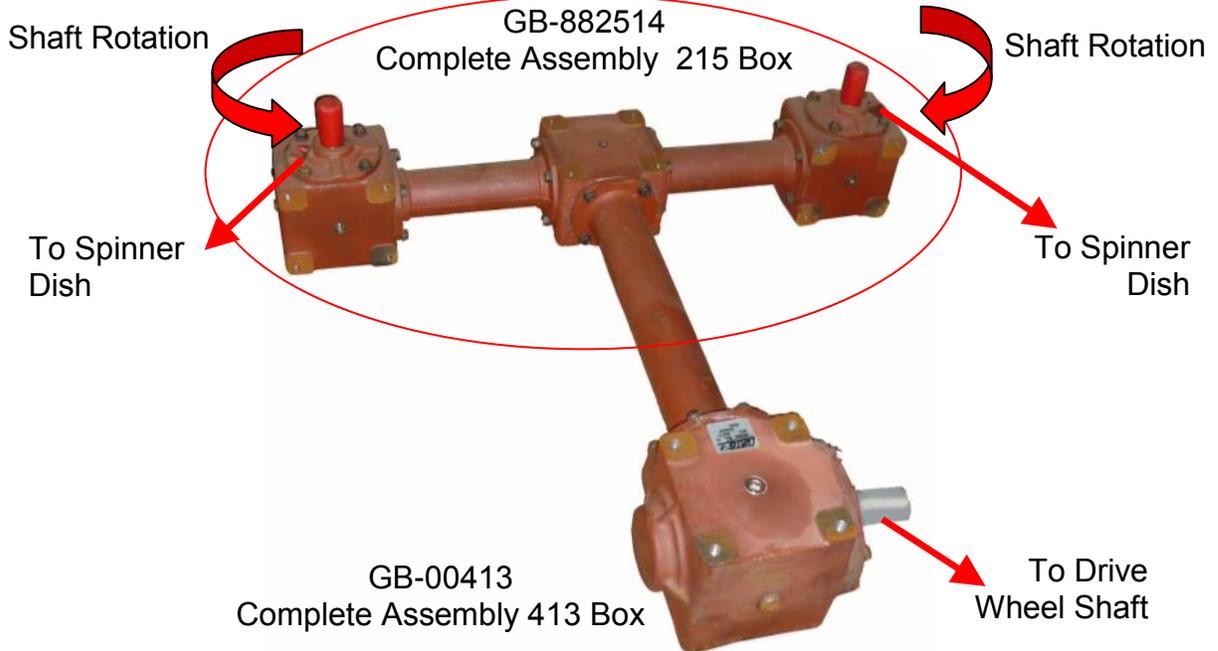


# Rebuilding the 215 Gear Box



When disassembling the gear box assembly, place on side and using a wrench, remove the bolts that hold the shaft casings.



Put the bolts aside. You will need them when you reassemble the gear box system

**Important!**

Be sure to count the gaskets, type and number. You will need to replace these exactly when you reassemble your gear box.

It is a good idea to have extra gaskets on hand. Sometimes you need to add them when reassembling your box.

