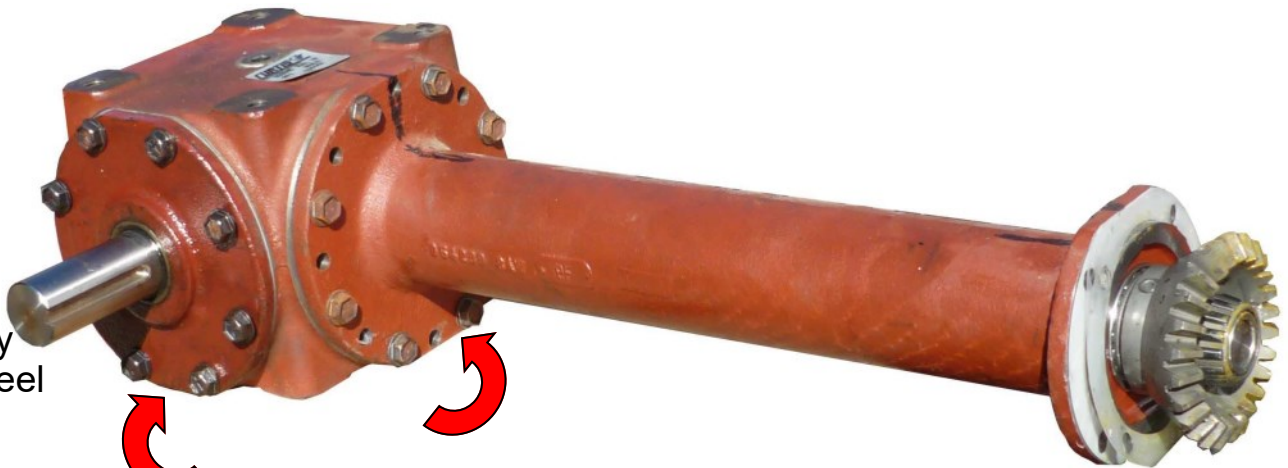


# DISASSEMBLING THE 413 BOX GEAR BOX

Driven by  
drive wheel



## Step 1

Place on side and using a wrench, remove the bolts that hold the shaft casing onto the center housing and the 413 shaft.



## Step 2

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



**Important!**

## Step 4

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

## Step 3

Pull out center section and 413 shaft out of housing



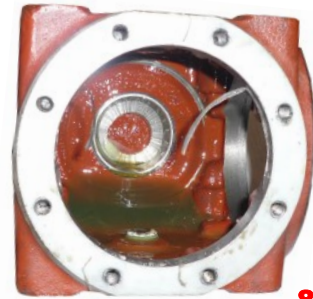
It is a good idea to have extra spacers on hand. Sometimes you need to add them when reassembling your box.

# GB-000413 GEAR BOX PARTS



ITEM #	PART#	DESCRIPTION
1	GB-150144	Race
2	GB-150136	Cone Bearing
3	GB-222083	Shaft
4	GB-600445	Key
5	GB-101030	Gear
6	GB-300020	Seal
7	GB-050211	Cap
8	GB-000182	Housing
9	GB-390195	Gasket.003, Clear, 413 box
10	GB-390021	Gasket.015, White, 413 box

7 Flipped over



8

**Parts Assembled –Ready to Insert into Housing—Makes the GB-000413**



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\\Technical Tips\\Assembling 413 Gear Box

# ASSEMBLING 413 GEAR BOX

## Step 1

Insert GB-300020 seal into cap GB-050211.



## Step 2

Drop GB-150144 Race into GB-050211 cap. It should seat firmly.—may need to be tapped lightly with hammer.



## Step 3

Place GB-600445 key into slot in side of shaft GB-222083.

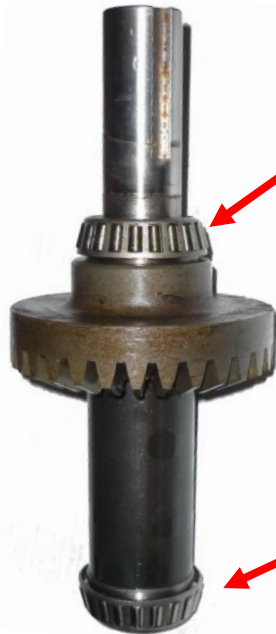


## Step 5

Place one GB-105136 cone bearing on top of gear

## Step 4

Slide gear GB-101030 onto shaft.



## Step 6

Place one GB-105136 cone bearing on bottom of shaft

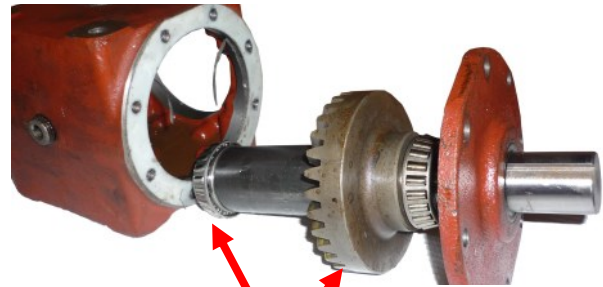


## ASSEMBLING 413 GEAR BOX

Finished assembly shown ready to insert into 413 gear box housing GB-050211

**Step 7** Insert shaft assembly into housing and bolt securely.

**Step 8** Insert 215 center section into 413 housing and bolt securely.



Make sure gears on 413 shaft mesh properly with gears on 215 shaft end section



## Gear Box Assembly Used on Drive Wheel Units

