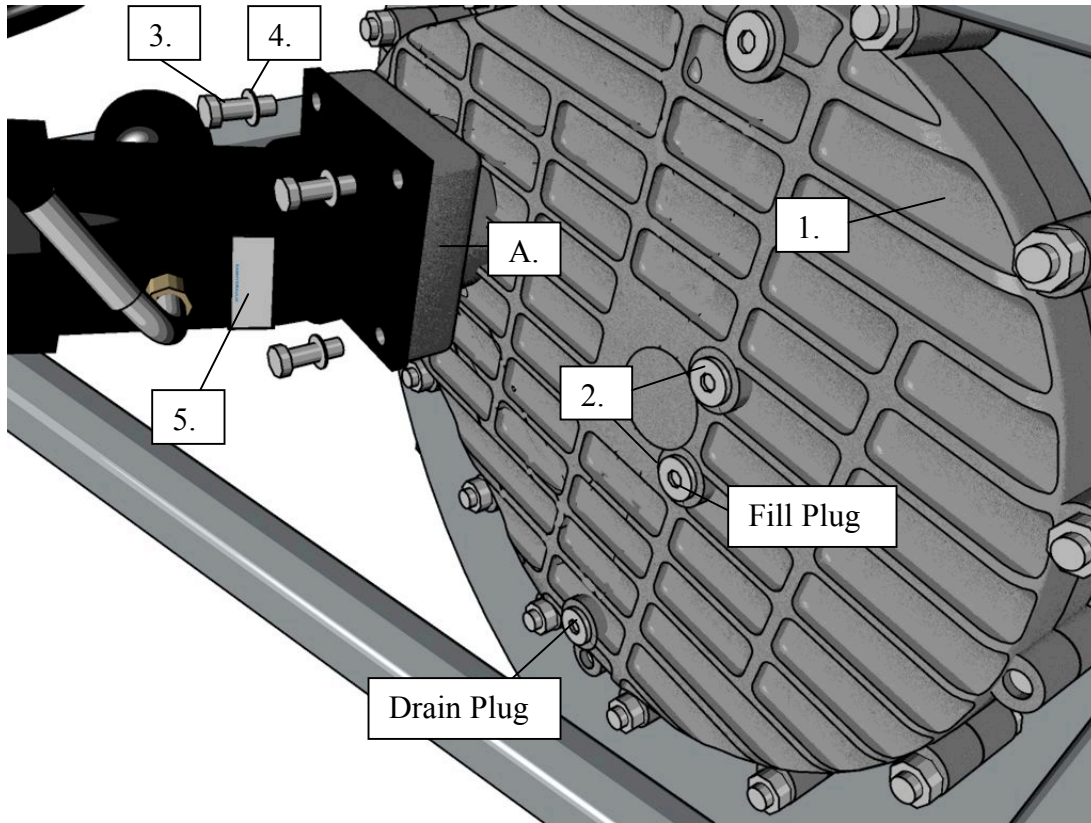


**PIPE MONSTER TRANSMISSION REPAIR AND PARTS MANUAL**

**PBL ENTERPRISES**

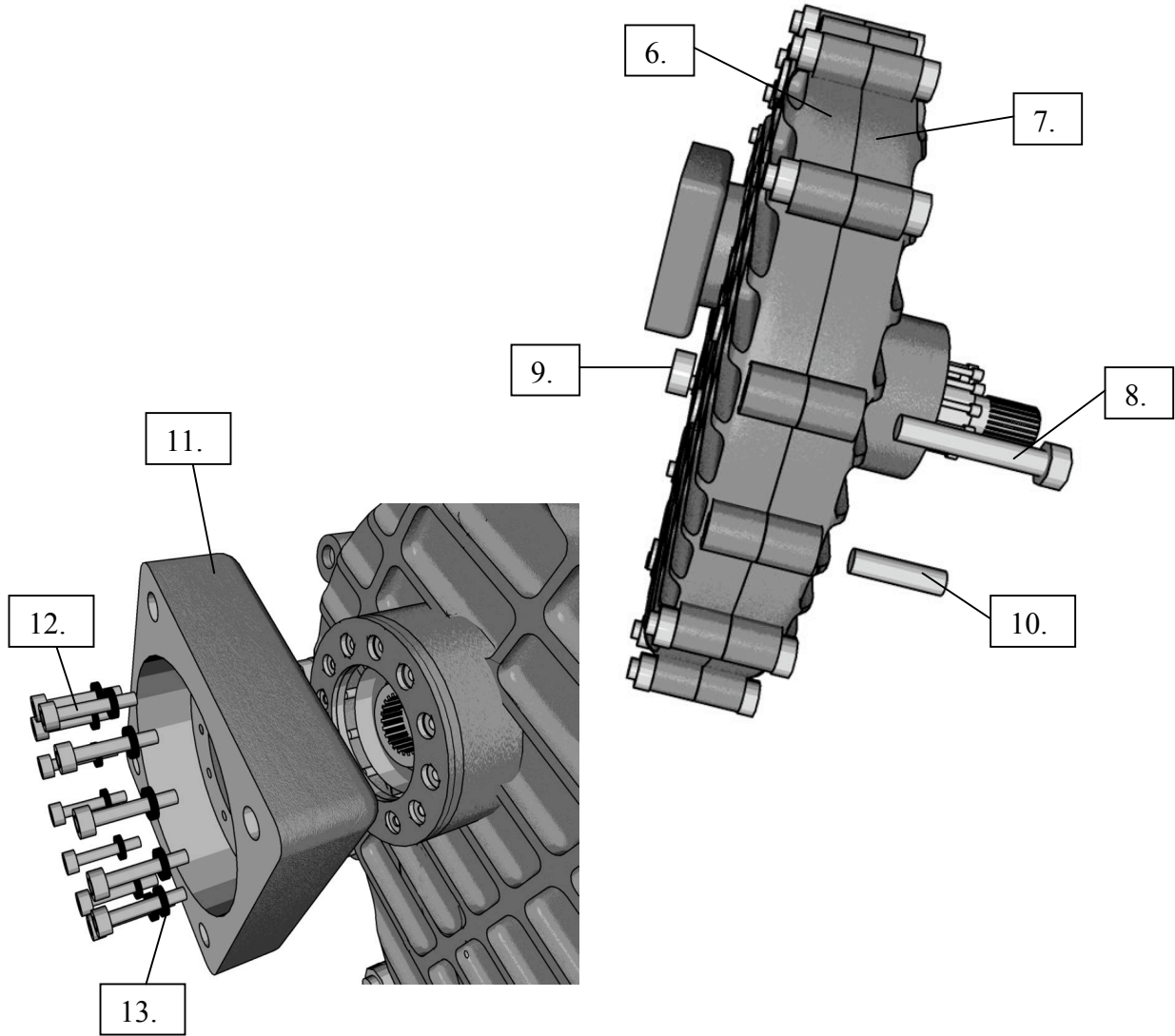
