

Fig. 1  
Independent Spring Reverse Shaft (SARS)

1) Oil Seal	11) Oil Seal	21) Bearing
2) Oil Seal	12) Oil Seal	22) Oil Seal
3) Bearing	13) Oil Seal	23) Oil Seal
4) Snap Ring	14) Oil Seal	24) Snap Ring
5) Gear	15) Oil Seal	25) Oil Seal
6) Snap Ring	16) Oil Seal	26) Gear
7) Bearing	17) Oil Seal	27) Bearing
8) Gear	18) Oil Seal	28) Snap Ring
9) Oil Seal	19) Oil Seal	29) Oil Seal
10) Oil Seal	20) Gear	

**Notes for Service Personnel**  
 1. Do not use any oil.

**Clutch Assembly**

- Remove the clutch control pressure by working control lever back and forth with the engine shut down. Remove clutch adjustment from both ends of the reverse shaft. Remove hydraulic tubes bearing from the back plates to the clutches on the rear end shaft.
- Grease lubricate from the back gear case. Remove the gear case cover.

- Check up under the R.A. reverse shaft clutch disk and gear so it will stay in place when the shaft is removed.
- Remove the L.A. clutch disk and gear.
- Remove the shaft and the L.A. side of the machine. The left hand side bearing bearing will be removed with the shaft. The R.A. bearing will remain in its bore. It may be necessary to tap on the back gear of the shaft to remove it into the oil pan bottom of the shaft.

- To remove the R.A. side bearing bearing, remove R.A. clutch disk and gear. Remove snap ring (18). Remove bearing from its bore.

**Reverse Shaft Adjustment**

- Install bearing (11) in its bore. Bearing is oriented, and is installed with the shaft to the motor. Install snap ring (18).
- Install gear (26) and shim (22) in place in bearing bore. Set clutch disk and gear in place. Check that

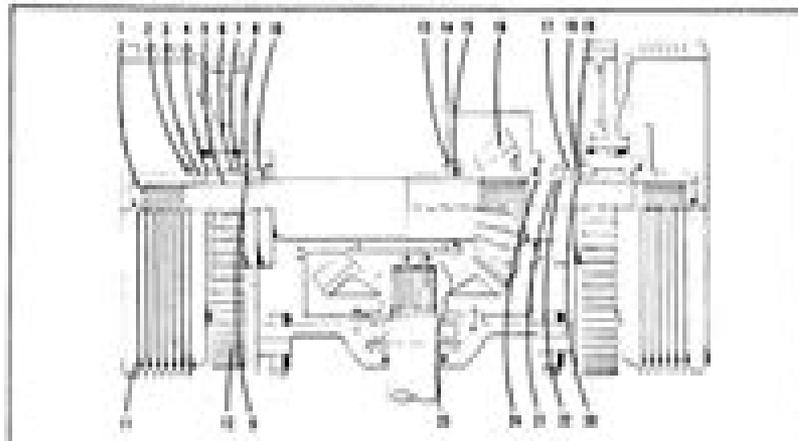


Fig. 2  
Independent Spring Reverse Shaft (SARS)

1) Oil Seal	11) Oil Seal	21) Bearing
2) Oil Seal	12) Oil Seal	22) Oil Seal
3) Bearing	13) Oil Seal	23) Oil Seal
4) Snap Ring	14) Oil Seal	24) Snap Ring
5) Gear	15) Oil Seal	25) Oil Seal
6) Snap Ring	16) Oil Seal	26) Gear
7) Bearing	17) Oil Seal	
8) Gear	18) Oil Seal	
9) Oil Seal	19) Oil Seal	
10) Oil Seal	20) Gear	

- and gear to hold them in place.
- Check condition of teeth on each side of back gear case. Replace if necessary.
- Install bearing (11) on shaft. Bearing is oriented and is installed with the shaft to the motor.
- Slide the shaft through the L.A. bearing bore and start it through back gear case. Install back gear, shim, spacer over shaft. Slide shaft completely into place. Adjust the back gear back-L.A. The back gear must be adjusted for full tooth contact, and 100% clearance, measured at the pitch line of the teeth. The back gear case is torqued into place and a single tooth mesh formed on the gear, and the back gear turned to the other gear. The clearance measurement must be taken

with the shafts which were positioned between the back gear teeth on the other gear. The clearance is adjusted by adding or subtracting shim behind the back gear on the reverse shaft in conjunction with adding or subtracting shim 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 notes are available for this adjustment.

**Reverse Shaft**

- Install bearing (11) back vertical center drive shaft (11) bearing (11) back
- Slide R.A. side bearing gear alignment with its bearing gear. There should be full tooth contact. If not, add or subtract shim as necessary to achieve full tooth

- contact. The following notes are used for this adjustment: 1) Snap bearing (11) and shim (22). Install L.A. clutch disk and gear. Check gear alignment and shim if necessary. Refer to line 17.
  - Install R.A. clutch assembly first, then install L.A. clutch assembly. Refer to SM5-1.3 for more information.
  - Connect all lines, hoses, fittings, etc. Install back gear case cover plate.
- Fill back 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 case as specified in Service Manual before operating machine.

# Link Belt Service Manual

**AW Rasmussen**



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