

## Tightening Torques

	Nm	(kpm)
Fastening bolt for tachometer drive and secondary pump	8	(0.8)
Phillips head screw for holding plate on locking piston	4	(0.4)

## Special Tool

Assembly mandrel	108 589 02 43 00
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## Disassembly

- 1 Remove rear transmission case (27.2–500).
- 2 Unscrew fastening bolt from cover plate of locking piston and remove locking piston (81) together with spring (Fig. 1).

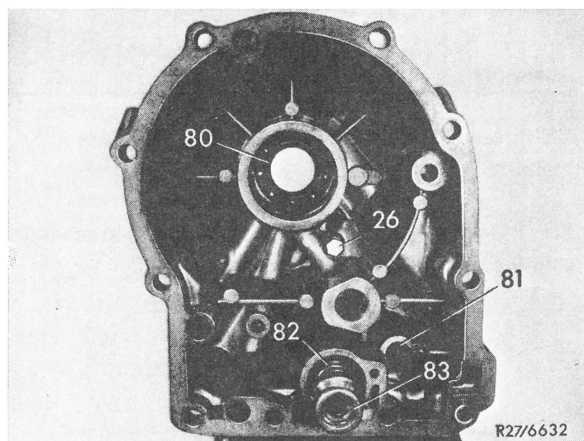


Fig. 1

- |                                      |                               |
|--------------------------------------|-------------------------------|
| 26 Fastening bolt for secondary pump | 81 Locking piston             |
| 80 Ball bearing                      | 82 Pressure receiving springs |
|                                      | 83 Spring plate               |

- 3 Remove spring plate (83) with two springs (82) and pressure receiving piston from rear transmission case cover.

- 4 Unscrew fastening bolt for tachometer drive.

- 5 Pull tachometer drive (31 to 33) out of rear transmission case, remove tachometer pinion (31) from bearing body (33) (Fig. 2).

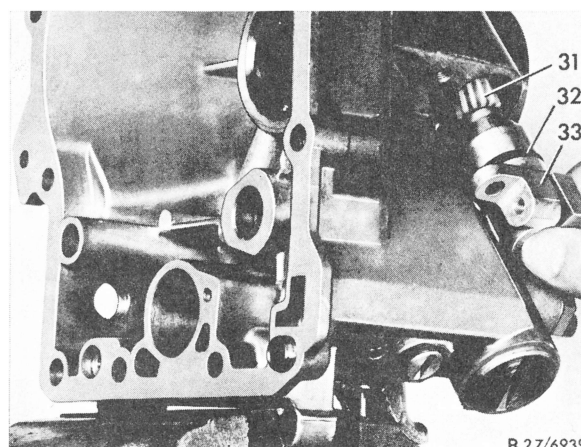


Fig. 2

- |                      |                 |
|----------------------|-----------------|
| 31 Tachometer pinion | 33 Bearing body |
| 32 O-ring            |                 |

- 6 Unscrew fastening bolt for secondary pump (26) (Fig. 1).

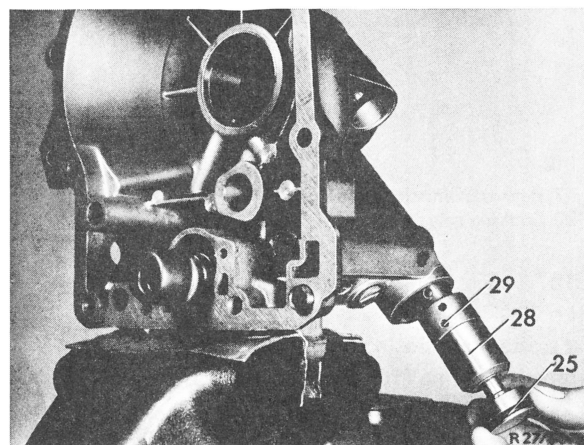


Fig. 3

- |                   |                   |
|-------------------|-------------------|
| 25 O-ring         | 29 Fastening bore |
| 28 Secondary pump |                   |

