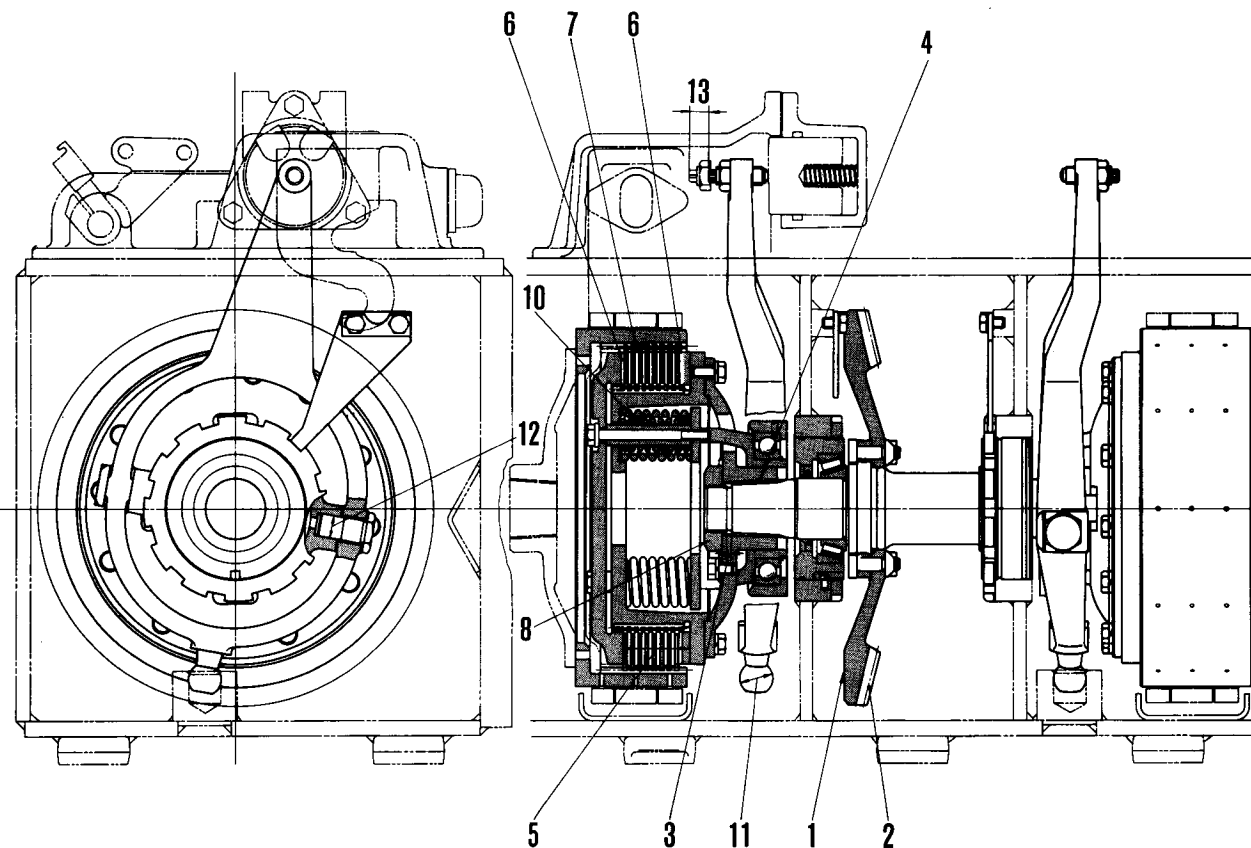


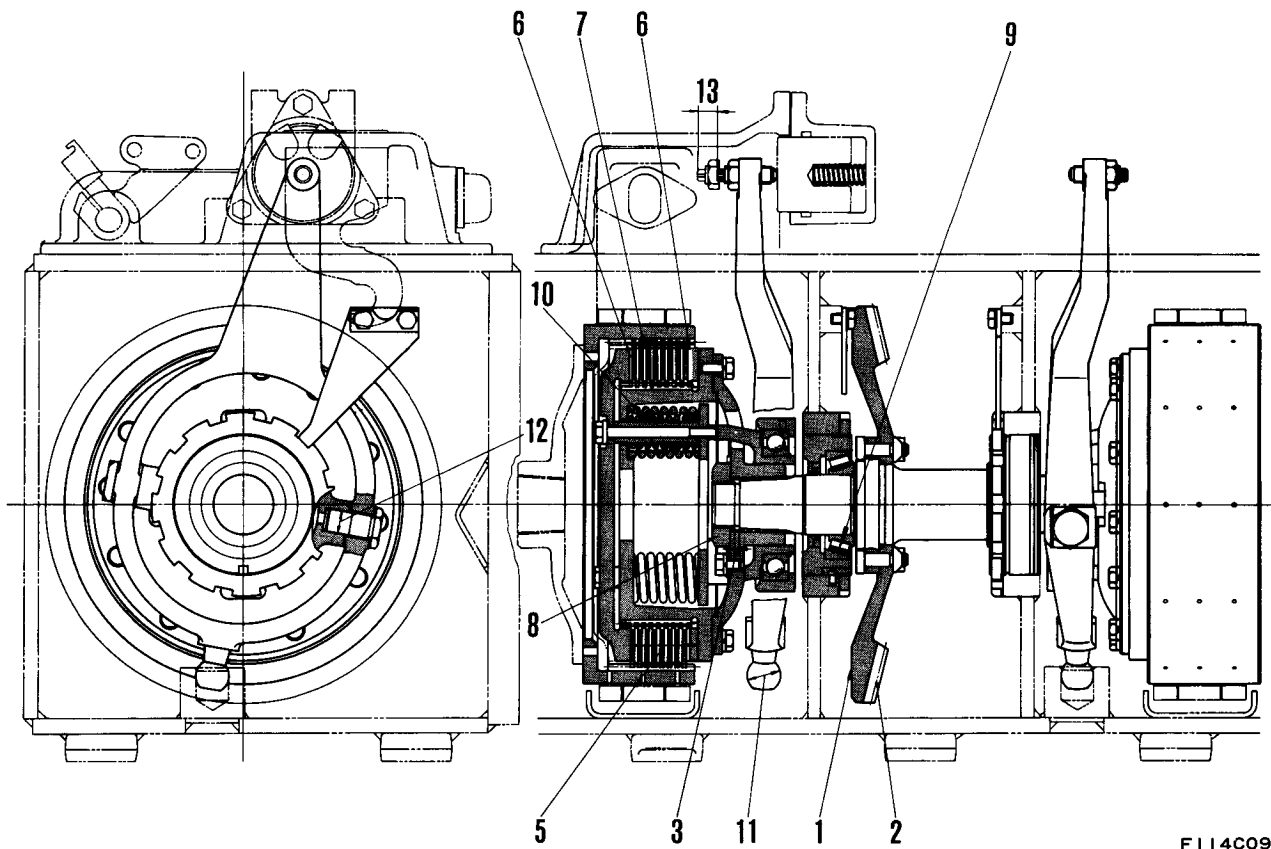
BEVEL GEAR SHAFT AND STEERING CLUTCH



F114C066

Unit: mm

No.	Check Item	Criteria		Remedy
1	Face runout of back face of bevel gear	Within 0.1mm: (With bevel gear shaft mount) (Face runout of bevel gear only; 0.08) Rectangularity of shaft flange: 0.02		Replace or repair. (Replace both the pinion and bevel gear as a unit, should either be in need of replacement.)
2	Backlash between bevel gear and pinion	Standard clearance 0.18 ~ 0.23	Clearance limit 0.18 ~ 0.30	
3	Dimension between bevel gear shaft hub and bevel gear shaft end face after press-fit	Standard size 8	Tolerance ± 0.7	Press-fitting again
4	Bevel gear shaft hub press-fitting pressure	4 ~ 12 ton		
5	Total thickness of 10 drive plates and 8 driven plates assembled in a steering clutch (at each side)	Standard size 63.8	Repair limit	Replace
6	Thickness of 1 drive plate A: 9 plates B: 1 plate	A: 2.6 B: 6.8	A: — B: 5.3	
	Distorsion of drive plate friction surface	0.3	0.3	
	Backlash between clutch drum and drive plate			

