

Description Atlas Units built before serial 12313

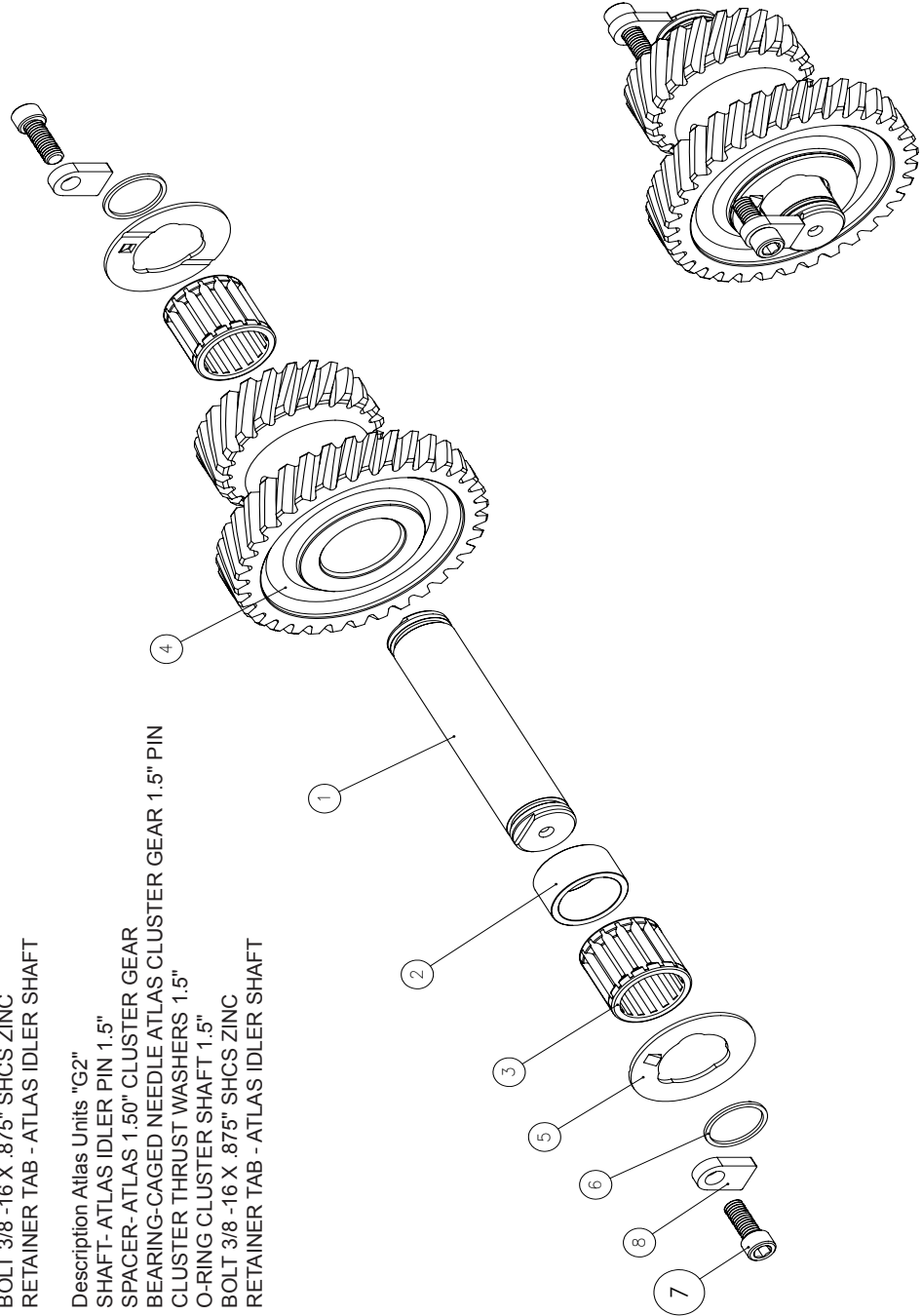
QTY	No.	Description
1	300122	CLUSTER PIN 1-1/4" SHORT
2	300357	SPACER - ATLAS 1 1/4" IDLER GEAR
3	300516	BEARING CAGED NEEDLE ATLAS 1 1/4" IDLER GEAR
5	300355	THRUST WASHER - ATLAS 1 1/4" IDLER GEAR
6	300358	O-RING 121 - ATLAS 1 1/4" IDLER SHAFT (Also 716708)
2	300359	BOLT-ATLAS CLUSTER SHAFT 12PT. 3/8 -16 X 1/2
2	723750	SEAL WASHER

