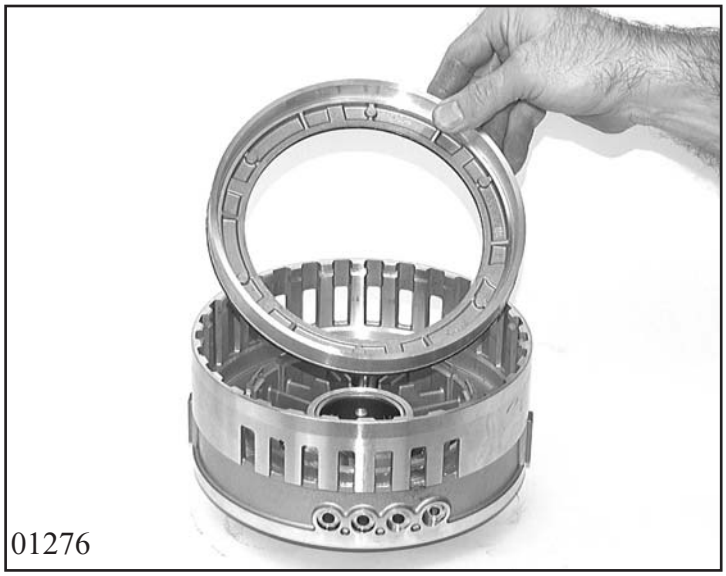
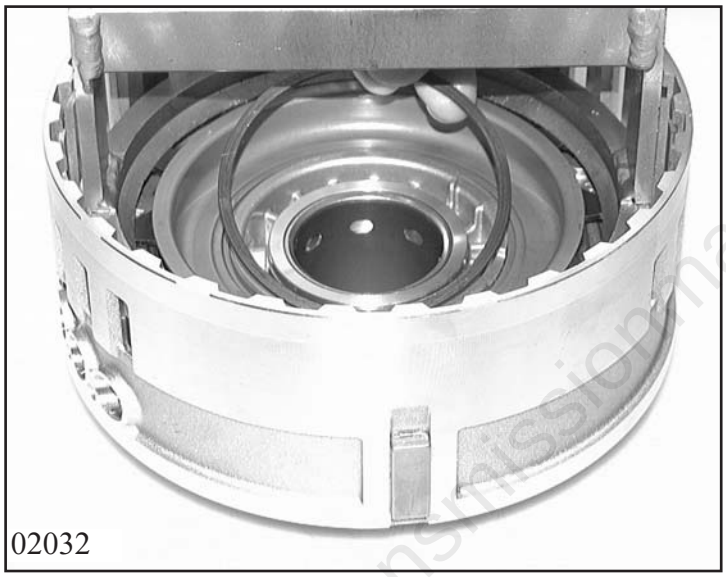


01276

Turn cylinder CD by 180°.
Pull 2 O-ring seals 75.040 and 75.050 onto piston C 75.030 and press it into the cylinder.



02032

Insert cup spring C 75.070 and retaining ring 75.080.
Press down cup spring C in the mandrel press with assembly bracket 5x46 001 501 and secure with snap ring 75.084.



01281

Insert complete clutch pack C into cylinder CD, starting with spring disk 75.100.
Then insert an outer disk 75.140 and a lined disk 75.120 alternately.
Secure the top outer disk 75.160 with snap ring 73.180.

