1. Adjust end play of bearings, item 26 to 0.006 - 0.012 [0.15 - 0.30] mm.
2. When installing the cotter pins, they must not extend beyond the levers by the following: Large cotter pin: 0.059 [1.50] small cotter pin: 0.047 [1.19].
3. Clutch adjustment: Clutch should be tightened until 218 to 289 lb-ft. (295 - 310 Nm) torque is required on lever shaft 21 to engage the clutch.
4. Torque bolts items 5 & 24 to 63 lb-ft. (112 Nm).
5. Torque nut item 10 to 90 - 110 lb-ft. (122 - 149 Nm).
6. Stamp "289" to 218 lb-ft. and "591" to 295 Nm" in blocks on nameplate.
8. A support plate must be used for side load applications.
9. OIL" is the standard for OIL. 0 bellhousing.
10. Do not install pitot type #9 on the shaft, ship loose.