Description Atlas Units built after serial 12314

QTY	No.	Description
1	300122A	SHAFT - ATLAS 1-1/4" IDLER
2	300357	SPACER - ATLAS 1 1/4" IDLER GEAR
3	300516	BEARING CAGED NEEDLE ATLAS 1 1/4" IDLER GEAR
5	300355	THRUST WASHER - ATLAS 1 1/4" IDLER GEAR
6	300358	O-RING 121 - ATLAS 1 1/4" IDLER SHAFT (Also 716708)
7	723774	BOLT 3/8 -16 X .875" SHCS ZINC
8	300361	RETAINER TAB - ATLAS IDLER SHAFT

Description Atlas Units "G2"

QTY	No.	Description
1	300122B	SHAFT- ATLAS IDLER PIN 1.5"
2	300367	SPACER- ATLAS 1.50" CLUSTER GEAR
3	300519	BEARING-CAGED NEEDLE ATLAS CLUSTER GEAR 1.5" PIN
5	300356	CLUSTER THRUST WASHERS 1.5"
6	300366	O-RING CLUSTER SHAFT 1.5"
7	723774	BOLT 3/8 -16 X .875" SHCS ZINC
8	300361	RETAINER TAB - ATLAS IDLER SHAFT





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P/N: Atlas Idler Gear

ITEM NUMBER 4 OPTIONS 1.250" IDLER

1	309420-FFA	2.11:1 IDLER GEAR (CURRENT 2.0:1 UNITS BUILT AFTER 4/14)
2	309420-FF	2.09:1 IDLER GEAR (OLD 2.0:1 UNITS BUILT BEFORE 4/14)
3	309430-FF	3.0:1 IDLER GEAR
4	309438-FF	3.8:1 IDLER GEAR
5	309443-FF	4.3:1 IDLER GEAR
6	309450	5.0:1 IDLER GEAR

ITEM NUMBER 4 OPTIONS 1.500" IDLER

1	310415-FFA	1.5:1 IDLER GEAR
3	310420	2.11:1 IDLER GEAR (2:0:1)
3	310430	3.0:1 IDLER GEAR
4	310438	3.8:1 IDLER GEAR
5	310443	4.3:1 IDLER GEAR

The idler gear has been updated over the years. The two most notably were the longer shaft in January 2012 and the larger idler 1.500" in October 2016.

Idler sub-assembly:

1. Apply assembly lube to one side of each idler gear thrust washer (item 5). This will help retain the washers in place while installing the idler gear assembly.
2. Install rear idler gear thrust washer inside case as shown.
3. Install idler gear shaft (item 1) from back side of transfer case, aligning flat relief area parallel with bottom of transfer case.
4. Push cluster gear shaft through rear case opening until flush with inner surface of rear cluster shaft washer (item 5).
5. Install front idler shaft washer to front inside of case. Use a socket to center the washer to the case during the install of the gear.
6. Install idler gear needle bearings and spacer into the idler gear.
7. Gently lower the idler gear into the main housing. Make sure the thrust washer do not fall down into the case. This is crucial as if they are not retained by the idler pin they will be consumed by the gears during operation and the entire unit may be destroyed.
8. Rotate front/rear output yokes back and forth until the cluster gear assembly drops into alignment.
9. Install first O-ring on back side of idler shaft.
10. Push cluster shaft through idler gear until the second O-ring groove is exposed on the opposite side of the main housing
11. Install second o-ring on exposed cluster shaft groove.
12. Install both idler shaft retaining tabs and bolts.

