

## Rear Planetary Rebuild Kit

### 77731-RK For 4-Pinion Planets

4 Pinion Gears  
4 Pinion Pins  
80 Rollers  
8 Washers (round)  
8 Bat Wing Washers

### 77731-02K Pinion Pin Kit

4 Pins  
**Note:** Pinion endplay factory specification of between .008" to .024".

Also available separately

### 77731-01

1 Pinion Gear

### 77731-03

80 Needle Rollers

### 77731-04

1 Round Washer

### 77731-05

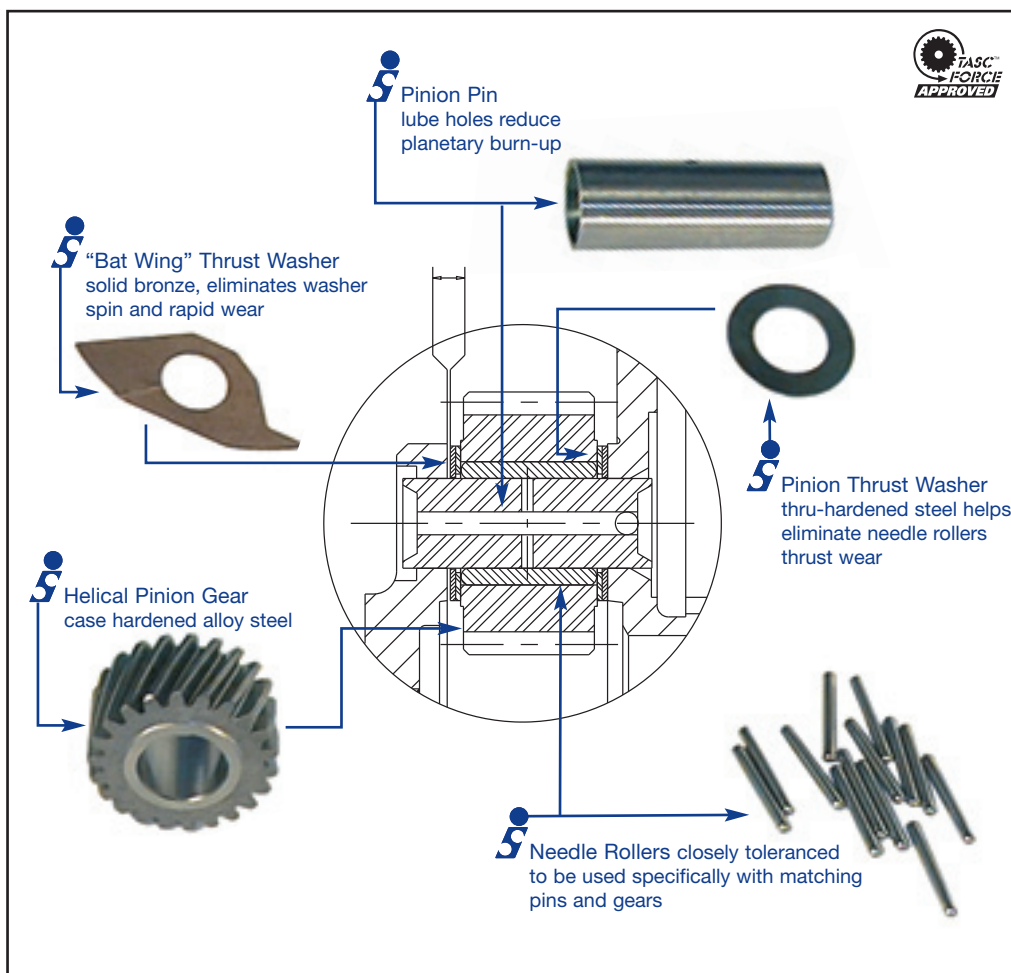
1 Batwing Washer

### 77731-08

1 Oil Deflector

### 77731-09

1 Thrust Bearing



### Installation Instructions

1. Inspect the carrier for cracks or spline wear.
2. When replacing the bat wing and steel thrust washers, the steel washer should be sandwiched between the helical gear and the bat wing washer. The bronze bat wing washer should be positioned such that the diagonal recessed oil groove is facing the steel washer, and the solid back is facing the reaction carrier.
3. Each helical gear should have 20 needle roller bearings surrounding the bore. A convenient method of holding these bearings in place during assembly is by using a shortened pin and Trans-Jel™.
4. When inserting the pinion pin, make sure that the opening to the axial blind hole is facing the top of the carrier, as indicated below. This will allow the oil deflector to direct lube down the pin hole and toward the needle rollers.
5. Stake the pinion pins in place such that the ends do not protrude past the recessed pockets in the reaction carrier. The pins should be staked on both ends.
6. It is recommended, especially in heavy-duty applications, to use the stamped oil deflector 77731-08 for added lubrication. This deflector is pressed onto the top of the reaction carrier after all necessary bearings, pins, washers, and gears have been replaced.

**Note:** When rebuilding individual gear assemblies, the best fix is obtained using only Sonnax gears, pinion pins and rollers.