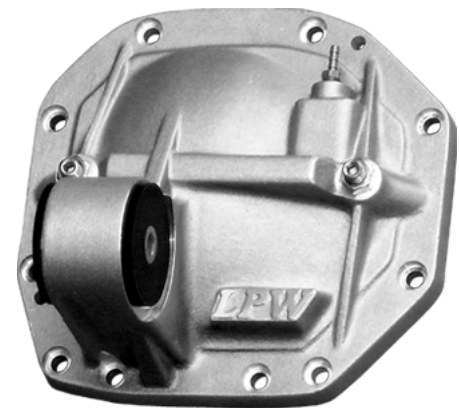


# ULTRA-IRS™

## Cover Installation

1. Prepare the housing for cover installation by cleaning the gasket surface and all cover mounting bolt holes.
2. Inspect the bearing caps and gears for excessive wear or cracks, replace if necessary
3. Remove the load bolt locking nuts and adjust the load bolts so they will not contact the bearing caps during cover installation.  
**Note: Adjust the swivel feet until they pivot freely on the load bolts before cover installation.**
4. Apply silicone gasket sealant to the cover gasket surface. Also apply a small amount to the load bolt threads at the locking nut area to provide a positive seal once the load bolt is adjusted and locking nut installed.
5. Install support cover with all the cover mounting bolts finger tight.
6. Torque the cover mounting bolts. Torque cover part# 201-8.8IRS mounting bolts to 25ft/lbs. Torque cover part # 201-10IRS mounting bolts to 41 ft/lbs.
7. Torque the load bolts to 10ft/lbs.  
**Note: Do not exceed 10ft/lbs of torque or bearing distortion and component failure will occur.**
8. Install and torque the load bolt locking nuts to 10ft/lbs.  
**Note: Do not over torque the load bolt locking nuts.**
9. Add fluid to correct level.  
**Note: LPW support covers increase fluid volume approximately one pint.**



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