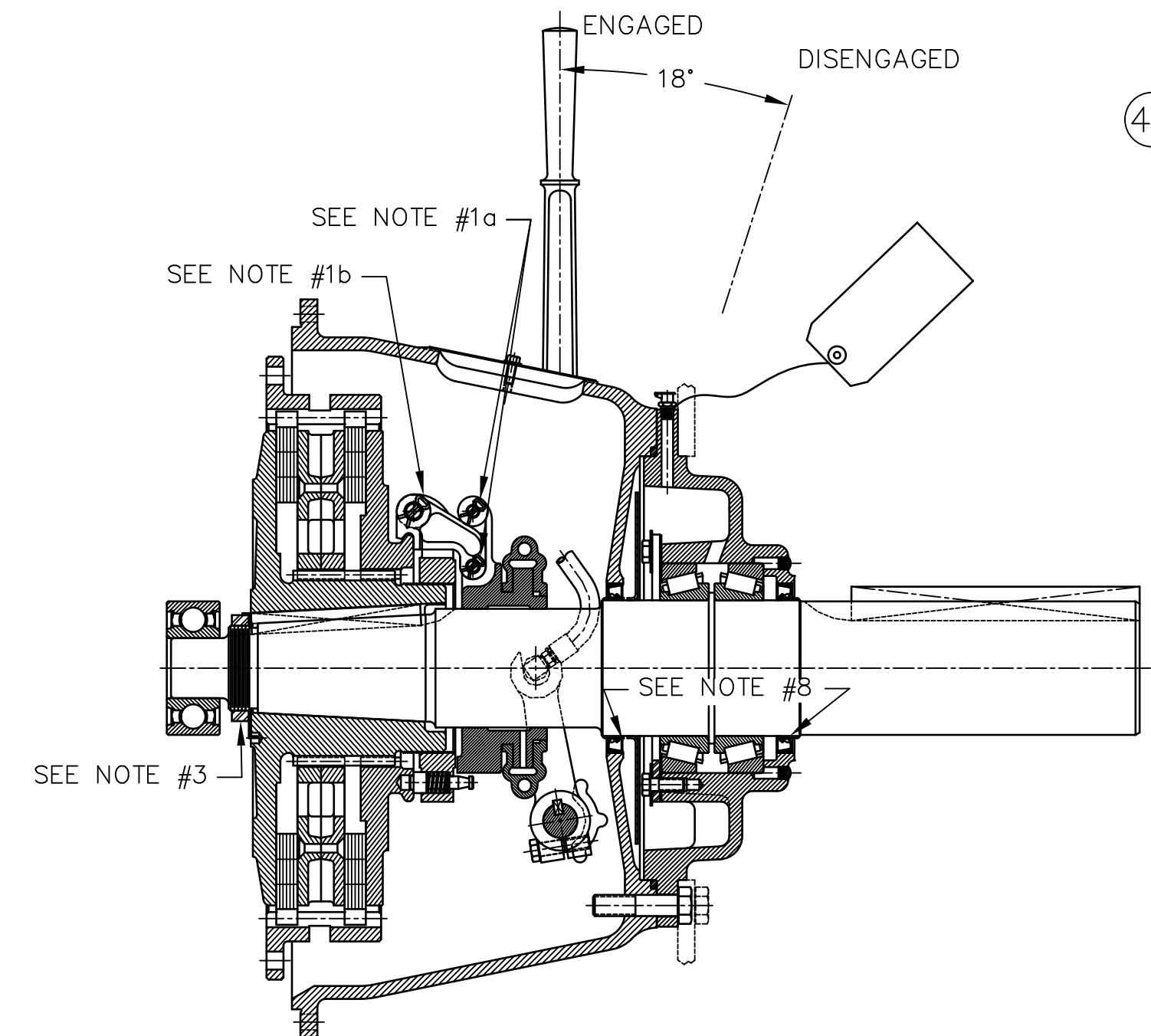
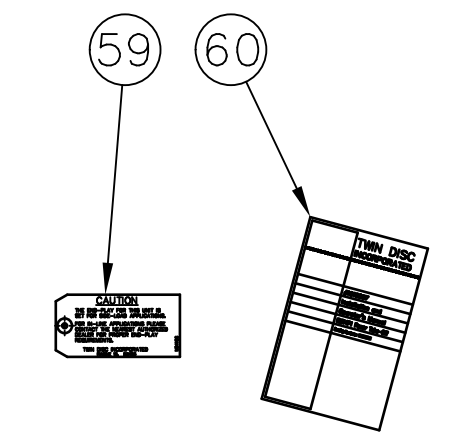


