

Servicing the Clutch Mechanism-

Torque Value for the Clutch Mechanism Retaining Nut (ifg. no. 3).

Grease / Lubrication — when assembling the internal clutch component parts: the Clutch Discs (ifg. nos. 5 and 6), Thrust Washers (ifg. no. 4) and Disc Springs (ifg. no. 8) are to be lightly coated with grease

(Cat. No. 49-08-4220 type 'J') during their assembly into the spindle gear.

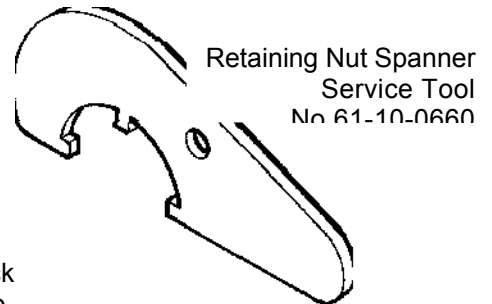
Grease / Lubrication specification includes coating internal bore of the spindle gear.

4	45-88-1140	Thrust Washers	(2)
5	43-06-0160	Clutch Discs-Outer	(3)
6	43-06-0150	Clutch Discs-Inner	(5)
8	40-50-2150	Spring Discs	(4)
	32-75-3430	Spindle Gear	(1)

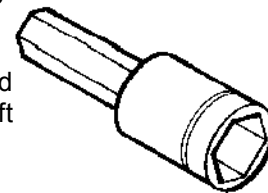
Service note: the assembly torque for the Clutch Mechanism Retaining Nut, No. 06-57-1050 (i , w h e static torque r e q u i r e d t o slip the cl mechanism, as lubricated, should be 45-50 ft-lbs.

With the gear case separated from the diaphragm & motor housing of the Clutch Dymo-Drill motor —

- insert & engage a **61-10-0660** retaining nut spanner with the notches in the **06-57-1 050** clutch adjustment retaining nut.
- with a **1/2" hex socket bit driver** attached to a torque wrench, interlock the male hex with the female hex found in the threaded end of the dymo-drill spindle.
- turn the torque wrench clockwise , observing the torque reading and tighten the clutch adjustment retaining nut on the rear of the spindle shaft until a value of 45-50 ft-lbs is obtained.



Retaining Nut Spanner
Service Tool
No. 61-10-0660



1/2 Hex Bit Driver
Snap-On #psa16,
Pronto #5441 1/2
or equivalent