Form No.	Issue Date	Rev. Date
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K 547–1

Y Series Transmissions Shim and Gasket Kit

Consists of the following:

Part Number	Description	Quantity
51065	Gasket – oil seal housing	1
51633–5	Shim – coupling shaft housing, .005 in. thick, (blue)	1
51633–7	Shim – coupling shaft housing, .007 in. thick, (natural)	1
51633–10	Shim – coupling shaft housing, .010 in. thick, (brown)	3
51709	Gasket – oil filter adapter	1
51727	Gasket – oil pump	1
51729–5	Shim – bearing housing, .005 in thick, (blue)	1
51729–10	Shim – bearing housing, .010 in. thick, (brown)	3
52509	Gasket – shift cover	2
53402	Tool – Pin Insertion	1
71638	Gasket – drive shaft housing	1
V 3160	Nut – Self Locking, 1–1/4”	2
V 3181	Washer – Plain, 1–1/4” H.T.	2
W 3704–2	O–ring, 1/4 x 3/8 in.	1
W 3714–2	O–ring, 7/8 x 1 in.	1
W3776–4	O–ring, 4–3/4 x 5	1
W33002–5	Pin – Spirol, Hvy, 1/16 x 5/16 in.	2

Shimming Instructions

Coupling Shaft Housing (.005 – .010 Axial Float) – See Figure 1

1. Install the coupling shaft and housing assembly with no shims.
2. Snug up cap screws evenly.
3. Lightly tap on end of the coupling shaft with a soft mallet to force the driveline forward.
4. Loosen screw and hold housing against case with hand pressure.
5. Measure gap between housing and case in several places. The gap thickness plus .005" is the minimum amount of shims to select.
6. Remove housing. Apply RTV sealant to shims and then reinstall housing with shims between the face of the housing and case. Install and tighten screws. Use cap screws with sealant on lower half.
7. Check driveline assembly to assure that axial float exists, either with an indicator or by feel. If in doubt, add an additional .005" shim.

Shimming Instructions

Bearing Housing (Driven Shaft) (.005 – .010 Axial Float) – See Figure 1

1. Assemble shaft, bearings, etc. with chain case cap. Leave oil pump off.
2. Lightly tap on sprocket end of the shaft with soft mallet to move shaft forward against oil seal housing.
3. Fit pilot of bearing housing into bore of the chain case cap (less shims) until it contacts face of outer race of the bearing.
4. While holding housing in position, measure gap between face of housing and cap with feeler gage in several places. This gap thickness plus .005" is the minimum amount of shims to select.
5. Remove housing. Apply RTV sealant to shims and reinstall housing with shims between face of the housing and chain case cap. Install and tighten screws.
6. Check to assure that axial float exists either with an indicator or by feel. If in doubt, add and additional .005" shim.
7. Install oil pump.

NOTE: Some gaskets and shims in this kit may not be used when repairing the chain case.

NOTE: Y series transmissions built prior to May, 1978 use a surface mounted, external oil filter. Gasket 51709 will not be used on later models (see Figure 5).

Refer to the following diagrams:

Figure 1 – Coupling Shaft Housing/Bearing Housing Shims and Gaskets

Figure 2 – Oil Seal Housing/Drive Shaft Housing Gasket

Figure 3 – Shift Gaskets

Figure 4 – Shift Fork O–rings/Chain Spirol Pin

Figure 5 – Oil Filter Adapter Gasket (Models built prior to May, 1978 only)

Nut Installation

2" Coupling and Drive Shaft

Transmissions built prior to May, 1998 used a castellated nut and cotter pin on the coupling and drive shaft. A self–locking nut is now used in its place. When installing the self–locking nut torque to 475–525 lb–ft.

2.35" Coupling and Drive Shaft

Transmissions built prior to May, 1998 used a castellated nut, washer and cotter pin on the coupling and drive shaft. A self–locking nut and washer is now used in its place. When installing the self–locking nut and washer (must use washers included in kit) torque to 475–525 lb–ft.