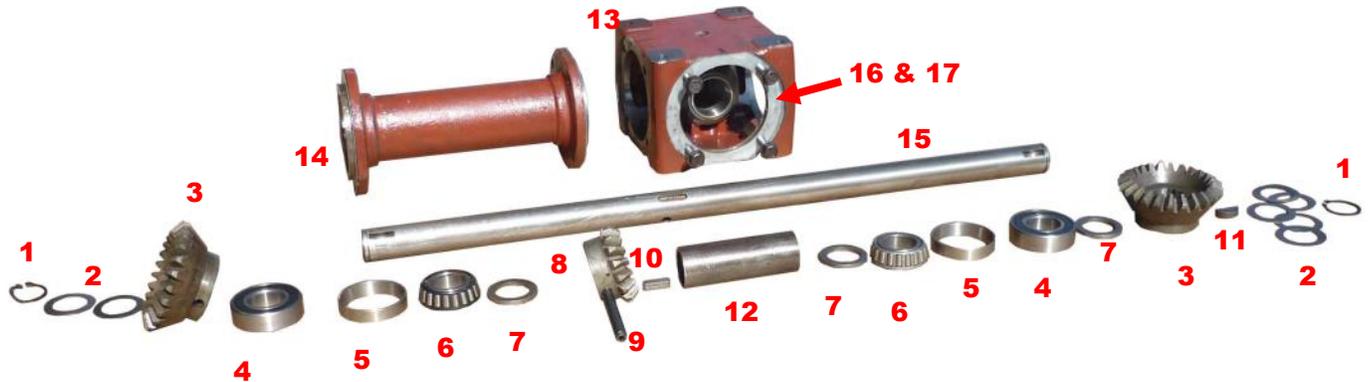


215 Center

413 Box



# 215 Gear Box Center Section Parts



ITEM #	PART#	DESCRIPTION
1	GB-620203	Retaining Plug
2	GB-370049/ 370056	Spacer
3	GB-100628	Gear
4	GB-150227	Bearing
5	GB-150102	Race
6	GB-150094	Bearing
7	GB-410571	Washer
8	GB-100610	Gear
9	GB-350009	Roll Pin
10	GB-600056	Key
11	GB-600262	Key
12	GB-450338	Spacer, Pipe
13	GB-00125	Housing, Left & Right
14	GB-054221	Connector Cap
15	GB-217570	Shaft
16	GB-390096	Gasket.003, Clear, 215 box
16	GB-390195	Gasket.003, Clear, 413 box
17	GB-390005	Gasket.015, White, 215 box
17	GB-390021	Gasket.015, White, 413 box

# These photos show the order & method for rebuilding the 215 Gear Box Center Section

## Step 1

Place GB-600056 key into slot in side of GB-217570 shaft.



## Step 2

Slide GB-100610 Gear with GB-350009 Roll Pin onto shaft. The slot in the gear must be turned to fit over the key. The roll pin will be hammered into the shaft to be flush with the gear.

*The roll pin has not been fully installed in the following photos.*

## Step 3

Next slide on GB-410571 Washer, then GB-150094 Bearing onto shaft.



## Step 4

Place GB-150102 Race into opening of GB-054221 Connector Cap



**Step 5**

Slide GB-054221 Connector Cap onto shaft.

Insert GB-150227 Bearing- solid side inside, into Connector Cap. The Bearing may need to be tapped in order to fully seat it in the Connector Cap



**Step 6**



**Step 7**

Next insert GB-600262 Key into shaft



**Step 8**

Slide gear # 4 onto shaft and 2 GB-370049 or 370056 Spacers

**Step 9**

Place GB-620203 Retaining Plug to lock parts into place.



### Step 10



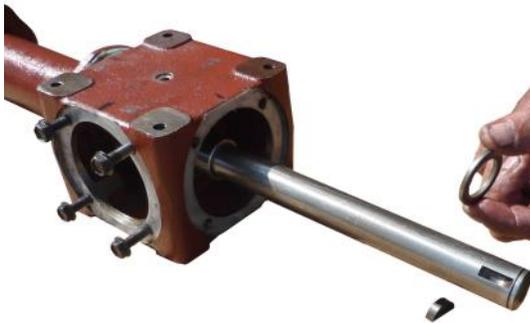
Slide GB-450338 Spacer, Pipe onto shaft and run shaft through GB-00125 Housing, Left & Right #13.



Slide onto shaft

### Step 11

GB-410571 Washer  
GB-150094 Bearing  
GB-150102 Race



### Step 12

Slide onto shaft  
GB-054221 Connector Cap  
GB-150227 Bearing  
GB-600262 Woodruff Key



GB-100628 Gear

GB-370049 or GB-370056 Spacer

GB-620203 Retaining Ring

The same parts will be put on the shaft in reverse order: Washer, Bearing, Race, Bearing, Washer, Gear, Key. There will be 5 Washers followed by Retaining Plug

