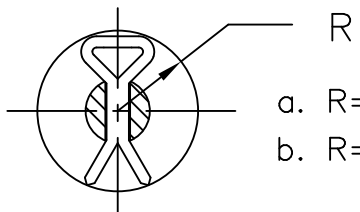
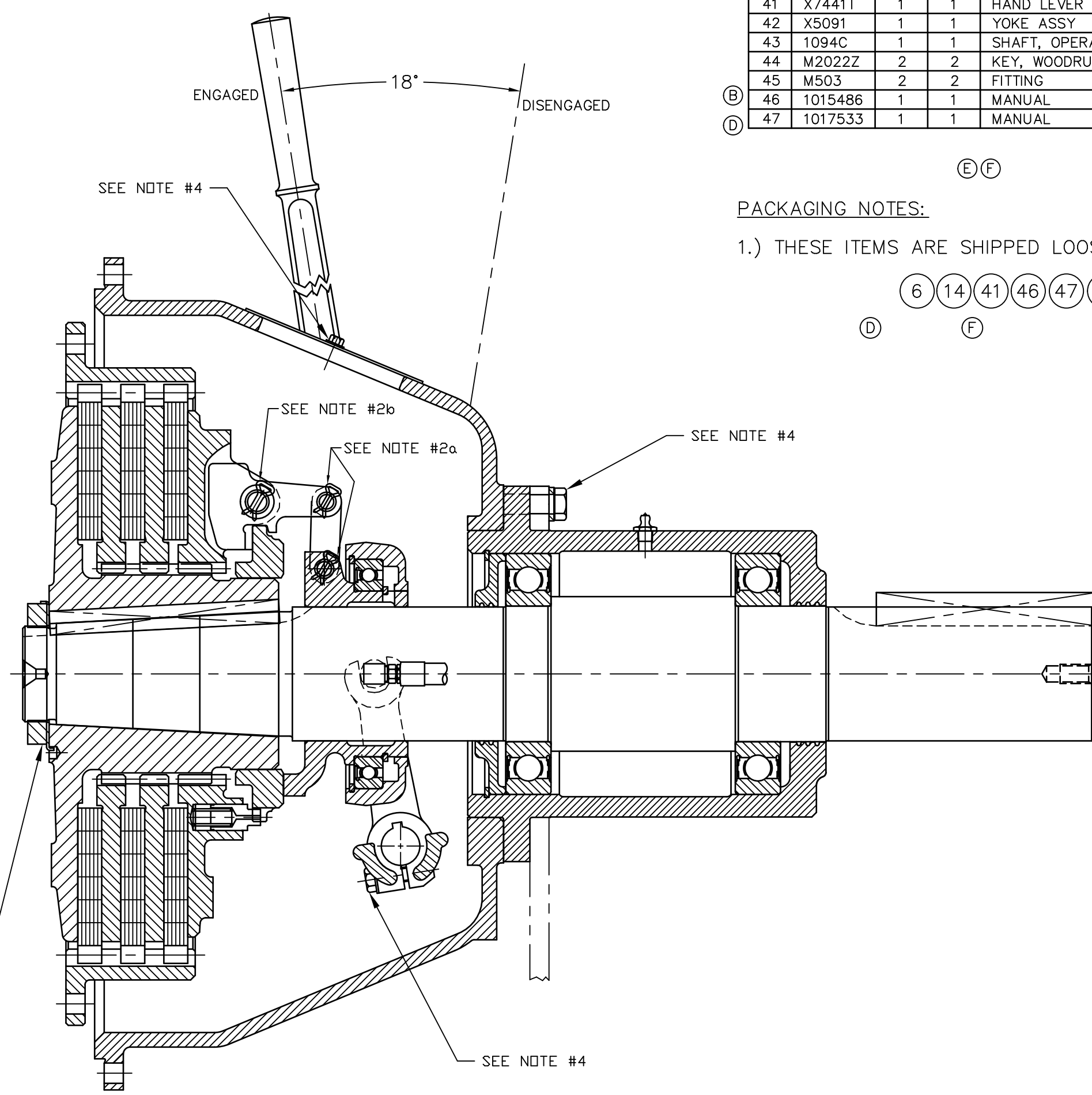
