

Product: WHEEL SCRAPER

Model: 621E WHEEL SCRAPER 6BB

Configuration: 621E TRACTOR-SCRAPER / POWER SHIFT / 6BB00001-01234 (MACHINE) POWERED BY 3406 ENGINE

Disassembly and Assembly 621E, 623E, & 627E TRACTORS POWER TRAIN

Media Number -SEN3303-01

Publication Date -01/02/1991

Date Updated -10/03/2010

SEN33030021

Transfer Gears

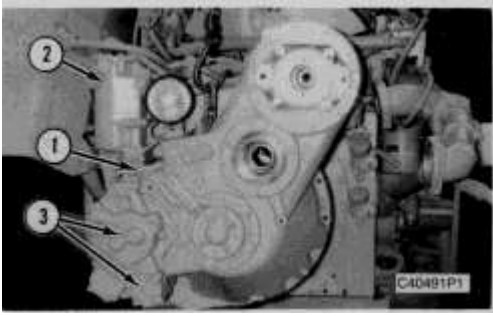
SMCS - 3159-015; 3159-016

Disassemble Transfer Gears

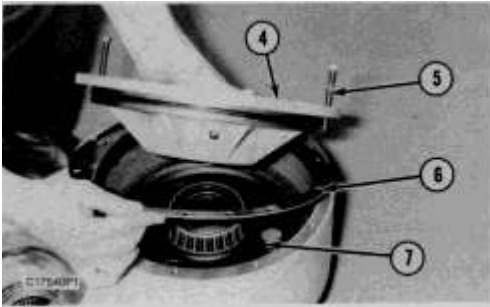
Tools Needed		A	B	C	D	E
1P520	Driver Group	1	1		1	
8B7560	Step Plate		1	1		
8B7551	Bearing Puller Attachment		1			
8B7548	Puller Assembly		1			
887554	Bearing Cup Pulling Attachment			1	1	
5F7345	Screw			1		
5P4170	Step Plate				1	1
1P2321	Puller Assembly					1

Start By:

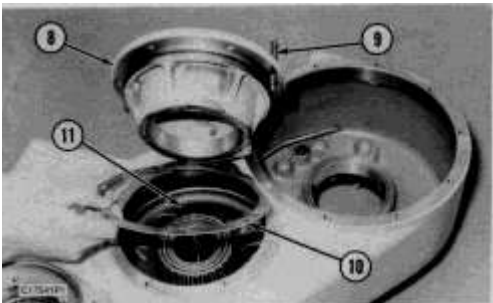
- a. remove transfer gears OR
- b. separation of transfer gears from transmission



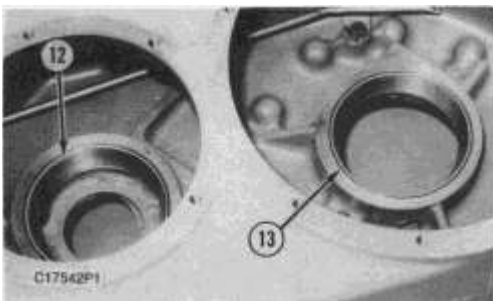
1. Remove bolts (1), and remove filter housing (2). Remove the pumps (3). See the topic, Transmission Oil Pump.



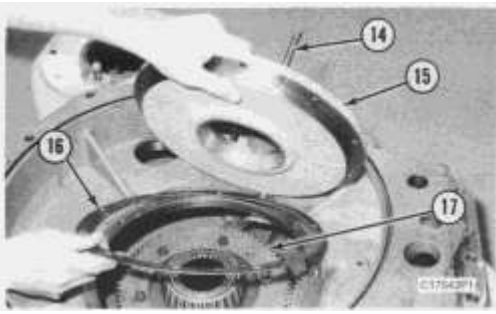
2. Remove the bolts that hold cage (4). Install two 3/8" - 16 NC forcing screws (5), and remove the cage, shims (6), and gear (7).



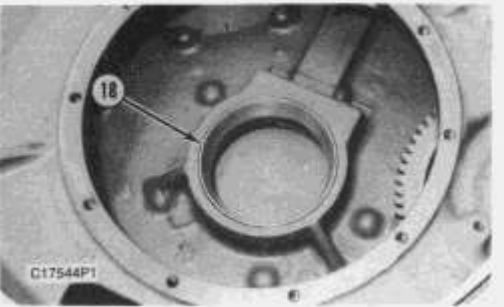
3. Remove the bolts that hold cage (8). Install two 3/8" - 16 NC forcing screws (9), and remove the cage, shims (10), and gear (11).



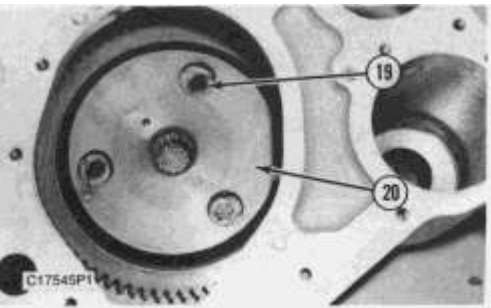
4. Remove bearing cups (12) and (13) from the case assembly with a hammer and a punch.



