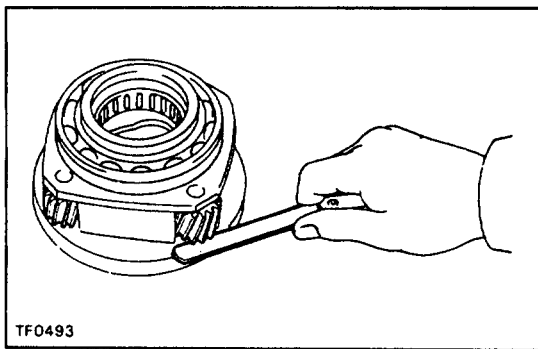
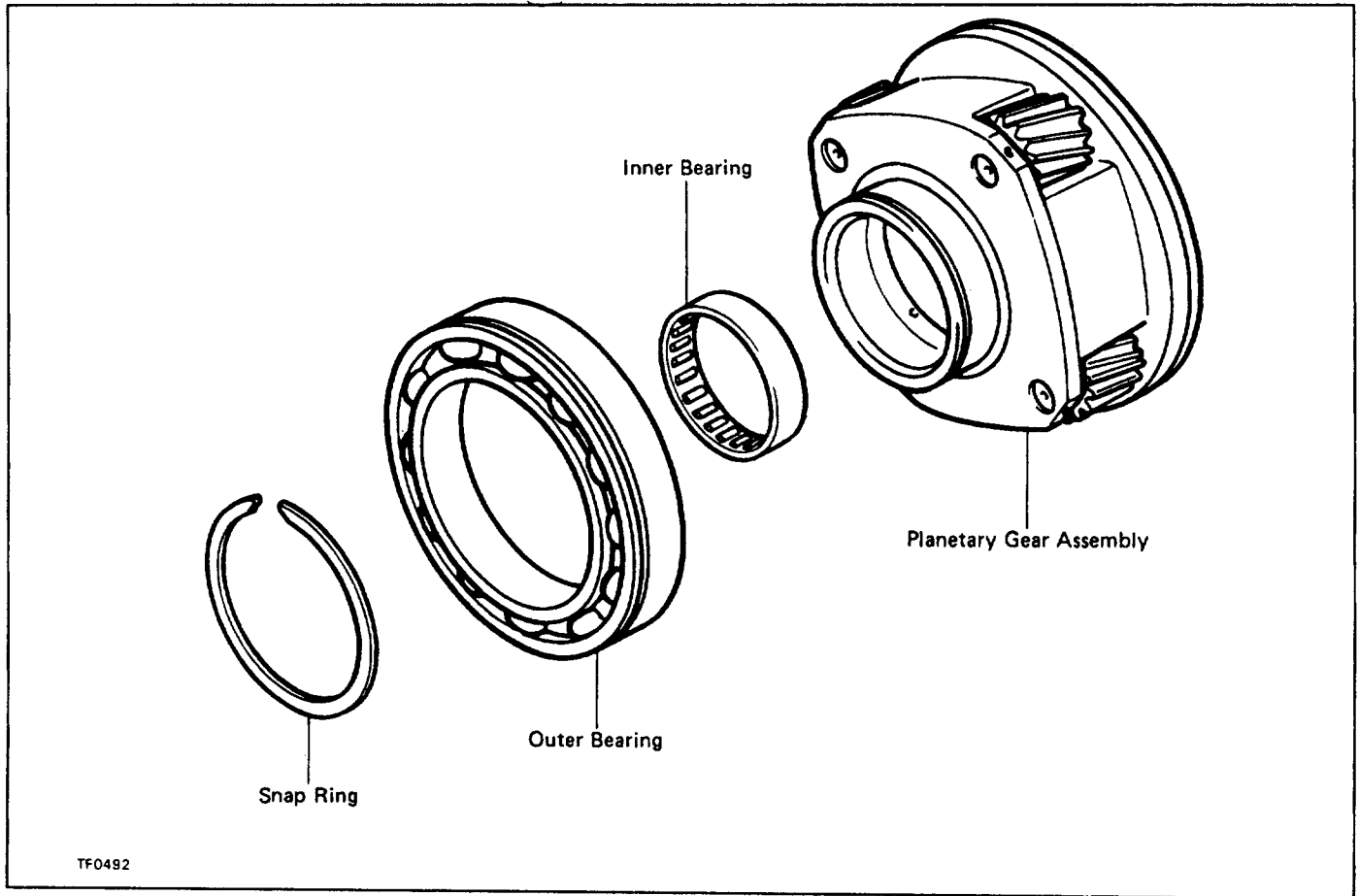


