

## INSPECTION

### 1. INSPECT PINION GEAR THRUST CLEARANCE

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

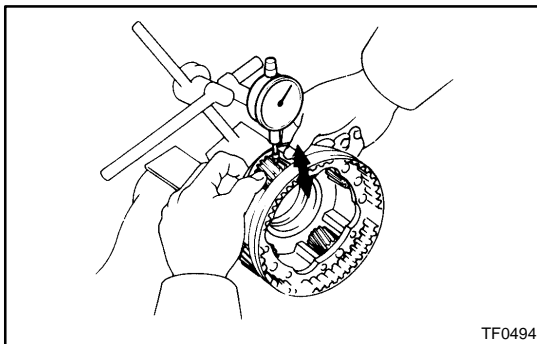
**Standard clearance:**

**0.11 to 0.84 mm (0.0043 to 0.0331 in.)**

**Maximum clearance:**

**0.84 mm (0.0331 in.)**

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



### 2. INSPECT PLANETARY PINION GEAR RADIAL CLEARANCE

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

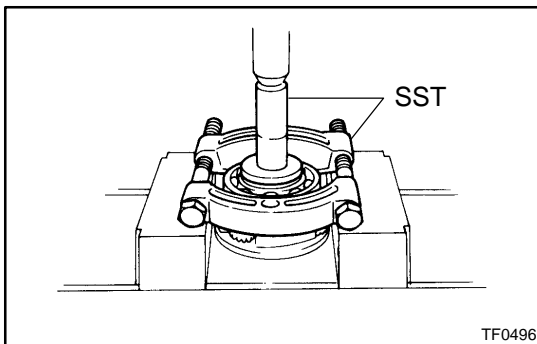
**Standard clearance:**

**0.009 to 0.038 mm (0.0004 to 0.0015 in.)**

**Maximum clearance:**

**0.038 mm (0.0015 in.)**

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

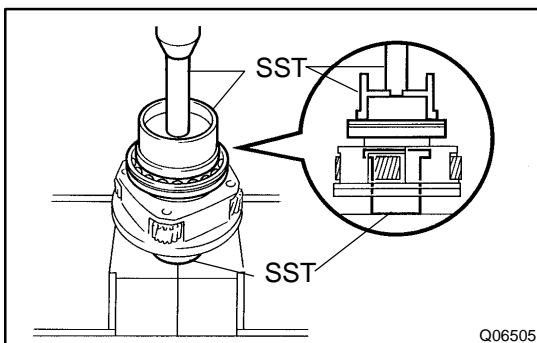


### 3. IF NECESSARY, REPLACE PLANETARY GEAR OUTER BEARING

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

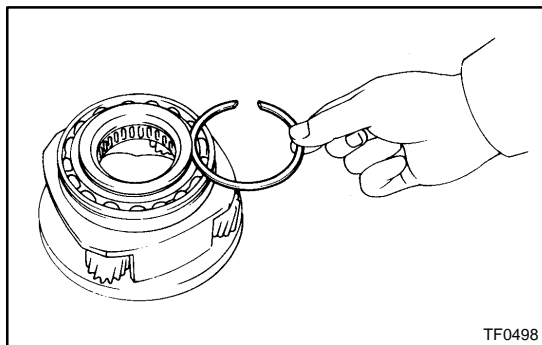
(b) Using SST and a press, remove the bearing.

SST 09554-30011, 09555-55010



(c) Using SST and a press, install a new bearing so that the groove does not face the planetary gear assembly.

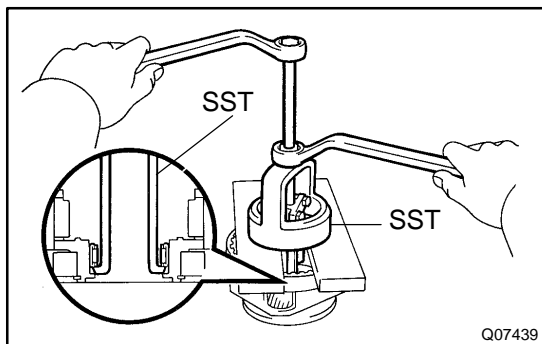
SST 09223-15020, 09515-30010, 09950-70010  
(09951-07100)



- (d) Select a snap ring that allows for minimum axial play.

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

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



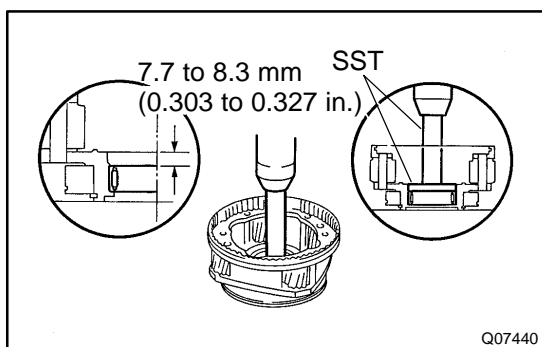
#### 4. IF NECESSARY, REPLACE PLANETARY GEAR INNER BEARING

- (a) Using SST, remove the bearing.

SST 09612-65014 (09612-01030, 09612-01050)

##### NOTICE:

Engage the claws of the SST securely so that there is no clearance between the inner bearing and planetary gear.



- (b) Using SST and a press, install a new bearing.

SST 09950-60010 (09951-00570), 09950-70010  
(09951-07100)

**Bearing press in depth:**

**7.7 to 8.3 mm (0.303 to 0.327 in.)**