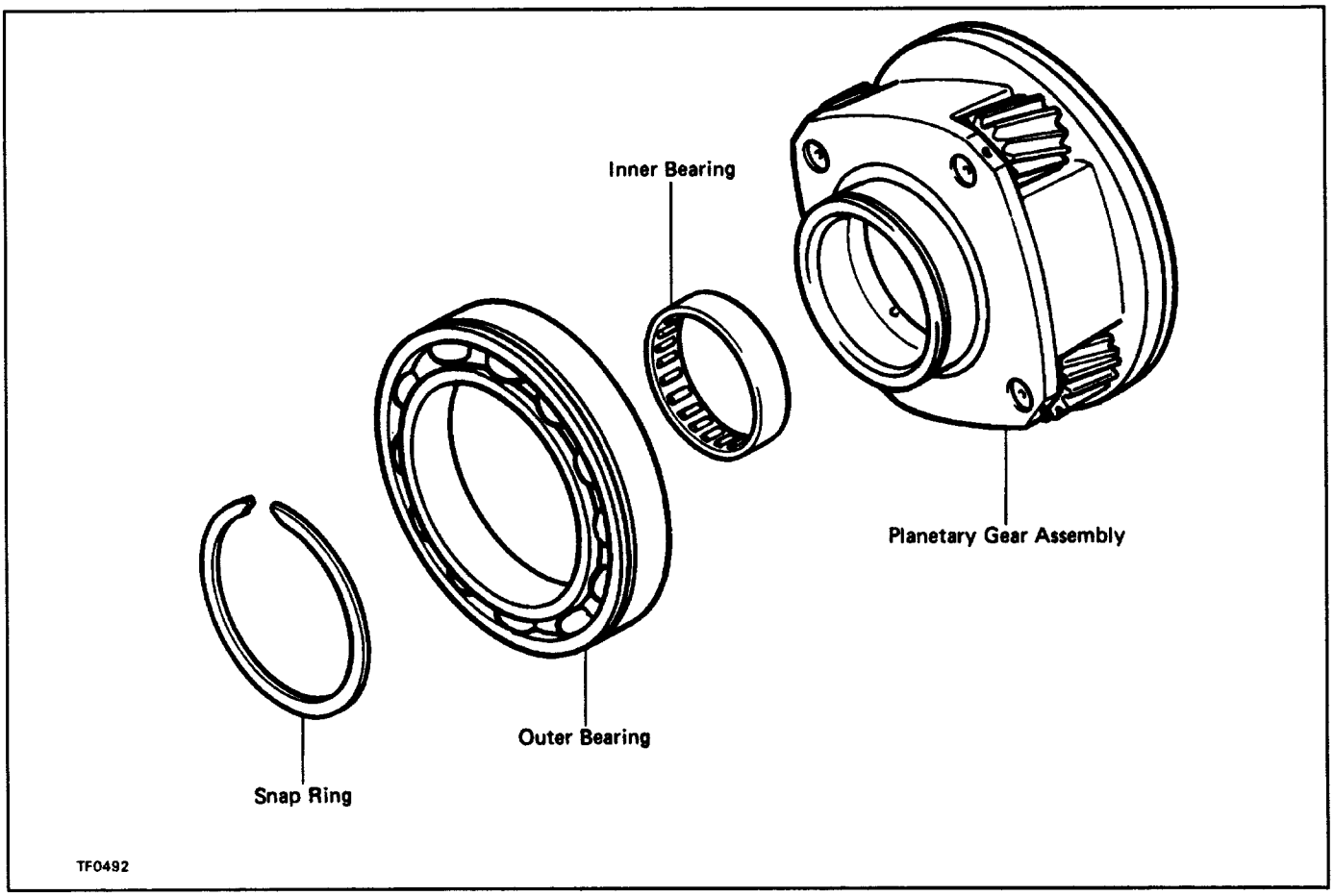
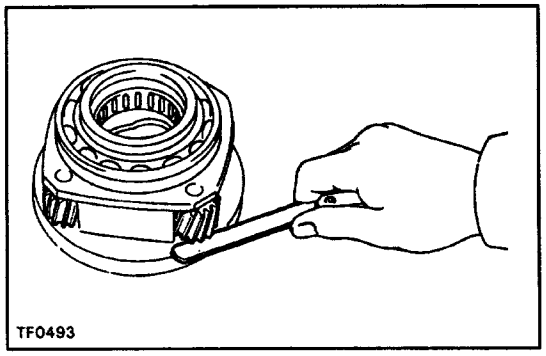
PLANETARY GEAR

