
NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.

Note: Cleanliness is an important factor. Before assembly, all parts should be thoroughly cleaned in cleaning fluid. Allow the parts to air dry. Wiping cloths or rags should not be used to dry parts. Lint may be deposited on the parts which may cause later trouble. Inspect all parts. If any parts are worn or damaged, use new parts for replacement.

Note: Prior to assembly, all threads that require sealant must be cleaned with a tap.

Note: O-ring seals, gaskets, and seals should always be replaced. A used O-ring seal may not have the same sealing properties as a new O-ring seal. Use Tooling (E) during the assembly procedure.

Note: Apply a light film of transmission oil to all components before assembly.

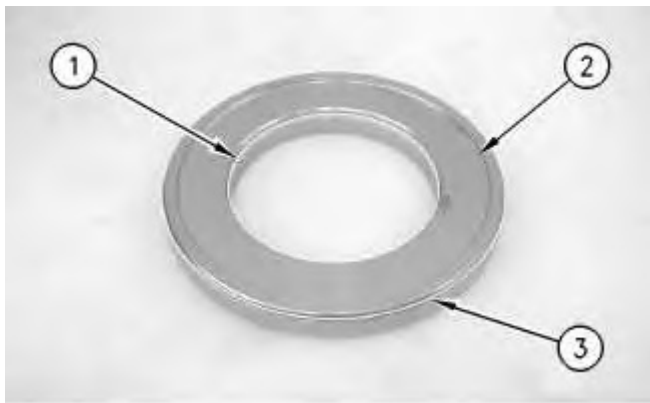
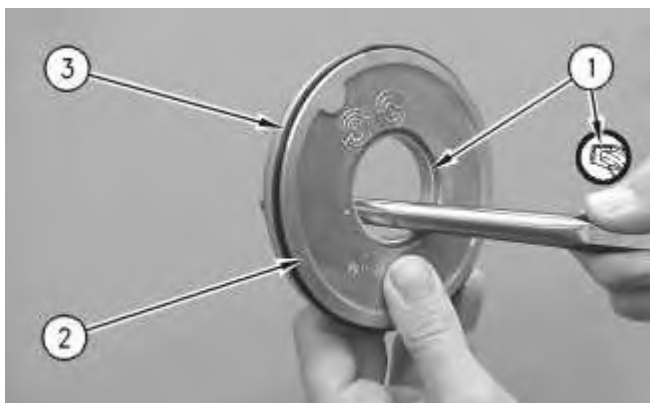


Illustration 1

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1. Install inner seal (1) and outer seal (3) into the seal grooves of piston (2).



2. Size inner seal (1) and outer seal (3) by holding a round object against the seal. Rotate piston (2) until the seal is flush with the outer diameter of the seal groove. Install the outer seal with the lip of the seal in the same direction as the inner seal.

Note: Lubricate the seals with the lubricant that is being sealed prior to the installation of the piston assembly. Take care not to damage the seals.



Illustration 3

3. Install piston (2) into hub (4).

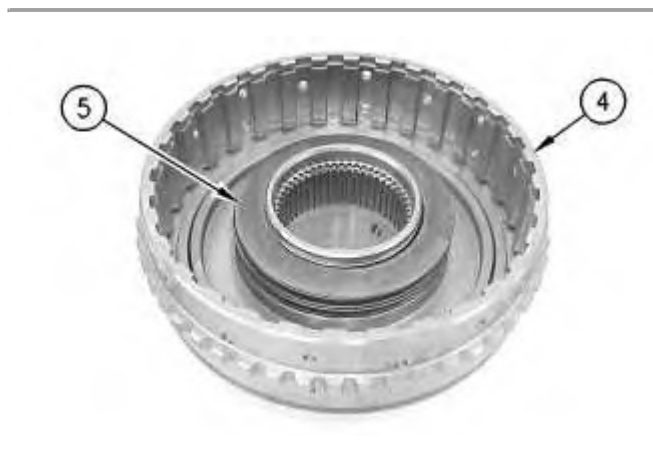


Illustration 4

4. Install disc springs (5) into the hub (4).

Note: The large diameter of the first disc spring is aligned with the piston. Alternate the following four disc springs.



Illustration 5

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5. Place plate (6) in position on disc springs (5).



Illustration 6

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6. Compress plate (6) and disc springs (5) in order to install retaining ring (7). Use Tooling (A) to install the retaining ring.



Illustration 7

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7. Turn over hub (4) and install seal (8) into the seal groove of hub (4).

Note: Size the seal by holding a round object against the seal. Rotate the round object around the seal until the seal is flush with the outer diameter of the seal groove.

Note: Lubricate the seal with the lubricant that is being sealed prior to the installation of the retarder housing.



Illustration 8

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8. Install retarder housing (9) onto hub (4).



Illustration 9

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9. Place rotor (10) in position on hub (4). The bolt holes in the rotor must be aligned with the bolt holes in the hub.
 10. Install bolts (11) that secure the rotor to the hub. Tighten bolts (11) to a torque of $28 \pm 7 \text{ N}\cdot\text{m}$ ($21 \pm 5 \text{ lb ft}$).
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