



Figure 3-3. Transmission Assembly (Upper Section) and Planetary Assembly (Sheet 1 of 2).

Table 3-1. Inspection After Cleaning (Cont.).

Inspection and Method	Serviceability Limit	Repair Limit	Corrective Action
Fig. 3-3, item 24 Retainer for damage, wear discoloration (visual)	See table 3-2	NONE ALLOWED	Replace
Fig. 3-3, item 25 Inner Ring for wear (SIE), cracks (MPI), and corrosion.	ID 1.2496 to 1.2501 (see table 3-2)		Replace
Fig. 3-3, item 21 Outer ring for cracks (MPI)	NONE ALLOWED		Replace
1. Teeth (Area D, fig. 3-22) for:			
a. wear (use 0.1920 dia. pins) (SIE)	OD 4.1779 to 4.1894		Replace
b. corrosion	NONE ALLOWED	Surface corrosion less than 0.0001 inch deep	Dress out with cloth (item 12 table 2-2).
c. nicks, dents and scratches	NONE ALLOWED	Nicks, dents, or scratches on upper gear teeth if they cannot be felt with a 0.010 inch scribe. None permitted on pitch line.	Dress out with India Stone (item 6, table 2-2) and sandpaper (item 28, table 2-2). Polish with cloth (item 12, table 2-2).
2. Race (Area C, fig. 3-22) for:			
a. wear (SIE)	See table 3-2		Replace
b. corrosion (MPI)	See table 3-2	Very minor surface corrosion	Dress out with No.4 emery polishing paper and clean or replace.
Fig. 3-3, item 17 Sun Gear			
a. nicks, cuts, scratches or frosting (visual)	NONE ALLOWED	Acceptable if cannot be felt with a 0.010 inch scribe on upper edge of gear teeth maximum of 0.015 inch deep. None acceptable on pitch line.	Remove with India Stone (item 6, table 2-2)

Table 3-1. Inspection After Cleaning (Cont.).

Inspection and Method	Serviceability Limit	Repair Limit	Corrective Action
b. corrosion (visual)	NONE ALLOWED	Surface corrosion less than 0.0001 inch deep	Remove with sandpaper (item 28, table 2-2) and polish with cloth (item 12, table 2-2)
1. Teeth (Area E, fig. 3-22) for:			
a. wear (SIE) (use 0.2160 dia. pins)	OD 3.3745 to 3.3850		Replace
b. cracks (MPI)	NONE ALLOWED		Replace
c. wear pattern	See figure 3-19		
2. Splines (Area F, fig. 3-22) for:			
a. wear (SIE) (use 0.1660 dia. pins)	OD 2.7290 to 2.7457		Replace
b. cracks (MPI)	NONE ALLOWED		Replace
3. Gear-Thrust Bearing Seat (Area G, fig. 3-22) for wear (SIE)	OD 2.5574 to 2.5583		Replace
Fig. 3-3, item 22 Bearing (Area H, fig. 3-22) (See para. 3-22)	ID 2.5585 to 2.5593		Replace
Fig. 3-3, item 16 Spider for corrosion	NONE ALLOWED	Surface corrosion less than 0.0001 inch deep	Remove with cloth (item 12, table 2-2)
1. Spline (Area I, fig. 3-22) for: (Use 0.1440 dia. pins.)			
a. wear (SIE)	ID 2.4710		Replace
b. cracks (MPI)	NONE ALLOWED		Replace
2. Bearing Shaft Seat (Area J, fig. 3-22) for:			
a. wear (SIE)	ID 1.2496 to 1.2502		Replace
b. cracks (MPI)	NONE ALLOWED		Replace