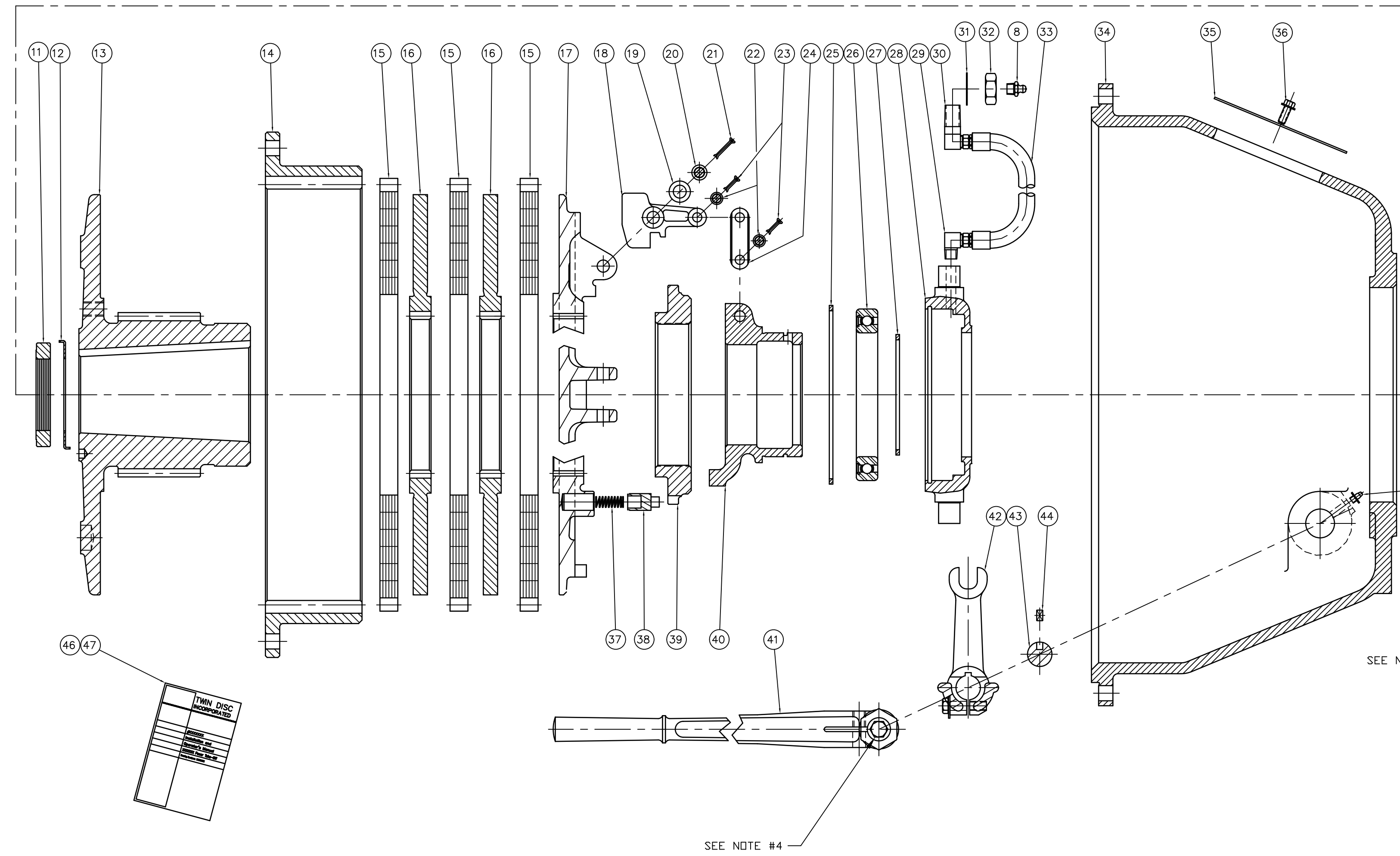
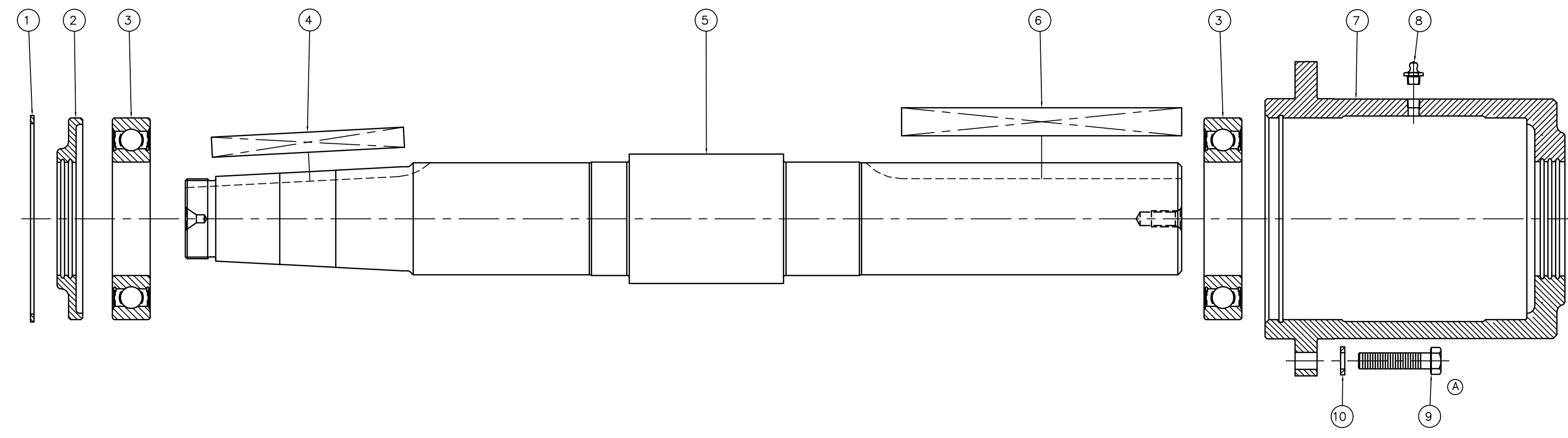


