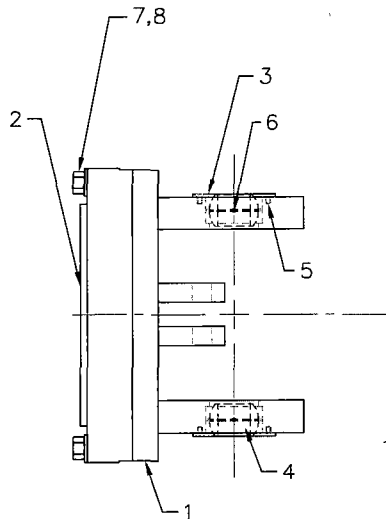
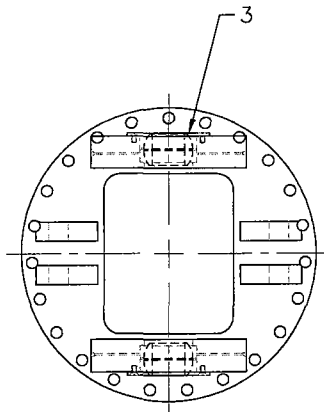
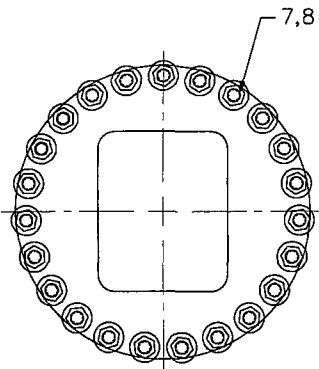
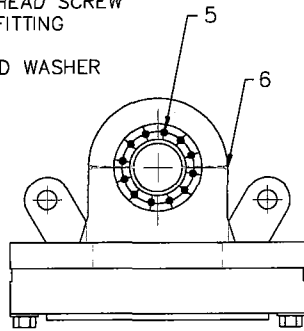


ITEM#	PART#	#	REQ'D	DESCRIPTION
1	016918	1		CENTER SECTION
2	016848X1	1		BALL BEARING
3	010179	2		RETAINING FLANGE
4	9019000134	2		SPHERICAL BEARING
5	1/2X1 1/4	24		SOCKET HEAD SCREW
6		4		GREASE FITTING
7		23		BOLT
8		23		HARDENED WASHER



**NOTES:**

**A. BEARING INSTALLATION PROCEDURE:**

AA) PRESS BEARING (4) INTO HOUSING  
APPLY FORCE AGAINST OUTER RACE ONLY  
UNTIL NO CLEARANCE CAN BE DETECTED  
BETWEEN THE BEARING AND HOUSING  
SHOULDER USING FILLER GAUGE.

AB) PLACE BEARING RETAINER (3) IN POSITION  
AND CHECK TO BE SURE THERE IS NO CLEARANCE  
BETWEEN OUTER RACE AND BEARING RETAINER  
USING A FILLER GAUGE.

AC) TORQUE (5) TO 80 FT LB WITH LOCTITE 271.

B. MOUNT OSCILLATION BEARING (2) WITH THE SOFT  
SPOT IN THE 3 OR 9 O'CLOCK POSITION FOR PROPER  
BEARING LOADING.

C. APPLY LOCTITE 242 TO OSCILLATION BEARING AND  
CENTER SECTION ASSEMBLY MOUNTING BOLTS (7).  
TORQUE TO 460 FT LB.

D. LUBRICATE AND ROTATE ROTEC BEARING 360° 2 TIMES.  
E. NO GAP SHOULD EXIST WHERE CENTER SECTION AND BALL  
BEARING MATE.

**HIGHLAND MACHINERY**

DESC. CENTER SECTION ASSEMBLY 488 W/BATTERY CHANGE & BUCKET			
REV. 1	DATE	1/21/02	BY
DES. SALES DRAWING	SCALE	NONE	CHK. JK