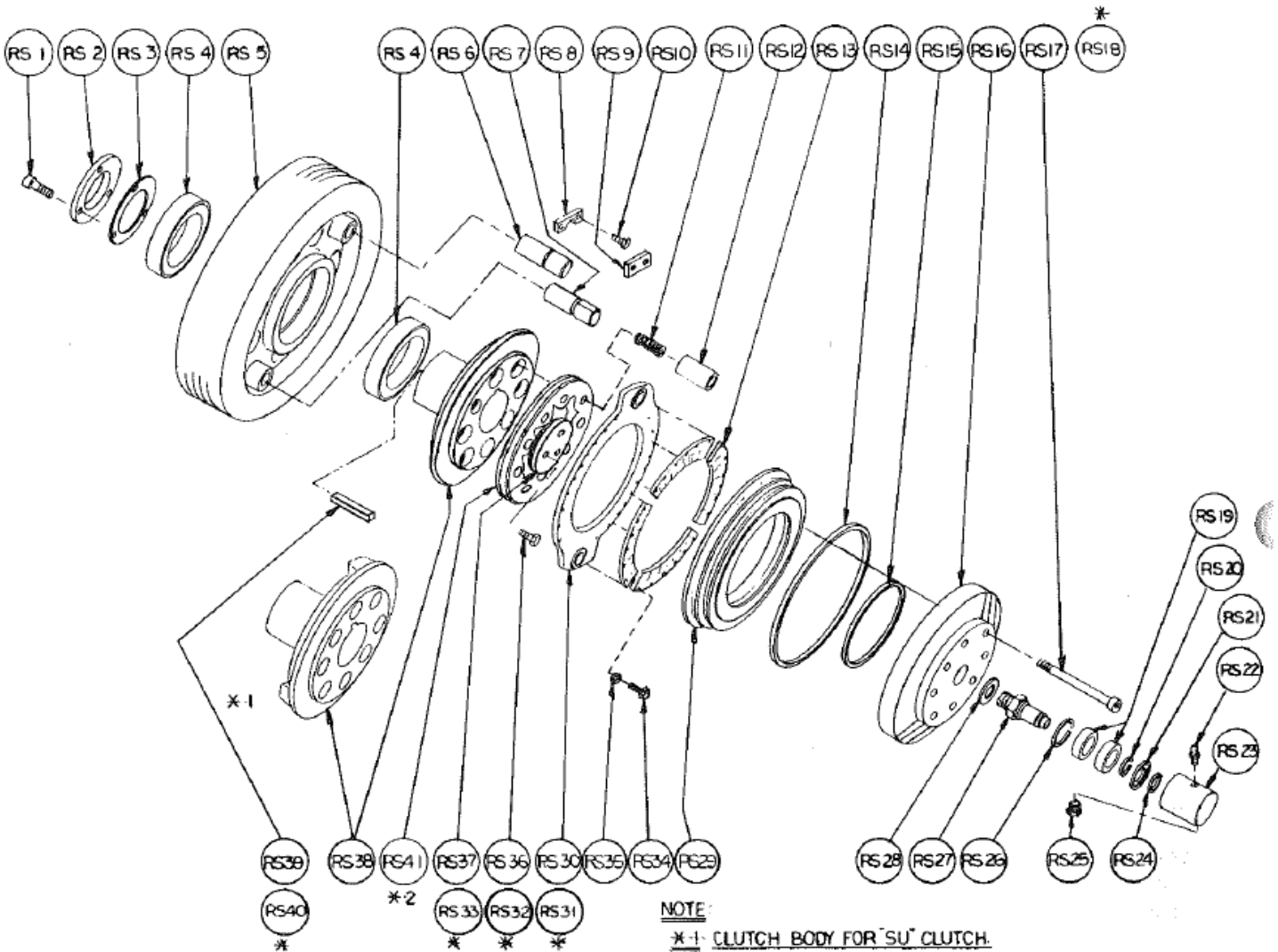


TYPE "R" AIR FRICTION CLUTCH



NOTE:
 *1- CLUTCH BODY FOR "SU" CLUTCH.
 *2- USED ON 241-SU & 371-SU CLUTCHES ONLY.

