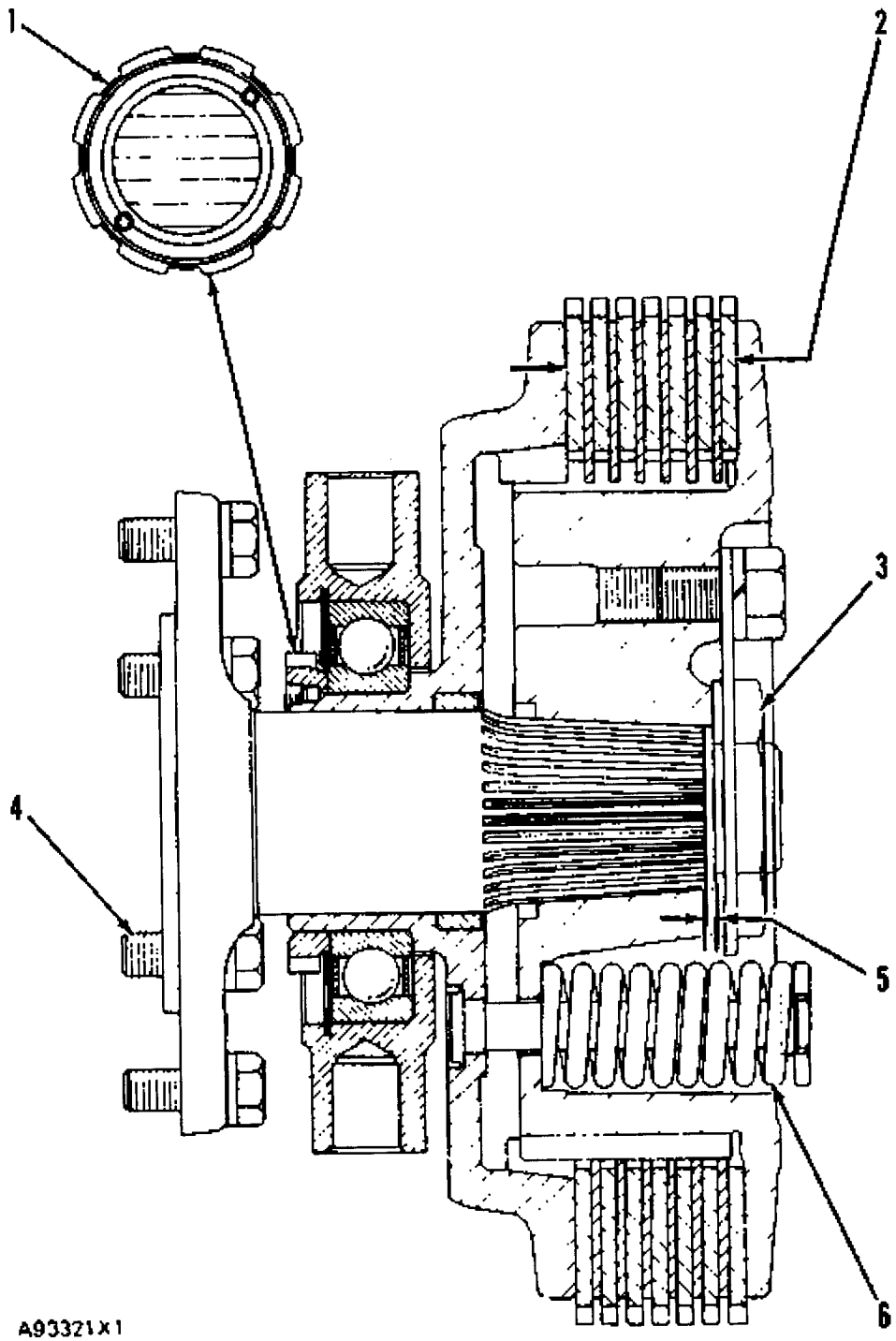
Steering Clutch



(1) Torque for the nut that holds the bearing in the cage . . . 350 ± 50 lb.ft.

(470 ± 70 N m)

Drill two 13/64in. (5.16 mm) holes .38 in. (9.7 mm) deep opposite each other on the separation line of the nut and plate assembly.

NOTE: Keep bearing free of foreign material.

Use a 1/4"-20 NC thread tap to tap both holes .31 in. (7.9 mm) deep. Install two screws and peen over.

(2) Thickness of six new driving discs and seven new driven discs . . . 1.785 to 1.939 in. (45.34 to 49.25 mm)

Minimum permissible thickness (worn) . . . 1.530 in. (38.86 mm)

Thickness of one new driven disc . . . .188 ± .005 in. (4.78 ± 0.13 mm)

Thickness of one new driving disc . . . .084 to .098 in. (2.13 to 2.49 mm)

(3) Torque for the nut that holds the drum on the shaft . . . 350 ± 50 lb.ft. (475 ± 68 N m)

(4) Torque for bolts in the shaft with 9S3263 Thread Lock on threads of bolts . . . 90 ± 5 lb.ft. (122 ± 7 N m)

(5) Distance between the face of the drum and the end of the splines on the shaft . . . .12 ± .03 in. (3.0 ± 0.8 mm)

after drum has been pushed on the shaft with a force of . . . 15 to 20 ton (135 to 180 kN)

(6) 6S3414 Spring:

Length under test force . . . 3.00 in. (76.2 m)

Test force . . . 338 ± 17 lb. (1510 ± 76 N)

Free length after test . . . 4.186 in. (106.32 mm)

Outside diameter . . . 1.442 in. (36.63 mm)