PLANETARY GEAR COMPONENTS



PLANETARY GEAR INSPECTION

1. MEASURE PLANETARY PINION GEAR THRUST CLEARANCE

Using a feeler gauge, measure the planetary pinion gear thrust clearance.

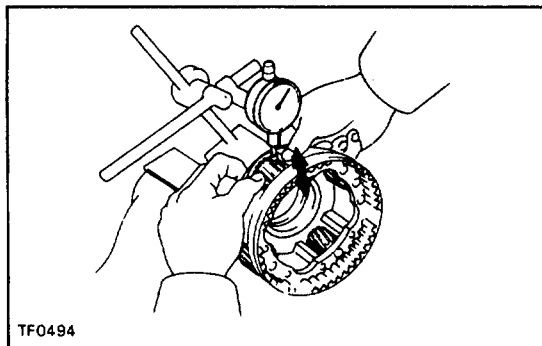
Standard clearance:

0.11–0.86 mm (0.0043–0.0339 in.)

Maximum clearance:

0.86 mm (0.0339 in.)

If the clearance exceeds the limit, replace the planetary gear assembly



2. CHECK RADIAL CLEARANCE OF PLANETARY PINION GEAR

Using a dial indicator, measure the radial clearance of the planetary pinion gear.

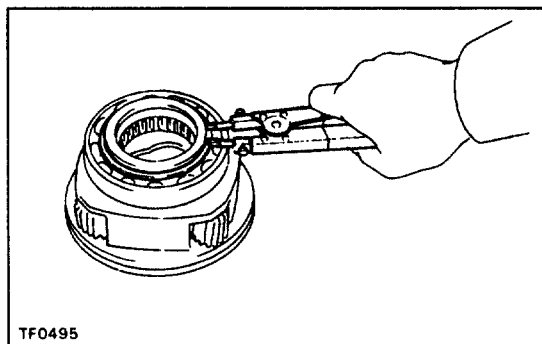
Standard clearance:

0.009–0.038 mm (0.0004–0.0015 in.)

Maximum clearance:

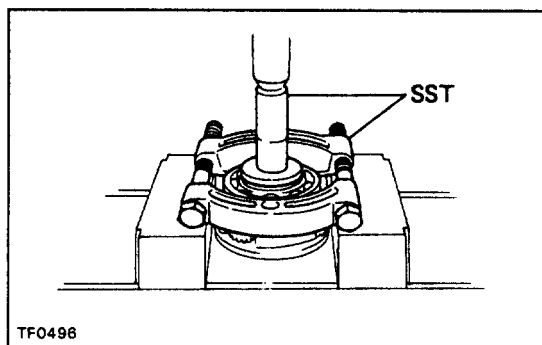
0.038 mm (0.0015 in.)

If the clearance exceeds the limit, replace the planetary gear assembly.

