

## Assembly

- Replace all seals and seal rings with new ones each time you reassemble the wheel motor. Lubricate all seals and seal rings with SAE 10W-40 oil or clean grease before assembly.
- **NOTE: Individual seals and seal rings as well as a complete seal kit are available.**
- **NOTE: Unless otherwise indicated, do not oil or grease parts before assembly.**
- Wash all parts in clean petroleum-based solvents before assembly. Blow them dry with compressed air.

1) If the housing (18) bearing components were removed for replacement, thoroughly coat and pack a new outer bearing (19) with clean corrosion resistant grease. Press the new bearing into the counterbore at the mounting flange end of the housing, using the appropriate sized bearing mandrel, (**Grasshopper PN 885288**) which will control the bearing depth. These housings require the use of the bearing mandrel to press the bearing (19) into the housing to a required depth of .290/.310 inches (7.37/7.87 mm) from the outside end of the bearing counterbore. **Figure 20**

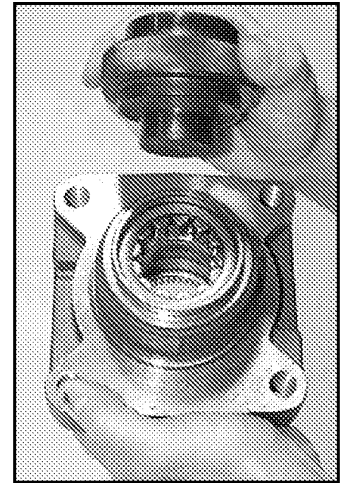


Figure 20

**NOTE: Bearing mandrel must be pressed against the lettered end of bearing shell. Take care that the housing bore is square with the press base and the bearing is not cocked when pressing the bearing into the housing.**

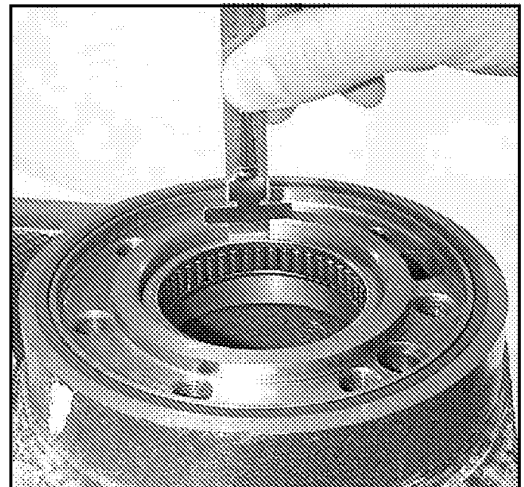


Figure 21

**CAUTION: If the bearing mandrel specified is not available and alternate methods are used to press in the outer and inner coupling shaft bearings (13 & 19) as specified. The specified depths must be achieved to insure adequate bearing support and correct relationship to adjacent components when assembled. Figure 21**

**CAUTION: Because the inner and outer coupling shaft bearings (13 & 19) have a press fit into the housing, they must be discarded when removed. They must NOT be reused.**