

Retrofit Instructions

Warning

Disassembly must be done in a clean environment to avoid contamination of the inner surfaces.

1. Remove square head set screws (Item 16)
2. Remove shaft seal (Item 27)
3. Remove retaining ring behind shaft seal (Item 11 on right side)
4. Using an arbor press, support the cylinder (Item 2), and press on the hub (Item 1)

Caution

The assembly removed will be heavy. Do not place fingers or handle the unit where the assembly will drop once it is pressed out of the unit.

5. Slowly and evenly remove the cap screws (Item 23)

Caution

The Assembly is spring loaded. Loosen the bolts slowly.

6. Clean gasket material off of Cylinder and spring housing (Items 2 & 20 respectively)
7. Orient the spring housing holes up.
8. Using an appropriate vice, secure the housing in a drill press.
9. Using an R (.339 inch Ø) size drill bit, drill one hole in the center of one spring pocket as shown in figure 2.
10. Flip the part over and tap a 1/8-27 NPT thread into the drilled hole.
11. Apply a small of Loctite 510 gasket eliminator to the mating faces of the Cylinder and spring housing (Items 2 & 20 respectively)

Warning

Using excessive amounts of Gasket Eliminator may result in non-actuation of the piston (Item 3) when the unit is assembled.

12. Assemble using instruction from Literature # 21187 (Enclosed , Spring-Engaged Tooth Clutch).
13. Install the air fitting (not shown) into the threaded hole.
14. Install the tube into the fitting and route the tubing toward the front of the truck.

UPDATE KIT # 910443

Part #	Description
170410	Seal, Shaft, 75 x 115 x 27
2046	Tubing, Nylon, .165 OD
2101	Fitting, Elbow, 90 Deg.
21287	Lit, Maintenance, 5H60SE,-E, SPCL

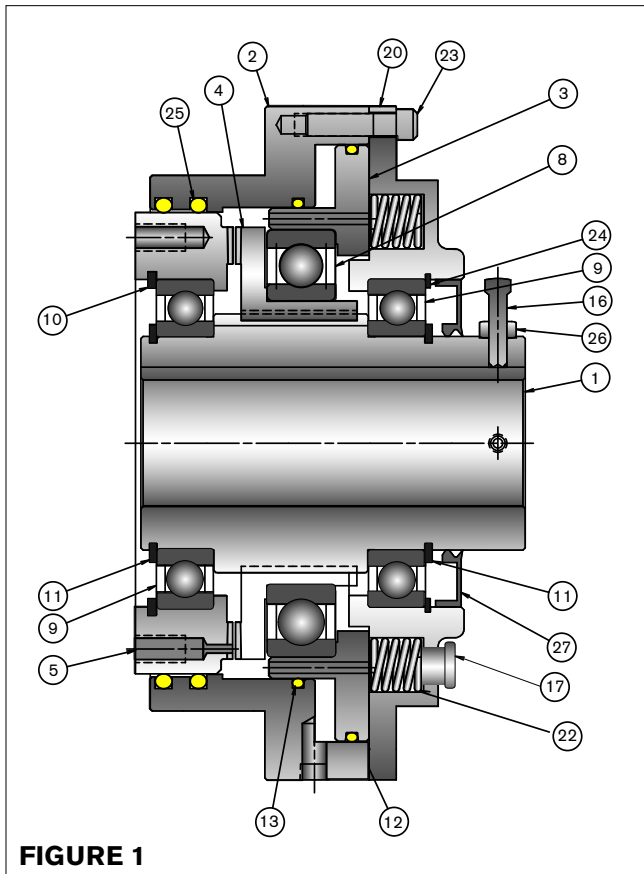


FIGURE 1

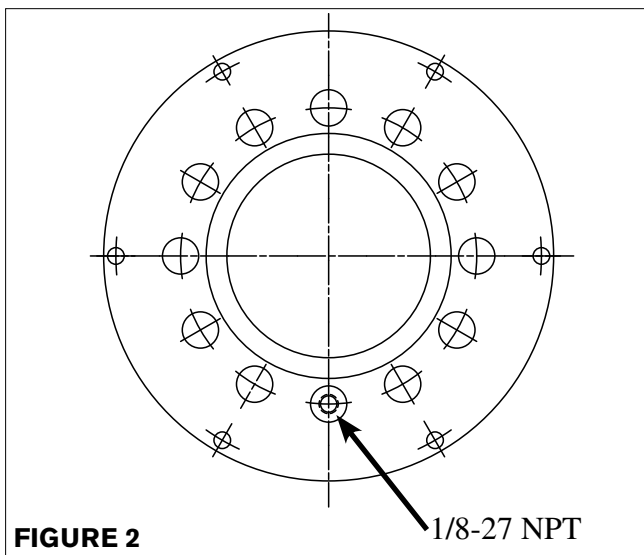


FIGURE 2