2–1/4" Coupling and Drive Shaft

Transmissions built prior to May, 1998 used a castellated nut, washer and cotter pin on the coupling and drive shaft. A self–locking nut is now used in its place. When installing the self–locking nut and reusing the original washer torque to 475–525 lb–ft.

Figure 1. Coupling Shaft Housing / Bearing Housing Shims

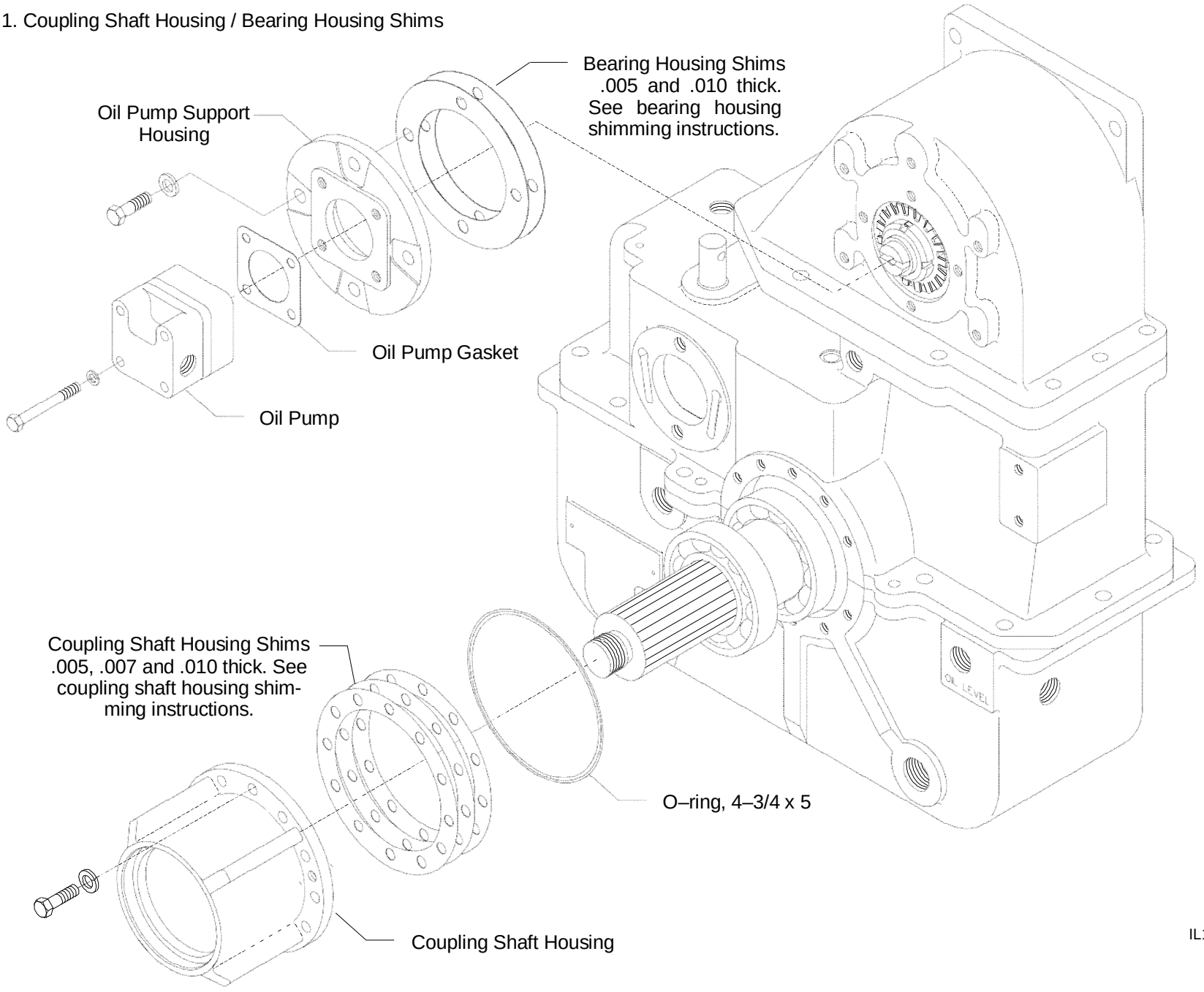


Figure 2. Oil Seal Housing / Drive Shaft Housing Gaskets

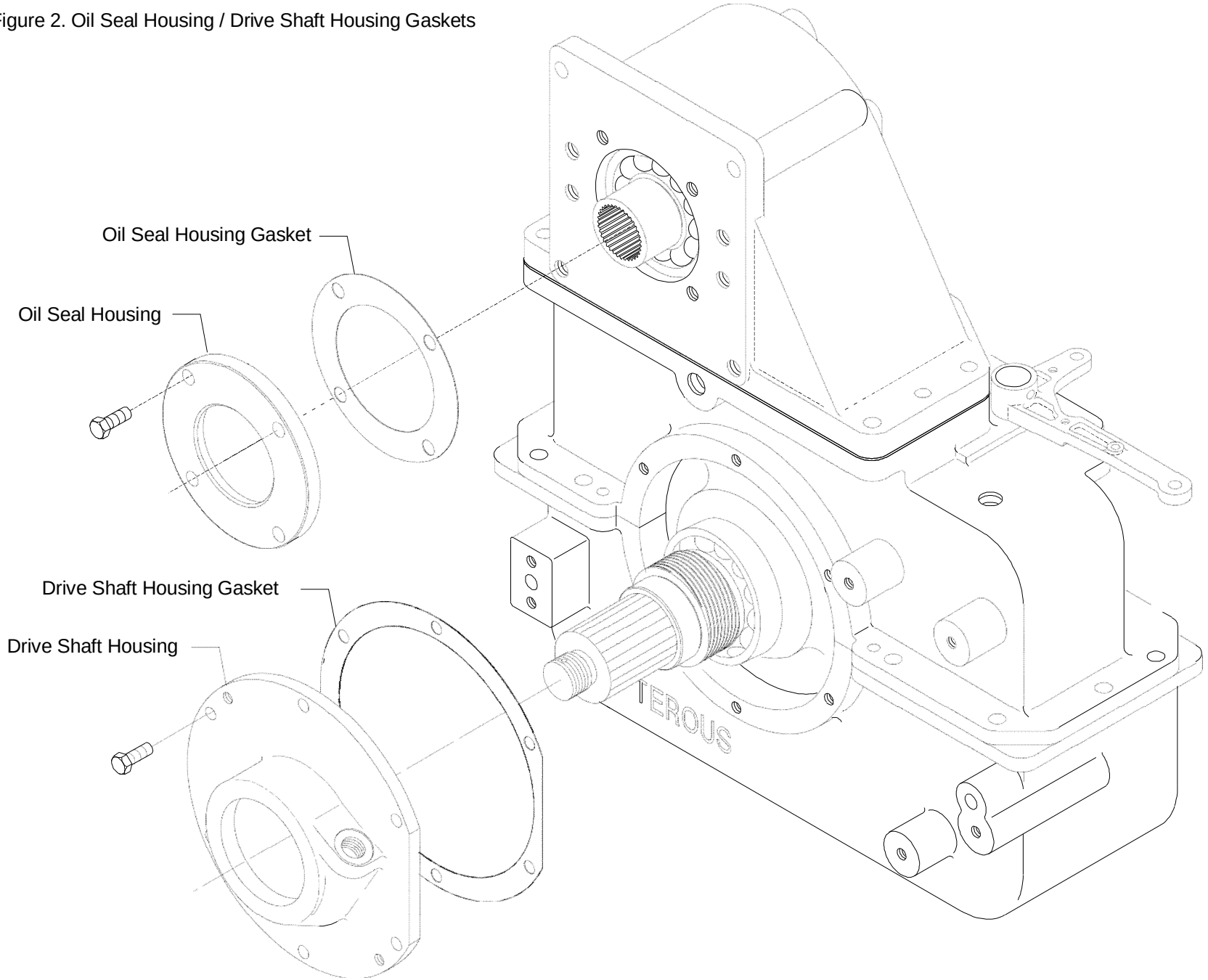


