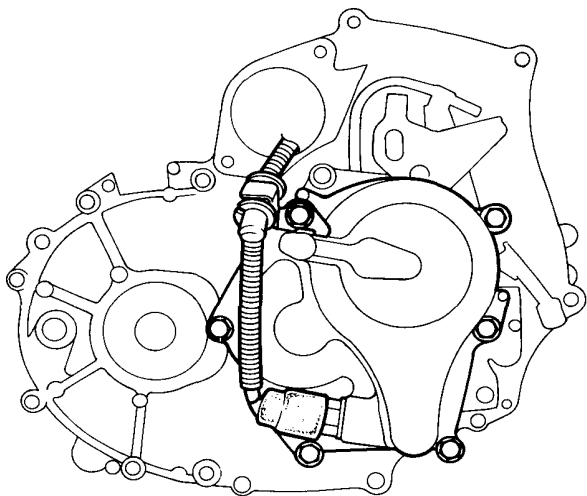


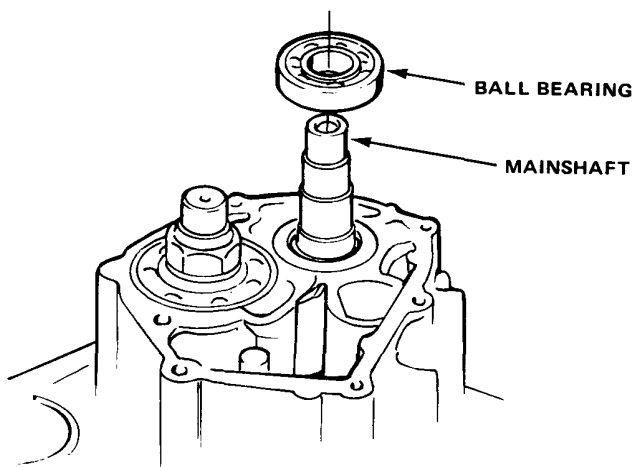
End Cover

Thrust Inspection

1. Remove the bolts from the end cover, then remove it.

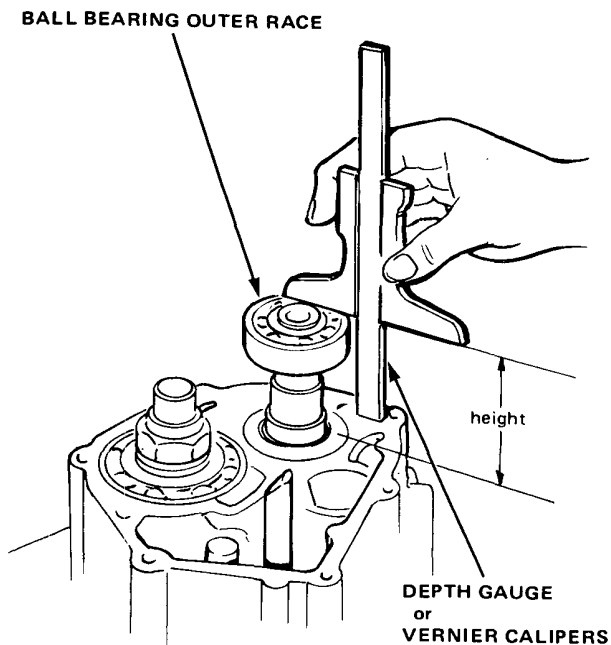


2. Remove the ball bearing from the mainshaft.

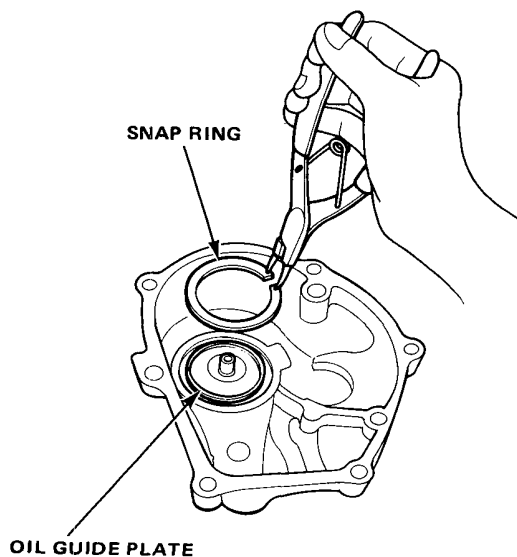


3. Leave the ball bearing on the mainshaft.

4. Clean all sealant residue from the transmission housing, then measure from the top of the ball bearing's outer race to the mounting flange for the end cover. Measure at two points and average the readings.