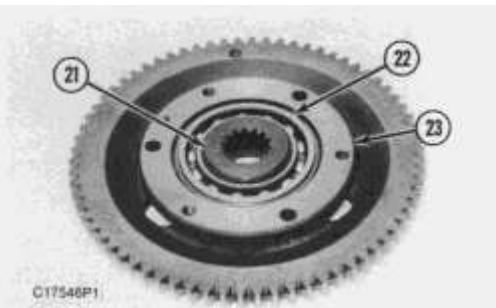
5. Turn the transfer gear case over. Remove the bolts that hold cage (15). Install two 3/8" - 16 NC forcing screws (14), and remove cage (15), shims (16), and gear (17).



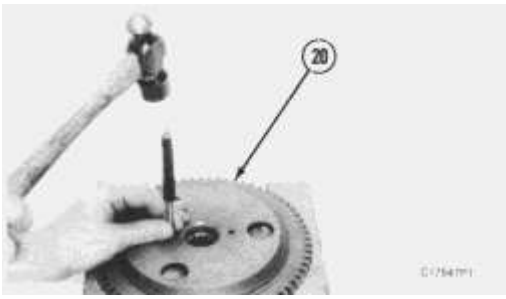
6. Remove bearing cup (18) from the case assembly with a hammer and a punch.



7. Turn the transfer gear case over. Remove three bolts (19). If required, install 3/8" - 16 NC forcing screws in holes 180° from the bolt holes, and remove gear (20).



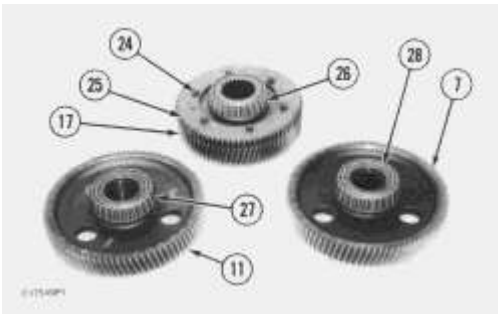
8. Remove retaining ring (21).



9. Use a punch and a hammer to drive bearing (22) and carrier (23) from gear (20).

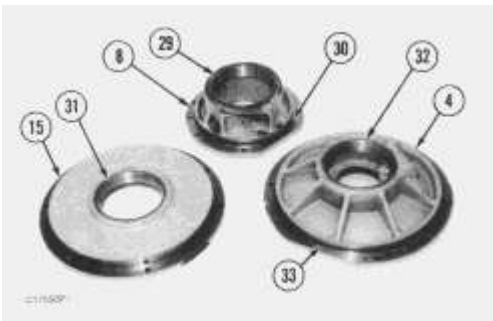


10. Remove bearing (22) from carrier (23).



11. Remove six bolts (24), and remove gear (25) from gear (17). Remove bearing cone (26) from gear (17) with tooling (B).

12. Remove bearing cone (27) from gear (11) and bearing cone (28) from gear (7) with tooling (E).



13. Remove bearing cup (29) from cage (8) with tooling (D). Remove O-ring seal (30) from the cage.

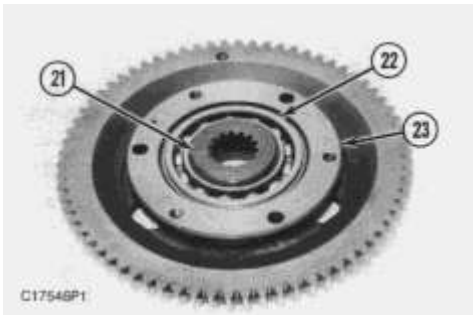
14. Remove bearing cup (31) from cage (15) with a hammer and punch. Remove bearing cone (32) from cage (4) with tooling (C). Remove O-ring seal (33) from cage (4).

Assemble Transfer Gears

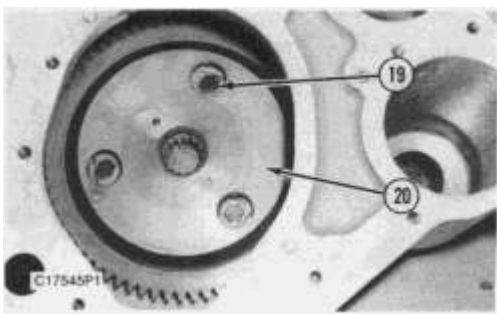
Tools Needed		A	F
1P510	Driver Group	1	
8S2328	Dial Test Indicator Group		1



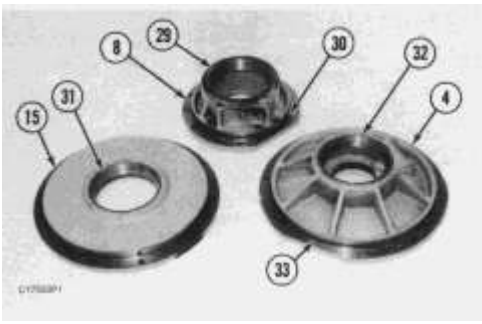
1. Install bearing (22) in carrier (23).