<http://service.zauggamerica.com>

## Drain and Fill Plugs



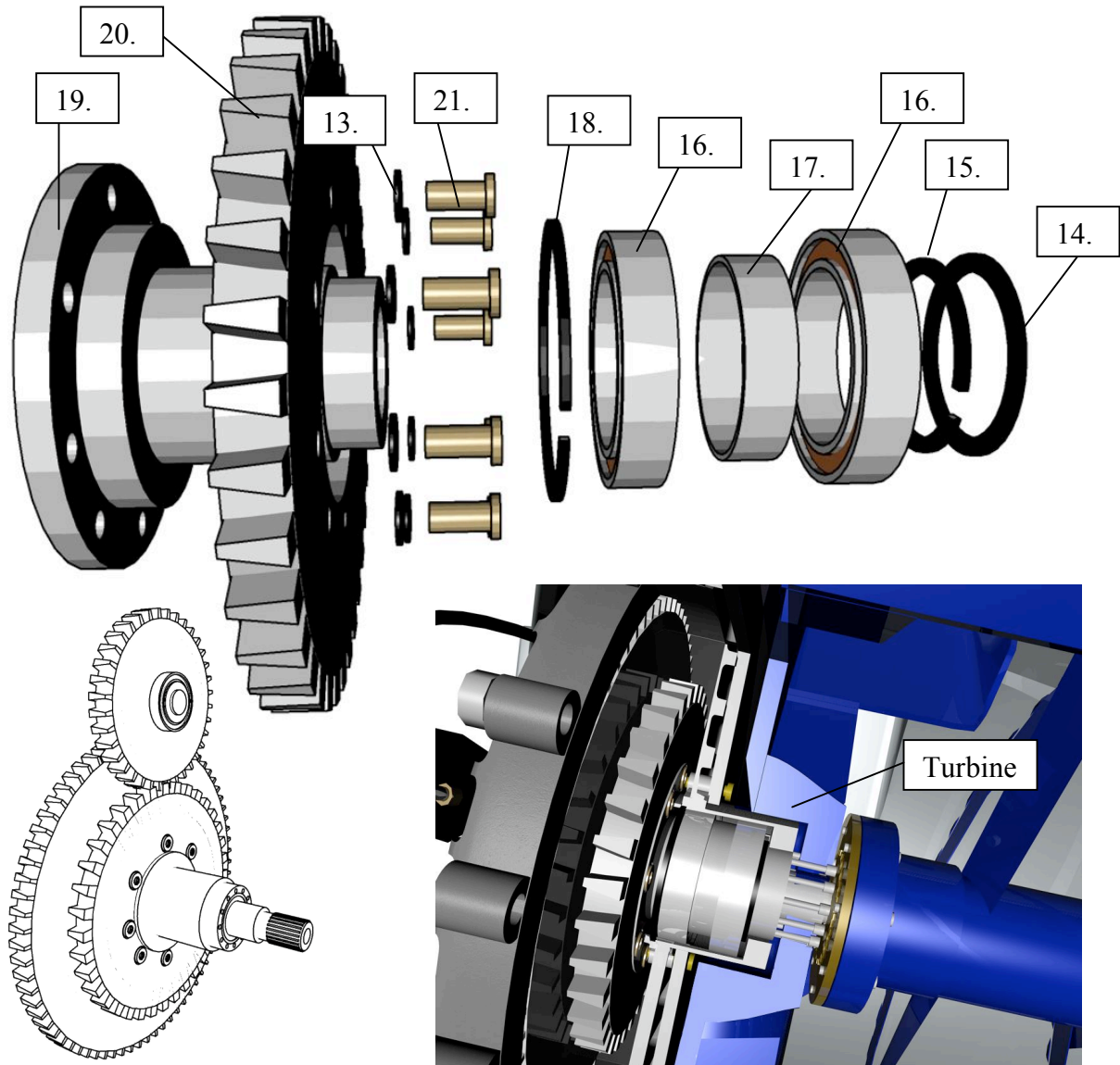
A. The aluminum motor mount flange must be warmed up to remove or install the drive motor. All it takes is a small amount of heat to allow the aluminum housing to expand.

