The number at the bottom gives the cone setting distance of the pinion and may be Zero (0), Plus (+) or Minus (−). When correctly adjusted, a pinion marked Zero will be at the zero cone setting distance, dimension "B" in Figure 8, from the centre line of the gear to the face on the small end of the pinion; a pinion marked Plus Two (+2) should be adjusted to the nominal (or Zero) cone setting plus .002", and a pinion marked Minus Two (−2) to the cone setting distance minus .002".

The Zero Cone Setting Distances for the various SALISBURY axles are as follows:—

MODEL 6HA	2.000"
. HA	2.125"
7HA	2.219"
3HA & 3HU ...	2.250"
4HA & 4HU ...	2.625"
2HA	2.750"
5HA	2.968"

The various dimensions shown in Figure 8 are tabulated on Page 25, Table 6.

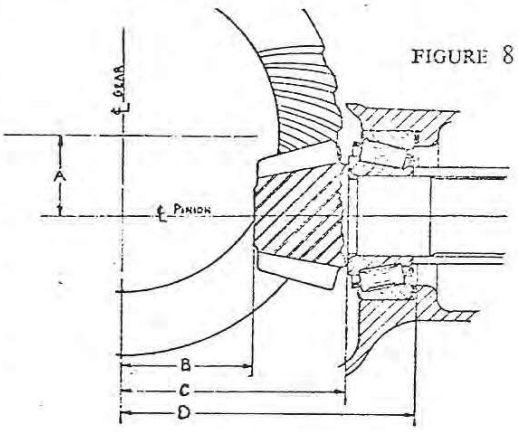

FIGURE 8

Thus, for a model 3HA pinion marked Minus Two (−2) the distance from the centre of the drive gear to the face of the pinion should be 2.248" (i.e. 2.250"—.002") and for a pinion marked Plus Three (+3) the cone setting distance should be 2.253".

When the pinion bearing cups have been installed in the gear carrier, with the original pinion inner bearing adjusting shims, as described in items 7 to 10 in the section entitled "Differential Bearing Adjustment", proceed with pinion adjustment as follows:—

(1) Place the pinion, with the inner bearing cone assembled, in the gear carrier.

(2) Turn the carrier over and support the pinion with a suitable block of wood for convenience before attempting further assembly.

(3) Install the pinion bearing spacer if fitted on the unit under repair (see Figure 1 for alternative construction).

(4) Install the original outer bearing shims on the pinion shank (or if fitting the abutment washer referred to in the note at the end of the section on "Removing Pinion", the original shims, less .048") so that they seat on the spacer or a shoulder on the pinion shank, according to the construction of the unit.

(5) Fit pinion outer bearing cone, companion flange, washer and nut only, omitting the oil slinger and oil seal assembly, and tighten the nut.

(6) Check the pinion cone setting distance by means of the gauge Tool No. SL.3P (SE.107), see Figure 9. The procedure for using the gauge SE.107 is:—

(a) Adjust the bracket carrying the dial indicator to suit the model being serviced, then set the dial indicator to zero with the setting block.

TABLE 6. SERVICE DATA

For key to dimensions in Section *(a)* refer to Figure 8, Page 14.

	Model	6HA	HA	7HA	3HA 3HU	4HA 4HU	2HA	5HA
(a)	Pinion Drop "A" ...	1.000″	1.250″	1.000″	1.375″	1.500″	1.750″	1.750″
	Zero Cone Setting "B" ...	2.000″	2.125″	2.219″	2.250″	2.625″	2.750″	2.968″
	Mounting Distance "C"	3.375″	3.625″	3.562″	3.937″	4.312″	4.625″	4.906″
	C/L to Brg. Housing "D"	4.193″	4.848″	4.753″	5.130″	5.505″	5.818″	6.131″
		4.183″	4.838″	4.743″	5.120″	5.495″	5.808″	6.121″
(b)	Axle Shaft End Float ...	.006″ to .008″ unless Disc Brakes fitted, then .003″ to .005″						
	Torque Spanner Setting ...	40-50	40-50	⅜″ 50-60	⅜″ 50-60	⅜″ 50-60	40-50	70-80
	Drive Gear Bolts lbs.ft. ...				7/16″ 70-80	7/16″ 70-80		
	Diff. Preload Shim Alice.	.005″ on All Models						
	Backlash	As etched on Drive Gear (Minimum .004″)						
	Pinion Bearing Preload ...	8-12lbs. in. on All Models						
	Spanner Setting for Diff. Case Securing Screws lbs. ft.				½″ 15-20 5/16″ 25-30			25-30
(c)	Torque Spanner Setting; Drive Pinion Nut ft. lbs.	6HA & 7HA		HA, 3HA, 3HU, 5HA, 2HA, 4HA, 3HU				
		95-105		120-130				

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