



- 1201 ECCENTRIC SHAFT
- 1202 ECCENTRIC SHAFT R.H. SLEEVE
- 1203 ECCENTRIC SHAFT R.H. SLEEVE BUSHING
- 1204 ECCENTRIC SHAFT L.H. SLEEVE
- 1205 ECCENTRIC SHAFT L.H. SLEEVE BUSHING
- 1208 MAIN PINION
- 1209 MAIN PINION SHAFT
- 1210 MAIN PINION RETAINER
- 1211 MAIN PINION BEARING
- 1212 MAIN PINION BEARING RETAINER
- 1213 MAIN PINION BEARING SEAL RING
- 1216 FLYWHEEL BEARING
- 1217 FLYWHEEL BEARING SEAL RING
- 1219 FLYWHEEL BEARING RETAINER
- 1220 FLYWHEEL RIM
- 1221 FLYWHEEL HUB

- 1222 FLYWHEEL CLAMP PLATE
- 1223 FLYWHEEL CLAMP BOLT
- 1224 FLYWHEEL FRICTION PLATES
- 1225 FLYWHEEL HUB RETAINER
- 1228 ECCENTRIC SHAFT SLEEVE BOTTOM WEDGE
- 1232 FLYWHEEL BEARING INNER SPACER
- 1240 FLYWHEEL BEARING OUTER SPACER
- 1243 FLYWHEEL CLAMP BOLT GUARD
- 1244 FLYWHEEL CLAMP BOLT NUTS
- 1245 BELLEVILLE SPRING
- 1246 FLYWHEEL CLAMP BOLT SHIMS
- 1260 MAIN PINION BEARING INNER SPACER
- 1261 MAIN PINION BEARING OUTER SPACER
- 1262 BELLEVILLE SPRING WASHER
- 1263 BELLEVILLE SPRING WASHER NUT

ECCENTRIC SHAFT

REMOVAL:

(ECCENTRIC SHAFT (1201) MAY BE REMOVED FROM EITHER SIDE OF PRESS):

- 1 - STOP PRESS AT "TOP DEAD CENTER" POSITION.
- 2 - BLOCK UP UNDER RAM, AND INSERT A SUITABLE JACK (JACK CAPACITY MUST SUPPORT WEIGHT OF RAM, PITMAN, AND ECCENTRIC SHAFT.
- 3 - BLOCK UP PITMAN, FRONT AND BACK TO KEEP IT IN A VERTICAL POSITION.
- 4 - REMOVE CLUTCH ASSEMBLY: REFER TO AIR CLUTCH PARTS SHEET.
- 5 - REMOVE BRAKE DRUM AND KNOCKOUT CAM: REFER TO BRAKE PARTS SHEET.
- 6 - USE JACK TO LIFT RAM TO TAKE OUT ALL CLEARANCES.
- 7 - REMOVE SCREWS SECURING ECCENTRIC SHAFT SLEEVE BOTTOM WEDGES (1228) TO SLEEVES (1202 & 1204). USE A JACK AND BRIDGE TO REMOVE SLEEVES (1202 & 1204).
- 8 - REMOVE CAP SCREWS SECURING ECCENTRIC SHAFT SLEEVES (1202 & 1204) TO FRAME.
- 9 - USE JACK TO LOWER RAM APPROXIMATELY 1/8" (3MM) TO RELIEVE PRESSURE FROM THE TOP OF THE SLEEVES.
- 10 - PULL THE ECCENTRIC SHAFT SLEEVES (1202 & 1204) OUT FROM EACH SIDE OF PRESS.
- 11 - USE JACK TO LOWER RAM UNTIL THE BOTTOM OF THE ECCENTRIC "A" IS 1/32" (1MM) ABOVE THE BOTTOM OF THE FRAME BORE "B".
- 12 - SLIDE THE ECCENTRIC SHAFT (1201) OUT (EITHER SIDE OF PRESS) FAR ENOUGH TO STABILIZE IT WITH A SLING. THEN, ALSO, SLING THE OPPOSITE SIDE AND THE ECCENTRIC, AND THEN SLIDE IT COMPLETELY OUT.

INSTALLATION:

REVERSE THE ABOVE PROCEDURE.

PINION SHAFT

NOTE: BEARINGS (1211 & 1216) MUST BE PRESSED [.002/.005" (0,06/0,12MM) TIGHT] ONTO PINION SHAFT (1209) PRIOR TO ASSEMBLY.

REMOVAL

(PINION SHAFT (1209) MAY BE REMOVED FROM EITHER SIDE OF PRESS), FOLLOWING PROCEDURE IS FOR REMOVAL FROM GEAR SIDE:

- 1 - REMOVE FLYWHEEL HUB RETAINER (1225).
- 2 - PULL THE TWO KEYS FROM THE FLYWHEEL HUB (1221).
- 3 - REMOVE THE FLYWHEEL ASSEMBLY AS A UNIT, USING A JACK AND BRIDGE ACROSS THE END OF THE PINION SHAFT (1209).
- 4 - CAREFULLY SLIDE OUT THE PINION SHAFT (1209) FROM THE PRESS. THE BEARING ROLLERS AND OUTER RACES (1211 & 1216) REMAIN IN THE PRESS, INNER RACES ARE ON THE SHAFT.
- 5 - REMOVE THE MAIN PINION RETAINER (1210) FROM THE PINION SHAFT (1209).
- 6 - PULL THE TWO KEYS FROM THE MAIN PINION (1208).
- 7 - REMOVE THE MAIN PINION (1208) FROM THE PINION SHAFT (1209) USING A JACK AND BRIDGE ACROSS THE END OF THE PINION SHAFT (1209).
- 8 - REMOVE THE BEARING RETAINERS (1212 & 1219).
- 9 - SLIDE OUT THE BEARING ROLLER AND OUTER RACE ASSEMBLIES (1211 & 1216).
- 10 - SLIDE OUT THE BEARING SEAL RINGS (1213 & 1217).

INSTALLATION:

REVERSE THE ABOVE PROCEDURE.

FLYWHEEL:

THE FRICTION SLIP BUILT INTO THE FLYWHEEL ASSEMBLY PROTECTS THE DRIVE IN CASE OF A SUDDEN STOPPAGE (JAM). NORMAL SETTING IS FOR A TORQUE EQUAL TO 110% OF THE CLUTCH TORQUE. IF SLIPPAGE OCCURS DURING NORMAL OPERATION, REFER TO INSTRUCTION SHEET SW-1 FOR METHOD OF SIZING SHIMS (1246) TO INCREASE CLAMP PRESSURE.

DISASSEMBLY:

- 1 - REMOVE THE FLYWHEEL SHIELD
- 2 - LOWER MOTOR BRACKET AND REMOVE DRIVE BELTS.
- 3 - REMOVE THE FLYWHEEL BOLT GUARD (1243).
- 4 - REMOVE THE BELLEVILLE SPRING WASHER NUTS (1263), WASHERS (1262), AND THE BELLEVILLE SPRINGS (1245) FROM THE FLYWHEEL CLAMP BOLTS (1223).
- 5 - REMOVE THE FLYWHEEL CLAMP PLATE (1222) AND THE OUTER FRICTION PLATE (1224).
- 6 - REMOVE THE FLYWHEEL RIM (1220).
- 7 - REMOVE THE INNER FRICTION PLATE (1224).

INSTALLATION:

REVERSE THE ABOVE PROCEDURE, BEING CERTAIN THAT PROPER SHIMS (1246), IF REQUIRED, ARE USED.