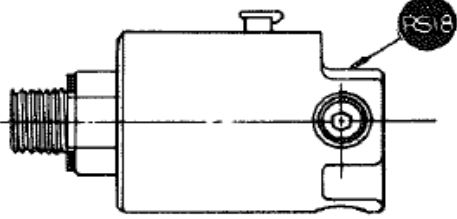
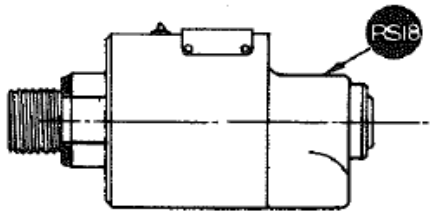
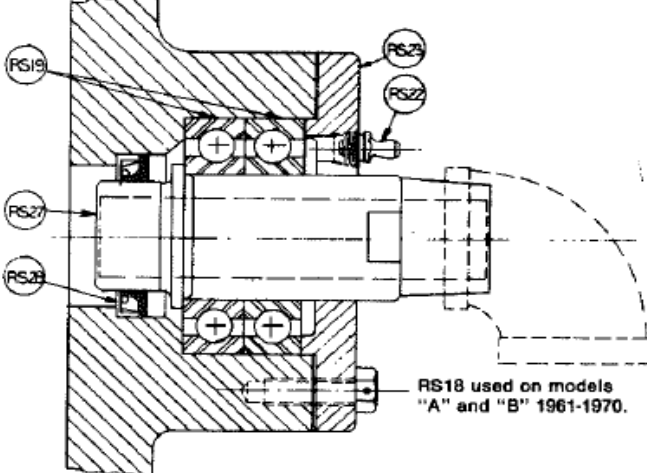
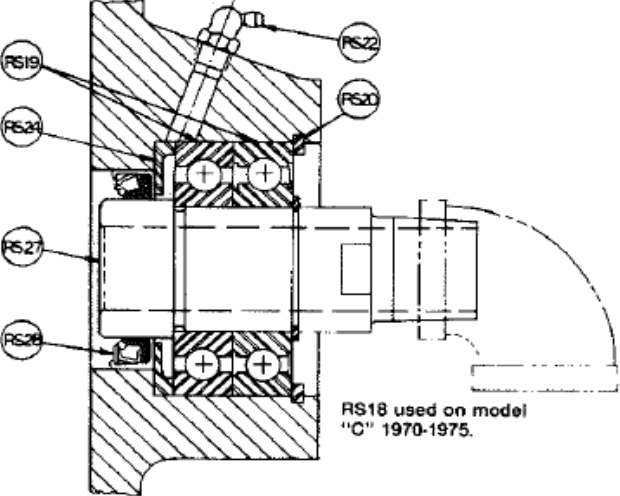
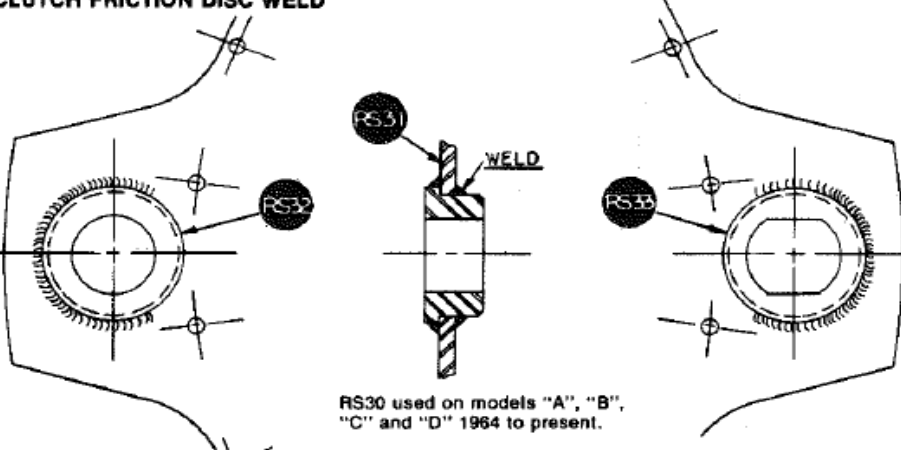
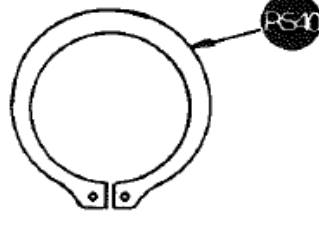
NOTE: Items that are preceded by an asterisk (*) are not illustrated above, and are clarified on page 4

