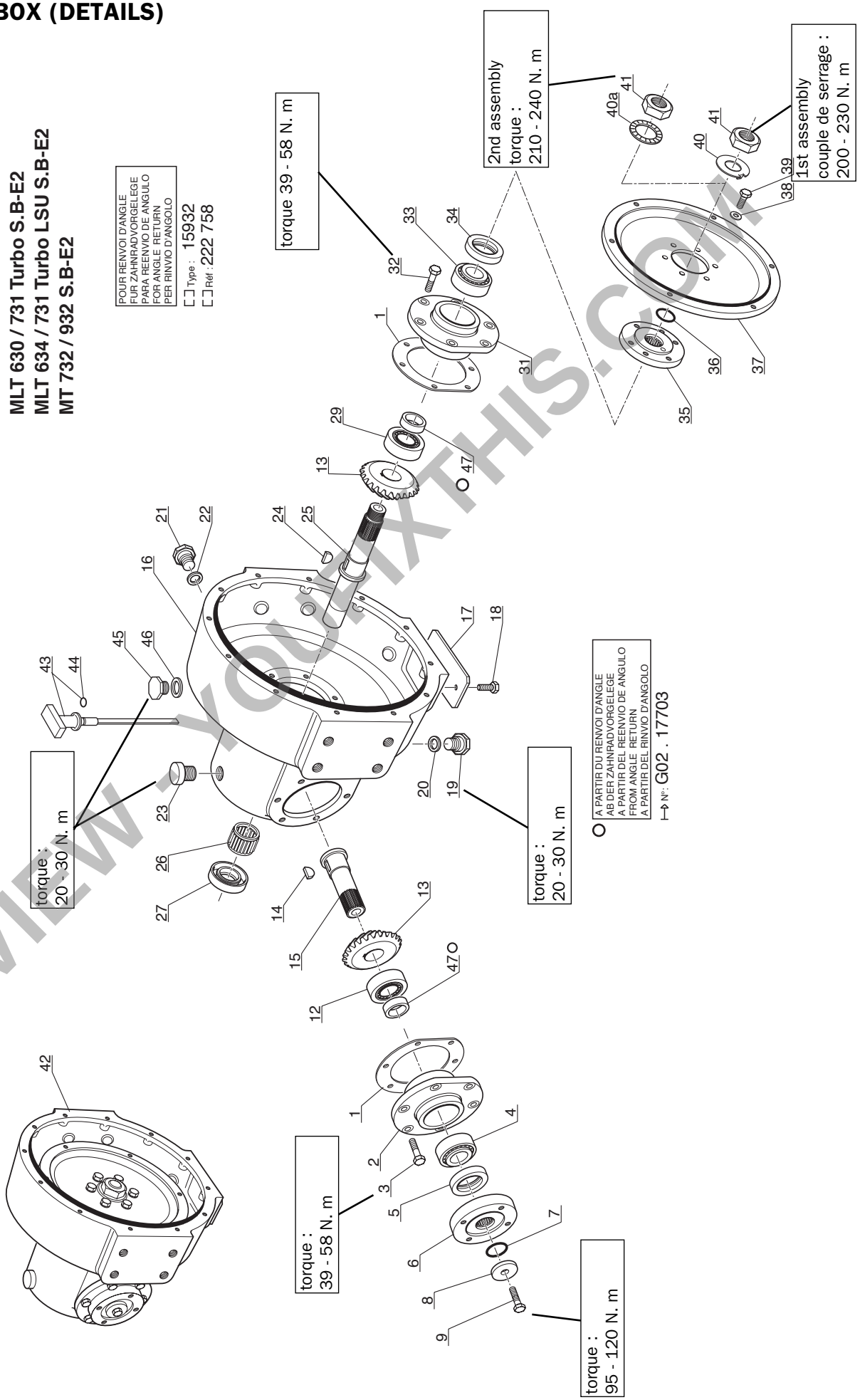
ANGLE GEAR BOX (DETAILS)

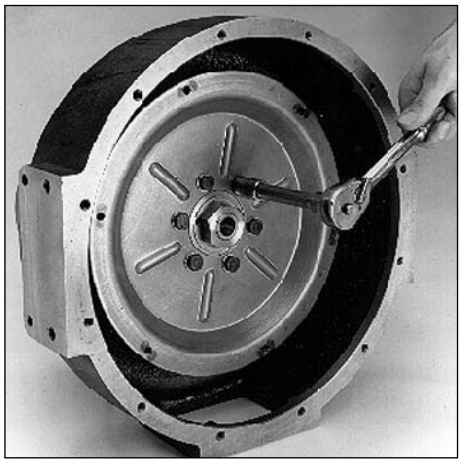
MLT 630 / 731 Turbo S.B-E2
MLT 634 / 731 Turbo LSU S.B-E2
MT 732 / 932 S.B-E2



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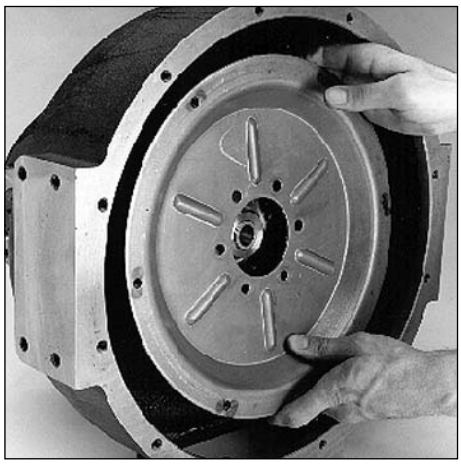
DISASSEMBLY