ITEM	PART NO.	101	102	103	104	105	NAME	REMARKS
1	M2006AB	8	8	8	8	8	SCREW, HX. HD.	
2	M2051B	2	2	2	2	2	PLUG, PIPE	
3	A6867E	1	1	1	1	1	CARRIER, BEARING	
4	A2885T	1	1	1	1	1	TUBE, OIL GAGE	
5	B3136E	1	1	1	1	1	GAGE, OIL LEVEL	
6	MA253	1	1	1	1	1	BREATHER FILTER	
7	M2410	1	1	1	1	1	TAG, CAUTIONARY	
8	M2686F	2	2	2	2	2	SLEEVE, WEAR	
9	MA773	2	2	2	2	2	SEALS	
10	MA590BQ	2	2	2	2	2	BEARING, CUP	
11	MA585CT	2	2	2	2	2	BEARING, CONE	
12	M2034BF	1	1	1	1	1	KEY	
13	B5244C	1	-	-	1	1	SHAFT, CLUTCH	
13	B5267B	-	1	1	-	-	SHAFT, CLUTCH	
14	M2033BH	1	1	1	1	1	KEY	
15	B2303	1	1	1	1	1	SLINGER, OIL	
16	B1648	1	1	1	1	1	SHIM	
17	B1648A	1	1	1	1	1	SHIM	
18	B1648B	1	1	1	1	1	SHIM	
19	B1648C	1	1	1	1	1	SHIM	
20	B1647	1	1	1	1	1	RETAINER, BEARING	
21	B1667	3	3	3	3	3	PLATE, LOCK	
22	M2002U	6	6	6	6	6	SCREW, HX. HD.	
23	M2327	1	-	-	1	1	BEARING, PILOT	
23	M2529	-	1	-	-	-	BEARING, PILOT	
23	M1985A	-	-	1	-	-	BEARING, PILOT	
24	1442	1	1	1	1	1	NUT, HUB	
25	A1590	1	1	1	1	1	WASHER	
26	A6518C	1	1	1	1	1	RING, DRIVING	
27	ZA6511C	1	1	1	1	1	HUB AND BACK PLATE	
28	05499E	2	2	2	-	-	PLATE, FRICTION	
28	5659P	-	-	-	2	2	PLATE, FRICTION	(C)
29	1016967	1	1	1	1	1	PLATE, CENTER	(C)
30	A6845	1	1	1	1	1	PLATE, PRESSURE	
31	A6848	1	1	1	1	1	YOKE, ADJUSTING	
32	B1636	4	4	4	4	4	LEVER	
33	B1540B	4	4	4	4	4	PIN, CLEVIS	
34	B1535D	4	4	4	4	4	PIN, COTTER	
35	B1538H	4	4	4	4	4	PIN, CLEVIS	
36	B1535C	8	8	8	8	8	PIN, COTTER	
37	B1650	8	8	8	8	8	LEVER	
38	B1538J	4	4	4	4	4	PIN, CLEVIS	
39	M1284	1	1	1	1	1	FITTING	
40	M1292H	1	1	1	1	1	HOSE	
41	M1283	1	1	1	1	1	FITTING	
42	M2046AF	1	1	1	1	1	WASHER	
43	M2027AN	1	1	1	1	1	NUT	
44	M268	1	1	1	1	1	FITTING	
45	9755A	1	1	1	1	1	HOUSING	
46	2815Z	1	1	1	1	1	PLATE, INSTRUCTION	(C)
47	02006092	2	2	2	2	2	SCREW	(B)
48	M2051F	1	1	1	1	1	PLUG, PIPE	
49	B1655A	1	1	1	1	1	PIN	
50	A2703AQ	1	1	1	1	1	SPRING, COMPRESSION	
51	A6866A	1	1	1	1	1	SLEEVE, SLIDING	
52	XA4648	1	1	1	1	1	COLLAR ASSEMBLY	
53	M503	2	2	2	2	2	FITTING	
54	M2074D	1	1	1	1	1	SEAL	
55	XA4650	1	1	1	1	1	YOKE ASSEMBLY	
56	M2022Z	2	2	2	2	2	KEY, WOODRUFF	
57	1580H	1	1	1	1	1	SHAFT, OPERATING	
58	X7441T	1	1	1	1	1	HAND LEVER ASSEMBLY	
59	M2410C	1	1	1	1	1	TAG, ENDFLAY	(C)
60	1015831	1	1	1	1	1	MANUAL	

