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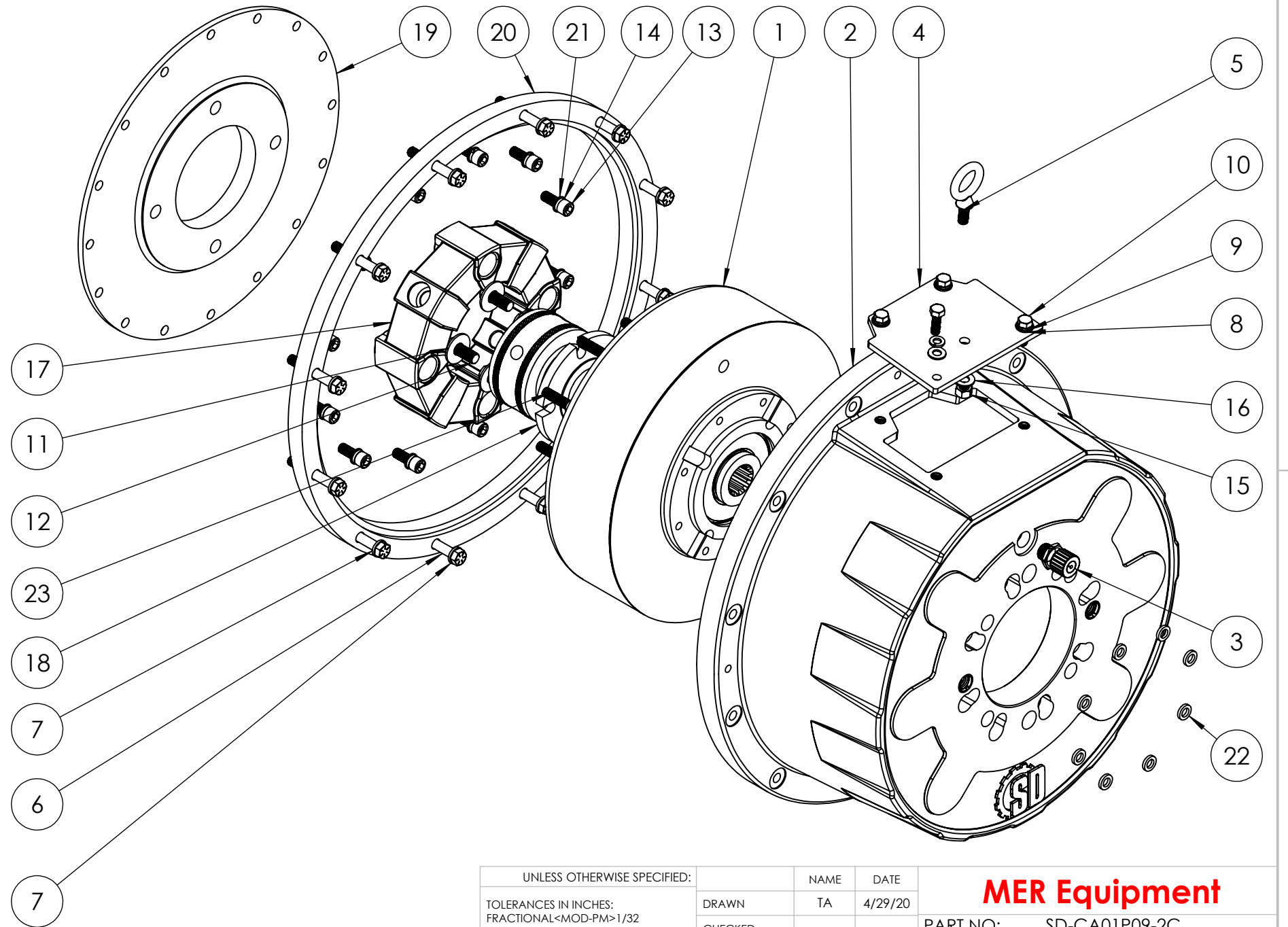
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	1136350	CLUTCH, H-49	1
2	PA10478	HOUSING, CLUTCH, MADE FROM RAW CASTING 34660A. PITTS 1000#, 1200#, SAE 2 BELL HOUSING, PAD, SAE C PUMP PAD, 2 & 4 BOLT. ADAPTS SAE #2 BELLHOUSING TO SAE HYDRAULIC PUMP PAD.FOR PA10478. INCLUDES THREADE INSERTS	1
3	.375 NPT CORD GRIP	SHOP SUPPLIES	1
4	34513A	BRACKET, COVER PLATE WITH PICKING EYE, FOR USE WITH DIXIE CUP 34504A, 1/4" MILD STEEL, CLEAR ZINC	1
5	34851	SHOP SUPPLIES	1
6	0.3750-16 X 2.50, HEX HEAD, GRADE 8, YELLOW CHROMATE PLATED	MCMMASTER PN 91257A634	12
7	Regular LW M10		12
8	5/16" FLAT WASHER, 18-8 SS, PLAIN FINISH	SHOP SUPPLIES	4
9	5/16" LOCK WASHER, GRADE 8, ZINC PLATED	SHOP SUPPLIES	4
10	5/16"-18 X 3/4", HEX HEAD, 18-8 SS, PLAIN FINISH	SHOP SUPLIES	4
11	98026A114	98026A114_GRADE 8 STEEL FLAT WASHER.SLDPRT	4
12	7/16"-20 X 1", HEX HEAD, GRADE 8, ZINC PLATED	SHOP SUPPLIES	4
13	3/8"-16 X 1.00", SHCS, GRADE 8, PLAIN FINISH	SHOP SUPPLIES	12
14	0.3750, HIGH COLLAR LOCK WASHER, GRADE 8, ZINC PLATED	BN_48626_3444970_high_collar_split_lock_washer_3_8.SLDPRT	20
15	3/8"-16, NYLOCK NUT, GRADE 8, ZINC PLATED	SHOP SUPPLIES	1
16	3/8" FLAT WASHER, GRADE 8, ZINC PLATED	SHOP SUPPLIES	1
17	lf50_s_element_SW2013		1
18	33817B	ADAPTER, HUB FOR SIZE 50 TORSIONAL COUPLING, WITH 1410 SPICER PATTERN. ADDED LENGTH FOR EASIER BOLT UP.	1
19	37242	DRIVEPLATE, #2 FLYWHEEL, FOR FRONT PTO KIT, C18 CAT, SD-CA01P09-2C	1
20	26-00358	BELL HOUSING SPACER, NUMBER 2, .75 INCH THICK	1
21	0.3750, FLAT WASHER, SHCS, SS 18-8, N960-C616	WACHER, SMALL OD FOR SHCS, .375"	12
22	91922A227	91922A227_MIL SPEC. STEEL FLAT WASHER, SMALL OD FOR SHCS APPLICATION	8
23	3/8"-16 X 1.50, SHCS, GRADE 8, BLACK OXIDE	SHOP SUPPLIES	8

