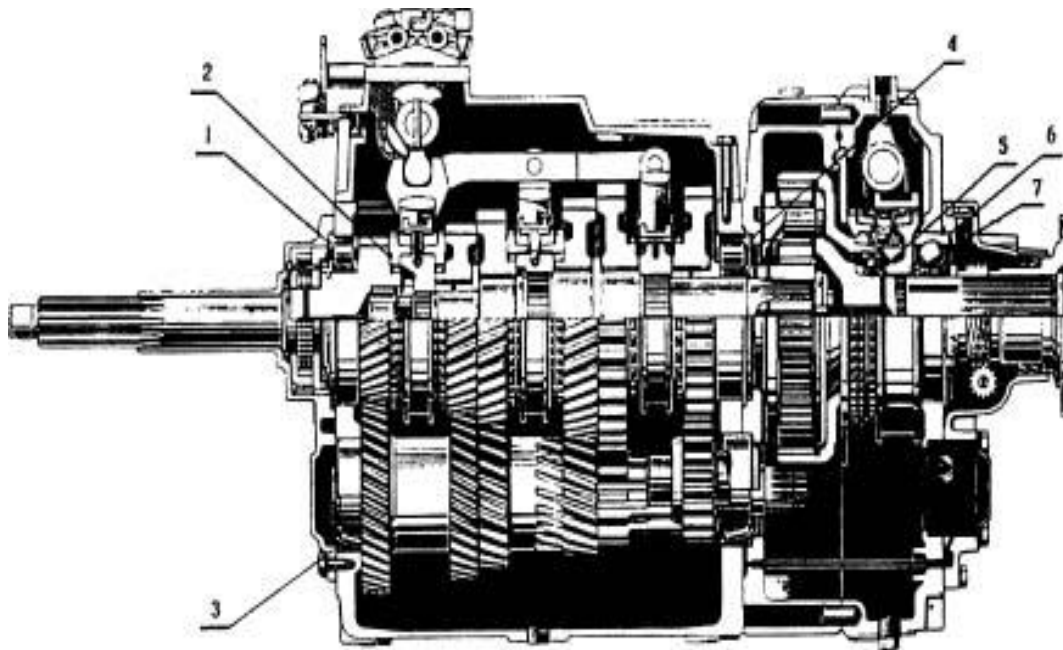




- **III. Assembling of the Gearbox**





Training Document

HOWO ZZ4257S3241V

- The assembling of the gearbox is divided into two parts, the assembling of the main gearbox and the assembling of the auxiliary gearbox. Basically, it is performed in the reverse procedures of the disassembling. Before assembling, take care to check whether the bearing, washers, the synchronizer components (especially the synchronizing cone and the conical ring), oil seals and adjusting washers meet the assembling criteria. If not, they should be replaced with new parts that meet the assembling criteria.
- As shown in the figure, the selection of the adjusting washers at all the locations has been explained clearly in the assembling procedures of the locations. It is necessary to perform the adjustment in light of the requirement.





Training Document

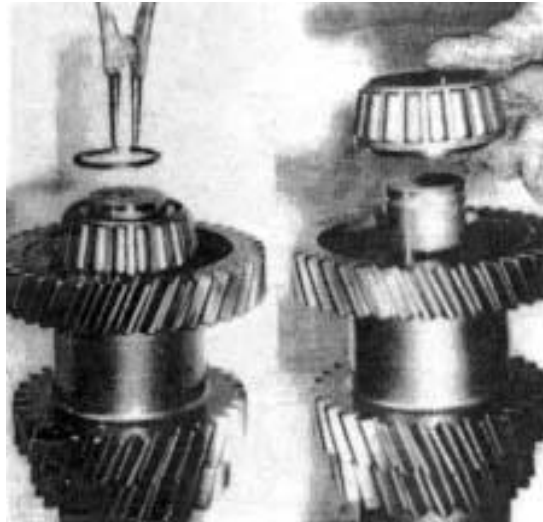
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- In the figure: 1—The washer for adjusting the axial clearance of the input shaft
- 2—The washer for adjusting the clearance of the 3rd -4th gear synchronizer
- 3—The washer for adjusting the axial clearance of the intermediate shaft
- 4—The washer for adjusting the axial clearance of the output shaft
- 5—The washer for adjusting the clearance of the auxiliary box synchronizer
- 6—The adjusting washer of the auxiliary box output shaft
- 7—The adjusting washer of the auxiliary box output shaft





- **1. Assembling of the main gearbox**
- Assemble the countershaft



- (1) Press all the countershaft gear on the intermediate shaft in sequence; make them lean against each other tightly without any axial clearance.