

Installation

- 01 Heat the output bearing's inner race to max. 110 °C. Place protection ring **1X56 138 187 (1)** onto the output bearing to do this.

NOTE

The shafts must be assembled correctly ready for installation.

**DANGER**

Only touch heated protective tool when wearing protective gloves.

- 02 Remove protection ring **1X56 138 187** and carefully insert the shafts fully into the transmission housing.
- 03 Pull the shafts into the correct axial position from the output end using a bushing (against the bearing inner race or speedometer worm) and a hex bolt (M12x1.5). Tightening torque = 120 Nm.

NOTE**Separate clutch housing version**

Check the installation is correct by measuring distance "B", see section 10.1. Remove the bushing and hex bolt.

- 04 Remove fixtures and auxiliary strip
- 05 Coat thread of articulated bolts with sealing compound. First screw in articulated bolts of 1st/2nd gear with spring washer.

NOTE

Articulated bolts for 1st/2nd gear (2) = approx 48.5 mm

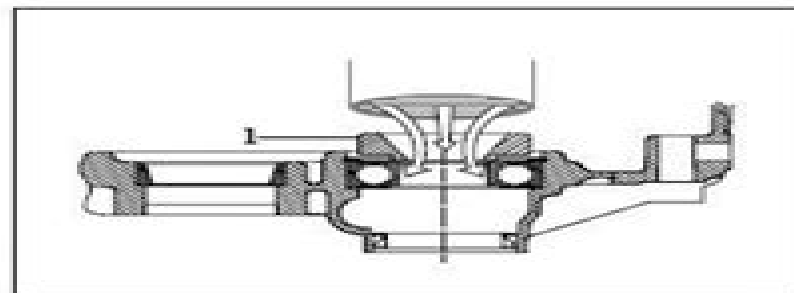
Articulated bolts for 3rd/4th gear (3) = approx 55.0 mm

Articulated bolts for 5th/6th gear (4) = approx 55.0 mm

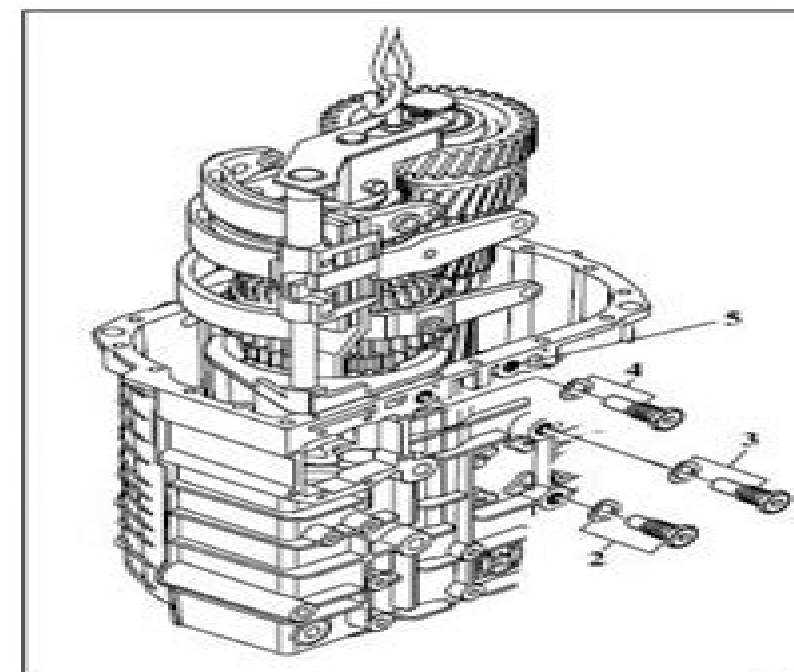
NOTE

Overdrive version (4),
direct drive version (5).

- 06 Screw in and tighten the remaining articulated bolts and spring washers as previously described. Tightening torque = 160 Nm.



001 33194



001 73807

Zf 6s1600 Gearbox Repair Manual

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Motor Heavy Truck Repair Manual ,2008 **The Haynes General Motors Automatic Transmission Overhaul Manual** Eric Godfrey,2002 Model 35 Automatic Transmission Workshop Manual Rootes Limited. Service Division,19??

The Haynes Ford Automatic Transmission Overhaul Manual Jeff Killingsworth,John Harold Haynes,1996 For the do it yourselfer and includes transmission identification theory of operation step by step overhaul and professional tips and tricks Photos **Trucks Service Manual** ,1975 **Humber Workshop Manual D.G. Type Automatic Transmission** Rootes Motors. Service Division,196? Repair Manual, Type 43 Audi 5000 Volkswagenwerk,1979 **DA Maverick Repair Manual Supplement** ,19?? Ford DA Maverick Repair Manual Supplement Ford Motor Company of Australia,

Humber Workshop Manual Humber, Ltd. Service Department,1957 **1997 Transmission/transaxle/transfer Case Unit Repair Manual** ,1996 **Fordomatic Transmission Service Manual** Paul-Marsh Co,1957 Workshop Manual for Model 35 Automatic Transmission Commer Cars Ltd,19??

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