

Tightening Torque in kpm

Hex. bolts for primary pump

2.0

Special Tools

Assembly mandrel for ball bearing in front transmission cover
(punch of removing tool)

115 589 00 35 00

Pulling fixture for ball bearing in front transmission cover

116 589 07 33 00

Removing fixture for radial sealing ring of primary pump

116 589 08 33 00

Installation sleeve for primary pump

116 589 19 61 00

2 Studs

self-made

1 Sleeve

self-made

Disassembly

1 Pull ball bearing (3) from front transmission cover (1) with pulling fixture 116 589 07 33 00 (Fig. 1).

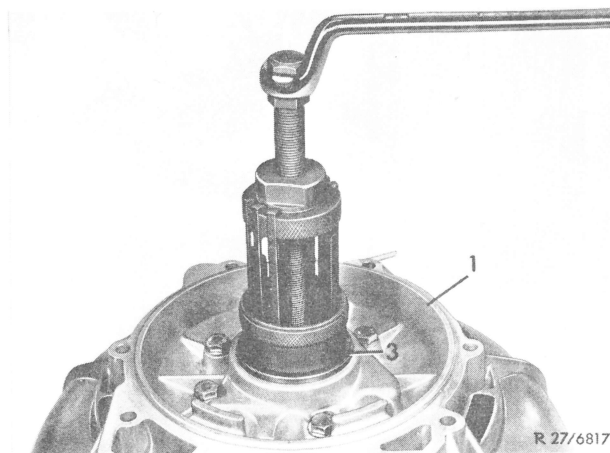


Fig. 1

- 1 Transmission cover
- 3 Ball bearing

2 Unscrew fastening bolts (4) (Fig. 2).

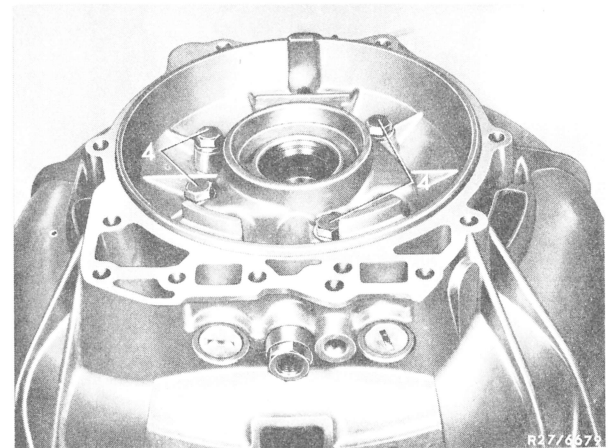


Fig. 2

- 4 Fastening bolts

3 Screw-in two hex. bolts approx. 50 mm long in opposite location (item 4, Fig. 3).

4 Loosen primary pump from transmission cover (1) by means of light blows against the two hex. bolts (4) (Fig. 3).

27.2 Disassembly and Reassembly of Front Transmission Cover with Primary Pump

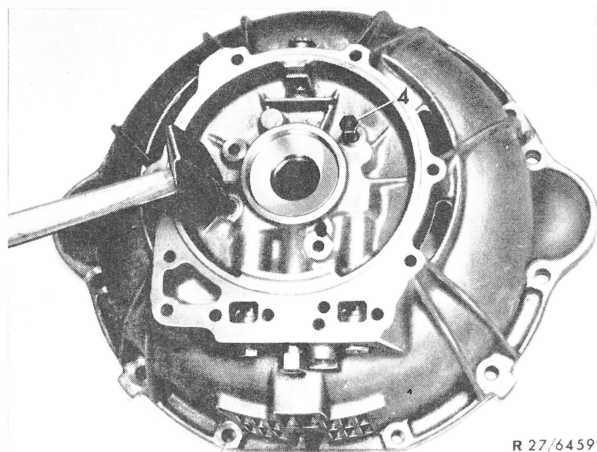


Fig. 3

4 Hex. bolts

5 Then remove primary pump (11) with intermediate plate (7) from front transmission cover (1) (Fig. 4).

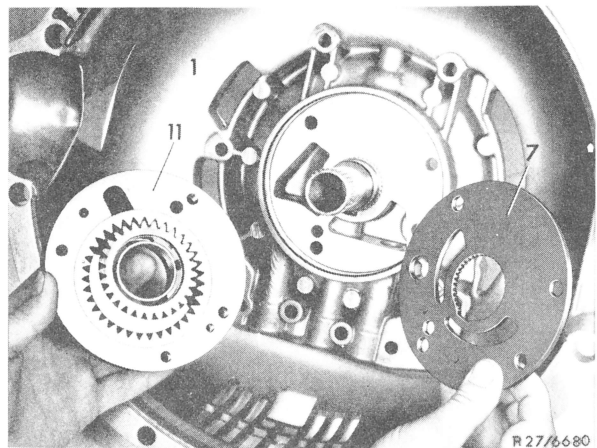


