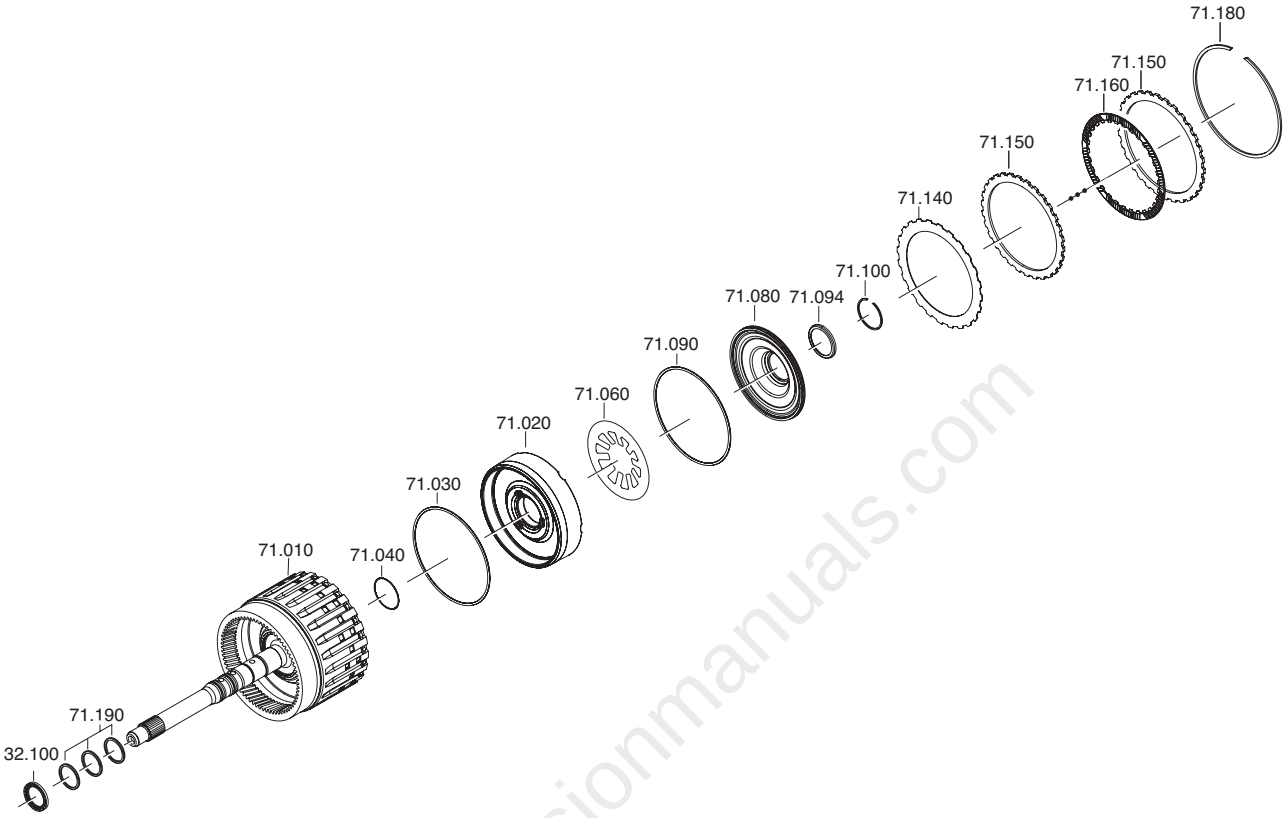
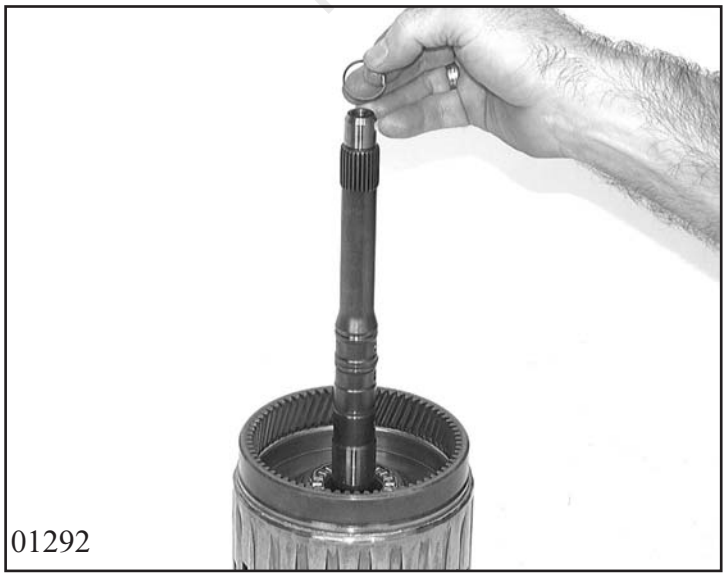
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3.5 Turret (drive with clutches A and E)
3.5.1 Clutch E (drive)