## 27.2 Disassembly and Reassembly of Rear Transmission Case

**7** Remove secondary pump (28) from rear transmission case (Fig. 3).

**8** Push sealing ring (86) out of rear transmission case (Fig. 4).

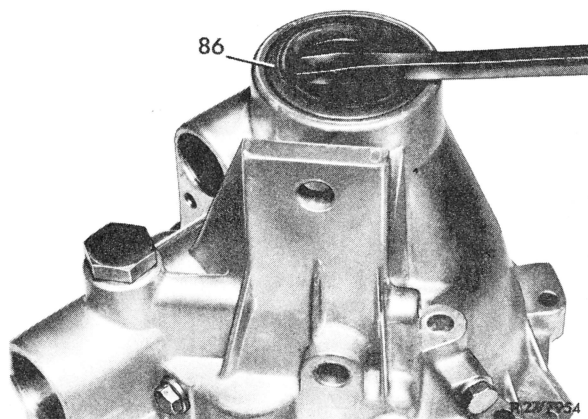


Fig. 4  
86 Sealing ring

**9** Remove locking ring (79) and press out ball bearing (80).

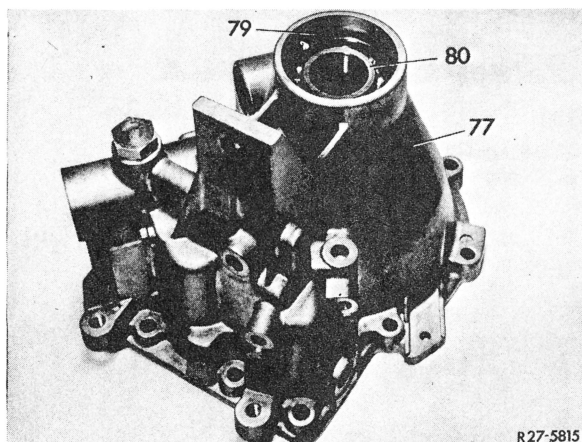


Fig. 5  
77 Rear transmission case    80 Ball bearing  
79 Locking ring

**10** Unscrew the two measuring connection plugs.

**11** Remove closing plug (13) together with compression spring (10) and glass ball (9) (Fig. 8).

**12** Unscrew closing plug (17) and remove steel ball (16) (Fig. 6).

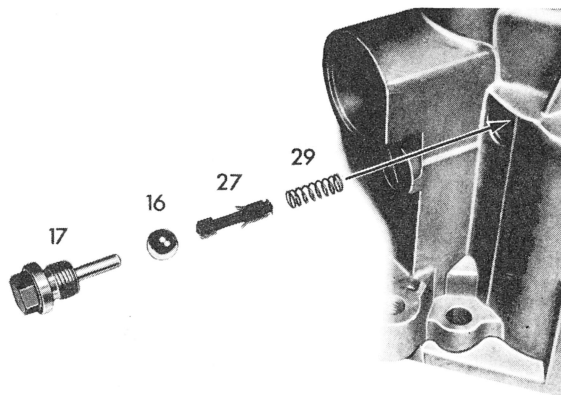


Fig. 6  
16 Steel ball                      27 Plastic pin  
17 Closing plug                29 Compression spring

**13** Check thrust pin (27) for smooth operation.

**Caution!** If the plastic pin (27) binds or drops out, be sure to replace. New transmission covers are already provided with the plastic pin (27), compression spring (29), ball (16) and closing plug (17).

### Assembly

**14** Press-in ball bearing (80) (Fig. 5) with assembly mandrel (78) (Fig. 7).

**15** Insert locking ring (79) (Fig. 5), press-in sealing ring (86) (Fig. 4).

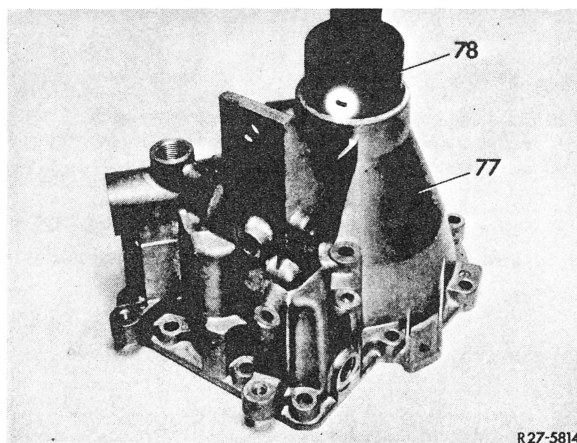


Fig. 7  
77 Rear transmission case  
78 Assembly mandrel 108 589 02 43 00

**16** Insert locking piston (81) with spring and screw down holding plate at 4 Nm (0.4 kpm) (Fig. 1).

**17** Introduce secondary pump (28) into rear transmission case until the fastening bore (29) is in alignment with the bore in transmission case (Fig. 3).

**18** Tighten fastening bolt (26) of secondary pump to 8 Nm (0.8 kpm) (Fig. 1).

**19** Insert tachometer pinion (31) into bearing body (33), introduce tachometer drive into rear transmission case until fastening bore is in alignment with bore in transmission case (Fig. 2).

