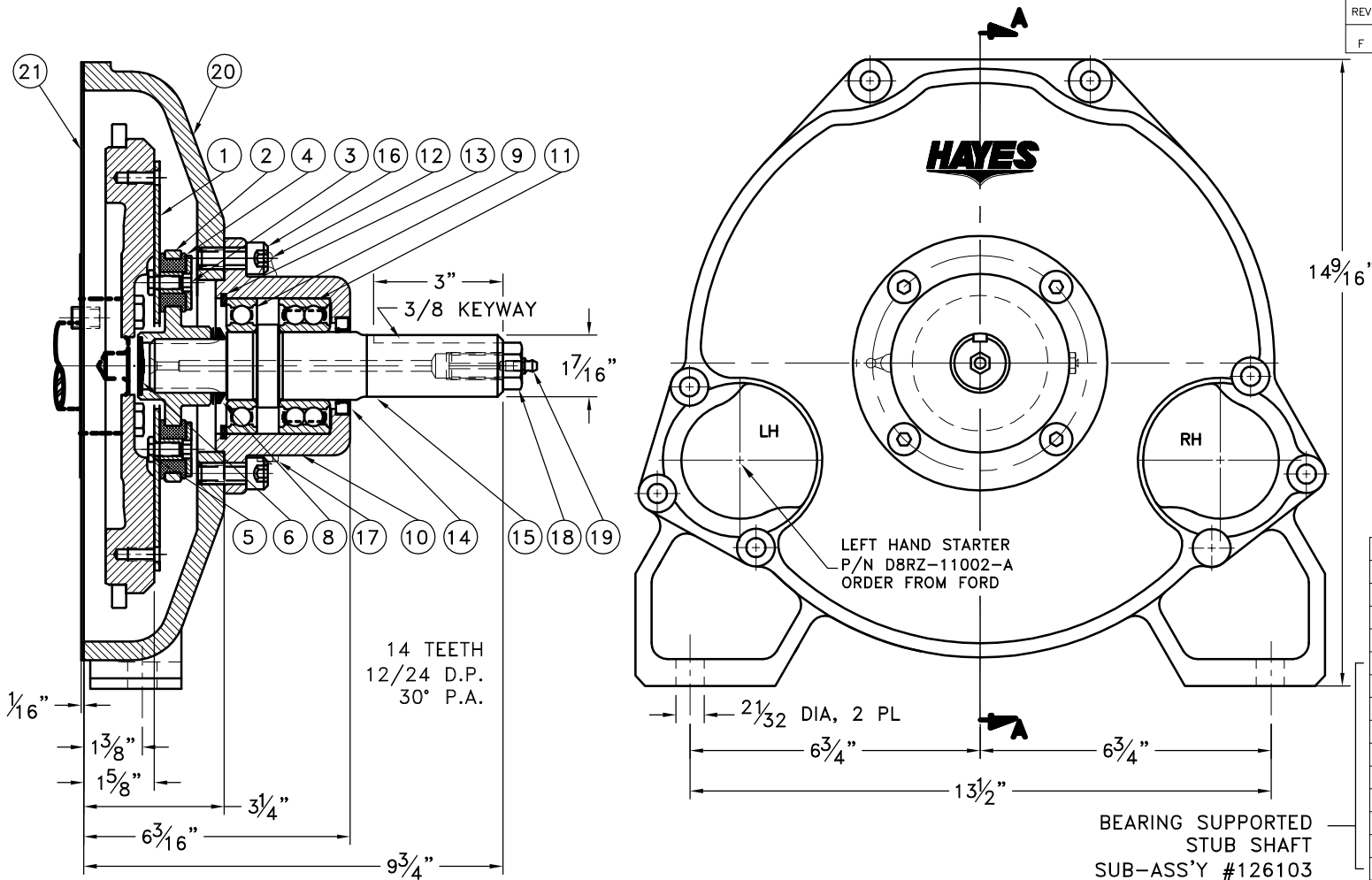


REV	DATE	CHANGE DESCRIPTION	MOD.BY	CK1	CK2
F	12/05/2002	ADDED 125294 AND 609000	ZS	RJH	HM



ASSEMBLY NOTE:
ENSURE THAT THE GREASE ZERT AND RELIEF VALVE ARE LOCATED HORIZONTAL WHEN MOUNTING ON TO PUMP MOUNT PLATE.

22	70HM-6397-AA	DOWEL (ORDER FROM FORD)	2
21	855265-LH	STARTER PLATE	1
20	881444-01	HOUSING	1
19	609000	GREASE ZERT	1
18	125294	5/8-11 HHB	1
17	1093K11	RELIEF VALVE	1
16	BOLT	1/2-13x1-1/8 SHCS DRILOC	4
15	126102	SPLINED SHAFT	1
14	15830	SEAL	1
13	RR-314	SPIROLOX SNAP RING	1
12	600000	GREASE ZERT	1
11	5208WD	DOUBLE BEARING	1
10	125007	BEARING HOUSING	1
9	208P	BEARING	1
8	VS-032	V-RING	1
7	801912	GREASE	1
6	R-0017-01	GREASE PLUG	1
5	HX300	SPECIAL 5/16-24x5/8 HHB	8
4	H52500	NEOPRENE INSERT	8
3	123729-01	THREADED BUSHING	8
2	125008	COUPLING HUB	1
1	124319	FLYWHEEL PLATE	1

NOTES:

1. LIGHTLY GREASE INTERNAL AND EXTERNAL AREA OF SPLINE AT ASSEMBLY USING SUPPLIED COUPLING GREASE (OVER GREASING COULD CAUSE A HYDRAULIC TYPE LIFT ON SEALS).
2. **AT ASSEMBLY GREASE BEARING HOUSING UNTIL PIN EXTENDS FROM PRESSURE RELIEF VALVE (LOCATED 180° FROM GREASE ZERK).** USE OF AN UNLEADED EXTREME PRESSURE LITHIUM GREASE, WITH NLGI NO.2 GRADE IS RECOMMENDED. RUN TIME BETWEEN GREASINGS NOT TO EXCEED 2,000 HOURS.
3. **WARNING!!!** INJURY OR DEATH FROM A ROTATING STUB SHAFT CAN OCCUR IF A CONDITION EXISTS WHICH WOULD CAUSE THE SHAFT TO BREAK OR COME APART FROM ANY PART OF THE ASSEMBLY. DEPENDING UPON THE APPLICATION (FOR EXAMPLE, FAN, PULLEY, SHEAVE, ETC.), THE AREA AROUND THE STUB SHAFT MUST BE SUFFICIENTLY GUARDED SO THAT IN THE EVENT OF FAILURE, THE GUARD WILL CONTAIN ANY AIRBORNE PARTS.

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SYMBOLS	DET.	PART NUMBER	DESCRIPTION	QTY.
DO NOT SCALE DRAWING TOLERANCES UNLESS OTHERWISE SPECIFIED 125 MAXIMUM ANGLE ±1/2° FRACTION ±1/32 DECIMAL .00 ±.01 .000 ±.005 .0000 ±.0005 FINISH	MAKE: <input type="checkbox"/> BUY: <input type="checkbox"/>	LAWSON	DATE 4-3-01	DRAWING NO. 877011
CLASS	DESCRIPTION	CHECKED BY RJH	SCALE	SHEET OF REV.

HAYES
MANUFACTURING INC. ®

TITLE
FORD VSG 413 BEARING STUB SHAFT ASS'Y

MATERIAL

DRAWING NO.

877011

SHEET OF REV.