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	INITIAL PRODUCTION RELEASE	5/19/2020	TA



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- NOTES:
- Drawing does not show coupling slide bolts, CFA050OS
  - Torque slide bolts & M16 SHCS to 160 ft-lbs

UNLESS OTHERWISE SPECIFIED:		NAME	DATE	<b>MER Equipment</b>	
TOLERANCES IN INCHES: FRACTIONAL<MOD-PM>1/32 ANGULAR: MACH<MOD-PM>1 BEND<MOD-PM>1 TWO PLACE DECIMAL <MOD-PM>.030 THREE PLACE DECIMAL<MOD-PM>.005		DRAWN	TA		
INTERPRET GEOMETRIC TOLERANCING PER:		CHECKED			PART NO: SD-CA01P09-2C
MATERIAL		ENG APPR.			DWG. NO. SD-CA01P09-2C-DRA
FINISH		MFG APPR.			SIZE DESCRIPTION REV
DO NOT SCALE DRAWING		REVISION NEEDED			B fPTO ELECTRIC CLUTCH KIT, C18 CAT. VERSION 2 WITH CFA50 COUPLING. SAE C PUMP PAD, 1000 FT-LB, C-SPLINED CLUTCH. A
		PROPRIETARY AND CONFIDENTIAL		SCALE: 1:10 WEIGHT: SHEET 1 OF 2	
		THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MER EQUIPMENT. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF MER EQUIPMENT IS PROHIBITED.			

