



RK-V-07042

XA-0307 Plastic Bearing Replacement for Mark V Landing Gear Manufactured after 2/1/90

Leg Dismantling:

(Numbers () refer to parts explosion on reverse of this sheet)

1. Disconnect cross shaft (36) by removing nuts and bolts (37), properly support the trailer and remove the landing gear from the trailer.
2. Remove all rust from projecting end of shaft (1, 2 or 35) and lubricate for easy removal.
3. Remove screws (16) and leg cover (17) and gasket (18).
4. Tap out groove pin (6) from bevel pinion gear (19).
5. Remove shaft (2 or 35) from landing gear making sure not to lose shims (51) or location of shims (51).
6. Remove plastic bearing(s) XB-0307 (52) by pushing into leg cavity. Discard.

Installation of kit RK-V-07042:

7. Slide the drive gear shaft (2 or 35) back into the leg.
8. Install the double step bearing(s) XA-LG0559 from kit(s) RK-V-07042, placing the bearing(s) (A) in position from the outside of the leg (see Figure 2). Make sure that the double d side of the bearing is facing out and that the opposite step seats into the leg tube. See Figure 1.
9. Place the retainer(s) (B) XA-LG1570 over the bearing(s), hold in place and tack weld.
10. Weld the retainer(s) into place using 2 welds per retainer (1/8" weld 1" in length). See Figure 1. Remove the shaft (2 or 35) from the leg, leaving the new bushing(s) in place. Continue with leg assembly.



WARNING

When welding, use a procedure which assures a sound, good quality weld and which protects the welding operator and others. Overwelding may cause distortion and damage and underwelding may not develop sufficient strength. A low hydrogen process and AWS E70XX filler metal are recommended. Take precautions to insure that the vehicle electrical system is not damaged by the welding.

Leg Assembly:

11. Place bevel pinion gear (19) on top of bevel gear (21) on the opposite side from mounting bracket of single speed outer leg (34), or mounting bracket side of 2-speed outer leg (33).
12. Install shaft (2 or 35) through outer leg (33 or 34). Install shims (51) removed previously and slide shaft (2 or 35) through shims (51) and bevel pinion gear (19).

