

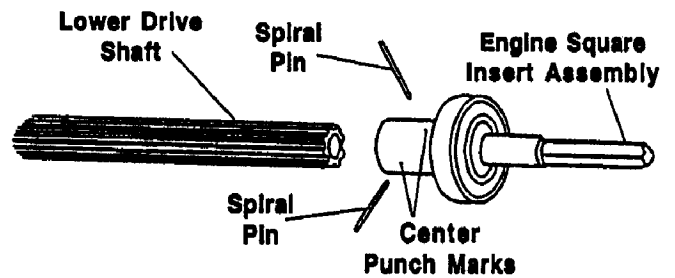


Engine Square Insert to Drive Shaft Assembly

Use the following installation procedures in order to prevent premature failure of drive shaft components.

NOTE: Do not bend or deform drive shafts while servicing them.
Never reuse old holes in drive shaft or engine square insert assembly.

1. Trial fit new engine square insert (P/N 61001222361) in engine clutch drum.
2. Saw the old engine square insert assembly off drive shaft and remove all burrs. Lower drive shaft length must be a minimum 57 in. after cutting.
3. Center punch the outside diameter of the engine square insert sleeve approximately $\frac{3}{8}$ in. from the open end. Rotate the sleeve 90 degrees and make a second center punch approximately $\frac{5}{8}$ in. from the open end.
4. Slide the engine square insert assembly onto the lower drive shaft as far as it will go. Turn the assembly clockwise (CW) until the internal splines rest solidly against the drive shaft splines.
Important: Do not twist the drive shaft.
5. Maintain (CW) torque and drill through both center punches with a $\frac{5}{64}$ in. drill. Finish the holes with a #41 drill ($\frac{3}{32}$ in. drill will work).
6. Maintain (CW) torque then tap in spiral pins Pin Center (P/N 88005022360) through both holes. Center the spiral pins Punch Marks in the holes and flare both ends to properly retain pins.



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