Figure 3. Shift Gaskets – Manual/Electric/Pneumatic Shift

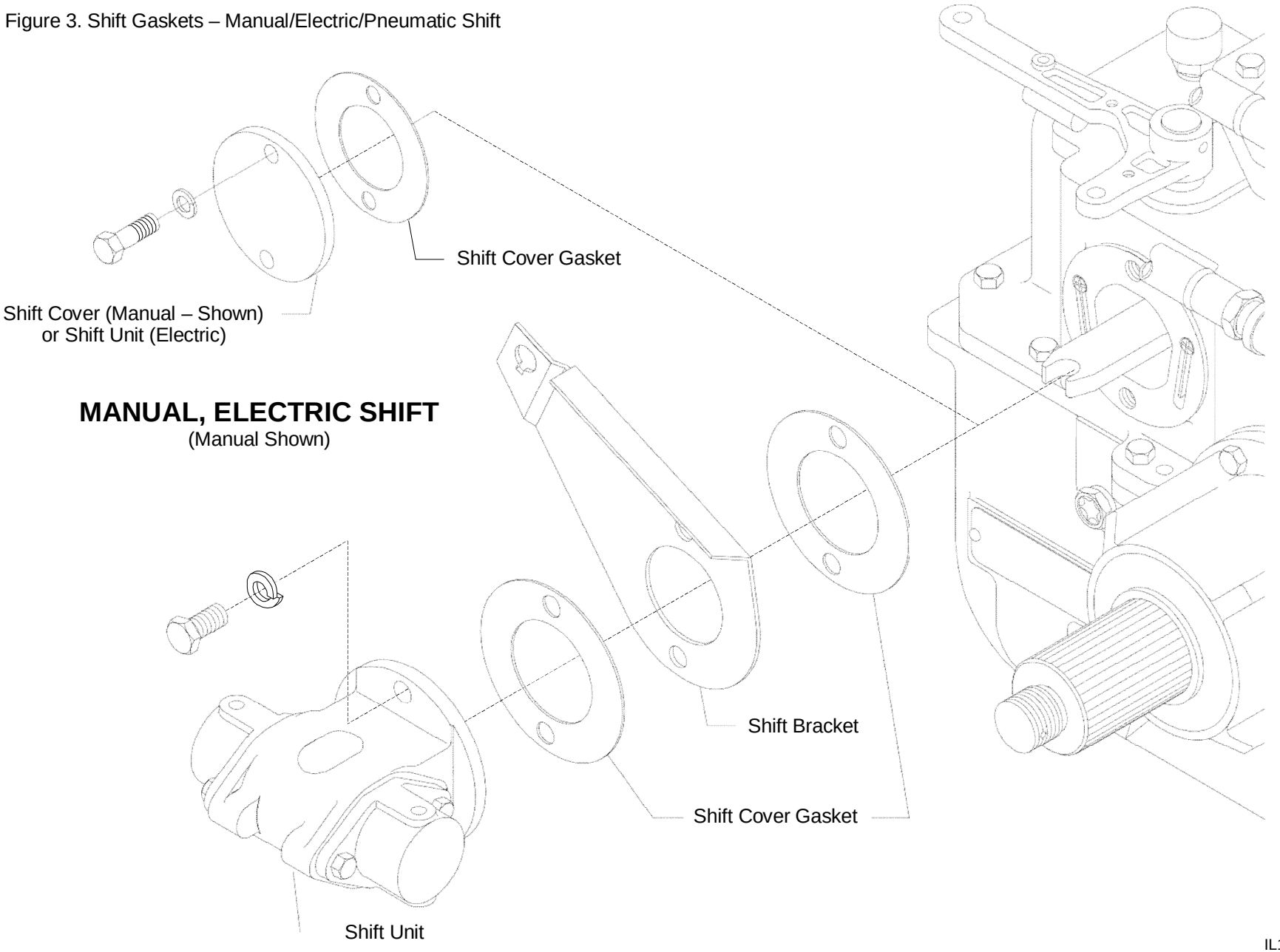


Figure 4. Shift Fork O–rings / Chain Spirol Pin

