

NOTE: If the Clutch/Brake Assembly is installed during assembly with a roller pin and chain as shown in Fig. 10, the roller pin is not required.



Figure 8 Recommended Roller Assembly

Buy-In Part: 822-0001 shown in Diagrams 1001-1002

Available from (P) Service Tool (S) Warehouse

NOTE: Roller head screw must be inserted into crankshaft and before inserting roller to prevent damage to crankshaft.

STEP 40
Remove the 2 Shoulder Screws and Pressure Springs. Then remove the Brake Plate (Fig. 14).



Figure 9 Shoulder Screws & Spring Removal
1. Brake Plate

STEP 41
Remove the Actuator Bearing Assembly (Fig. 10).



Figure 10 Actuator Bearing Assembly

STEP 42
Remove the Actuator & Arm Assembly. This will assist removal of the Clutch/Brake Housing. The roller pin is not required.



Figure 11

NOTE: It may be necessary to use a roller pin (the type shown in Fig. 10) to remove the Actuator & Arm Assembly.



Clutch/Brake Reassembly and Installation

Reassembly Inspector

Carefully inspect all components for signs of damage or excessive wear.

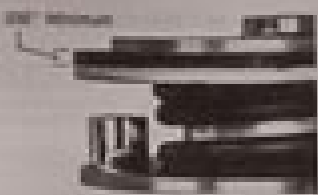


NOTE: Most problems with excessive bearing wear are caused by improper load limits, (over engagement) or a loss of lubrication.



SAFETY WARNING: Clutch/Brake Unit must be replaced if needed for any reason for 100% or less use following instructions.

SEEK OUTLINE REFERENCES



NOTE: Clutch/Brake Unit components (except bearing hardware) are not available as service items. If any part or parts are unsuitable for reuse or if the Clutch/Brake Assembly was damaged during disassembly, the entire Clutch/Brake Unit must be replaced.



Clean and inspect crankshaft. Use grinding paper to prepare crankshaft for Clutch/Brake Unit installation.

Insulation Procedure



SAFETY WARNING: Apply Loctite 4271 to all pin hardware during assembly.

STEP 43
Pre-assemble the Actuator & Arm into the Clutch/Brake Housing. Then position the Actuator Shaft into the Arm as shown in Fig. 10.



Figure 12 Clutch/Brake Unit Pre-assembly

1. Actuator & Arm Assembly
2. Actuator Shaft
3. Clutch/Brake Housing

STEP 44
Fit the assembly onto the engine with the Actuator Arm through the Engine Mounting Plate as shown in Fig. 13.

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Figure 13 Correct Actuator Arm Location

STEP 45
Install the Actuator Bearing & Retainer Assembly and the Brake Plate.



NOTE: Arrow on Brake Plate must point toward exhaust ports (Fig. 14).



Figure 14 Correct Brake Plate Position

STEP 46
Install the 2 Shoulder Screws and Pressure Springs. Tighten to 15 ft. lbs. (140 in. lbs.).

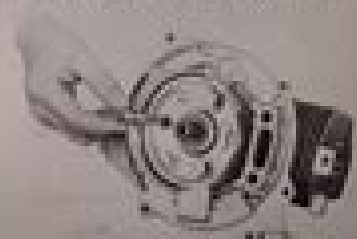


Figure 15 Shoulder Screws & Spring Installation

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