Figure 1

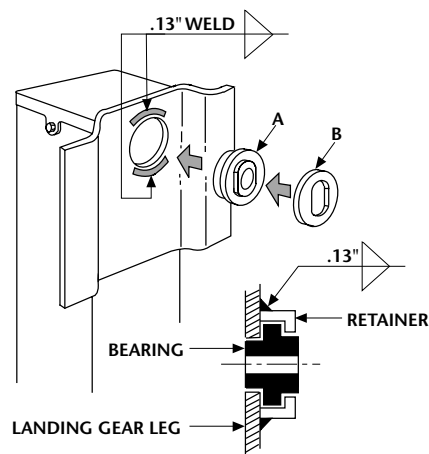
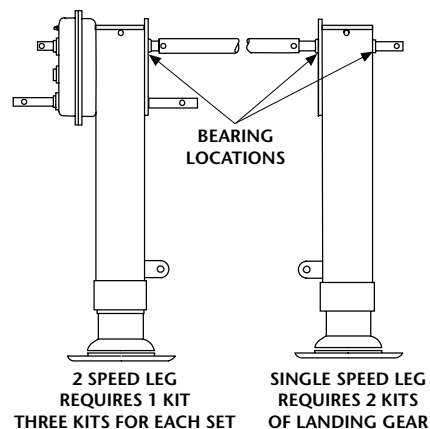
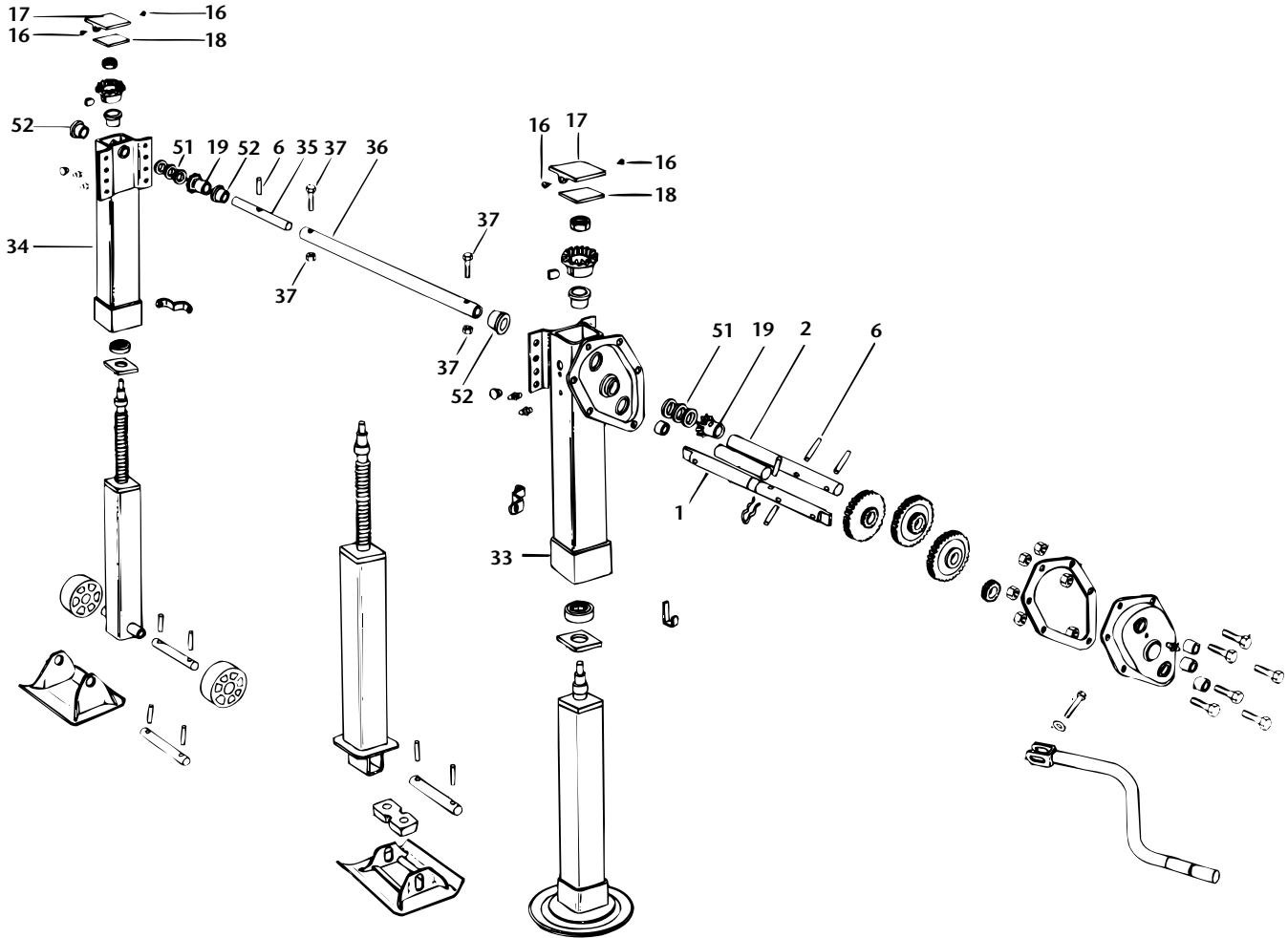


Figure 2



13. Align holes in bevel pinion gear (19) with hole in shaft (2 or 35), insert groove pin (6) so that shafts turn freely and the two gears are engaged properly.
14. Check for proper shimming. Proper shimming is achieved when the shafts turn freely and there is no more than .06" gap between the shims and the outer leg when shaft (2 or 35) is pushed toward the bevel gear.
15. Make sure this assembly is well lubricated with a permanent type lubricant (1/2 pound, minimum).
16. Replace gasket (18), metal cover (17) and self tapping screws (16).
17. Install landing gear back on trailer. Adjust both legs to the same extended length and install cross shaft (36) and bolts and nuts (37). When installing cross shaft make sure there is enough end play and gears crank freely.

Parts for Landing Gear Manufactured after February 1, 1990



RK-V-07042

PARTS INCLUDED IN KIT

XA-LG0559 BEARING

XA-LG1570 RETAINER

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