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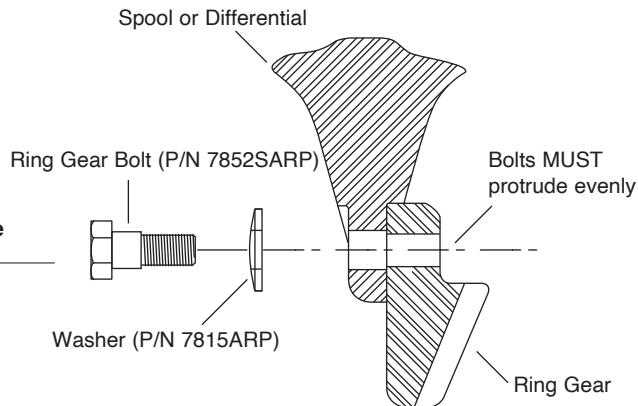
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# Short Threaded Ring Gear Bolt Kit KIT P/N 9381S

Note: Use FT-LBS scale only.  
Not M-KGS or Newtons.

- Make certain ring gear bolts and tapped holes in ring gear are clean and oil free.
  - Use red Loctite® on threads. Mount ring gear and align holes.
  - Install bolt through washer and thread into ring gear. **Make sure that washer is lubricated and installed as shown.**
  - Torque ring gear bolts in a criss-cross pattern to 35-40 FT-Lbs, then final torque to 60 FT-Lbs.
  - Bolts should protrude evenly out the tooth side of the ring gear.
- Any perceptible variation - Bolts must be re-torqued.**



**Caution:** When using a steel spool, ring gear bolt must be shortened to allow for clearance between bolt end and center housing.