CHANGE IN LOCKING THE PLANET GEAR SHAFTS

Change:
The planet gear shafts have been changed so that there are machined shoulders in their ends and the new planet carrier also has matching shoulders to ensure the locking of the planet gear shafts. This change also increases the space between the planet carrier and the hub nut.

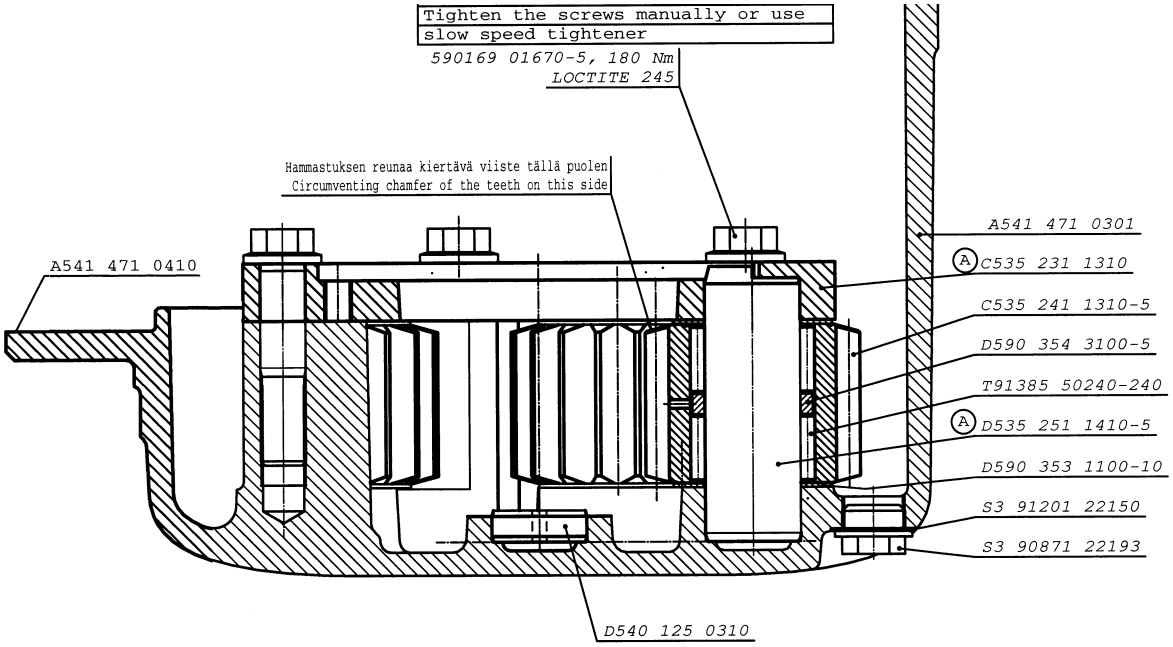
Identify:
This change concerns the hub reductions with the Sisu Compact Hubs (integral hub housing and planetary gear assembly construction) in the following axle types:
FRMP- & FRDP-11/13/16 rear axles and FSDP-, FSMP- & FSFP-14 front axles.
Axle part numbers have not been changed.

Changed Parts:

Description	Old Part No.	New Part No.
Planet Gear Shaft	535-251-1400	535-251-1410
Planet Carrier	535-231-1300	535-231-1310

Interchangeability:
The planet gear shafts (5 pcs) and the planet carrier have to replaced all at the same time.
The changed parts alone of the new design are not interchangeable with the parts of the previous design.
The new planet gear shafts have to positioned before installing. The part No. of the positioning tool for the planet gear shafts is 7543-049-030.

Date of Change: January 25, 2001, serial No. 10374



Picture 1. New Design, changed parts marked (A).

Installing instructions:

Picture 2.

Install the guide plate 7543-049-06 by the planet carrier attaching bolts.

Install the planet gear shafts by hand.

Picture 3.

Do the positioning of the planet gear shafts by the positioning tool 7543-049-030.

Remove the positioning tool.

Picture 4.

Press the planet gear shafts to the hub housing.

Use the support plate 7543-049-02 under the hub housing while pressing the shafts.

Remove the guide plate 7543-049-06 when the shafts are in place.

Install the planet gears with needle rollers and thrust according to the Maintenance Manual.

Install the planet carrier by using a workshop press. Use Loctite 245 or equivalent locking liquid on threads and tighten the planet carrier retaining screws manually or by using a slow speed tightener to 180 Nm [130 lb.-ft] torque.

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