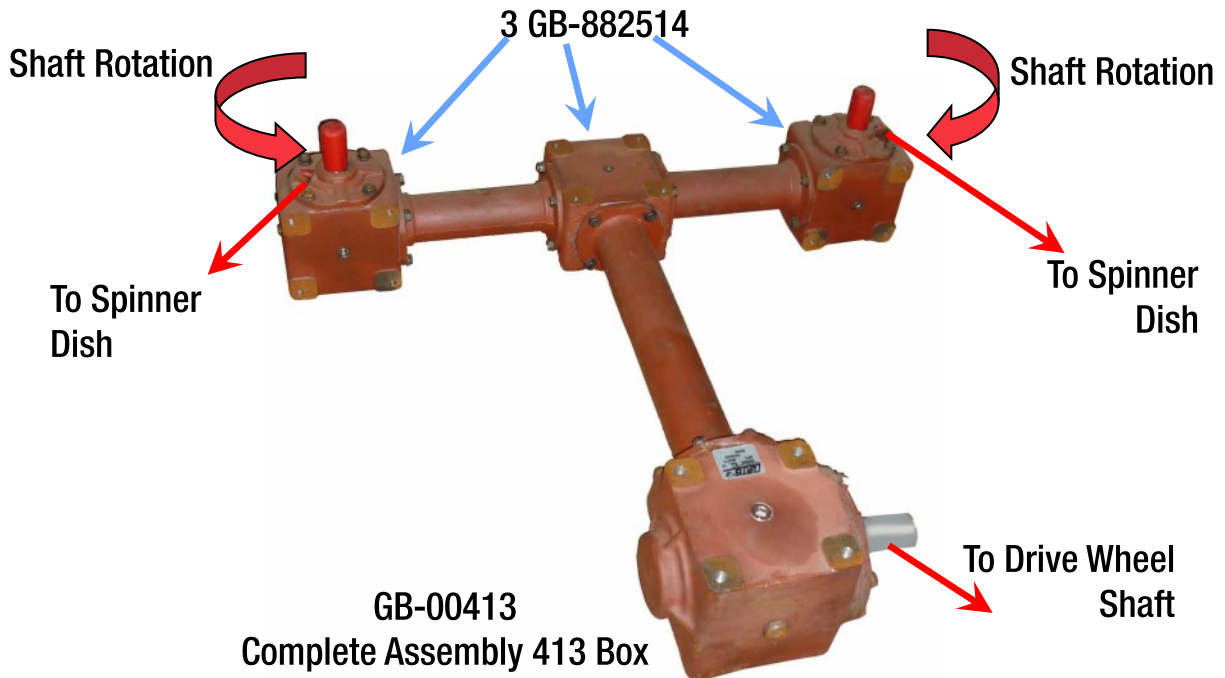


# REBUILDING THE CENTER 215 GEAR BOX



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

**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.

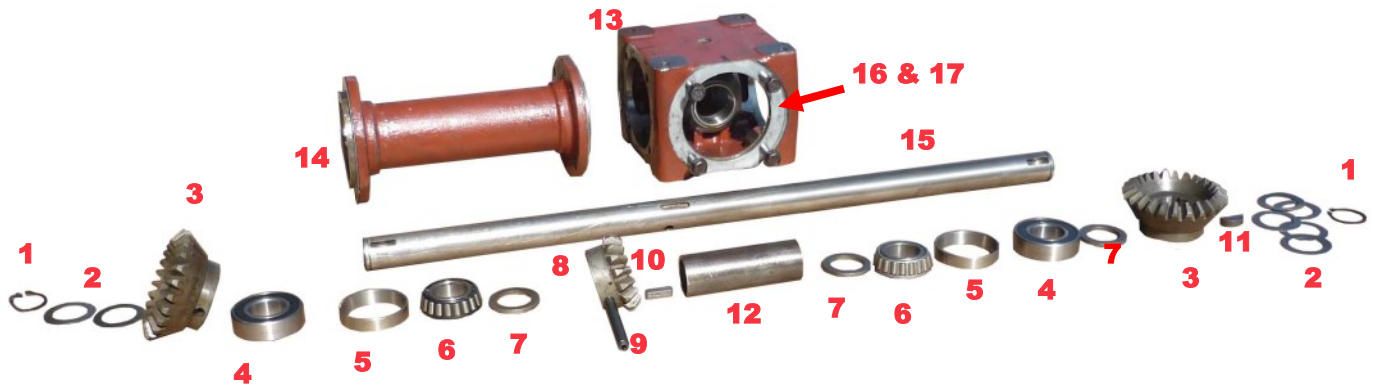


*Helpful Tip: Grab some old cardboard and lay out the parts in order as you remove them from the shaft. (See photo to left) This makes "matching" your new rebuild parts easier.*



