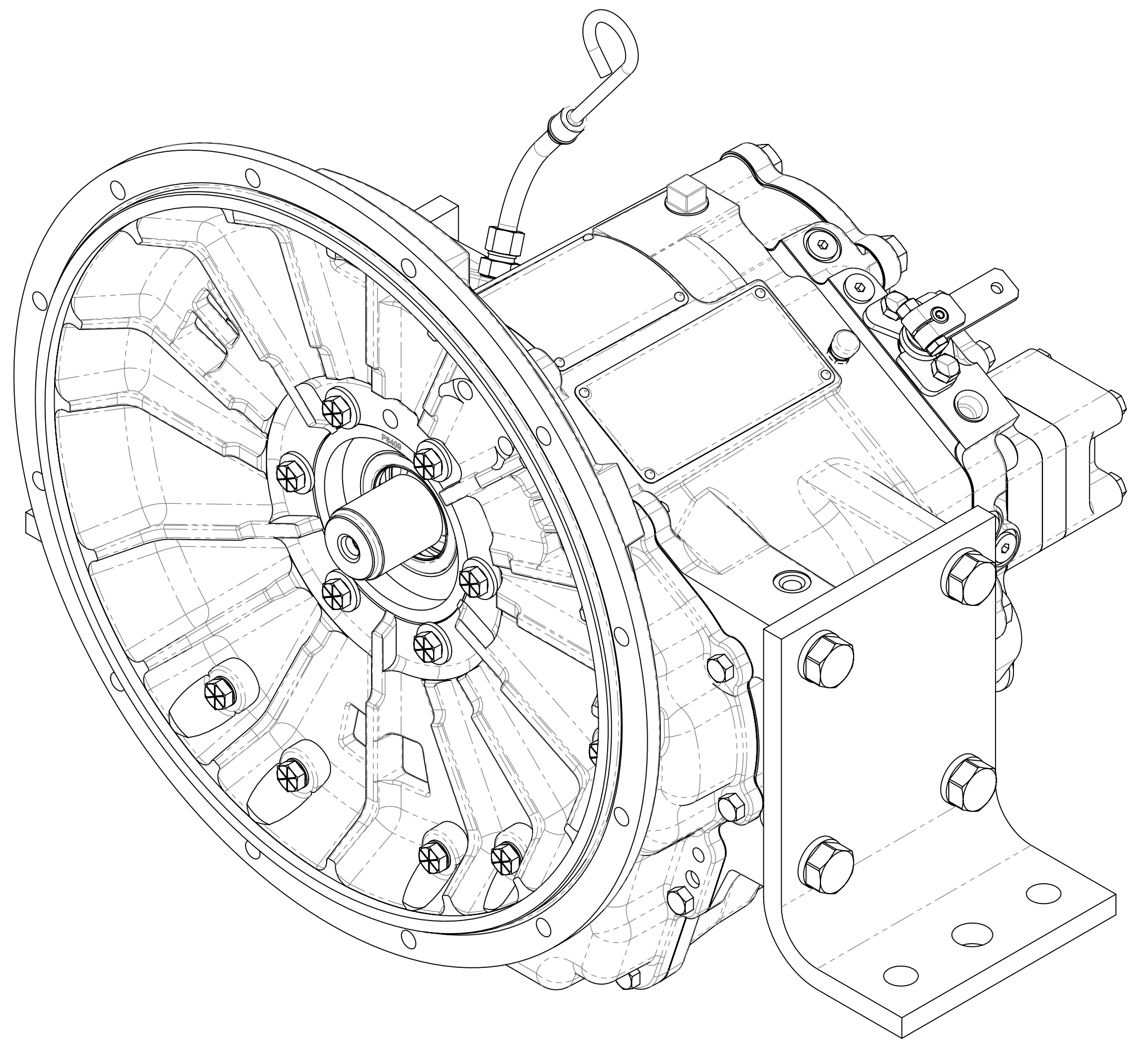


- 8  
7  
6  
5  
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3  
2  
1

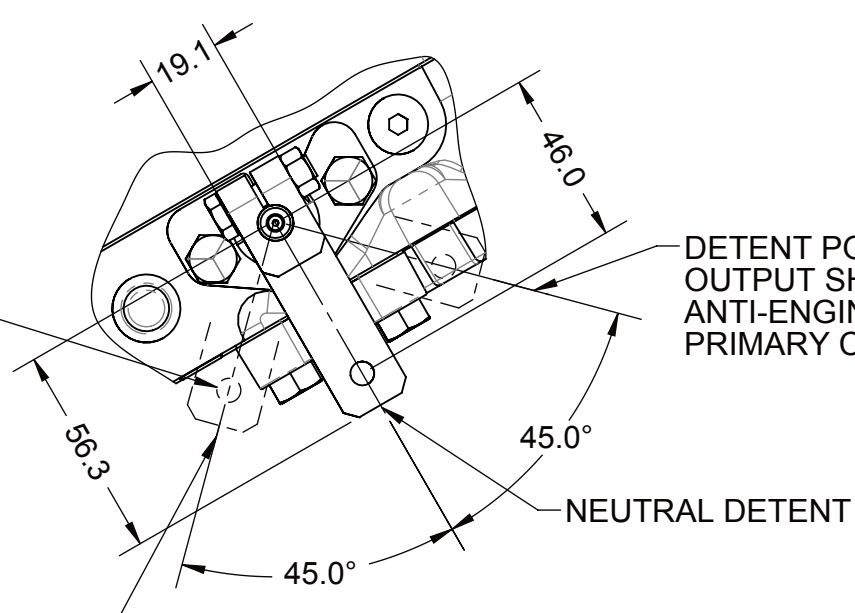
Technical drawing of a cross-section of a mechanical assembly. The drawing shows a shaft with a diameter of  $\phi 451.0$  and a length of  $\phi 428.6$  REF. B.C. The shaft is secured with a nut and a washer. The nut has a diameter of  $\phi 408.5107 \pm 0.0635$ . The washer has a diameter of  $\phi 408.5107 \pm 0.0635$ . The assembly is labeled SAE#3. A dimension of 50.5 is shown for the total length of the assembly. A dimension of 6.4 is shown for the thickness of the washer. A dimension of 10.0 is shown for the thickness of the nut. A label '1' is shown in a box.