**20** Tighten fastening bolt of tachometer drive to 8 Nm (0.8 kpm).

**21** Screw-in closing plug (13) with spring (10), as well as glass ball (9) and new sealing ring (Fig. 8).

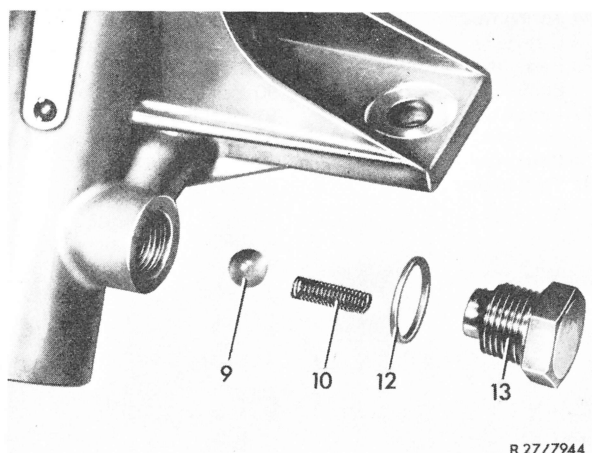


Fig. 8

9 Ball valve  
10 Compression spring  
12 Sealing ring  
13 Closing plug

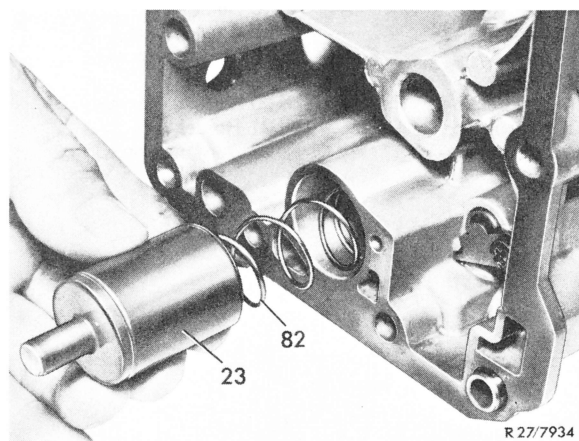


Fig. 10

23 Pressure receiving piston  
82 Pressure receiving spring

**22** Screw-in the two measuring connection plugs with new sealing ring.

**23** Insert pressure receiving piston:

Insert compression spring (82) into piston (23) and introduce both together into case (Fig. 10).

## 27.2 Disassembly and Reassembly of Rear Transmission Case

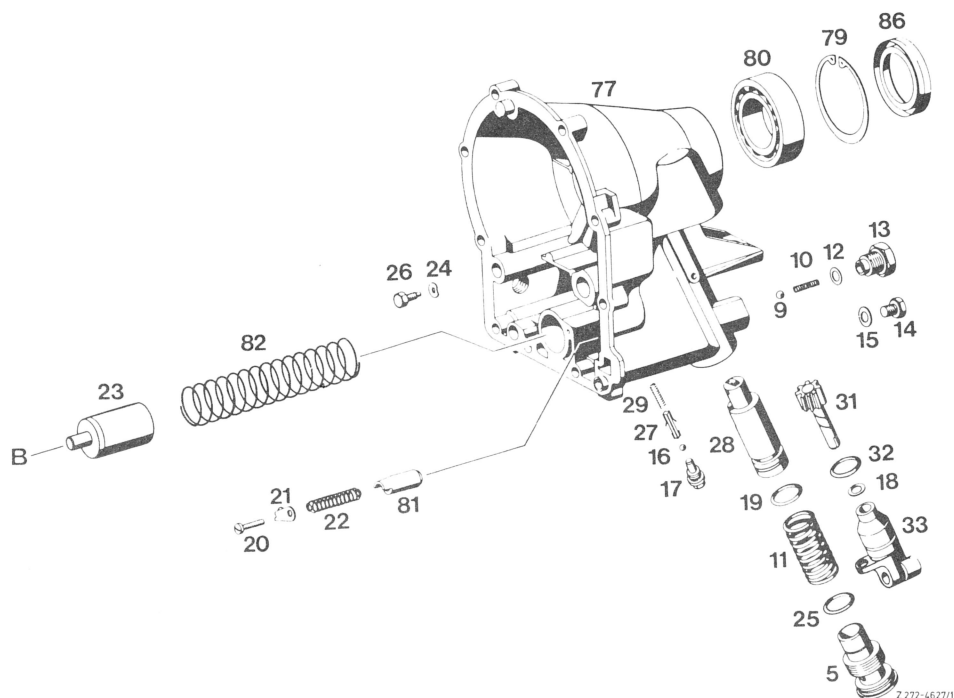


Fig. 11

- |  |                       |                                      |                               |
|--|-----------------------|--------------------------------------|-------------------------------|
| 5 Plug with inlet valve for secondary pump | 14 Closing plug       | 23 Pressure receiving piston         | 32 O-ring                     |
| 9 Ball                                     | 15 Sealing ring       | 24 Spring washer                     | 33 Bearing body               |
| 10 Compression spring                      | 16 Ball               | 25 O-ring                            | 77 Rear transmission case     |
| 11 Compression spring                      | 17 Closing plug       | 26 Fastening bolt for secondary pump | 79 Locking ring               |
| 12 Sealing ring                            | 18 Sealing ring       | 27 Plastic pin                       | 80 Ball bearing               |
| 13 Closing plug                            | 19 O-ring             | 28 Secondary pump                    | 81 Locking piston             |
|  | 20 Oval-head screw    | 29 Compression spring                | 82 Pressure receiving springs |
|  | 21 Holder             | 31 Tachometer pinion                 |                               |
|  | 22 Compression spring |                                      | 86 Radial sealing ring        |