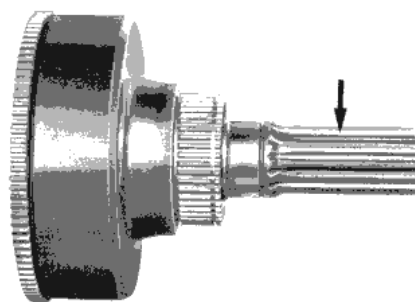
26/2188 **7** Disassemble synchronizing member.



26/179 **8** Remove locking ring of synchronizer bell housing and knock off synchronizer bell housing toward the bottom.



- 26/180 **9** Remove planet carrier from hollow gear.



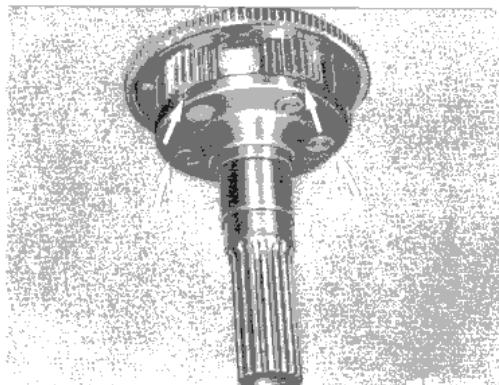
UR 26-0807/1

- 26/77 **10** Remove shaft sealing ring.

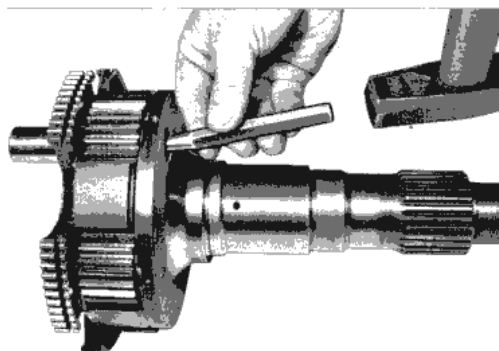


UR 26-0808/1

- 26/183 **11** Unscrew locking screw for planet shaft.



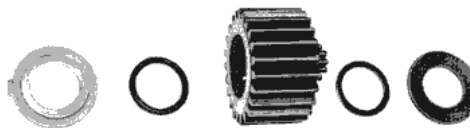
- 26/184 **12** Remove planet shaft.



UR 26-0323

26/185 **13** Remove bearing needles and spacer washers.

01/25 **14** Clean all parts, check, exchange as required.

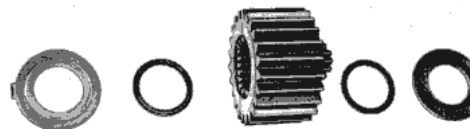


UR 26-0324

26/1306 **15** The assembly takes place in the same manner in reverse sequence, at the same time the following must be observed:

26/186 – Insert bearing needles and thrust washers with lubricating grease no. 7 and install in planet gear.

26H24 **Note:** Bearing needles of the planet gear (22 each) must only be removed and replaced as sets.



UR 26-0324

26/188 – Secure planet axle with bolt and punch blow.



UR 26-0324/1

26/91 – Install grooved ball bearings and secure.

26H26 **Note:** The grooved ball bearing has radial clearance to ensure that the sun gear and the planet gears center by themselves.

Radial clearance 0,4 mm.

26/2179 Only valid with transmission ratio  $i = 9,35$ .



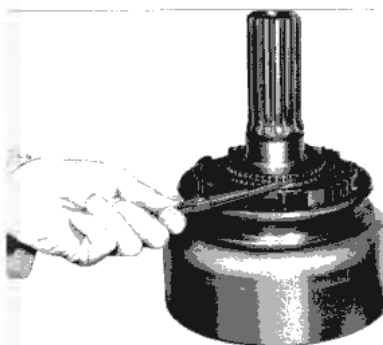
UR 26-0808/1

J  
26.15

7.1/4

26.1  
7.11

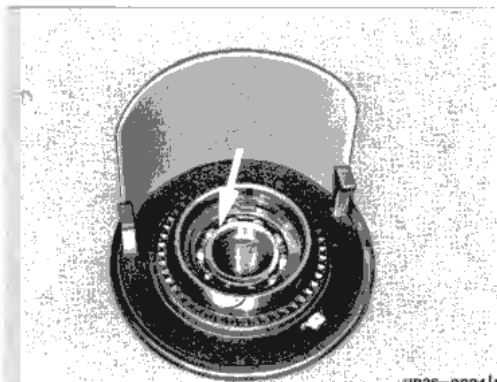
- 26/194 – Install synchronizing member with driver and shift sleeve, check axial clearance.  
Permissible axial clearance  $\pm 0$  mm.



UR 26-0814

- 26/198 – Install grooved ball bearing with shim and secure, coat oil baffle plate with adhesive no. 4 and no. 5 and install.

- 26/2179 Only valid with transmission ratio  $i = 9,35$ .

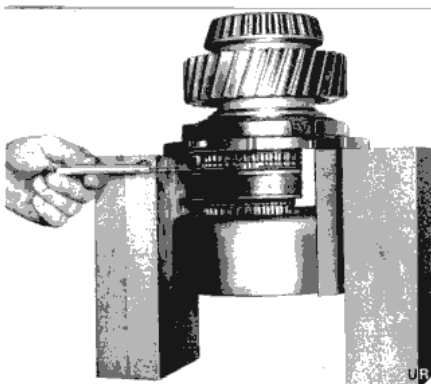


UR26-0994/1

- 26/202 – Place support beneath planet carrier and check synchromesh clearance.

Permissible synchromesh clearance  
 $1,3 \pm 0,2$  mm.

- 26H260 **Note:** If the synchromesh clearance is too great, a thinner shim and a thicker locking ring must be installed. If the synchromesh clearance is too small, a thicker shim and a thinner locking ring must be installed.



UR 26-0815