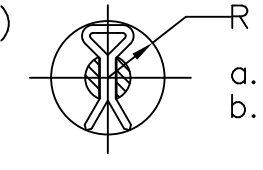
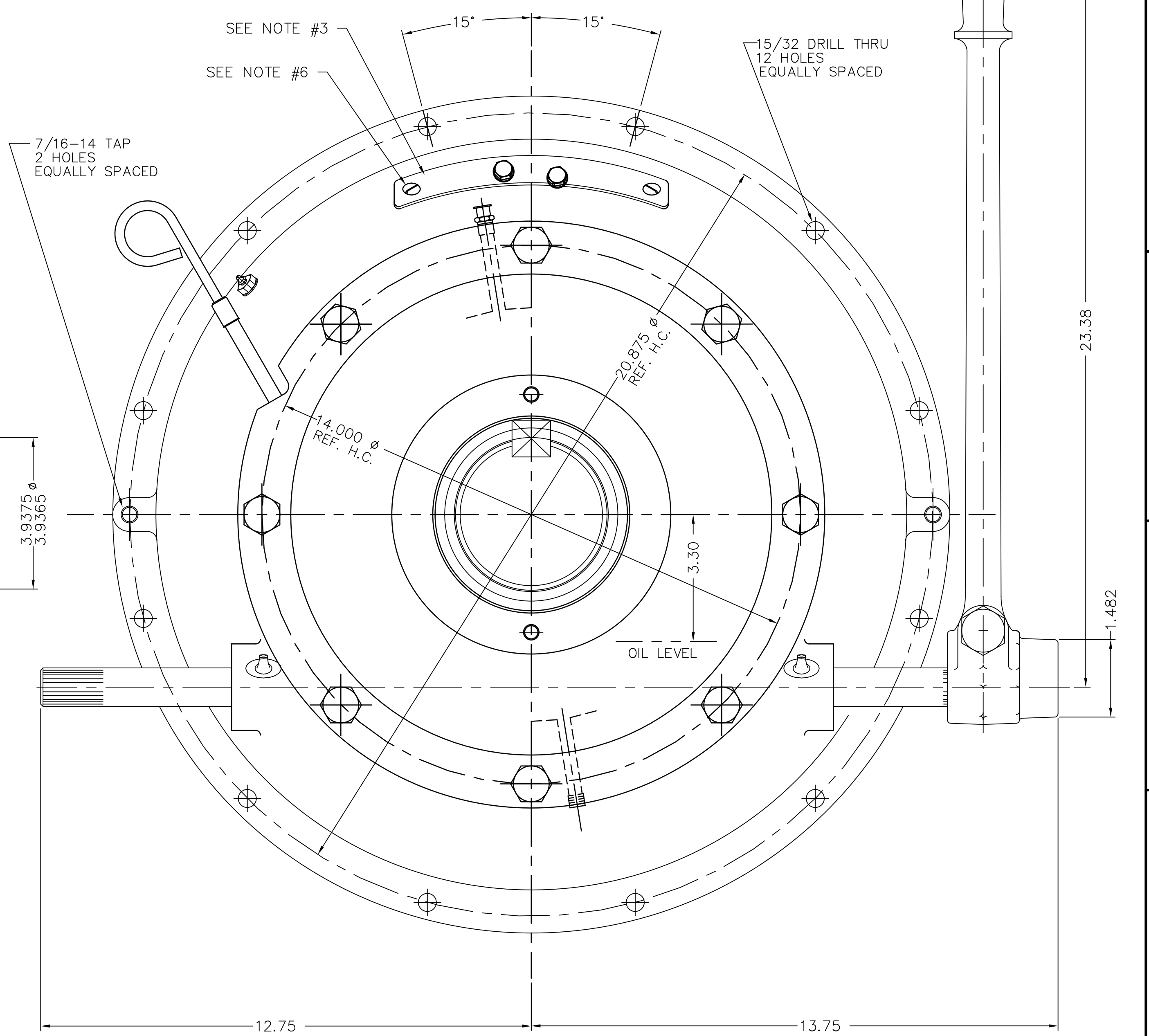


**ASSEMBLY NOTES:**

- 1.) SEAT HUB USING 30 LB. FT. (41.0 Nm) TORQUE ON NUT. THEN TIGHTEN NUT BY TURNING AN ADDITIONAL 180° TO 210°.
- 2.) 
  - a. R=.47 MAX. FOR COTTER PINS
  - b. R=.58 MAX. FOR COTTER PINS
- 3.) STAMP 163-123 IN LBS. BLOCK AND 21.3 IN INCH BLOCK FOR HAND LEVER FORCE.
- 4.) BEFORE ASSEMBLY OF SEALS, APPLY GREASE OR OIL TO LIPS AND WEAR SLEEVE SURFACES.
- 5.) BEARING ADJUSTMENT: TAKE UP BEARING RETAINER UNTIL 60 LB.-IN. IS REQUIRED TO ROTATE SHAFT WITHOUT SHIMS. MEASURE SHIM GAP AND ADD .013 TO GET PROPER SHIM THICKNESS. ASSEMBLE SHIMS AND RETAINER, BEARING ENDPLAY TO BE .006-.010 IN.
- 6.) TORQUE BOLTS TO 9±1 LB.-FT.(12 +2/-1 Nm).
- 7.) TORQUE BOLTS TO 33±3 LB.-FT.(45±4 Nm).
- 8.) TORQUE BOLTS TO 112±12 LB.-FT.(214±16 Nm).



PART NO.	A	B	TYPE
M1969A	2.8346 2.8341	1.0625 1.0575	BALL
M1985A	3.1496 3.1491	1.3750 1.3700	BALL
M2327	3.9370 3.9364	1.5625 1.5575	BALL
M2529	3.1506 3.1501	1.3750 1.3700	ROLLER
M2713	3.9384 3.9378	1.5625 1.5575	ROLLER

**GENERAL NOTES:**

- a.) REFER TO BOM LIST WHEN ORDERING PARTS.
- b.) REFER TO CARE & OPERATION MANUAL FOR ADDITIONAL INFO.
- c.) A SUPPORT PLATE MUST BE USED WHEN SIDE LOADS ARE APPLIED TO THE SHAFT.
- d.) CLUTCH MUST BE RIGIDLY SUPPORTED DURING HANDLING AND SHIPPING TO PREVENT SEAL DAMAGE.

NOTICE! THIS PRINT CONTAINS PROPRIETARY INFORMATION AND IS NOT TO BE USED IN ANY MANNER DETRIMENTAL TO THE INTERESTS OF TWIN DISC, INCORPORATED RACINE, WI 53403 - USA  
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MATERIAL	WEIGHT LBS.	WT. LBS. IN <sup>3</sup>	UNLESS OTHERWISE SPECIFIED MACHINED DIMENSIONS XX ±0.030 XXX ±0.010 XXX ±0.005 ALL ANGULAR TOLERANCES ±1° GEOMETRIC TOLERANCING PER ANSI Y14.5M 1982	DATE 5/24/94
HEAT TREAT	FIRST USE	ASSY. MODEL	NAME	DRN. RDW
SURFACE TREATMENT	NAME	APPD. JMS		

THIRD ANGLE PROJECTION  
SIMILAR TO

**TWIN DISC**  
INCORPORATED  
RACINE, WI 53403 - USA

IB314P104  
IB314P105  
IB314P106  
IB314P107  
IB314P108  
IB314P109  
IB314P110  
IB314P111

SCALE  
.50=1"

SHEET 2 OF 2 REV C