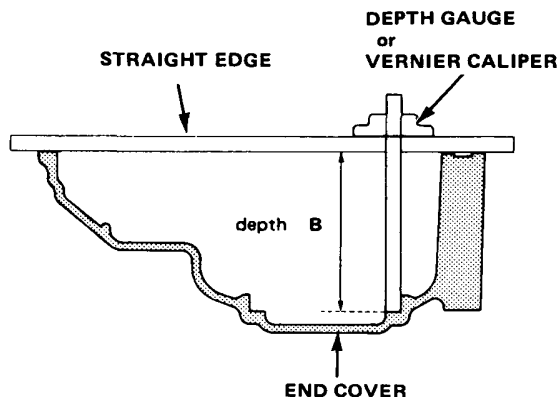


5. Remove the 52 mm snap ring and the oil guide plate from the end cover.





6. Place a straight edge on the end cover and measure the depth on the snap ring installation hole. Measure at two points and average the readings. Subtract the thickness of the straight edge from the reading.



7. Select the correct thickness snap ring as follows:
- Subtract the bearing height (step 4) from the depth of the end cover (step 6).
 - Subtract the Standard Clearance 0.11 mm – 0.18 mm (0.004 – 0.007 in.) from the dimension determined in step 7a,

EXAMPLE:

Housing depth: 57.00 mm (2.244 in.)
 Bearing height: -54.50 mm (2.145 in.)
 2.50 mm (0.099 in.)

2.50 mm (0.099 in.)
 Snap ring height: -0.11 mm (0.004 in.)
 (minimum) 2.39 mm (0.095 in.)

2.50 mm (0.099 in.)
 Snap ring height: -0.18 mm (0.007 in.)
 (maximum) 2.32 mm (0.092 in.)

Select the Snap ring in the range between 2.39 mm (0.095 in.) and 2.32 mm (0.092 in.) from the parts list.

Parts Number	Thickness
23931-PE6-000	0.500 mm (0.0196 in.)
23932-PE6-000	1.100 mm (0.0433 in.)
23942-PE6-000	1.125 mm (0.0442 in.)
23933-PE6-000	1.150 mm (0.0452 in.)
23943-PE6-000	1.175 mm (0.0462 in.)
23934-PE6-000	1.200 mm (0.0472 in.)
23944-PE6-000	1.225 mm (0.0482 in.)
23935-PE6-000	1.250 mm (0.0492 in.)
23945-PE6-000	1.275 mm (0.0501 in.)
23936-PE6-000	1.300 mm (0.0511 in.)
23946-PE6-000	1.325 mm (0.0521 in.)
23937-PE6-000	1.350 mm (0.0531 in.)
23947-PE6-000	1.375 mm (0.0541 in.)
23938-PE6-000	1.400 mm (0.0551 in.)
23948-PE6-000	1.425 mm (0.0561 in.)
23939-PE6-000	1.450 mm (0.0570 in.)
23949-PE6-000	1.475 mm (0.0580 in.)
23940-PE6-000	1.500 mm (0.0590 in.)
23950-PE6-000	1.525 mm (0.0600 in.)
23941-PE6-000	1.550 mm (0.0610 in.)
23951-PE6-000	1.575 mm (0.0620 in.)

NOTE: If the measurements determined in 7b are greater than the thickest snap ring, you may use two snap rings (For the example above, you could use the 1,250 mm and the 1,100 mm rings for a total of 2,350).

CAUTION: Do not use more than two rings together.