

MD-525 MINI-LOCKER SIDE GEAR MODIFICATION

GENERAL NOTES

Without modification the Mini-locker side gears will not allow the drive flanges to fit all the way in the differential. The out board splines on the side gear will bottom out on the drive flange splines prematurely.

PROCEDURE

1. Disassemble side gear by tapping through the 3 holes on the side gear thrust surface. Circlip and inner ring will come out of groove.
2. The splines on the side gear will need to be machined back about .300" on the out board side. This will allow the side gear to slide further down the splines on the drive flange. Make sure to de-burr the splines after machining for a good slip fit. The splines on the drive flange will stick out the side gear by about .125" when the splines have been machined back enough.
3. Spread circlip from outer side, and put over inner ring. With clip still spread, install into the groove of the side gear as far as it will go. Finish by tapping ring and clip completely into groove of side gear.
4. After side gears have been reassembled please follow installation instructions provided by manufacturer.



IF YOU HAVE ANY QUESTIONS

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