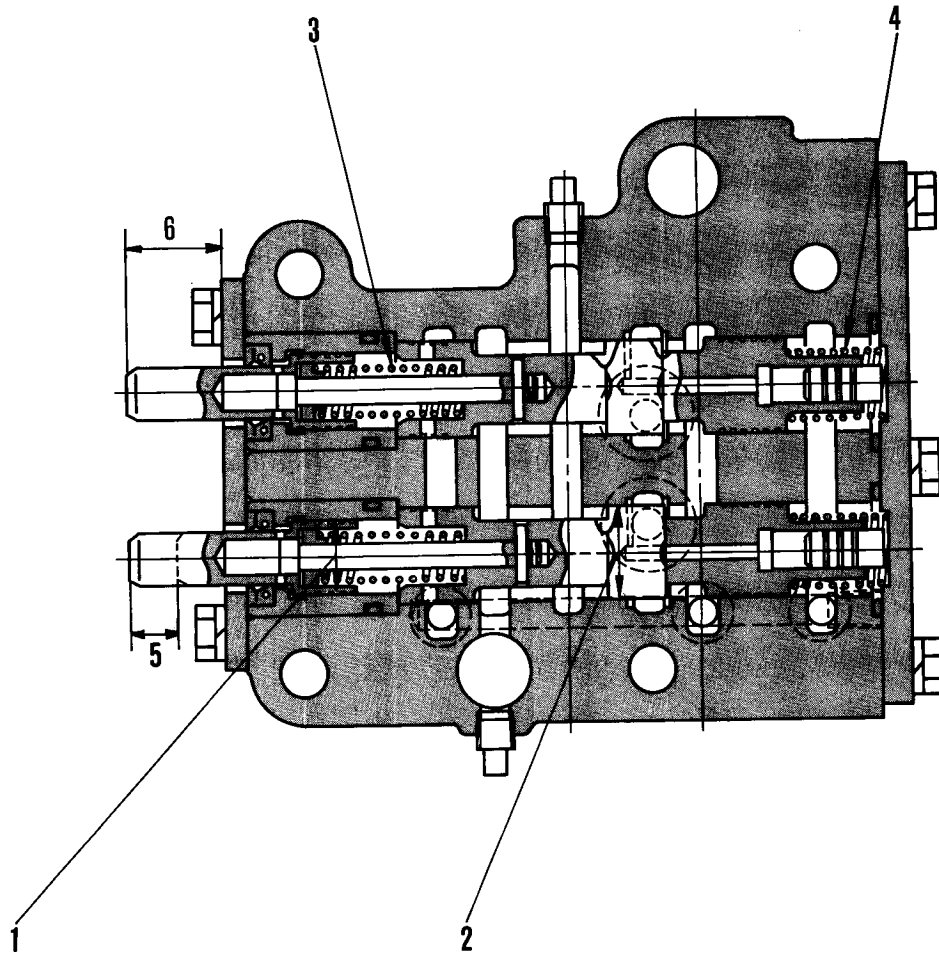


F114C096

Unit: mm

No.	Check Item	Criteria					Remedy
7	Thickness of 1 driven plate (8 plates in a set)	Standard size		Repair limit		Replace	
		4.2		3.5			
	Distorsion of driven plate frictional surfaces	Standard clearance		Clearance limit			
		0.2		0.3			
	Backlash between brake drum and driven plate						
8	Tightening torque of bevel gear shaft hub nut	35 ± 5 kg.m					Retighten or replace
9	Preload bevel gear and pinion	Bevel gear shaft turning torque: 0.14 ~ 0.24 kg.m (with pinion engaged)					Adjust
10	Steering clutch spring	Standard size			Repair limit		Replace
		Free length	Installed height	Installed load	Free height	Installed load	
		(Small)	94	65	70 kg	88	
	(Large)	97.6	65	130 kg	92	117 kg	
11	Clearance between yoke-ball and ball seat	Standard size	Tolerance		Standard clearance	Clearance limit	
			Shaft	Hole			
		30	-0.1 -0.2	+0.20 0	0.1 ~ 0.4	1	
12	Clearance between bearing cage and pin	20	-0.05 -0.07	+0.021 0	0.05 ~ 0.091	0.2	
13	Yoke travel	18					Adjust

