

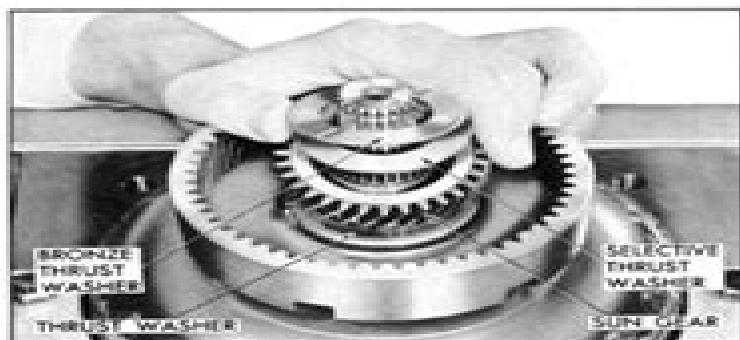


Fig. 167 Installing Sun Gear and Selective Washer for Front Unit End Clearance Check

2. Install front unit internal gear.
3. Install (black) steel thrust washer, needle bearing, and second (bright) steel thrust washer in recess of hub of internal gear.
4. Install snap ring in groove of driven torus shaft.
5. Slide front unit sun gear onto shaft of driven torus.
6. Lay a No. 1 (.046") steel selective washer (spacer) against sun gear followed by bronze thrust washer.
7. Install drive torus snap ring in groove on intermediate shaft next to bronze thrust washer.
8. Push intermediate shaft and sun gear firmly to rear of transmission (Fig. 165) to make sure all end play is taken up.



Fig. 168 Selecting Front Unit Spacer Using Special Tool

9. Push snap ring down against rear of groove and very carefully measure clearance between snap ring and bronze thrust washer using a set of feeler gauges (Fig. 165). **CAUTION:** The feeler gauge must be flat against the thrust washer to obtain an accurate reading.

10. Compare measurement found with feeler gauge with the chart in Fig. 164 to determine the correct selective spacer washer to use.

Example: If the feeler gauge measurement is .067", a No. 4 (.084"-.086") selective washer must be used to obtain the desired clearance of .020"-.035". This is determined by adding the mean thickness (.046") of No. 1 washer to gauge reading giving total thickness of .113". Then subtract thickness of No. 4 washer (.085"); this gives .028" which is within desirable clearance.

11. Remove snap ring, sun gear with bronze washer and steel selective spacer, snap ring, and internal gear with steel spacers and roller thrust bearing.

12. Remove front unit coupling.

SPECIAL TOOL METHOD

1. Rotate transmission to the vertical position with the intermediate shaft up.
2. Install front unit internal gear over coupling driven shaft (Fig. 166).
3. Install (black) steel washer needle bearing and second (bright) steel thrust washer over the coupling driven shaft and into recess in internal gear.
4. Install large snap ring over coupling driven shaft.
5. Install front unit sun gear with recessed side over snap ring (Fig. 167).



Fig. 169 Installing Servo and Accumulator Assembly

Hydra Matic Drive Pontiac Shop Manual

SJ Ball



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Table of Contents Hydra Matic Drive Pontiac Shop Manual

1. Understanding the eBook Hydra Matic Drive Pontiac Shop Manual
 - The Rise of Digital Reading Hydra Matic Drive Pontiac Shop Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Hydra Matic Drive Pontiac Shop Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Hydra Matic Drive Pontiac Shop Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Hydra Matic Drive Pontiac Shop Manual
 - Personalized Recommendations

- Hydra Matic Drive Pontiac Shop Manual User Reviews and Ratings
- Hydra Matic Drive Pontiac Shop Manual and Bestseller Lists
- 5. Accessing Hydra Matic Drive Pontiac Shop Manual Free and Paid eBooks
 - Hydra Matic Drive Pontiac Shop Manual Public Domain eBooks
 - Hydra Matic Drive Pontiac Shop Manual eBook Subscription Services
 - Hydra Matic Drive Pontiac Shop Manual Budget-Friendly Options
- 6. Navigating Hydra Matic Drive Pontiac Shop Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Hydra Matic Drive Pontiac Shop Manual Compatibility with Devices
 - Hydra Matic Drive Pontiac Shop Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Hydra Matic Drive Pontiac Shop Manual
 - Highlighting and Note-Taking Hydra Matic Drive Pontiac Shop Manual
 - Interactive Elements Hydra Matic Drive Pontiac Shop Manual
- 8. Staying Engaged with Hydra Matic Drive Pontiac Shop Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Hydra Matic Drive Pontiac Shop Manual
- 9. Balancing eBooks and Physical Books Hydra Matic Drive Pontiac Shop Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Hydra Matic Drive Pontiac Shop Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Hydra Matic Drive Pontiac Shop Manual
 - Setting Reading Goals Hydra Matic Drive Pontiac Shop Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Hydra Matic Drive Pontiac Shop Manual
 - Fact-Checking eBook Content of Hydra Matic Drive Pontiac Shop Manual

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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