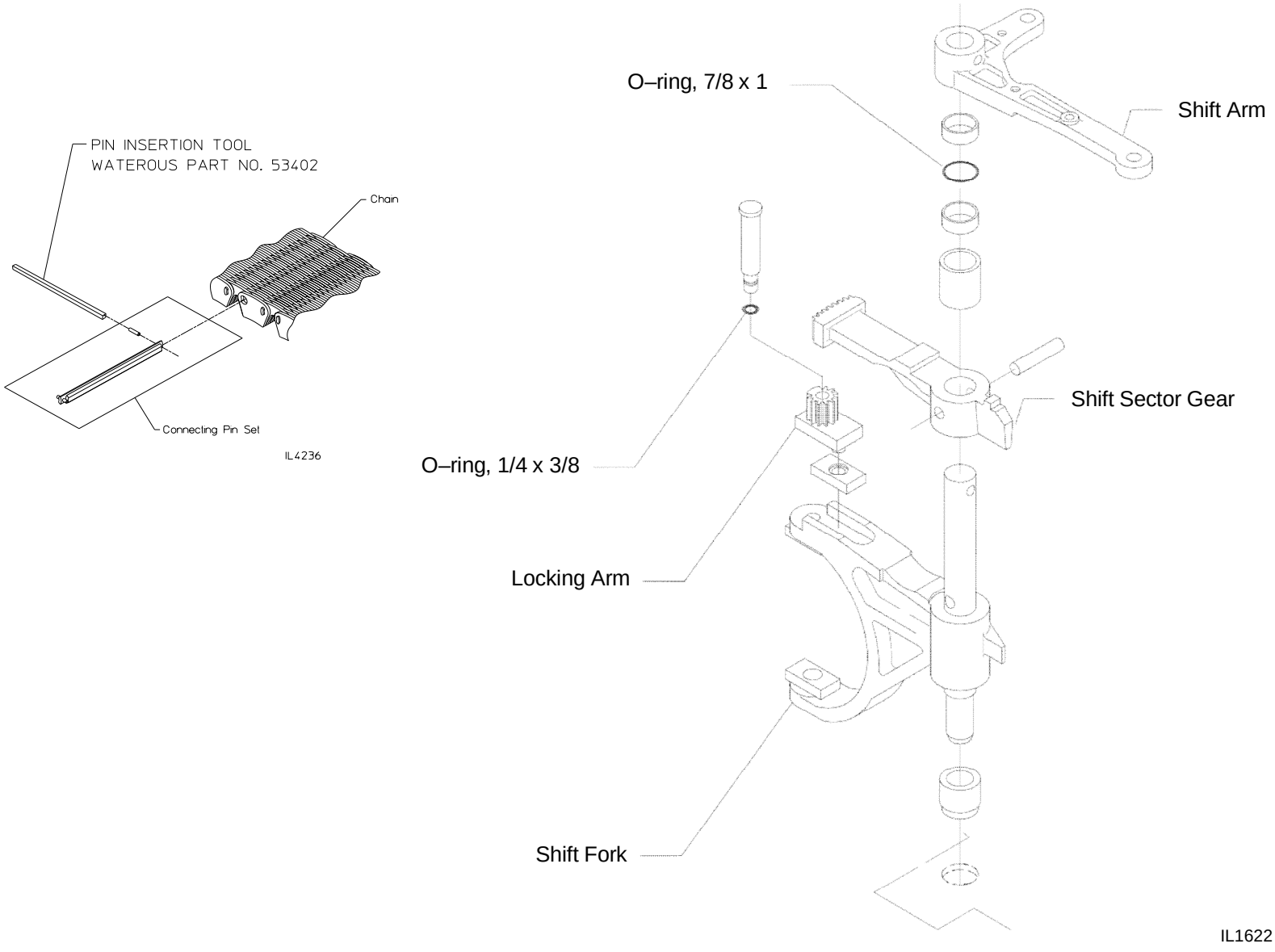
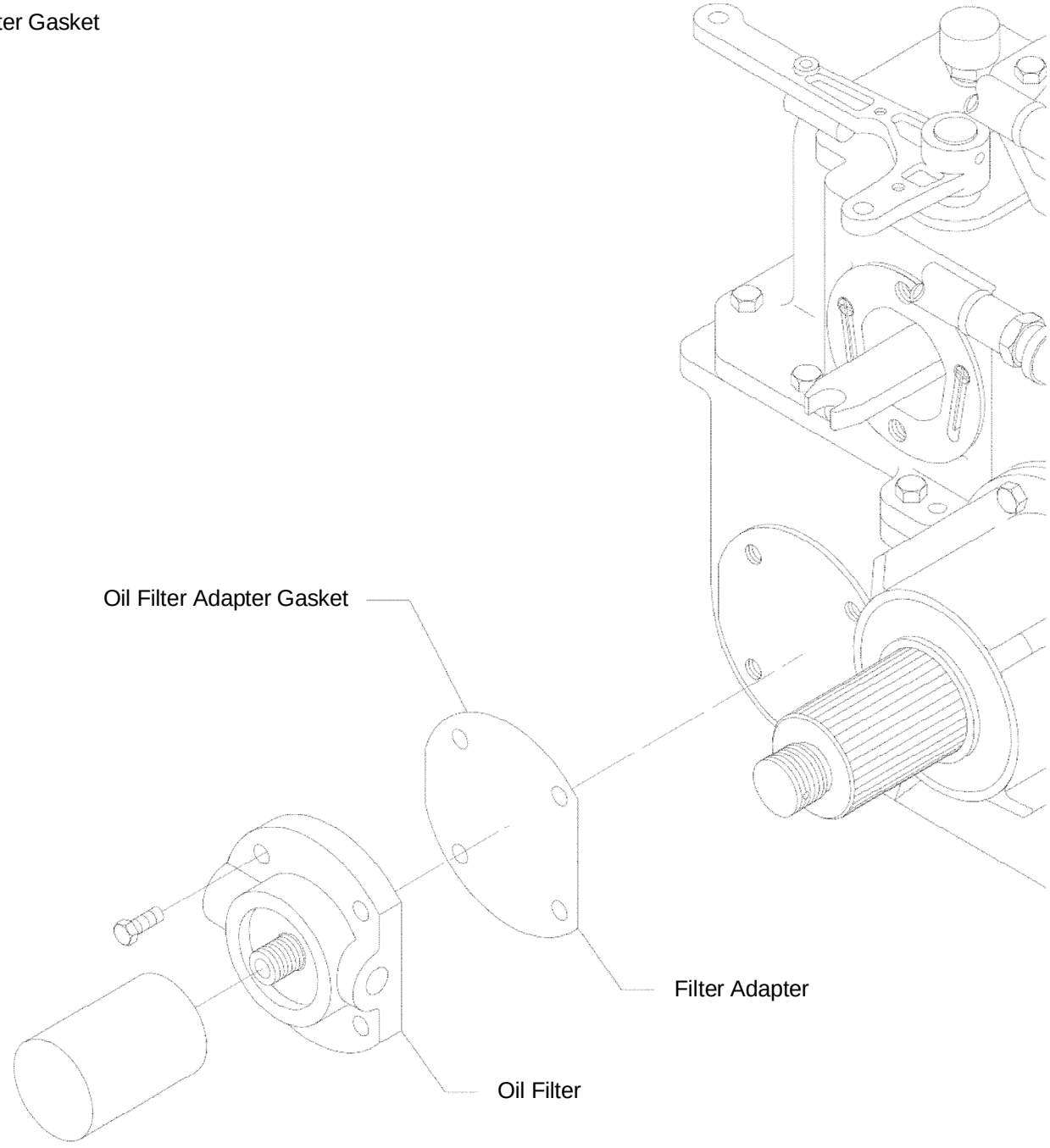


Figure 5. Oil Filter Adapter Gasket



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