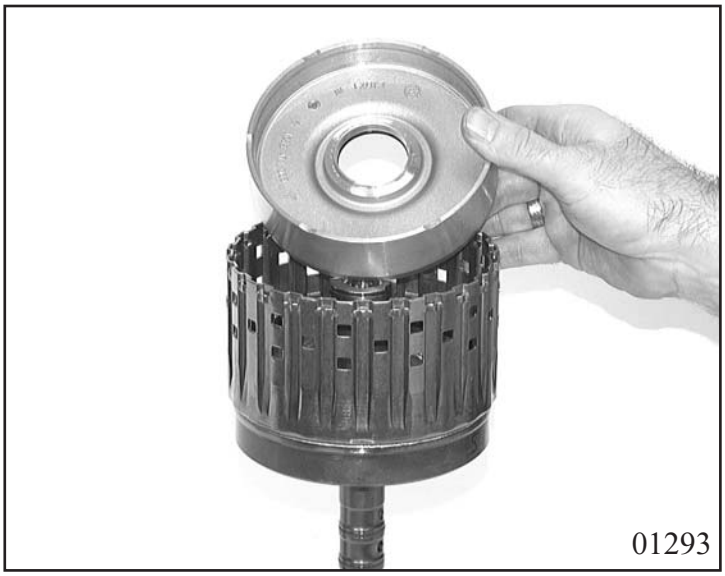


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Pull 3 new rectangular-section rings 71.190 onto cylinder E 71.010 with input shaft.
Clip axial needle roller bearing cage 32.100 into cylinder (ring gear side).

Pull new seal rings 71.030 and 71.040 onto piston E 71.020.
Press piston E into cylinder E.

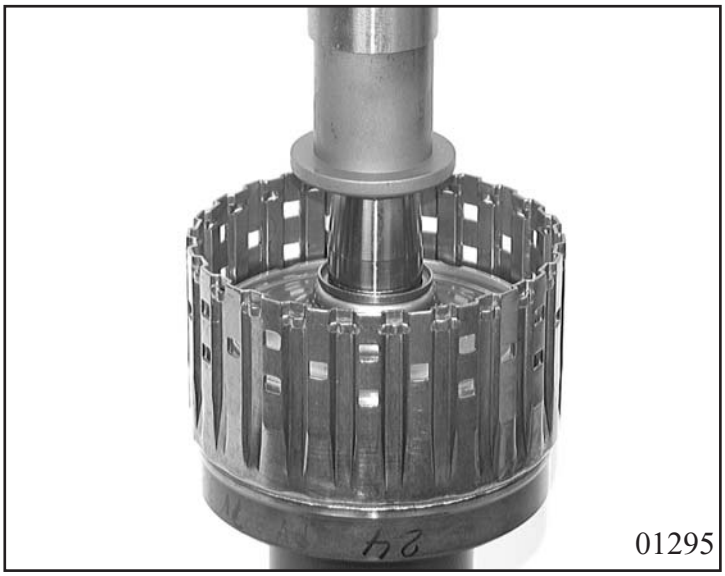


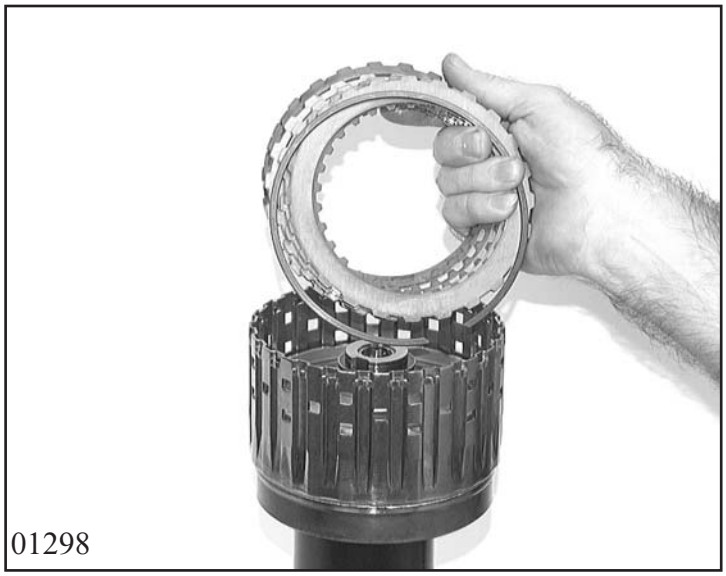
Pull new O-ring seal 71.090 onto baffle plate 71.080. Insert cup spring 71.060 into cylinder E with the projections facing downwards and press in the baffle plate.