Fig. 4

1 Transmission cover
7 Intermediate plate
11 Pump housing

6 Remove primary pump gears (8) and (9) from pump housing (11) (Fig. 5).

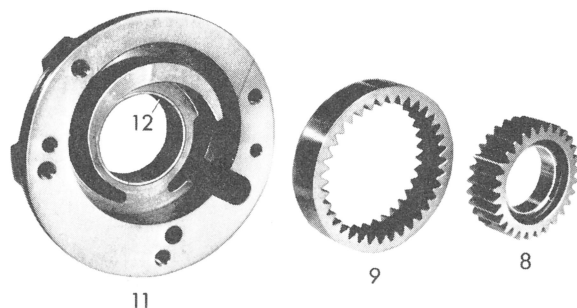


Fig. 5

8 Drive gear
9 Hollow gear
11 Pump housing
12 Bronze bushing

7 Remove O-ring (10) and radial seal (13), if required (Fig. 7).

Note: The removing fixture 116 589 08 33 00 shown in Fig. (6) can also be used on mounted transmission.

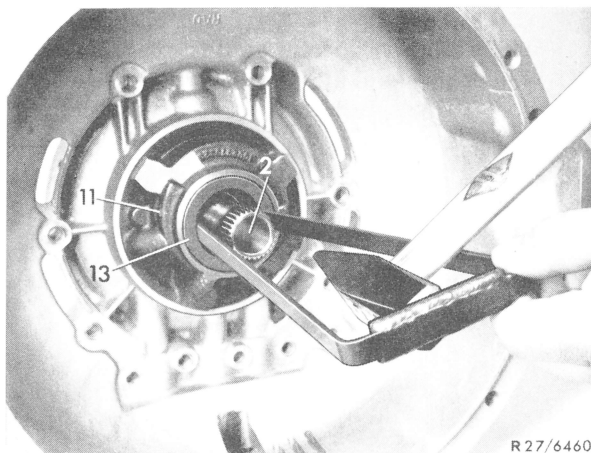


Fig. 6

2 Stator shaft
11 Pump housing
13 Radial sealing ring

Assembly

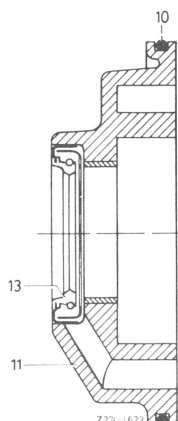
8 Install new O-ring (10) and radial sealing ring (13) into pump housing (11) (Fig. 7).

9 Lubricate primary pump gears (8 and 9) and insert into pump housing (11).

The bevelled outer edge of the pump gear (9) should face the bronze bushing (12) (Fig. 5).

Fig. 7

- 10 O-ring
- 11 Pump housing
- 13 Radial sealing ring



10 Insert intermediate plate (7) in such a manner that the fastening bores for the primary pump are in alignment (Fig. 8).

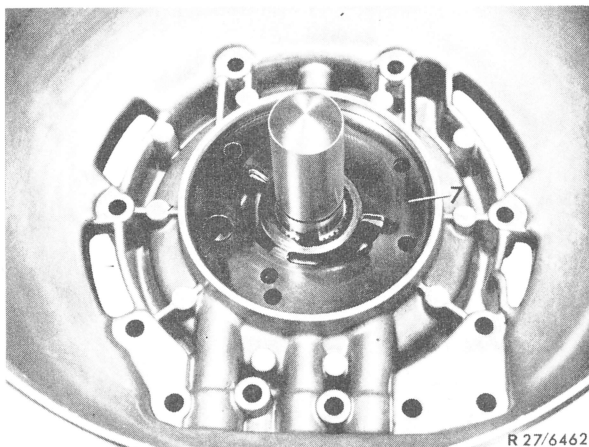


Fig. 8

- 7 Intermediate plate

11 Place installation sleeve 116 589 19 61 00 onto stator shaft and screw-in two studs for guiding primary pump (Fig. 9).