COMPONENTS





PLANETARY GEAR INSPECTION

1. INSPECT PINION GEAR THRUST CLEARANCE

Using a feeler gauge, measure the planetary pinion gear thrust clearance.

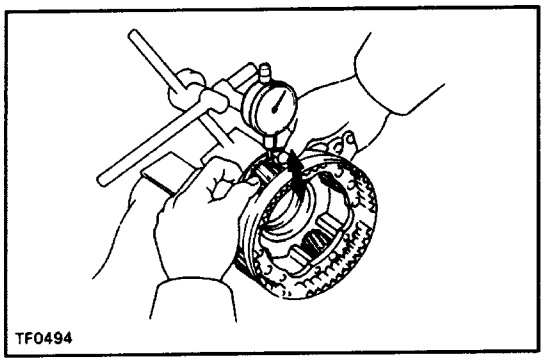
Standard clearance:

0.11 – 0.86 mm (0.0043 – 0.0339 in.)

Maximum clearance:

0.86 mm (0.0339 in.)

If the clearance exceeds the maximum, replace the planetary gear assembly


TF0494

2. INSPECT PLANETARY PINION GEAR RADIAL CLE–ARANCE

Using a dial indicator, measure the planetary pinion gear radial clearance.

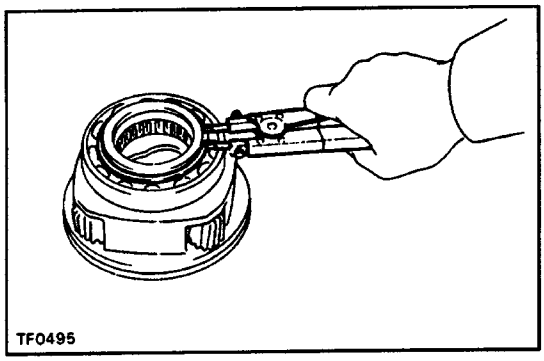
Standard clearance:

0.009 – 0.038 mm (0.0004 – 0.0015 in.)

Maximum clearance:

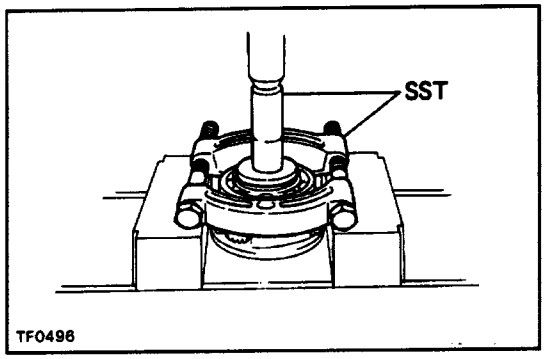
0.038 mm (0.0015 in.)

If the clearance exceeds the maximum, replace the planetary gear assembly.


TF0495

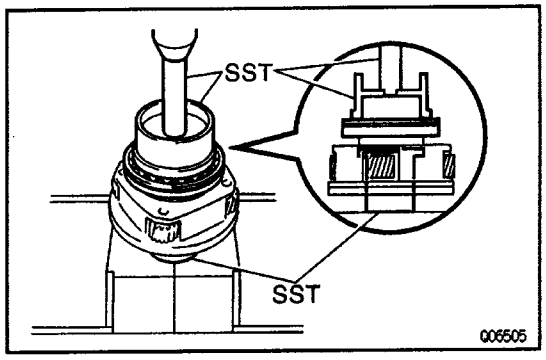
3. IF NECESSARY, REPLACE PLANETARY GEAR OUTER BEARING

(a) Using a snap ring expander, remove the snap ring.