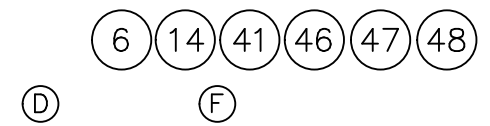
- ASSEMBLY NOTES:
- SEAT HUB USING 40.7 Nm (30ft.-lbs.) TORQUE ON NUT. THEN TIGHTEN NUT BY TURNING AN ADDITIONAL 150° - 180°.
  - 
    - R=11.9 MAX. FOR COTTER PINS
    - R=14.7 MAX. FOR COTTER PINS
  - REFER TO BOM FOR STAMPING INFORMATION.
  - REFERENCE TWIN DISC TORQUE STANDARD S-574.



ITEM	PART NO.	-108	-111	NAME	REMARKS
1	A2669CS	1	1	RING, SNAP (INTERNAL)	
2	B6339B	1	1	RETAINER, BEARING	
3	1016519	2	2	BEARING	
4	M2033BK	1	1	KEY, HUB	
5	1016522	1	1	SHAFT, CLUTCH	
6	M2034CM	1	1	KEY	
7	1016518	1	1	CARRIER, BEARING	
8	M268	2	2	FITTING	
9	M2004AA	6	6	SCREW, HEX. HD. (1/2 x 2)	
10	M2047AA	6	6	WASHER, LOCK (1/2)	
11	1442	1	1	NUT, HUB	
12	A1590	1	1	WASHER, LOCK (HUB NUT)	
13	ZA6511A	1	1	HUB & BACKPLATE	
14	A6518A	1	1	RING, DRIVING	
15	5659K	3	-	PLATE, FRICTION	
15	05499E	-	3	PLATE, FRICTION	
16	A6513	2	2	PLATE, CENTER	
17	A6512C	1	1	PLATE, PRESSURE	
18	B1284	4	4	LEVER	
19	M2115D	8	8	WASHER	
20	B1540A	4	4	PIN, HEADED	
21	B1535D	4	4	PIN, COTTER	
22	B1538B	8	8	PIN, HEADED	
23	B1535C	8	8	PIN, COTTER	
24	119B14	8	8	LINK	
25	A2669W	1	1	RING, SNAP (EXTERNAL)	
26	M3503	1	1	BEARING, BALL	
27	A2622A	1	1	RING, SNAP (EXTERNAL)	
28	A6603	1	1	COLLAR, B.B.	
29	M1284	1	1	FITTING	
30	M1283	1	1	FITTING	
31	M2046AF	1	1	WASHER, LOCK (5/8)	
32	M2027AN	1	1	NUT, JAM (5/8)	
33	M1282B	1	1	HOSE	
34	9584	1	1	HOUSING, SAE #1	
35	2815AQ	1	1	PLATE, INSTRUCTION	
36	02006092	2	2	SCREW, RD. HD. (1/4 x 1/2)	
37	A2702BE	1	1	SPRING	
38	B2341	1	1	PIN, ADJUSTING LOCK	
39	A4241	1	1	RING, ADJUSTING	
40	A6635	1	1	SLEEVE, SLIDING	
41	X7441T	1	1	HAND LEVER ASSY	
42	X5091	1	1	YOKE ASSY	
43	1094C	1	1	SHAFT, OPERATING	
44	M2022Z	2	2	KEY, WOODRUFF (15)	
45	M503	2	2	FITTING	
46	1015486	1	1	MANUAL	
47	1017533	1	1	MANUAL	

