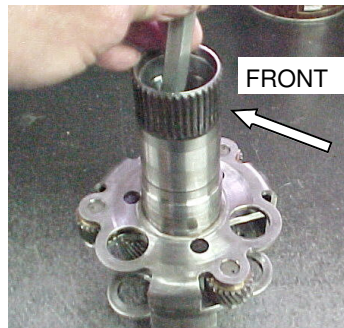
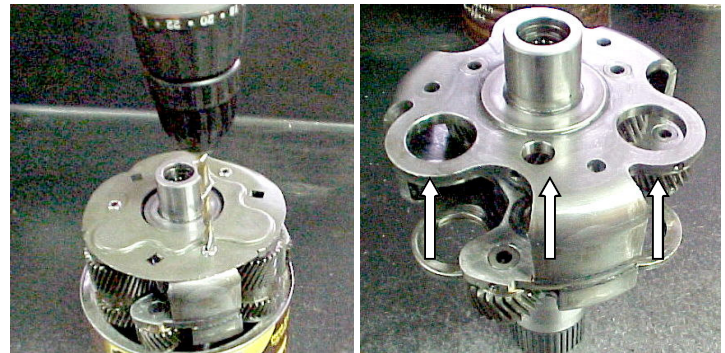
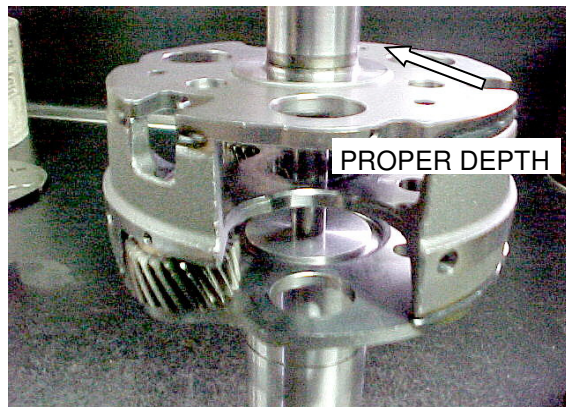
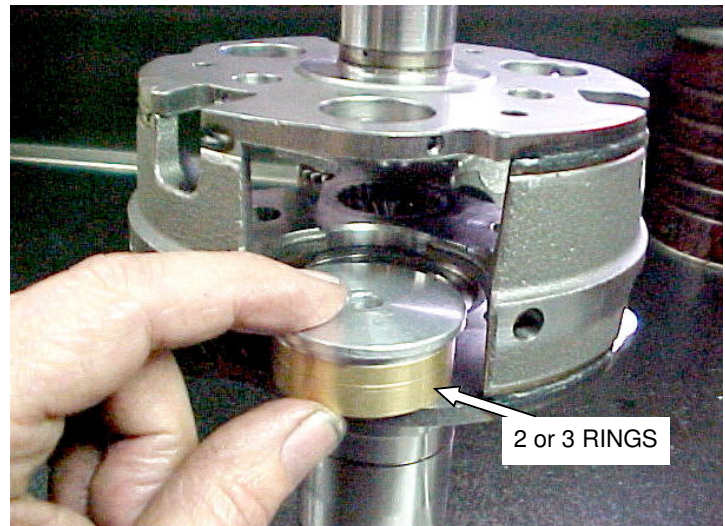


This planetary unit must be disassembled to install bushings for the OD/reverse hub.

1. Using a 1/4" drill bit, drill out the three rivets on the rear plate and remove the plate.
2. Remove the lock pin from 2 of the large planet gears and the small planet gear between them, as shown. Lock pins and shafts are slip fit and come out easily.
3. Remove the two sun gears and radial thrust washers. No further disassembly is required.
4. With a long bushing cutter, remove the bushing closest to the sun gear and then remove the front bushing near the front splines.
5. The outside of the replacement bushings have identification rings. The single ring bushing goes into the **front** position.
6. The difficult one near the sun gear must be installed from the rear. Use tool #98325 to install **the bushing which has 2 rings. BE SURE TO USE THE 2 RING BUSHING FIRST.** Bottoming out the tool indexes the bushing at the proper depth.
7. Check the fit by inserting the OD/REV hub. If the fit is too tight, remove the 2 ring bushing and install the one with 3 rings. Check the fit again. The planetary housings vary enough to mandate select fit bushings.
8. When the OD/REV hub fits properly, reassemble the planets into the carrier. Don't try to reinstall either of the two large planetary gear pins until both planetary gears index with the sun gear. Be sure the little shaft locks are still in place and put the back plate on with POP rivets.



Single ring bushing will install at arrow (left)



Your feedback is welcome on all our products!

Omega Machine & Tool, Inc.
 "Precision and Innovation for Today"

Tel. 800 601 7722 – Fax 916 372 6020
 www.omegachine.com