

## 485-5 DANA REAR AXLES



Figure 10—Assembling the Pinion

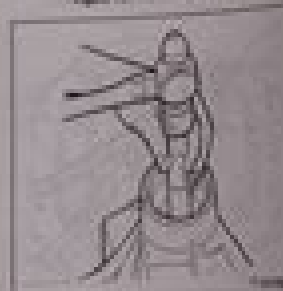


Figure 11—Assembling the Ring Gear



Figure 12—Assembling the Pinion and Ring Gear

### Pinion

#### Inspect

- The pinion teeth for noise or scoring that would reduce the wear properties of the pinion teeth from either normalizing burn and wear fluting.
- The bearing and shaft for noise or fluting. Measure and record the noise.
- The pinion for noise. Replace the pinion if it is noisy or worn.
- The bearing for noise. Replace the bearing if it is noisy or worn.
- The bearing for noise. Replace the bearing if it is noisy or worn.
- The bearing for noise. Replace the bearing if it is noisy or worn.

### Assemble

#### Inspect

- Check pinion and ring gear teeth for scoring, chipping, scoring, or excessive wear.
- Check pinion for wear.
- Check pinion for noise.
- Check pinion for noise.
- Check pinion for noise.
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### Pinion and Ring Gear

#### Inspect

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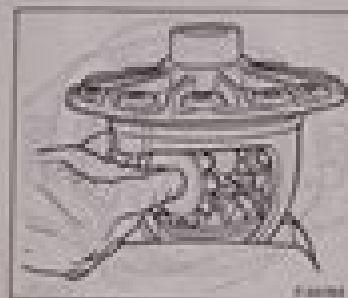


Figure 17—Installing the Pinion Gear

### Notes

#### Inspect

- Check for scoring and chips. Scoring marks should be removed with an emery cloth before use.

## ASSEMBLY OF THE REAR AXLE

### Pinion Assembly

#### Differential Case Assembly

##### Install or Remove (Figure 1)

1. Lubricate all parts with oil and grease.
2. New side gear thrust washers (27) to the side gear (28).
3. Side gear (28) to the differential case.
  - Place the side gear in place on the same side as removed (Figure 1).
4. Pinion gear (29) to the differential without the thrust washers (26).
  - Place the pinion gear into the side gear so that the holes in the pinion gear are 180 degrees apart.
  - Rotate the pinion gear so that the holes in the pinion gear are 180 degrees apart.
5. New thrust washers (26).
6. Rotate the pinion gear toward the differential bearing just enough to ride in the pinion thrust washers.
7. Pinion shaft (30).
  - Align the lock pin holes in the case and the shaft.
8. Lock pin (31) (Figure 18).
  - Place the lock pin into the case and the shaft.
9. Check that the mating surfaces of the differential case and the ring gear are clean and free of oil.
10. Ring gear (32) to the differential case (33).
  - Thread two bolts into the ring gear to remove noise.



Figure 18—Installing the Lock Pin

### Notes

- Place the ring gear into the case, and align the holes in the case with the shaft.
- New ring gear bolts (34) (Figure 19).
- Tighten the ring gear bolts alternately in stages gradually pulling the ring gear into the differential case.

### Tighten

- The new ring gear bolts in sequence in 180° (in 180° to 180°) after 10 "torque" for best performance.
- Rotate differential bearings (35) (Figure 19) to the differential (Figure 20).
- Refer to "Determining Total Drive Shaft Size" in this section.

### DETERMINING TOTAL DIFFERENTIAL DRIVE SHAFT SIZE

1. Assemble the differential case (33) to the axle housing. The pinion must not be installed.



Figure 19—Installing the Ring Gear Bolt

# Chevrolet Truck Repair Guide

**Chilton Book Company**



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