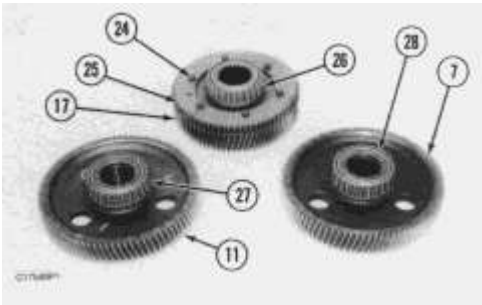
2. Install bearing (22) and carrier (23) on gear (20) with a hammer and a punch. Install retaining ring (21).



3. Install gear (20) in the transfer gear case, and install bolts (19). Tighten the bolts to a torque of $50 \pm 7 \text{ N}\cdot\text{m}$ ($37 \pm 5 \text{ lb ft}$).



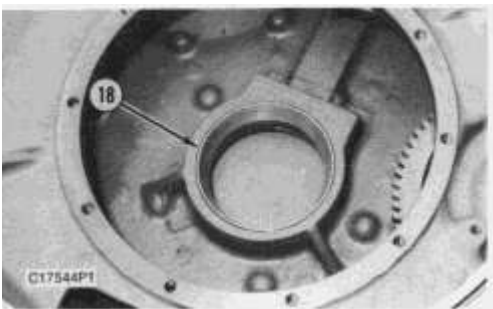
4. Lower the temperature of bearing cups (29), (31), and (32). Install bearing cups (29), (31), and (32) with tooling (A). Make sure O-ring seals (30) and (33) are in position on the cages.



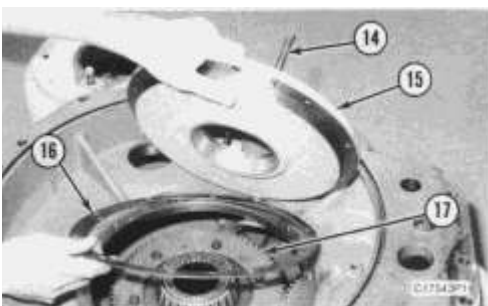
5. Heat bearing cone (26) to a maximum temperature of **149° C (300° F)** and install it on gear (17). Install gear (25) on gear (17) and bolts (24) that hold it. Tighten the bolts to a torque of **50 ± 7 N·m (37 ± 5 lb ft)**.

6. Heat bearing cone (27) to a maximum temperature of **149° C (300° F)** and install it on gear (11).

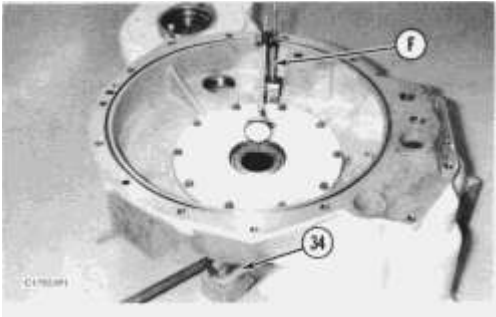
7. Heat bearing cone (28) to a maximum temperature of **149° C (300° F)** and install it on gear (7).



8. Turn the transfer gear case over. Lower the temperature of bearing cup (18), and install it with tooling (A).

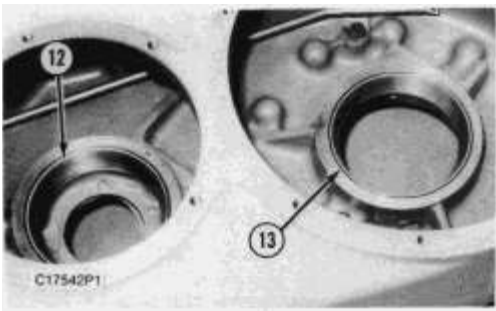


9. Remove the forcing screws from the cage. Install gear (17), shims (16), cage (15) and the bolts that hold the cage.



10. Install tooling (F) and measure the end play in the gear with pry bar and blocks (34). Add or remove shims under the cage to get $0.15 \pm 0.05 \text{ mm}$ ($.006 \pm .002 \text{ in.}$) end play in the gear.

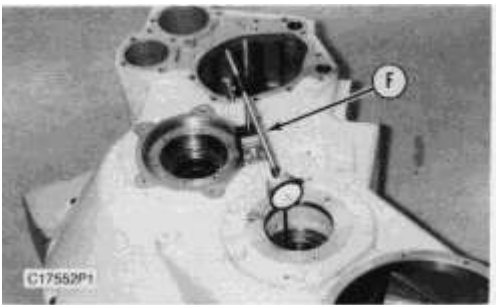
11. Tighten the bolts that hold cage (15) to a torque of $50 \pm 7 \text{ N}\cdot\text{m}$ ($37 \pm 5 \text{ lb ft}$).



12. Turn the transfer gear case over. Lower the temperature of bearing cups (12) and (13), and install them with tooling (A).



13. Remove the forcing screws from the cage. Install gear (11), shims (10), cage (8) and the bolts that hold the cage.



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