PACKAGING NOTES

1.) THESE ITEMS ARE SHIPPED LOOSE FROM PTO.

(12) (23) (26) (58) (60)



ASSEMBLY NOTES:

- 1.) R
 a. R=11.9 MAX. FOR COTTER PINS
 b. R=14.7 MAX. FOR COTTER PINS
- 2.) REFER TO BOM FOR INSTRUCTION PLATE STAMPING INFORMATION.
- 3.) SEAT HUB USING 40.7 Nm (30 LB.-FT.) TORQUE ON NUT, THEN TIGHTEN NUT BY TURNING AN ADDITIONAL 180° TO 210°.
- 4.) REFER TO TWIN DISC STANDARD S574 FOR TORQUE VALUES.
- 5.) REFER TO TWIN DISC STANDARD S564 FOR LUBRICATION PROCEDURES.
- 6.) MOLYKOTE INSTRUCTIONS:
 BRUSH APPLY MOLYKOTE #3402 BONDED LUBRICANT TO THE FOLLOWING ITEMS:
 (ALLOW PARTS TO AIR DRY FOR AT LEAST TEN MINUTES BEFORE ASSEMBLING CLUTCH.)
 (27) (31) THREAD ONLY (33) (35) (38) (49)

- 7.) HUB & BACKPLATE THREAD TO BE LIGHTLY OILED.
- 8.) BEFORE ASSEMBLY OF SEALS, APPLY GREASE OR OIL TO SEAL LIPS AND WEAR SLEEVE SURFACE.
- 9.) ITEM #59 IS ATTACHED ABOVE THE INSTRUCTION PLATE (#46) USING SCREW (#47).
- 10.) BEARING ADJUSTMENT:
 TAKE UP BEARING RETAINER UNTIL 60 LBS.IN. IS REQUIRED TO ROTATE THE SHAFT WITH NO SHIMS. MEASURE SHIM GAP AND ADD 0.013 TO GET PROPER SHIM THICKNESS. ASSEMBLE SHIMS AND RETAINER. BEARING ENDFLAY TO BE .006-.010.

REV	SHEET	ZONE	CH. NO.	DATE	REV	SHEET	ZONE	CH. NO.	DATE
D	2		ECNWF-23279	1-28-13					
C	1,2		ECN15019	09-17-07					
B	1		ECN10406	10-10-01					
A	1		29708	12-14-99					

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE mm MACHINED DIMENSIONS ARE ±0.25 X .XX ±0.13 ALL ANGULAR TOLERANCES ±1° GEOMETRIC TOLERANCING PER ASME Y14.5M 1994

WEIGHT N.m³ kg

FIRST USE ASSY. IB214P101 MODEL IBF214OP1

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METRIC

THIRD ANGLE PROJECTION

MATERIAL SIMILAR TO

HEAT TREAT IBF314P1

NAME IBF214OP1

POWER TAKE-OFF

TWIN DISC INCORPORATED RACINE, WI 53403 - USA

IB214P101
 IB214P102
 IB214P103
 IB214P104
 IB214P105

DATE 08-07-96
 SCALE .25 = 1
 DRN. RDW
 TRK. TRL
 APPD. JMS
 DWG SIZE A1
 SHT. 1 OF 2
 REV D