12 Insert primary pump into transmission cover and tighten fastening bolts (4) to 2.0 kpm (Fig. 2).

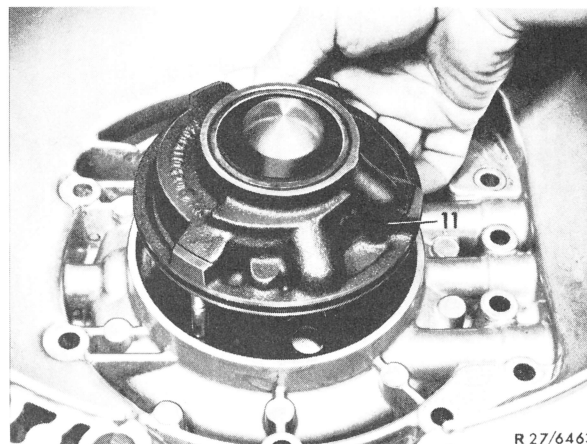


Fig. 9

- 11 Pump housing

13 Press ball bearing (3) into transmission cover (1) with suitable mandrel. Use punch of remover 115 589 00 35 00 for this purpose (Fig. 10).

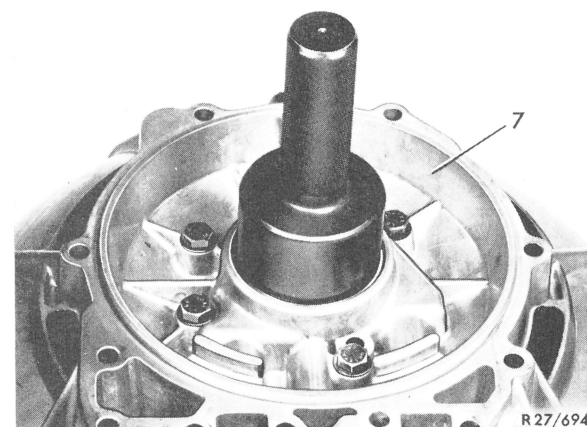


Fig. 10

- 1 Transmission cover

27.2 Disassembly and Reassembly of Front Transmission Cover with Primary Pump

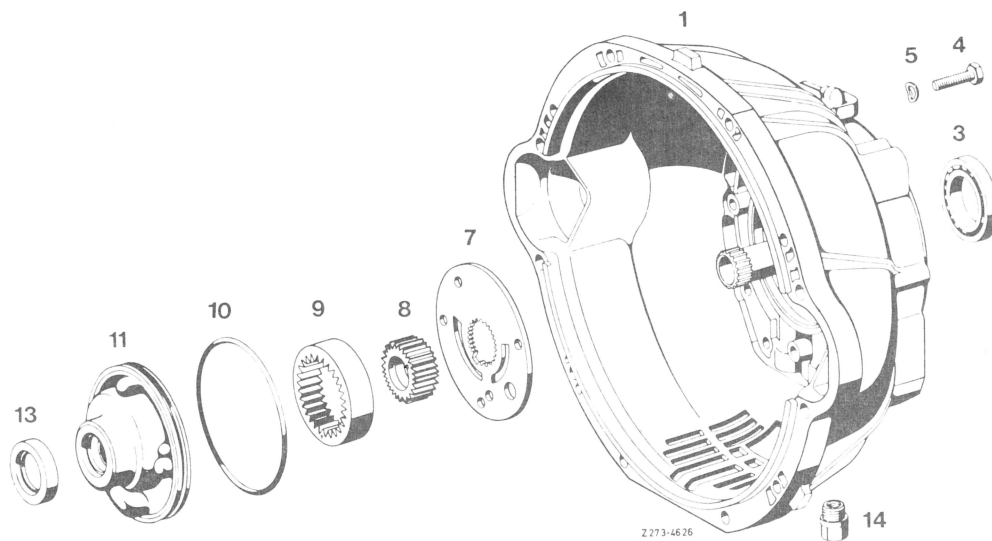


Fig. 11

1 Transmission cover
3 Ball bearing

4 Fastening screw
5 Spring washer
7 Intermediate plate

8 Drive gear
9 Ring gear
10 O-ring

11 Primary pump housing
13 Radial sealing ring
14 Threaded plug