Item Number	Description	Quantity	254-R Mod.A Dec. 1961	254-R Mod.B Jan. 1967	254-R Mod.C Aug. 1970	254-R Mod.D Nov. 1975
RS-1	Bearing Collar Screw	6 pcs.	1314-3-0027-2	1314-3-0027-2	1314-3-0027-2	
	Bearing Collar Screw	3 pcs.				1314-3-0027-2
RS-2	Bearing Collar	1 pc.	0043-2-0076-2	0043-2-0076-2	0043-2-0076-2	3380-B-1828-2
RS-3	Fw. Bearing Shims					
	.003" Thk.- Green	2 pcs.	0043-3-0162-2	0043-3-0162-2	0043-3-0162-2	3125-A-1124-2
	.005" Thk.- Blue	2 pcs.	0043-3-0161-2	0043-3-0161-2	0043-3-0161-2	3125-A-1125-2
	.0075" Thk.-Trans.	2 pcs.	0043-3-0160-2	0043-3-0160-2	0043-3-0160-2	3125-A-1126-2
RS- 4	Flywheel Bearings					
	Timken Cup	2 pcs.	6150-0-1770-2	6150-0-1770-2	6150-0-1770-2	6150-0-1770-2
	Timken Cone	2 pcs.	6151-0-2582-2	6151-0-2582-2	6151-0-2582-2	6151-0-2582-2
RS- 5	Flywheel	1 pc.	Check Record	Check Record	Check Record	Check Record
RS-6	Friction Disc Pin - Round	2 pcs.	0042-2-0419-2			
	Friction Disc Pin - Round	1 pc.		0042-2-0419-2	0042-2-0419-2	0042-2-0419-2
RS-7	Friction Disc Pin-Flat	1 pc.		0042-3-0467-2	0042-3-0467-2	0042-3-0467-2
RS-8	Keeper Plate - Round	2 pcs.	0043-2-0247 -2			
	Keeper Plate-Round	1 pc.		0043-2-0247-2	0043-2-0247-2	0043-2-0247-2
RS- 9	Keeper Plate - Flat	1 pc.		0042-3-0439-2	0042-3-0439-2	0042-3-0439-2
RS- 10	Keeper Plate Screws	4 pcs.	1314-3-0012-2	1314-3-0012-2	1314-3-0012-2	1314-3-0012-2
RS-11	Brake Springs	4 pcs.	6661-0-0157-2	6661-0-0157-2	6661-0-0157-2	6661-0-0157-2
RS- 12	Drive Pins	8 pcs.	0047-3-0068-2	0047-3-0068-2	0047-3-0068-2	0047-3-0068-2
RS- 13	Clutch Linings	8pcs.	0042-1-0138-2	0042-1-0138- 2	0042-1-0138-2	0042-1-0138-2
RS- 14	U- Packing-Outer	1 pc.	5920-0-0082-2	5920-0-0082 -2	5920-0-0082-2	5920-0-0082-2
RS-15	U- Packing - Inner	1 pc.	5920-0-0053-2	5920-0-0053-2	5920-0- 0053-2	5920-0-0053-2
RS-16	Air Cylinder	1 pc.	0047-1-0041-2	0047-1-0183-2	3684-D-8524-2	3684-C-8525-2
RS-17	Air Cylinder Bolts	8 pcs.	6326-0-0371-2	1314-3-0029-2	1314-3-0029-2	2013-A-9100-2
*RS-18	Air Swivel Assembly	1 pc.				0048-1-0232-4
RS-19	Swivel Ball Bearings	2 pcs.	2421-A-3113-2	2421-A-3113-2		
	Swivel Ball Bearing	1 pc.			2421-A-3113-2	2421-A-3112-2
	Swivel Ball Bearing	1 pc.			2422-A-3713-2	2422-A-3712-2
RS-20	Retainer Ring	1 pc.	Not Used	Not Used	2125-A-0058-2	2125-A-0053-2
RS-21	U- Packing	1 pc.	Not Used	Not Used	Not Used	5920-0-0110-2
RS-22	Alemite Fitting	1 pc.	2294-A-2101 -2	2294-A-2101-2	2294-A-2101-2	8393-0-0150-2
RS-23	Housing	1 pc.	0043-2-0001-2	0043-2-0001-2	Not Used	0048-2-0233-2
RS-24	Spacer Ring	1 pc.	Not Used	Not Used	3318-A-6112-2	0048-3-0234-2

BLISS

PARTS
MANUAL

Below are illustrations showing design changes on the "R" and "SU" clutches.
 Below each illustration is the model and approximate years to which they apply.
 The items highlighted in black with white numbers are those that are referred to on previous pages.

<p>AIR SWIVEL</p>  <p>RS18 used on type 14-R and 44R models "A", "B" and "C" 1964-1975.</p>	<p>AIR SWIVEL</p>  <p>RS18 used on type 11-SU, 21-SU, 31-SU and 41-SU model "B" 1966-1975.</p>	
<p>AIR SWIVEL PARTS</p>  <p>RS18 used on models "A" and "B" 1961-1970.</p>	<p>AIR SWIVEL PARTS</p>  <p>RS18 used on model "C" 1970-1975.</p>	
<p>CLUTCH FRICTION DISC WELD</p>  <p>RS30 used on models "A", "B", "C" and "D" 1964 to present.</p>		<p>SNAP RING</p>  <p>RS40 used on 241-SU and 371-SU models "A", "B", and "D" clutches only.</p>