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# 215 GEAR BOX CENTER SECTION PARTS



| ITEM # | PART#             | DESCRIPTION                |
|--------|-------------------|----------------------------|
| 1      | GB-620203         | Retaining Plug             |
| 2      | GB-370049/ 370056 | Spacer                     |
| 3      | GB-100628         | Gear                       |
| 4      | HM-X6940          | Bearing, seals removed     |
| 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-000125         | Housing, Left & Right      |
| 14     | GB-054221         | Connector Cap Sleeve       |
| 15     | GB-217570         | Shaft                      |
| 16     | GB-390096         | Gasket.003, Clear, 215 box |

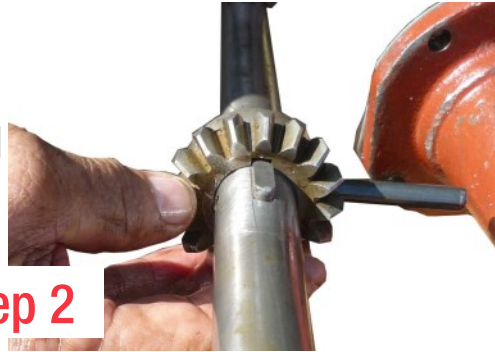
# REBUILDING THE CENTER 215 GEAR BOX



## Step 1

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

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.



## Step 2

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

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

## Step 3



## Step 4

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



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## REBUILDING CENTER 215 GEAR BOX



**Step 5**

Slide GB-054221 Connector Cap onto shaft.



**Step 6**

Insert HM-X6940 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 7**

Next insert GB-600262 Key into shaft



**Step 8**

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



**Step 9**

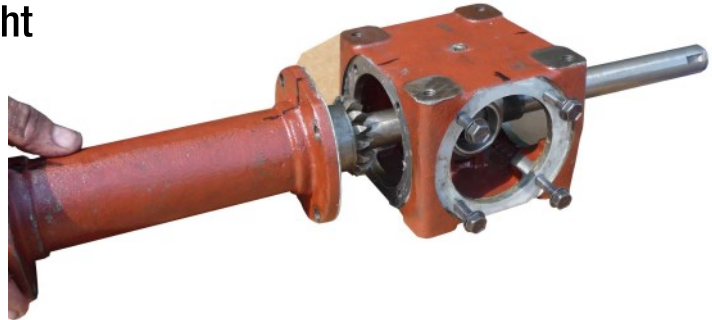
Place GB-620203 Retaining Plug to lock parts into place.

# REBUILDING CENTER 215 GEAR BOX

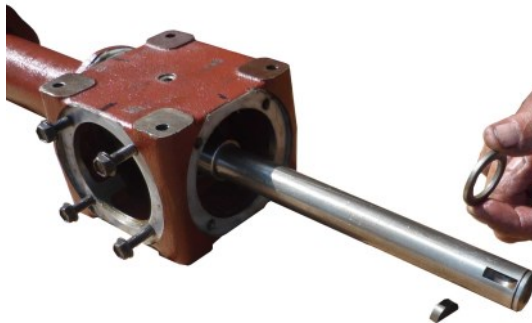


Slide GB-450338 Spacer, Pipe onto shaft and run shaft through GB-00125 Housing, Left & Right

**Step 10**



**Step 11**



Slide onto shaft: GB-410571 Washer + GB-150094 Bearing + GB-150102 Race

**Step 12**



Slide onto shaft:

GB-054221 Connector Cap Sleeve

GB-150227 Bearing

GB-600262 Woodruff Key

GB-100628 Gear

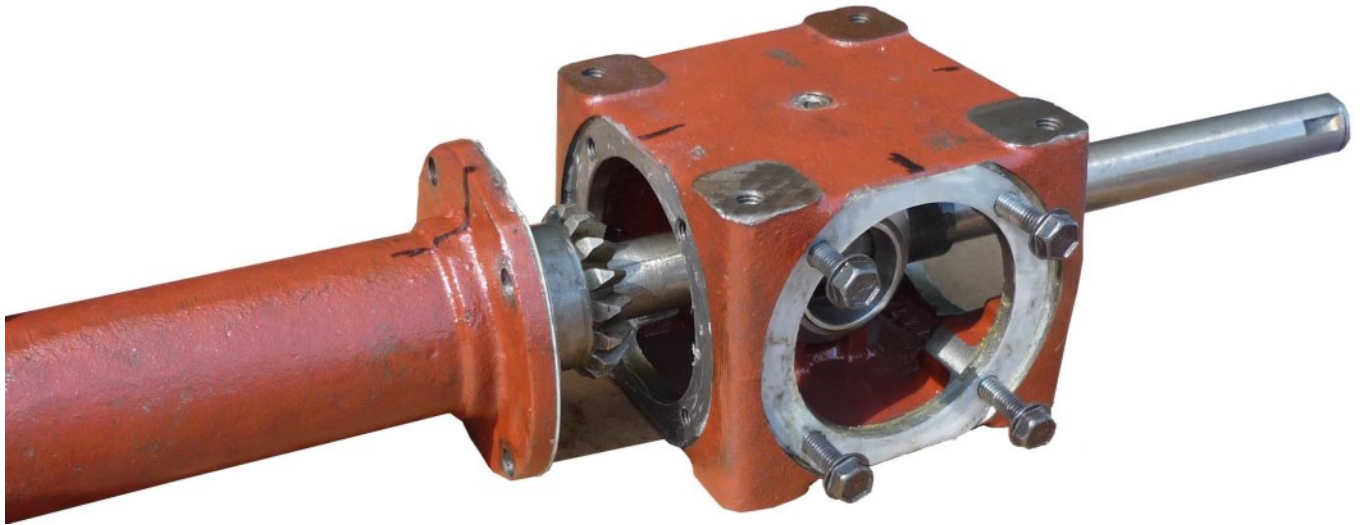
GB-370049 or GB-370056 Spacer

GB-620203 Retaining Ring



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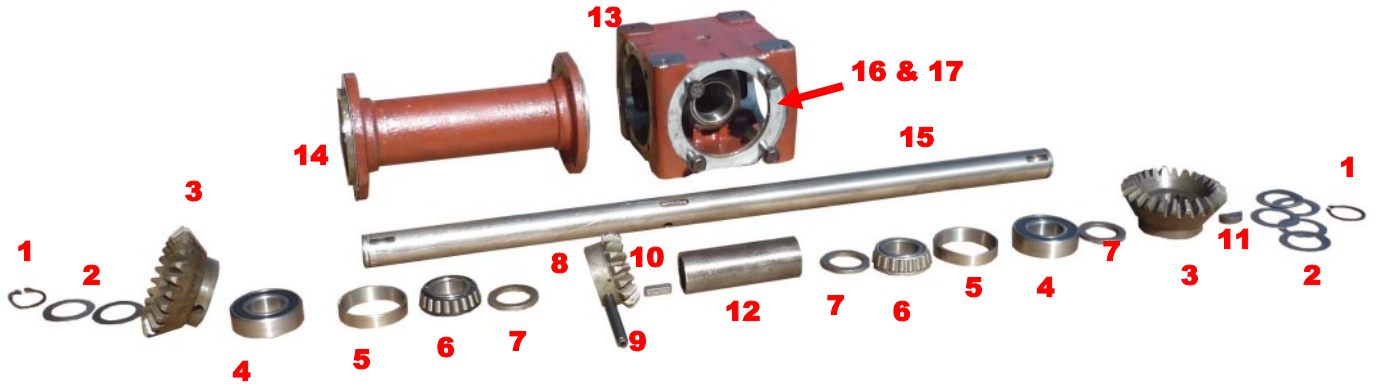
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The parts are identical on the shaft for each side of the center box.