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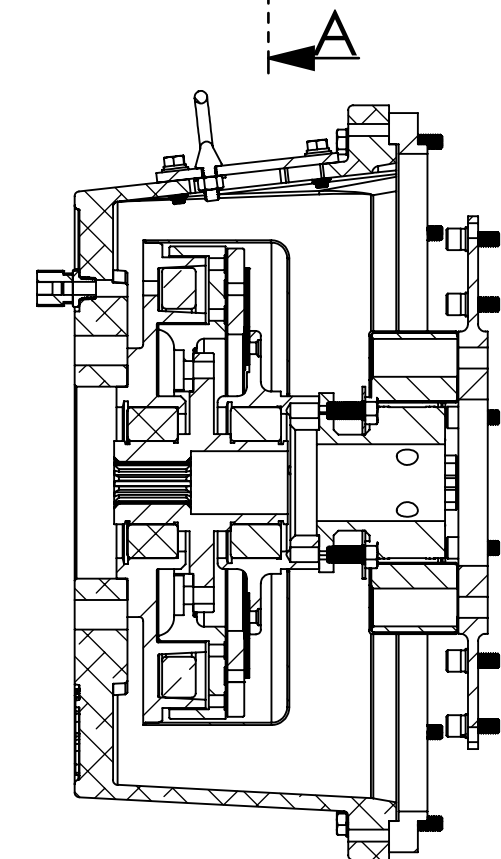
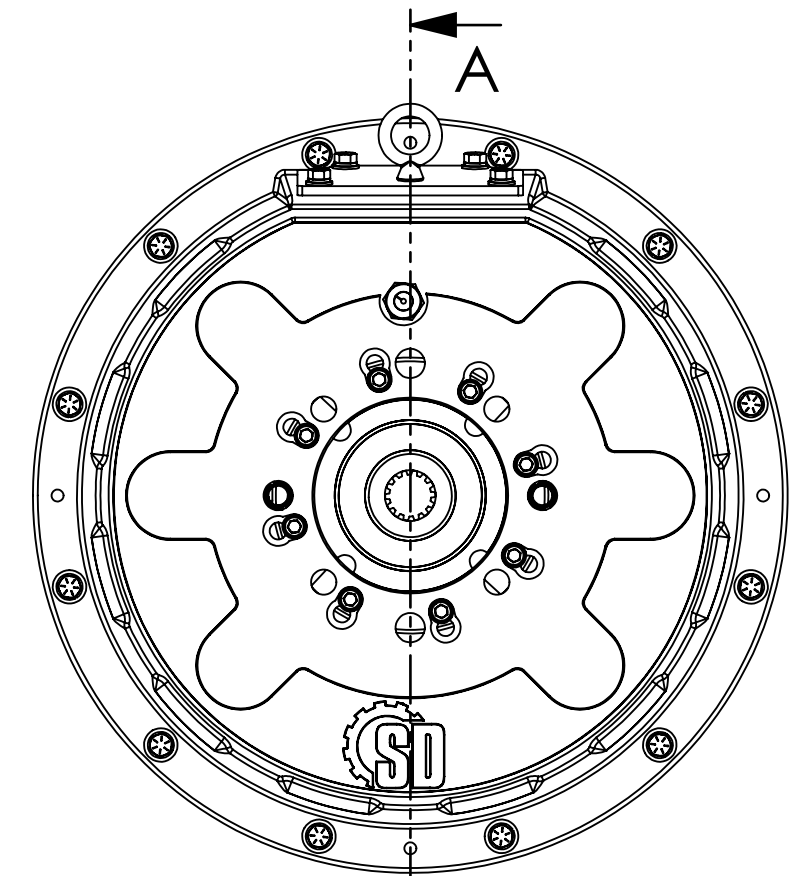
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### Installation Notes:

1. Bolt the clutch (#1) to the aluminum clutch housing (#2) with the 3/8-16 SHCS bolts in the clutch box AND the 3/8" flat washers supplied in the hardware kit.
  - a. Apply blue Loctite to the SHCS
  - b. Thread the power cable for the clutch through the electrical cable gland that is already installed in the housing.
  - c. Torque the SHCS to 45 ft-lb
  - b. Tighten the gland nut
2. Bolt the adapter (#17) to the input side of the clutch w/ the supplied 7/16" fine thread bolts and flat washers. The rubber element is supplied already bolted to the adapter.
  - a. Apply blue Loctite to the bolts
  - b. Torque to 65 ft-lbs
3. Bolt the adapter plate (# 19) to the engine flywheel with the 3/8-16x1" SHCS, flat and lock washers
  - a. Apply blue Loctite to the bolts
  - b. Torque to 49 ft-lbs
4. Bolt the slide bolts to the adapter.
  - a. DO NOT apply blue Loctite to the bolts
  - b. Torque to 160 ft-lb
  - c. If for any reason the slide bolts or the M16 SHCS in the coupling need to be removed, they can be installed a total of three times before they need to be replaced.
5. Lightly grease the spacer ring (#20) and pop it onto the engine front bell housing register. If the spacer will not stay in place, fit it to the housing instead. Use a couple of the 3/8-16 x 2.5" cap screws to keep it in place.
  - a. Make sure the bolt holes are aligned.
6. Bolt the housing to the front engine bellhousing, through bolting the spacer ring between the housing and the front bell housing using the 3/8-16x2.5" hex head cap screws and flat washers.
  - a. The housing can be lifted into place with the lifting eye bolted to the top of the inspection plate in the housing.
  - b. Rotate the coupling so the slide bolts fixed to the engine adapter line up with the slide bolt holes in the rubber coupling.
  - c. Bolt the coupling to the housing with the supplied 3/8" bolts, through bolting the spacer
    - i. Apply blue Loctite to the bolts
    - ii. Torque to 40 ft-lb
7. Visually inspect the clearance between the face of the engine adapter (#19) and the rubber element. There should be a .025" gap between the two. The acceptable range however is .006-.040" of clearance. If the gap falls outside that range, consult your vendor for guidance.
8. Install the hydraulic pump
9. Refer to the overhung load limit of the front bell housing to determine whether the weight of the pump needs to be supported. For reference, the PTO assembly weight is 135 lbs.
10. Notify the manufacturer when the unit is placed into service to activate our warranty.



SECTION A-A

SCALE 1 : 5

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