

Fig. 1
Independent Spring Reverse Shaft (SAR)

1) Oil Pan	11) Oil Pan	21) Bearing
2) Oil Seal	12) Oil Seal	22) Gear Ring
3) Bearing	13) Gear	23) Gear
4) Gear Ring	14) Gear	24) Gear
5) Gear	15) Gear	25) Gear
6) Gear Ring	16) Gear	26) Gear
7) Bearing	17) Gear	
8) Gear	18) Gear	
9) Gear	19) Gear	
10) Gear	20) Gear	
	27) Bearing	
	28) Gear Ring	
	29) Gear	
	30) Gear	
	31) Gear	
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	33) Gear	
	34) Gear	
	35) Gear	
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	100) Gear	

Remove the Machine Assembly

- Check oil level under the S.A. reverse shaft clutch drum and gear oil in both cases to place over the shaft to remove.
- Remove the S.A. clutch drum and gear.
- Remove the shaft and the S.A. side of the machine. The left hand side bearing housing will be removed with the shaft. The S.A. bearing will remain in its bore. It may be necessary to tap on the gear side of the shaft to remove it from the drilled portion of the shaft.

- Check oil level under the S.A. reverse shaft clutch drum and gear oil in both cases to place over the shaft to remove.
- Remove the S.A. clutch drum and gear.
- Remove the shaft and the S.A. side of the machine. The left hand side bearing housing will be removed with the shaft. The S.A. bearing will remain in its bore. It may be necessary to tap on the gear side of the shaft to remove it from the drilled portion of the shaft.

- To remove the S.A. side bearing housing, remove S.A. clutch drum and gear. Remove gear ring (38). Remove bearing from its bore.

Special Tools Information:
 (1) **INVERT BEARING (11)** to fit bore. Bearing is oriented, and is installed with the shield to the inside. Install gear ring (38).
 (2) **INVERT GEAR (26)** and ring (27) to place in bearing bore. Set clutch drum and gear in place. Check drum and gear to hold them in place.

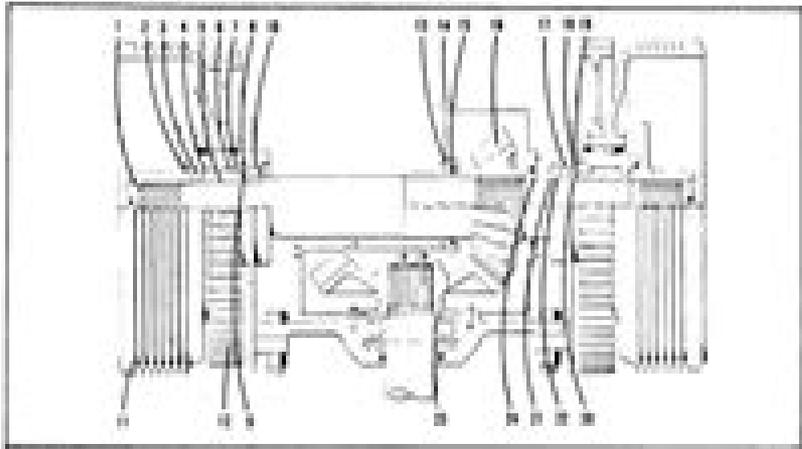


Fig. 2
Independent Spring Reverse Shaft (SAR)

1) Oil Pan	11) Oil Pan	21) Bearing
2) Oil Seal	12) Oil Seal	22) Gear Ring
3) Bearing	13) Gear	23) Gear
4) Gear Ring	14) Gear	24) Gear
5) Gear	15) Gear	25) Gear
6) Gear Ring	16) Gear	26) Gear
7) Bearing	17) Gear	
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- and gear to hold them in place.
- Check condition of teeth on each side of lead gear case. Replace if necessary.
- Install bearing (21) on shaft. Bearing is oriented and is installed with the shield to the inside.
- Slide the shaft through the S.A. bearing bore and start it through lead gear case. Install lead gear, shaft, covers over shaft. Slide shaft completely into place. Adjust the lead gear back-S.A. The lead gear must be adjusted for full tooth contact, and 100% clearance, measured at the pitch line of the teeth. The lead gear side is marked with. There will be a single tooth mesh formed on the gear, and the tooth will be on the other gear. The clearance measurement must be taken

with the shaft which were positioned between the lead gear teeth on the other gear. The clearance is adjusted by adding or subtracting shims behind the lead gear on the reverse shaft in conjunction with adding or subtracting shims between the oil seal retainer and bearing housing at the bottom of the vertical spring center drive shaft. See line 4 for more information. The following items are available for this adjustment.

Reverse Shaft:
 (1) **INVERT BEARING (21)** to fit shaft.
 (2) **INVERT GEAR (26)** and ring (27) to place in bearing bore. Set clutch drum and gear in place. Check drum and gear to hold them in place.

- Install S.A. clutch assembly first, then install S.A. clutch assembly. Refer to SM5-1.3 for more information.
 - Connect all lines, lines, fittings, etc. Install lead gear case cover plate.
- Fill lead gear case with lubricant. Refer to Section 2 of Operators Manual for the proper type and amount of lubricant to use.
- Lubricate side housing bear from as specified in Service Manual before operating machine.

Link Belt Service Manual

Scott C. Dulebohn



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