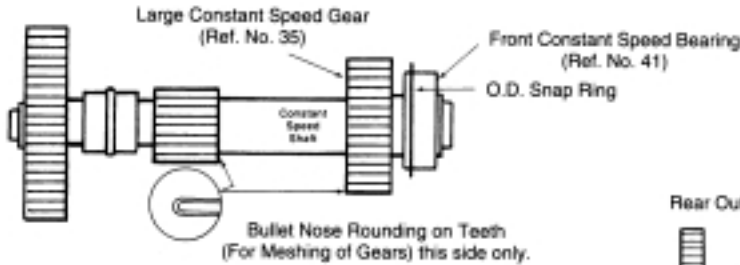
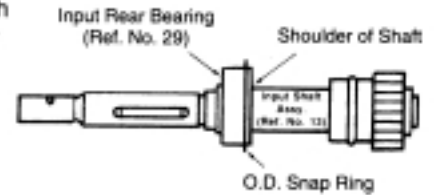
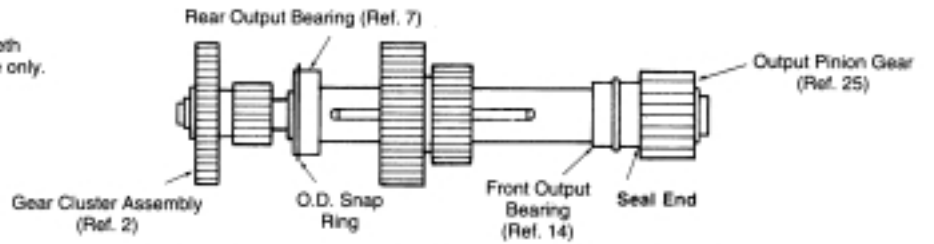


**Service Notes  
Transmission**

Position Bearing (Ref. No. 29) with O.D. Snap Ring towards shoulder of Input Shaft.



Position Large Constant Speed Gear Ref. No. 35 so that bullet nose side of gear teeth are facing toward center of shaft.  
Position O.D. Snap Ring towards Large Constant Speed Gear.

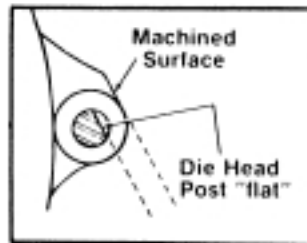


Position Bearing (Ref. No. 7) with O.D. Snap Ring towards Gear Cluster (Ref. No. 2)

Position Seal End of Front Output Bearing (Ref. No. 14) towards Output Pinion Gear (Ref. No. 25)

**Replacement Instructions for Die Head Post**  
All 1224 Die Heads— 541, 542, 711, 713, 714, 911, 913, 914

**—IMPORTANT—**  
Post must be properly oriented to insure oil flow through head. Insert illustrates proper relationship (parallel) of "flat" on die head post to flat "machined surface" of die head casting.



**Oil Pump**

**Installing Oil Pump Onto Input Shaft Assembly**

1. Align Square Slot (behind seal) in the No. 27307 Oil Pump with the Drive Pin in the No. 26902 Gear Box Input Shaft Assembly.
2. Slide Oil Pump onto Input Shaft Assembly.
3. When Pump is properly engaged onto Shaft, the distance between Pump body and Keyway Slot should not exceed 1/8 inch.