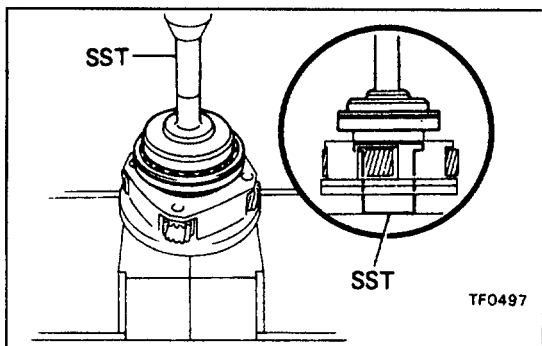


3. IF NECESSARY, REPLACE PLANETARY GEAR OUTER BEARING

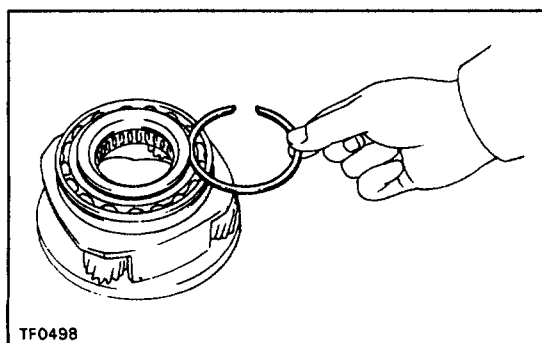
(a) Using a snap ring expander, remove the snap ring.



(b) Using SST and a press, remove the bearing.
SST 09554-30011, 09555-55010

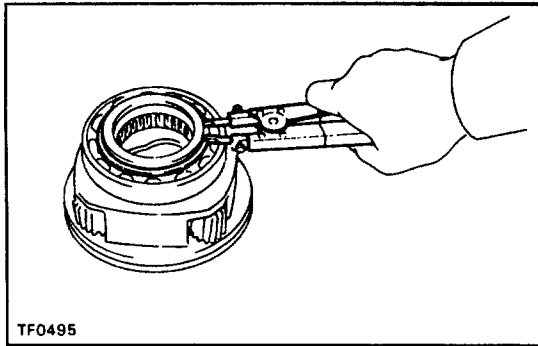


(c) Using SST and a press, install a new bearing with the outer race snap ring groove the front.
SST 09223-15010, 09515-30010

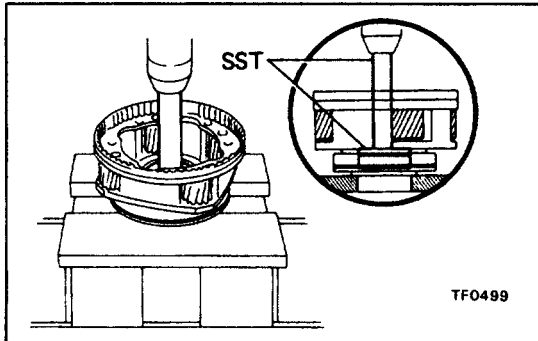


(d) Select a snap ring that will allow minimum axial play.

Mark	Thickness mm (in.)
1	1.45–1.50 (0.0571–0.0591)
2	1.50–1.55 (0.0591–0.0610)
3	1.55–1.60 (0.0610–0.0630)
4	1.60–1.65 (0.0630–0.0650)
5	1.65–1.70 (0.0650–0.0669)

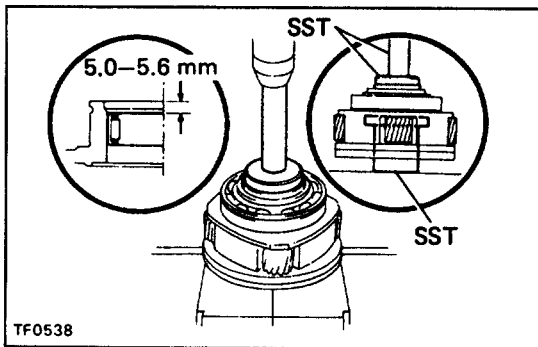


- (e) Using a snap ring expander, install the snap ring.



4. IF NECESSARY, REPLACE PLANETARY GEAR INNER BEARING

- (a) Using SST and a press, remove the bearing.
SST 09550-10012 (09252-10010, 09557-10010)



- (b) Using SST and a press, install a new bearing.
SST 09550-10012 (09252-10010, 09557-10010),
09515-30010

Bearing depth:

5.0-5.6 mm (0.197-0.220 in.)