

Fig. 1
Independent Spring Reverse Shaft (I.S.R.S.)

1) Oil Pan	11) Oil Pan	21) Bearing
2) Oil Seal	12) Oil Seal	22) Oil Seal
3) Bearing	13) Oil Ring	23) Gear
4) Gear Ring	14) Gear	24) Gear
5) Gear	15) Gear	25) Gear
6) Oil Ring	16) Gear	26) Gear
7) Bearing	17) Gear	27) Gear
8) Gear	18) Gear	28) Gear
9) Oil Pan	19) Gear	29) Gear
10) Oil Seal	20) Gear	30) Gear
31) Bearing	41) Gear	51) Gear
32) Oil Ring	42) Gear	52) Gear
33) Gear	43) Gear	53) Gear
34) Gear	44) Gear	54) Gear
35) Gear	45) Gear	55) Gear
36) Gear	46) Gear	56) Gear
37) Gear	47) Gear	57) Gear
38) Gear	48) Gear	58) Gear
39) Gear	49) Gear	59) Gear
40) Gear	50) Gear	60) Gear

Remove the Machine Assembly
from the Machine

Shaft Removal

- Remove the electrical control assembly by working around from back and forth with the engine shut down. Remove electrical connections from both ends of the reverse shaft. Remove hydraulic tubes leading from the back plate to the cylinders on the rear end shaft.
- Drain lubricant from the head gear case. Remove the gear case cover.

- Check up under the I.S.R. to verify shaft clutch drum and gear set it will stay in place when the shaft is removed.
- Remove the I.S.R. clutch drum and gear.
- Remove the shaft and the I.S.R. side of the machine. The left hand side bearing housing will be removed with the shaft. The I.S.R. bearing will remain in its bore. It may be necessary to tap on the head gear at the shaft to remove it into the oil pan portion of the shaft.

- To remove the I.S.R. side bearing housing, remove I.S.R. clutch drum and gear. Remove any ring (36). Remove bearing from its bore.

Reverse Shaft Reassembly

- Install bearing (21) in its bore. Bearing is oriented, and is installed with the shield to the inside. Install oil ring (36).
- Install gear (23) and ring (22) in place in bearing bore. Set clutch drum and gear in place. Check drum

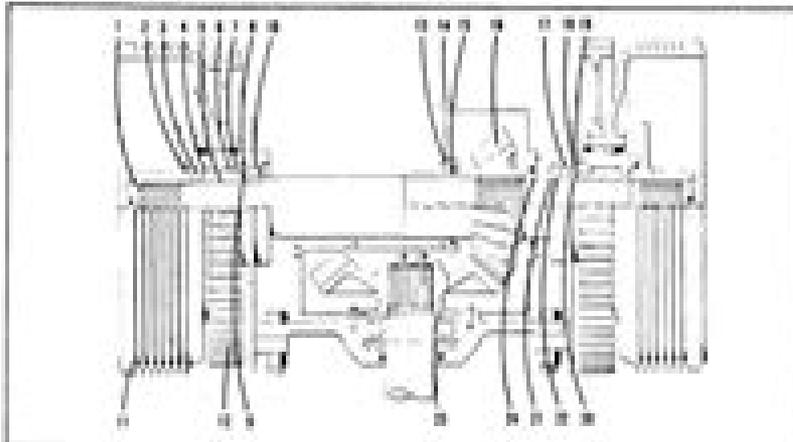


Fig. 2
Independent Spring Reverse Shaft (I.S.R.S.)

1) Oil Pan	11) Oil Pan	21) Bearing
2) Oil Seal	12) Oil Seal	22) Oil Seal
3) Bearing	13) Oil Ring	23) Gear
4) Gear Ring	14) Gear	24) Gear
5) Gear	15) Gear	25) Gear
6) Oil Ring	16) Gear	26) Gear
7) Bearing	17) Gear	27) Gear
8) Gear	18) Gear	28) Gear
9) Oil Pan	19) Gear	29) Gear
10) Oil Seal	20) Gear	30) Gear
31) Bearing	41) Gear	51) Gear
32) Oil Ring	42) Gear	52) Gear
33) Gear	43) Gear	53) Gear
34) Gear	44) Gear	54) Gear
35) Gear	45) Gear	55) Gear
36) Gear	46) Gear	56) Gear
37) Gear	47) Gear	57) Gear
38) Gear	48) Gear	58) Gear
39) Gear	49) Gear	59) Gear
40) Gear	50) Gear	60) Gear

and gear to hold them in place.

- Check condition of teeth on each side of head gear case. Remove if necessary.
- Install bearing (21) on shaft. Bearing is oriented and is installed with the shield to the inside.
- Slide the shaft through the I.S.R. bearing bore and start it through head gear case. Install head gear, oil ring, covers over shaft. Slide shaft completely into place. Adjust the head gear back-I.S.R. The head gear must be adjusted for full tooth contact, and 100% clearance, measured at the pitch line of the teeth. The head gear case is torqued into place and a single tooth mesh formed on the gear, and the tooth mesh turned to the other gear. The clearance measurement must be taken

with the shafts which were positioned between the two mesh points on the other gear. The clearance is adjusted by adding or subtracting shims behind the head gear on the reverse shaft in conjunction with adding or subtracting shims between the oil seal retainer and bearing housing at the bottom of the vertical spring center drive shaft. See line 4 for more information. The following shims are available for this adjustment.

Reverse Shaft

- Shim (31).....30 Saept
- Shim (32).....30 Saept
- Shim (33).....30 Saept
- Shim (34).....30 Saept
- Shim (35).....30 Saept
- Shim (36).....30 Saept
- Shim (37).....30 Saept
- Shim (38).....30 Saept
- Shim (39).....30 Saept
- Shim (40).....30 Saept
- Shim (41).....30 Saept
- Shim (42).....30 Saept
- Shim (43).....30 Saept
- Shim (44).....30 Saept
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- Shim (55).....30 Saept
- Shim (56).....30 Saept
- Shim (57).....30 Saept
- Shim (58).....30 Saept
- Shim (59).....30 Saept
- Shim (60).....30 Saept

- Remove the following shims and use the shim adjustment (31).....30 Saept Shim (31).....30 Saept Shim (32).....30 Saept Shim (33).....30 Saept Shim (34).....30 Saept Shim (35).....30 Saept Shim (36).....30 Saept Shim (37).....30 Saept Shim (38).....30 Saept Shim (39).....30 Saept Shim (40).....30 Saept Shim (41).....30 Saept Shim (42).....30 Saept Shim (43).....30 Saept Shim (44).....30 Saept Shim (45).....30 Saept Shim (46).....30 Saept Shim (47).....30 Saept Shim (48).....30 Saept Shim (49).....30 Saept Shim (50).....30 Saept Shim (51).....30 Saept Shim (52).....30 Saept Shim (53).....30 Saept Shim (54).....30 Saept Shim (55).....30 Saept Shim (56).....30 Saept Shim (57).....30 Saept Shim (58).....30 Saept Shim (59).....30 Saept Shim (60).....30 Saept
 - Install I.S.R. clutch assembly first, then install I.S.R. clutch assembly. Refer to SM5-1.3 for more information.
 - Connect all lines, lines, fittings, etc. Install head gear case cover plate.
- Fill head gear case with lubricant. Refer to Section 2 of Operators Manual for the proper type and amount of lubricant to use.
- Lubricate side bearing gear mesh as specified in Service Manual before operating machine.

Link Belt Service Manual

Joacim Rocklöv



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