When shaft bevel gear and bevel gear have to be adjusted then in the interest of the most rational sequence keep to the following order:

1. Adjusting shaft bevel gear (S3 and S4)

- Determine thickness of shim "S4" and insert. The required preloading for the shaft bevel gear taper roller bearing is therefore set.

- Determine thickness of shim "S3" and insert. The shaft bevel gear is thus fixed axially such that the dimension from centre of bevel gear to face of shaft bevel gear corresponds to the installation dimension "R" calculated during production.

- Carry out check measurement of S3.

2. Adjusting bevel gear (S1 and S2)

- Adjust bevel gear taper roller bearing preloading via Stotal and friction torque.

- Adjusting backlash. Select shims "S1" and "S2" so that the prescribed backlash between bevel gear and shaft bevel gear is obtained.

- Check backlash.

The aim of this adjustment is to re-attain the position which offers the quietest running as calculated on the test machine during production. The utmost care and cleanliness during all assembly work and measurements is essential to achieve a good result.