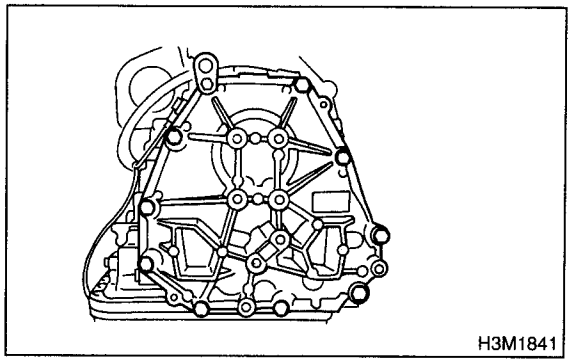
8. Transmission Cover S510640

A: REMOVAL S510640A18

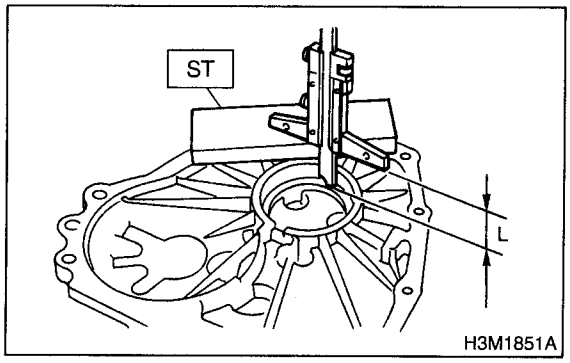
1) Remove transmission cover.



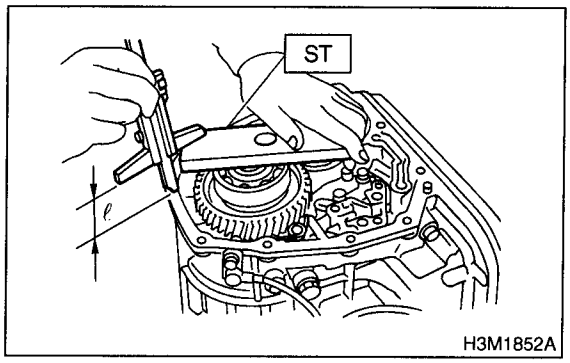
2) Take out shim from transmission cover.

B: INSTALLATION S510640A11

1) Measure distance L from end of transmission cover point at bearing location with ST.
ST 398643600 GAUGE
L = Measured value – 15 mm



2) Measure the distance "ℓ" from the transmission case mating surface to end of bearing with ST.
ℓ = Measured value – 15 mm
ST 398643600 GAUGE



3) Calculation equation:

NOTE:
Add 0.05 mm (0.0020 in) and 0.20 mm (0.0079 in) thick shims to area "T". Calculate formula 2 to determine "H". The calculated "H" refers to the shim thickness range. Select shims of suitable thicknesses within the calculated "H" range.

(0 to 6 teeth)
T = (L + G) – ℓ – H
T: Shim clearance
L: Distance from end of extension case to end of rear drive shaft
G: Gasket thickness [0.45 mm (0.0177 in)]
ℓ: Height from end of transmission case to end of reduction drive gear
H: Shim thickness
0.05 — 0.25 mm (0.0020 — 0.0098 in)

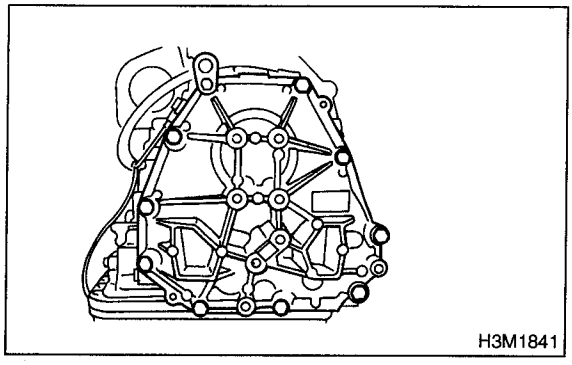
Adjusting shim	
Part No.	Thickness mm (in)
31288AA020	0.15 (0.0059)

4) Attach the selected adjusting shim to transmission cover.
5) Install the transmission cover to the transmission case.

CAUTION:
Be sure to use a new gasket.

6) Tighten bolts to secure the case.

Tightening torque:
25 N·m (2.5 kgf-m, 18.1 ft-lb)



C: INSPECTION S510640A10

Make sure that the transmission cover has no cracks.