# 215 GEAR BOX CENTER SECTION PARTS



**Item #1** GB-620203 Retaining Plug



**Item #2** 5 GB-370049 or GB-370056 Spacers



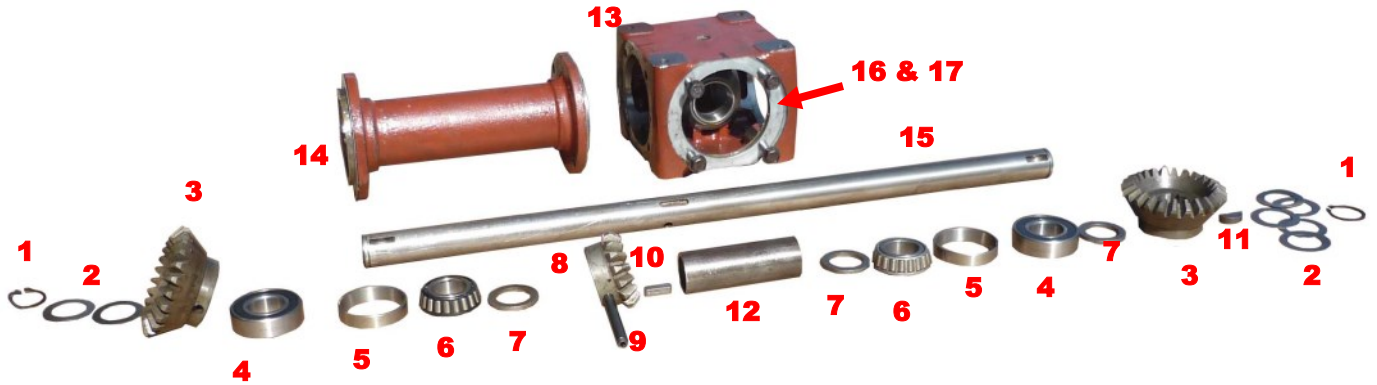
**Item #3** GB-100628 Gear



**Item #4** HM-X6940 Bearing



# 215 GEAR BOX CENTER SECTION PARTS



**Item #5**

**GB-150102 Race**



**Item #6**

**GB-150094 Bearing**



**Item #7**

**GB-410571 Washer**



**Item #8**

**GB-100610 Gear**

**Item #9**

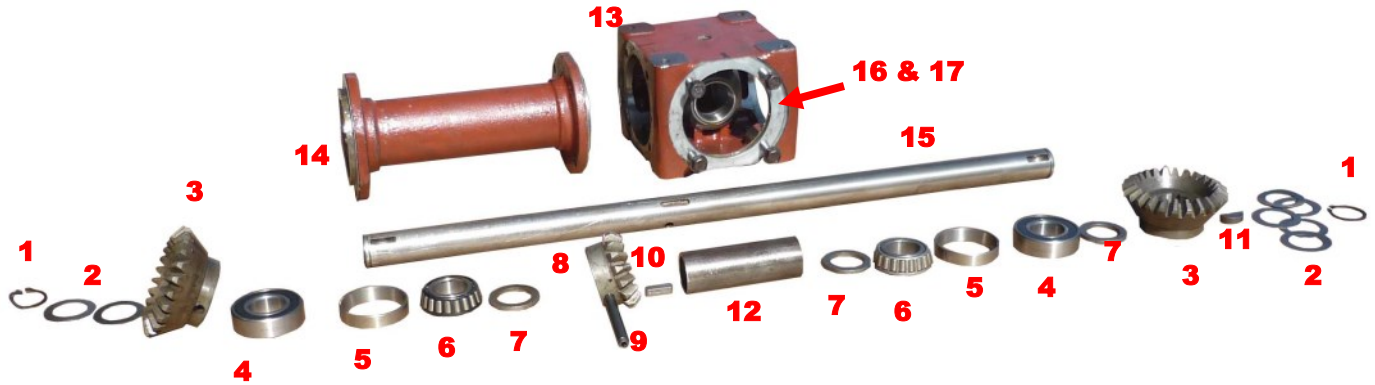
**GB-350009 Roll Pin**



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# 215 Gear Box Center Section Parts



**Item #10** GB-600056 Key



**Item #11** GB-600262 Key



**Item #12** GB-450338 Pipe Spacer



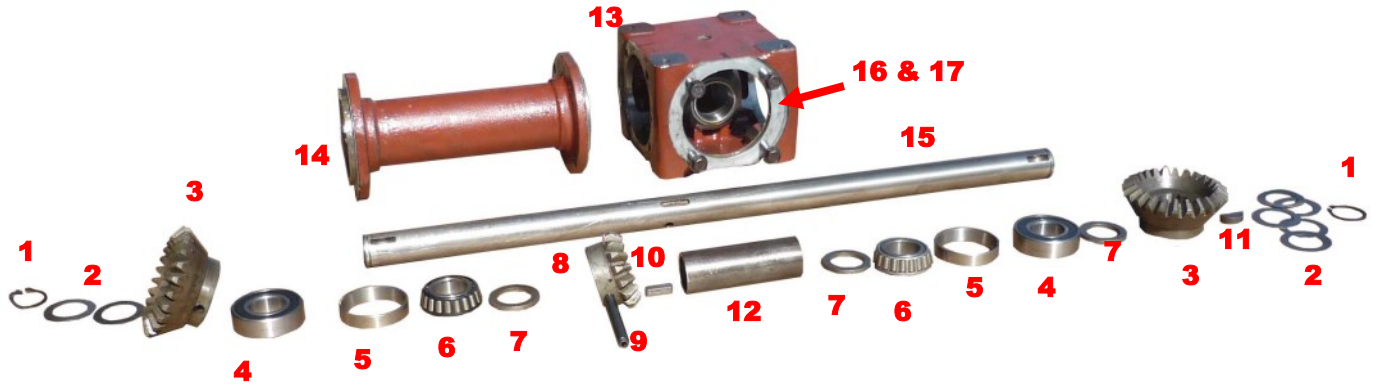
**Item #13** GB-00125 Housing



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# 215 Gear Box Center Section Parts



**Item #14** GB-054221  
Connector Cap Sleeve



**Item #15** GB-217570 Shaft



**Item #16**  
GB-390096 Gasket .003 Clear

**Item #17**  
GB-390005 Gasket .015 White