TF0496

(b) Using SST and a press, remove the bearing.
SST 09554 – 30011, 09555 – 55010



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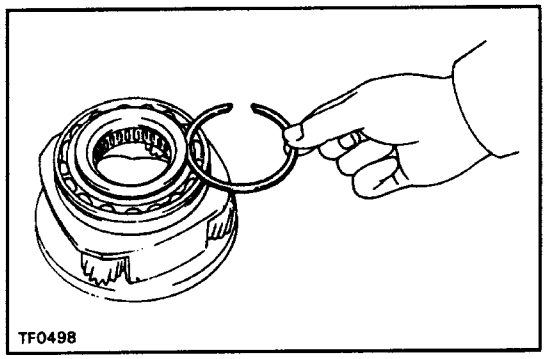
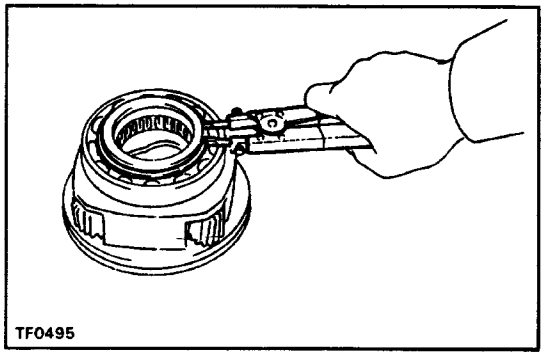
(c) Using SST and a press, install a new bearing with the outer race snap ring groove the front.
SST 09223–15020, 09515–30010, 09550–22011 (09550–00020)

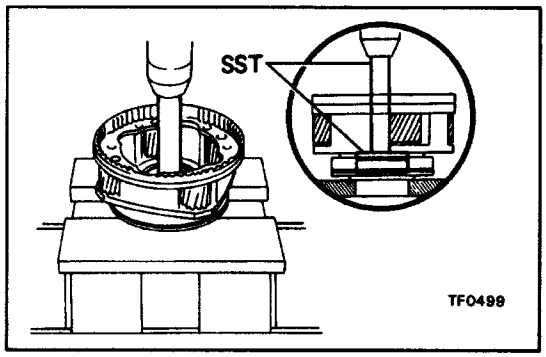

TF0498

(d) Select a snap ring that will allow minimum axial play.

Mark	Thickness mm (in.)
1	1.45 – 1.50 (0.0571 – 0.0591)
2	1.50 – 1.55 (0.0591 – 0.0610)
3	1.55 – 1.60 (0.0610 – 0.0630)
4	1.60 – 1.65 (0.0630 – 0.0650)
5	1.65 – 1.70 (0.0650 – 0.0669)

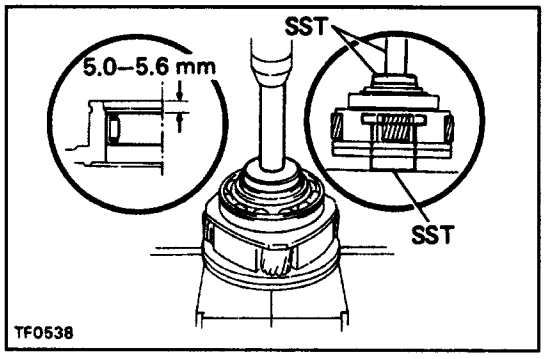


(e) Using a snap ring expander, install the snap ring.



4. IF NECESSARY, REPLACE PLANETARY GEAR INNER BEARING

(a) Using SST and a press, remove the bearing.
SST 09550–10012 (09252–10010, 09557–10010)



(b) Using SST and a press, install a new bearing.
SST 09550 –10012 (09252 –10010, 09557 –10010), 09515–30010

Bearing depth:
5.0 – 5.6 mm (0.197 – 0.220 in.)