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Insert angular plate 71.094 with groove facing upwards.
Attach assembly tool 5x46 002 571 and push on snap ring 71.100. Press down tube section 5x46 002 571 with snap ring and cup spring in the mandrel press until the snap ring engages in the slot.





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Insert complete clutch pack E. Start with spring disk 71.140, then insert outer disk 71.150 and lined disk 71.160 alternately. Insert final disk 71.150 and secure with snap ring 71.180.

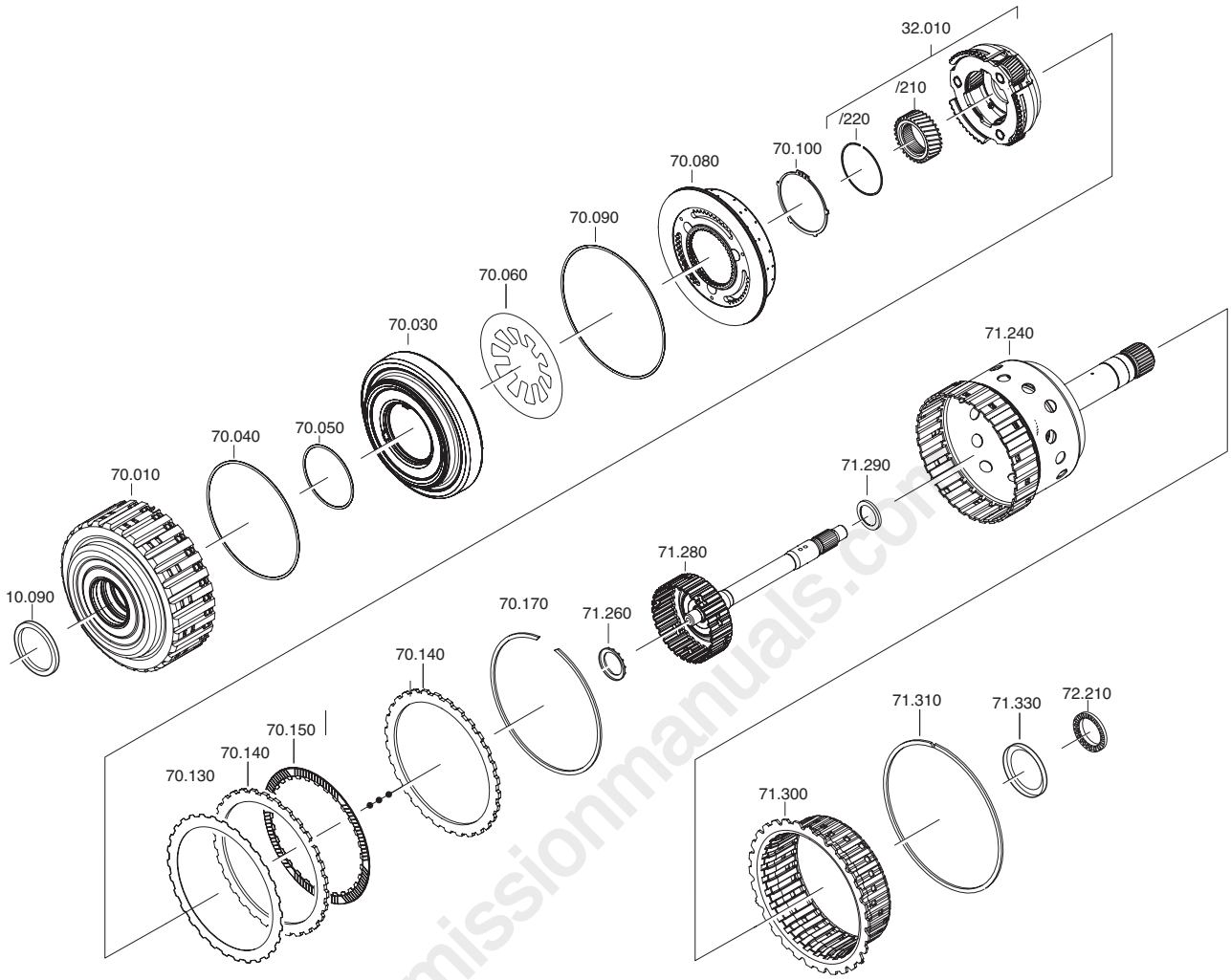
Note:
For adjusting work, see **Chapter 1.4.5**

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3.5.2 Clutch A (input)



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