## Outer Case



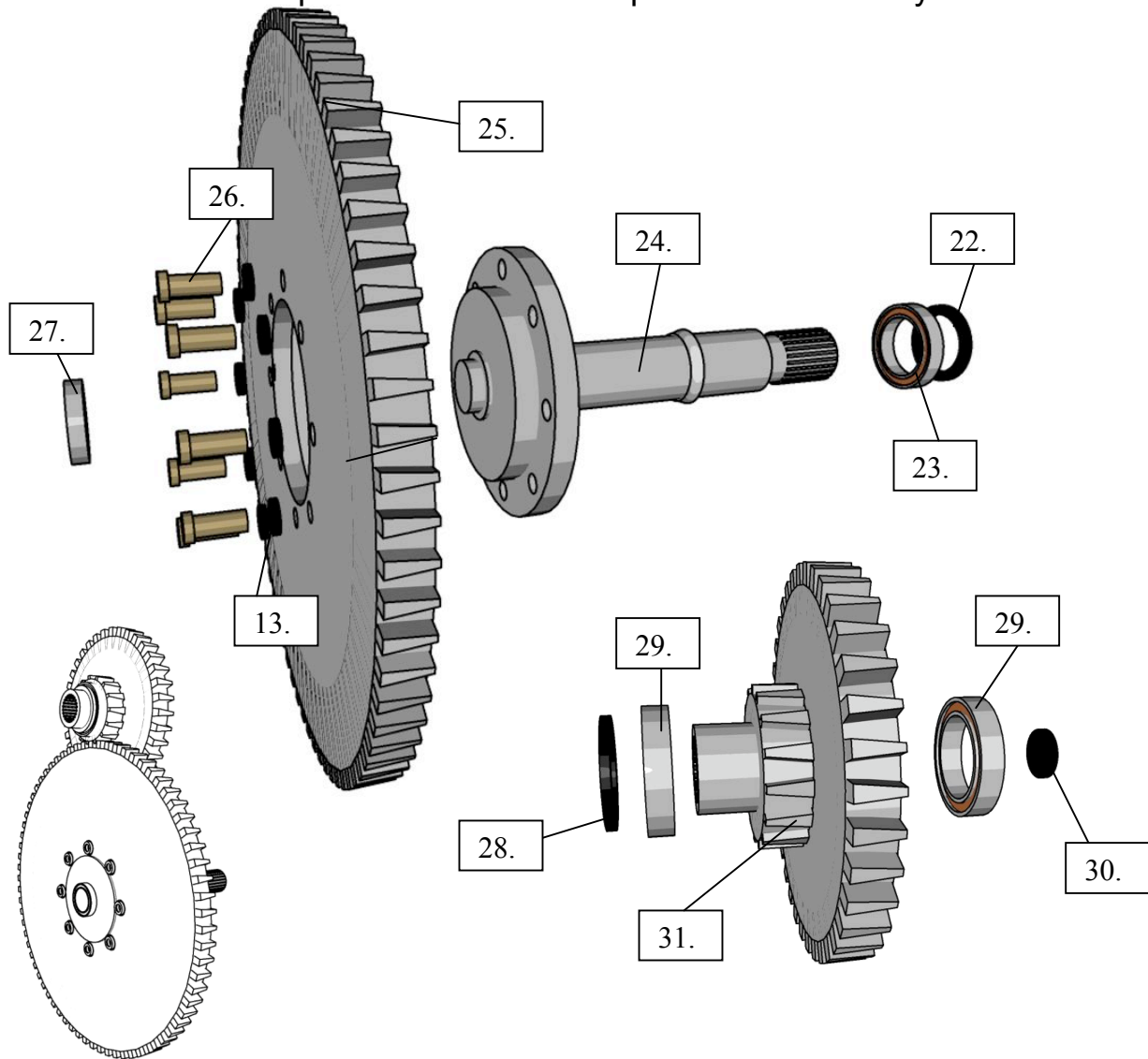
This area is for information regarding maintenance on these parts.

## Turbine Drive Gear assembly



14-15. The seal and snap ring must be removed first to access the Gear and bearings.

## Haspel Drive Gear and Input Shaft Assembly



24. This Spline shaft will break first if a rock or other debris stops the haspels from turning.

## Transmission Parts List

|    |                    |                                   |
|----|--------------------|-----------------------------------|
| 1  | SF 2953-0-103      | Transmission                      |
| 2  | VSTI R1/2Z-ED      | Drain Plug                        |
| 3  | D931 M16X45        | Hex head cap screw 8.8            |
| 4  | NT 201 M16         | Washer                            |
| 5  | HY 1537-0-108      | Hydraulic Motor                   |
| 6  | SF 6908            | Outer case front                  |
| 7  | SF 6907            | Outer case back                   |
| 8  | D931 M10X65        | Hex head cap screw 8.8            |
| 9  | D985 M10           | Lock nut                          |
| 10 | D1474 8X25         | Dowel Pin                         |
| 11 | SF 4859            | Hydraulic Motor Flange            |
| 12 | D7984 M10X30       | Cylinder head stud 8.8            |
| 13 | NT 204 M10         | Washer                            |
| 14 | D3760 A 120/150X12 | Oil Seal                          |
| 15 | D471 A 120X4       | Snap Ring                         |
| 16 | 6024               | Ball Bearing                      |
| 17 | SF 6906            | Spacer                            |
| 18 | D472 J 180X4       | Snap Ring                         |
| 19 | SF 6905            | Turbine Gear Base                 |
| 20 | SF 6902            | Turbine Gear wheel 68 cogs        |
| 21 | D7984 M10X25       | Cylinder head stud 8.8            |
| 22 | D3760 A 50/80X8    | Oil Seal                          |
| 23 | 6210               | Ball Bearing                      |
| 24 | SF 6904-0-102      | Haspel Gear Base and Spline Shaft |
| 25 | SF 6903            | Haspel Gearwheel 81 cogs          |
| 26 | D7984 M10X20       | Cylinder head stud 8.8            |
| 27 | 6208               | Ball Bearing                      |
| 28 | D3760 55/85X8      | Oil Seal                          |
| 29 | 6211               | Ball Bearing                      |
| 30 | NT 193 47X7        | Welch Plug                        |
| 31 | SF 6901            | Double Gearwheel                  |