- 1 -

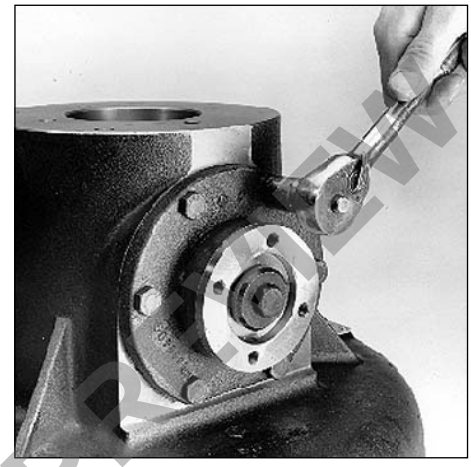
MAIN HOUSING DISASSEMBLY

- Remove 6 bolts retaining the drive plate. (17mm socket).



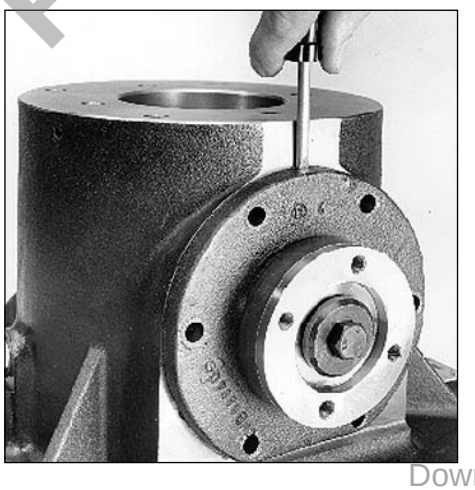
- 2 -

- Remove the drive plate.



- 3 -

- Remove 6 bolts retaining the input shaft housing (17mm socket).



- 4 -

- Separate the input shaft housing using the levering slots if required.

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- 40 -

- Lightly coat the flutings of the shaft with some fixing agent 649; Réf.- 562227.

- Refit the input flange and the elastic washer.
- Coat the screw threading of the 19MM screw, of brake net 243 Réf.187526, and refit it.

- **Torque : 95-120 Nm**



- 41 -

- Measure the torque, which must be comprised of between 1,1 et 2,2 Nm.

- If necessary adjust the shim pack to give correct torque.

- If one increases the value of the shim pack, the torque decreases.
- If one increases the value of the shim pack, the torque increases.

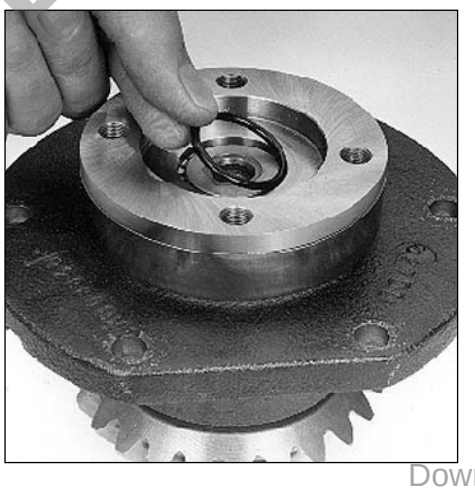


- 42 -

- When the correct shim pack has been found, remove the shaft.

- Assembly from the housing and using a suitable tool.

- Replace the input shaft oil seal to a depth of 1.5mm below the housing face.



- 43 -

- Rebuild as previously described.

- On final assembly fit the o-ring under the flange retaining washer and use stop threaded to secure the bolt (Ref. 187526).

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ANGLE GEAR BOX MAINTENANCE

RECOMMENDED LUBRICANTS

Oil used by MANITOU

Oil MANITOU Mechanical transmission for axles and box SAE 80W90

Capacity

2.5 l

For good lubrication and a good operating temperature, it is very important to use an specified oil and to maintain the correct lever.

Oil replacing

It is recommended to change the oil in the following working periods :

After first 50 hours services.

Every 800 hours max.

Many factors having an influence on the oil changing require to increase the oil changing frequency.

Oil level

The level must be checked with the oil gauge dipstick, the oil must be located between both mini. and maxi marks.

* Do not fill above the maxi. level , then this could lead to an increase in temperature, because of the oil splash lubrication by the drive gears (emulsion and destruction of oil). This could also provoke outer leaks.

The purpose of drains is also to eliminate metallic particles of intern components, these metallic particles being the result of normal use.

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REMONTAGE



- 32 -

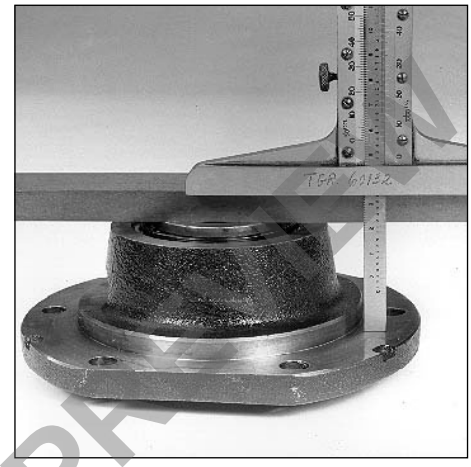
INPUT SHAFT REASSEMBLY

- Using suitable sized tubes, refit the bearing cups into the input shaft housing.



- 33 -

- Refit the inner bearing cone.



- 34 -

- Using suitable equipment measure the distance from the input housing mounting face to the rear of the inner bearing.

Measurement A :



- 35 -

- Using a suitable press refit the input gear to the shaft taking care to correctly align the woodruff key with the keyway.

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