STEERING CONTROL VALVE

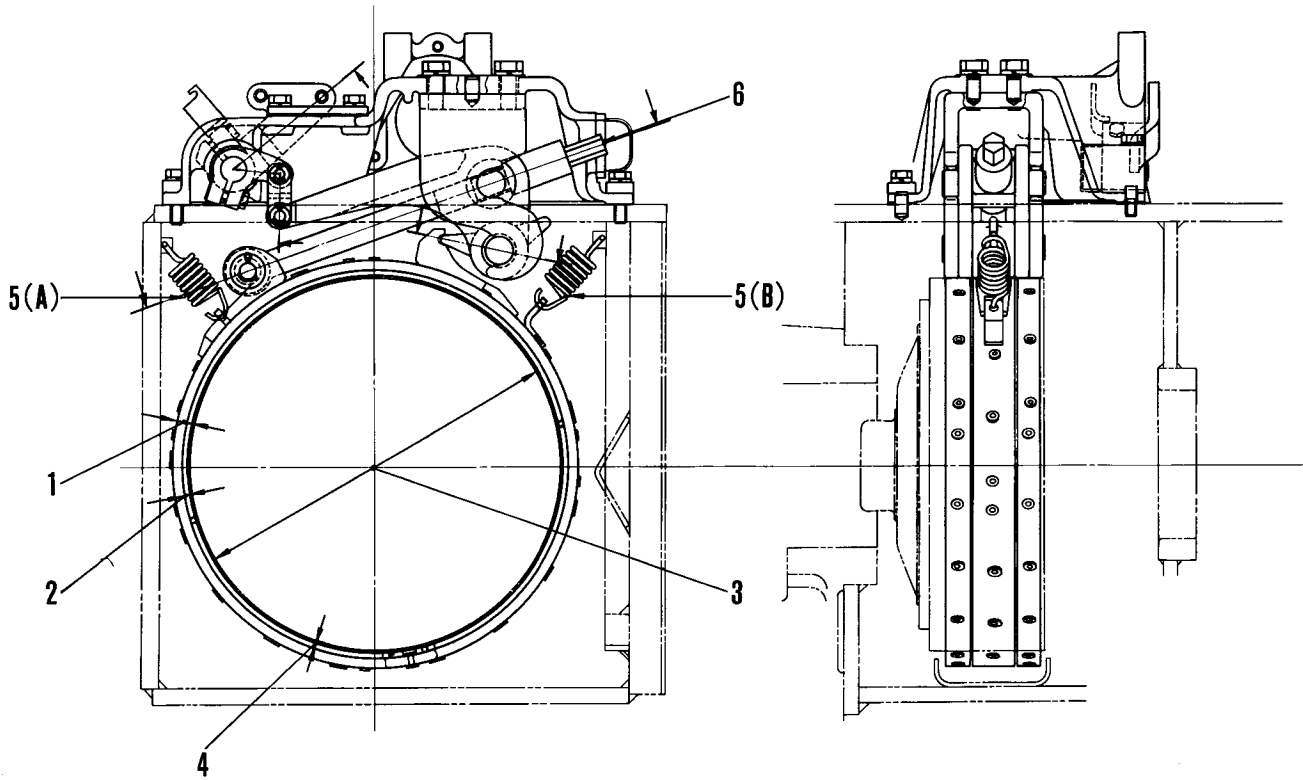


F114C067

Unit: mm

No.	Check Item	Criteria					Remedy
		Standard size	Tolerance		Standard clearance	Clearance limit	
1	Clearance between stem and collar		20	-0.035 -0.045			+0.013 0
2	Clearance between spool and valve body	25	-0.035 -0.045	+0.013 0	0.035 ~ 0.058	0.08	
3	Modulating valve spring	Standard size			Repair limit		
		Free length	Installed length	Installed load	Free length	Installed load	
		61	40	10.9 kg	-	-	
4	Spool return spring	71.4	25	3.25 kg	-	-	
5	Spool travel	Standard size			Repair limit		
		17					
6	Stem installed length	31.5			-		

STEERING BRAKE



114F036

Unit: mm

No.	Check Item	Criteria				Remedy	
		Standard size		Repair limit			
1	Assembled thickness of brake band and lining	Standard size		Repair limit		Replace lining	
		14		12			
2	Thickness of lining	6		4			
3	Outside diameter of brake drum	330				Repair or replace	
4	Lining to drum clearance	0.3				Adjust	
5	Brake band support spring	Standard size			Repair limit		Replace
		Free length	Installed length	Installed load	Free length	Installed load	
		A	72	77	8.7 kg	—	
B	72	76.5	8.2 kg	—	—		
6	Lining adjustment bolt	Tighten adjustment bolt to 4 kg.m and turn back 2.5 rotations.				Adjust	