



## Contents

<b>00 - Technical data</b>	<b>1</b>
<b>1 Safety information</b>	<b>1</b>
1.1 Safety measures when working on vehicles with a start/stop system	1
1.2 Safety precautions when using testers and measuring instruments during a road test	1
<b>2 Repair instructions</b>	<b>2</b>
2.1 Rules for cleanliness	2
2.2 General repair instructions	2
2.3 Contact corrosion	3
2.4 Gaskets and seals	4
2.5 Nuts and bolts	4
<b>3 Technical data</b>	<b>5</b>
3.1 Capacities	5
3.2 Allocation gearbox - engine	5
<b>4 Identification</b>	<b>6</b>
4.1 Gearbox identification	6
<b>30 - Clutch</b>	<b>7</b>
<b>1 Clutch operation</b>	<b>7</b>
1.1 Assembly overview - clutch mechanism	7
1.2 Removing and installing clutch pedal	9
1.3 Removing and installing over-centre spring	10
1.4 Removing and installing mounting bracket	10
1.5 Removing and installing clutch master cylinder	10
1.6 Removing and installing clutch slave cylinder together with release bearing	11
1.7 Removing and installing bearing bush	12
1.8 Removing and installing bleeder	12
1.9 Bleeding clutch mechanism	13
1.10 Removing and installing clutch position sender G476	14
<b>2 Clutch</b>	<b>15</b>
2.1 Assembly overview - clutch	15
2.2 Assembly overview - clutch release mechanism	17
2.3 Removing and installing clutch	17
<b>34 - Controls, housing</b>	<b>20</b>
<b>1 Selector mechanism</b>	<b>20</b>
1.1 Installation position - selector mechanism	20
1.2 Assembly overview - selector mechanism	21
1.3 Removing and installing selector mechanism	21
1.4 Adjusting selector mechanism	23
1.5 Checking selector mechanism	26
1.6 Removing and installing gear selector cable	26
1.7 Renewing selector shaft seal	28
1.8 Removing and installing selector lever handle	29
1.9 Removing and installing gearbox selector lever and gearbox gate lever	30
<b>2 Removing and installing gearbox</b>	<b>32</b>
2.1 Specified torques for gearbox	32
2.2 Removing gearbox	32
2.3 Installing gearbox	35
2.4 Removing gearbox, vehicles with power take-off system and additional gear oil cooler	36
2.5 Installing gearbox, vehicles with power take-off system and additional gear oil cooler	40
<b>3 Assembly mountings</b>	<b>43</b>
3.1 Assembly overview - assembly mountings	43



3.2	Assembly overview - gearbox carrier with gearbox mounting	43
3.3	Removing and installing gearbox mounting	44
3.4	Removing and installing gearbox carrier	44
<b>4</b>	<b>Transporting gearbox</b>	<b>46</b>
<b>5</b>	<b>Securing to engine and gearbox support</b>	<b>48</b>
<b>6</b>	<b>Gear oil circuit</b>	<b>49</b>
6.1	Assembly overview - gear oil cooling	49
6.2	Removing and installing gear oil cooler	50
6.3	Removing and installing oil pump	51
6.4	Removing and installing oil pressure lines	53
<b>7</b>	<b>Gear oil</b>	<b>58</b>
7.1	Checking gear oil level	58
7.2	Draining and filling gear oil	59
7.3	Filling gear oil and checking oil level with auxiliary gear oil cooler	59
7.4	Bleeding cooling system of gearbox	62
<b>35 - Gears, shafts</b>		<b>64</b>
<b>1</b>	<b>Input and output shafts</b>	<b>64</b>
1.1	Assembly overview - output shaft seals	64
1.2	Renewing input shaft seal	64
1.3	Renewing output shaft seal	66
1.4	Removing and installing output shaft flange	68