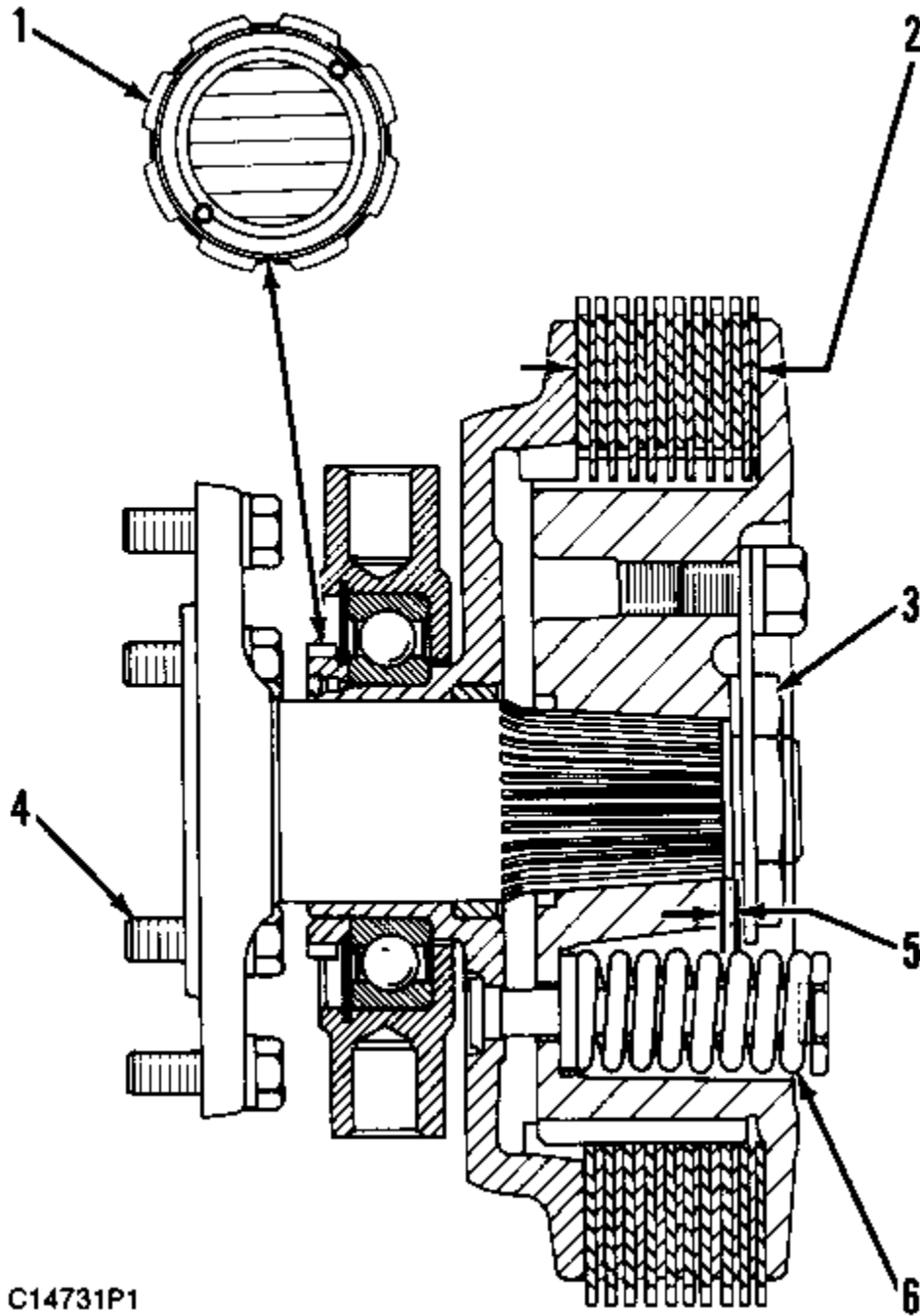


D3C and D4C



C14731P1

(1) Torque for the nut that holds the bearing in the cage ... $475 \pm 68 \text{ N}\cdot\text{m}$ ($350 \pm 50 \text{ lb ft}$)

Drill two 5.2 mm (.20 in) holes 10.0 mm (.39 in) deep opposite each other on the separation line of the nut and plate assembly.

NOTICE

Keep bearing free of foreign material.

Use a 1/4 in. -20 NC thread tap to tap both holes 8.0 mm (.31 in) deep. Install two screws and peen over.

(2) Thickness of nine new driving discs and nine new driven discs and one new driven disc ... 52.39 ± 1.80 mm ($2.063 \pm .071$ in)

Thickness of one new 6Y7914 Disc ... 3.45 ± 0.13 mm ($.136 \pm .005$ in)

Thickness of one new 5K8616 Disc ... $1.905 \pm .05$ mm ($.0750 \pm .002$ in)

Thickness of one new 5V593 Disc ... 4.19 ± 0.18 mm ($.165 \pm .007$ in)

NOTE: The 5V593 Disc must be installed next to the drum.

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

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

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

After drum has been pushed on the shaft with a force of ... 120 ± 10 kN ($27,000 \pm 2250$ lb)

(6) 6S3414 Spring:

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

Test force ... 1503 ± 76 N (338 ± 17 lb.)

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

Outside diameter ... 36.63 mm (1.442 in)