PACKAGING NOTES:

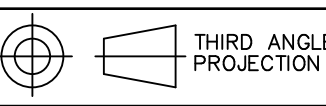
- THESE ITEMS ARE SHIPPED LOOSE FROM PTO.



REV	SHEET	ZONE	CH. NO.	DATE	REV	SHEET	ZONE	CH. NO.	DATE
D	-	-	27905	7/18/97	H	2	4C	ECN14426	10-12-00
C	-	-	27839	6/6/97	G	1		ECN10409	10-10-01
B	-	-	27439	12/13/96	F	1	A	29882	2/10/00
A	-	-	27245	8/29/96	E	2	A	28765	11/30/98

UNLESS OTHERWISE SPECIFIED	WEIGHT	WR <sup>2</sup>	FIRST USE
DIMENSIONS ARE mm	kg	N.m <sup>2</sup>	ASSY. SP314P108
MACHINED DIMENSIONS			MODEL SP314L1
X ±0.25			
XX ±0.13			
XXX ±0.075			
ALL ANGULAR TOLERANCES ±1°	NOTICE: THIS PRINT CONTAINS PROPRIETARY INFORMATION AND IS NOT TO BE USED IN ANY MANNER DETRIMENTAL TO THE INTEREST OF TWIN DISC, INCORPORATE		
GEOMETRIC TOLERANCING PER ASME Y14.5M 1994	THIS NOTICE IS NOT INTENDED TO NULLIFY OR LIMIT RIGHTS GRANTED TO THE U.S. GOVERNMENT OR OTHERS BY CONTRACT.		

**METRIC**



THIRD ANGLE PROJECTION

MATERIAL	HEAT TREAT	NAME
SIMILAR TO		SP314L1 PTO

DATE 6/13/96	<b>TWIN DISC</b> INCORPORATED RACINE, WI 53403 - USA
SCALE .38 = 1	
DRN. TRL	SP314P108 SP314P111
CHK. RDW	
APPD. JMS	DWG SIZE A1
SHT. 1 OF 2	REV H