G0015 Leg Tilt Housing Removal and Bearing Replacement

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1. Raise the stabilizer housing high enough to place a 75x75mm block of wood or similar between stabilizer tilt cylinder and the module base.
2. Lower the cylinder until it is in contact with the 75x75mm block. Ensure no wiring or hydraulic hoses are crushed.
3. Remove the pin keeper bolts from the pin that connects the tilt cylinder to the stabilizer tilt housing. You may need to heat the bolt heads to break the loctite.
4. Disconnect the Smartlift sensor wires from module junction box, either junction box C or D. Ensure you mark where each cable is removed from and also which terminal each wire is removed from. Failure to do this may result in the connection of a wire in the wrong place, damaging the ECUs.
5. Remove the 16mm plug situated in the top of the leg extension housing. Fit an eye bolt into this lifting point.
6. Release residue pressure and then disconnect the hydraulic hoses that go around stabilizer tilt housing pivot pin (pin H). Plug the hoses and cap the pipes.
7. Remove pin keeper bolts from the pin (pin H) that connects the stabilizer tilt housing to the module base. You may need to heat the bolt heads to break the Loctite.
8. Attach a lifting strop from an overhead crane, or similar lifting device, to the eye bolt and take the weight of the stabilizer tilt housing.
9. Draw out the pin H using a pin puller. The stabilizer tilt housing should now only be connected to the stabilizer tilt cylinder.
10. Draw out the pin connecting the stabilizer tilt housing to the tilt cylinder using a pin puller. The stabilizer tilt housing should now be free and ready for removal from the Sidelifter.
11. Remove and wash the stabilizer tilt housing.
12. Place the stabilizer tilt housing on trestles to allow repairs to be carried out.
13. Clean the bore by cleaning with a light hone. Do not over hone, as this will over size the bore and the bearings will not stay in place.
14. Remove the pin H bearings:
    1. Find the joint in the bearing and with a small, sharp cold chisel work the edge of the join in towards the centre of the bearing. Take care not to damage the surface of the bore.
    2. Once one corner of the bearing is bent out, continue working down the split of the bearing. This will eventually cause the two surfaces of the bearing to overlap and the bearing will shrink, allowing easy removal.
15. Clean the bore by cleaning with a light hone. Ensure you do not over hone, as this will over-size the bore and the bearings will not stay in place.
16. Check the bore size and ensure that the bearings are a firm fit.
17. Prime the bore with Loctite bearing retainer compound.
18. Drive new bearings into the bore with a drift. Bearings should be flush with the bore.
19. Check bearing clearance with the new pin to be fitted. The pin should turn freely. Do not hone new bearings to suit the pin as the new bearings have a Teflon coating.
20. Lightly grease the bearings before assembly.