Note:
For adjusting work see **Chapter 1.4.2**

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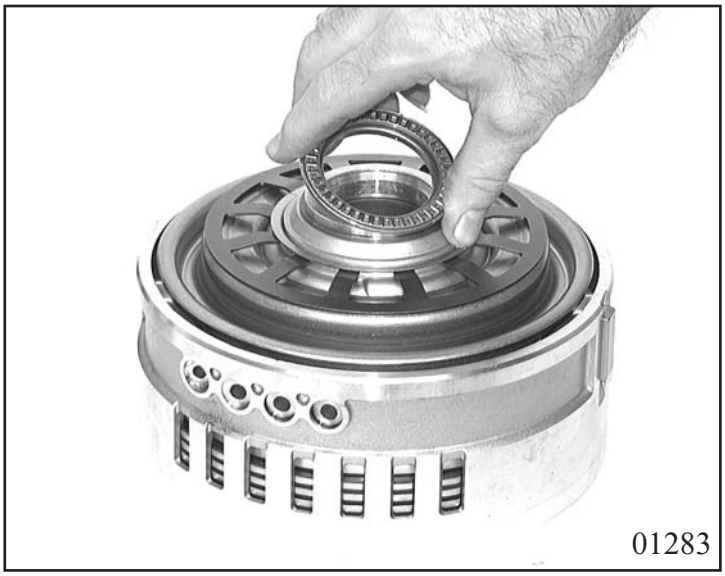
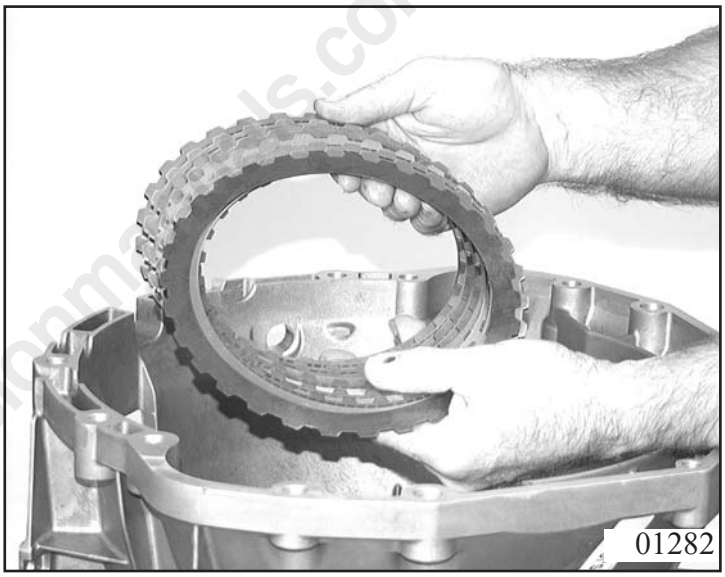
Turn cylinder CD and clip axial needle bearing 73.320 into position at the cylinder web (brake D side).

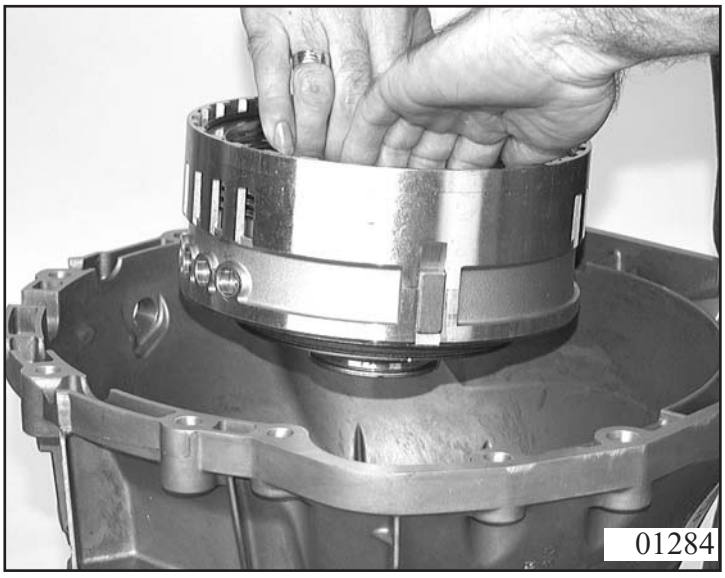


Insert complete clutch pack D into housing, starting with final disk 73.260, then insert lined disk 73.250 and external disk 73.240 alternately.
Complete with spring disk 73.230.



Note:
For adjusting work see **Chapter 1.4.3**

Insert complete cylinder CD in transmission housing.



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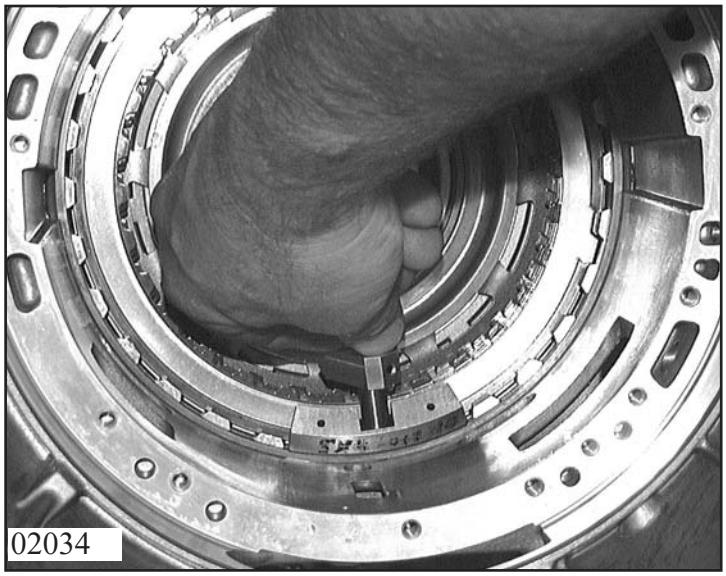
02034

Secure with snap ring 73.210.
Use driving-in tool 5x46 001 930 to drive the snap ring into the housing groove all round.

Note
Dismount the handle of the tool for a better usibility.

[redacted]

[redacted]

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