Technical drawing of the rear view of a transmission assembly. The drawing includes the following dimensions and callouts:

- Dimensions:**
  - Overall width: 311.8
  - Distance between eye bolt mounting points: 285.8
  - Distance between eye bolt mounting points (alternative): 285.8
  - Distance between eye bolt mounting points (alternative): 190.5 FOR EYE BOLT
  - Distance between eye bolt mounting points (alternative): 134.6 FOR EYE BOLT
  - Overall height: 171.3
  - Distance between mounting points: 120.5
  - Distance between mounting points: 68.7
- Callouts:**
  - 1:** 20.6 DRILL THRU 2 HOLES
  - 2:** 17.5 DRILL THRU 4 HOLES
  - 3:** 3/8-16 UNC THREAD 33.0 DEEP. 2 HOLES FOR STANDARD EYE BOLTS. THESE BOLTS MAY BE USED FOR LIFTING MARINE TRANSMISSION ONLY.
  - 4:** OIL FILLER HOLE 1/2-14 NPTF THREAD (DRYSEAL). TIGHTENING TORQUE 68-8 N-m. 10.2mm CLEARANCE REQUIRED TO REMOVE OIL FILTER. TO ADD OIL.
  - 5:** PRIMARY CLUTCH LUBE PRESSURE PORT 1/2-20 UNF THREAD (-5). CONFORMS TO SAE J1926. TIGHTENING TORQUE 20-2.5 N-m.
  - 6:** OIL IN FROM HEAT EXCHANGER 3/8-18 NPTF THREAD DRYSEAL. CONFORMS TO 476. REMOVE THREAD PROTECTOR BEFORE USE. TIGHTENING TORQUE 37-4 N-m.
  - 7:** PRIMARY CLUTCH PRESSURE PORT 1/2-20 UNF THREAD (-5). CONFORMS TO SAE J1926. TIGHTENING TORQUE 20-2.5 N-m.
- Other Labels:**
  - QHX1**
  - QPC**
  - G**
- Notes:**
  - THE 90° LEVER ROTATION REQUIRE FALL ANYWHERE WITHIN THE 360° MAY BE CLAMPED.



CONTROL VALVE SELECTOR  
LEVER RANGE 33N (7.5 lbs) MAX.  
REQUIRED TO MOVE.  
Ø6.35 DRILL THRU.



- DETENT POSITION
- OUTPUT SHAFT TURNS
- ANTI-ENGINE ROTATION
- PRIMARY CLUTCH IS ENGAGED

[illegible]

SECONDARY CLUTCH  
PRESSURE PORT  
1/2-20UNF THREAD (-5)  
CONFORMS TO SAE J1926  
TIGHTENING TORQUE  $20 \pm 2.5$  N-m

— SECONDARY CLUTCH  
LUBE PRESSURE PORT  
1/2-20 UNF THREAD (-5)  
CONFORMS TO SAE J1926  
TIGHTENING TORQUE  $20 \pm 2.5$  N-m

13.7mm CLEARANCE  
REQUIRED TO  
REMOVE PUMP

-CENTER OF GRAVITY

NPTF THREAD(DRYSEAL)  
FORMS TO J476  
TIGHTENING TORQUE 68 ± 8 N-m  
MINIMUM CLEARANCE  
REQUIRED TO REMOVE  
RAIN PLUG

MOUNT GAGE IN PILOT HOUSE  
PRESSURE GAGE LINE LOCATION  
1/4-18 NPTF THREAD (DRYSEAL)  
CONFORMS TO J476  
TIGHTENING TORQUE  $34 \pm 4$  N-m

OIL OUT TO HEAT EXCHANGER  
3/8-18 NPTF THREAD (DRYSEAL)  
CONFORMS TO J476  
REMOVE THREAD PROTECTOR BEFORE USE  
TIGHTENING TORQUE  $37 \pm 4$  N-m

SECONDARY CLUTCH SHAFT 

1/2-13UNC, 6.3 DEEP  
47.0mm CLEARANCE  
REQUIRED TO REMOVE  
SUCTION SCREEN

4 Ø16.3 (41/64") DRILL THRU  
6 HOLES EQUALLY SPACED  
USE GRADE 8 QUALITY CAPSCREWS  
PER SAE J429 AND TORQUE TO S574  
OR SERVICE MANUAL VALUES

—R.H. ENGINE DRIVING  
THRU PRIMARY CLUTCH

**NOTES:**  
ALL POINTS AVAILABLE FOR TESTING ARE CODED

**EQUIPMENT SHOWN:**  
 - MG-5061A PER PX11640  
 - SAE#3 ADAPTOR HOUSING  
 - MECHANICAL CONTROL VALVE  
 - 1016428R MOUNTING BRACKETS

**A**