

RPH 12

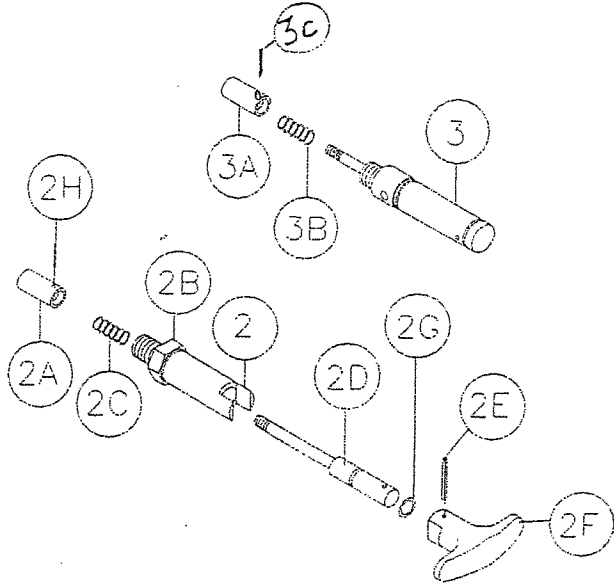
MANUAL SHIFTER ASSEMBLY

Screw jam nut (item #2B) onto threaded end of cylinder (item #2). Place well oiled o-ring (item #2G) over shaft (item #2D) and seat into groove of shaft. Place handle (item #2F) over end of shaft. Align hole in handle with hole in shaft. Drive pin (item #2E) through handle and shaft to secure handle to shaft. MOLYKOTE plunger.

Place end of shaft through cylinder (item #2) and spring (item #2C). Push plunger (item #2A) onto shaft slightly compressing the spring. Insert a .125 dia. rod thru the hole in the plunger and half way thru the shaft hole to align parts. Drive roll pin (item #2H) thru the plunger and shaft so the roll pin is centered in the plunger. Flare both ends of roll pin with 82o punches. The ends of roll pin must be below flush with the outside diameter of the plunger.

AIR CYLINDER SHIFTER ASSEMBLY

Place spring (item #3B) over shaft of cylinder (item #3). Apply Loc-tite 272 or equivalent to threads on end of shaft and thread plunger (item #3A) onto shaft. MOLYKOTE plunger.



Air Shift Assembly

276053

Item #	P/N	Description
3	433027	CYLINDER-AIR, Bimba #D-93617-A-1
3A	<u>426046</u>	PLUNGER-CLUTCH, MANUAL SHIFT
3B	494103	SPRING-SHIFTER, CLUTCH, AIR CYL VERSI
3C	470088	PIN-SPRING, UNBRAKO#31-S-125-0562/EQ

Manual Shifter Assembly

276052

Item #	P/N	Description
2	<u>426050</u>	CYLINDER-CLUTCH
2A	<u>426045</u>	PLUNGER-CLUTCH, MANUAL SHIFT
2B	418088	NUT-JAM
2C	<u>494104</u>	SPRING-SHIFTER, CLUTCH, AIR CYL VERSI
2D	<u>489016</u>	SHAFT-SHIFTER
2E	470033	SPIROL PIN-1/8X7/8, #125-8750-HBS
2F	336026	HANDLE-SHIFTER
2G	462045	O-RING-1/16X1/2OD X3/8ID
2H	470088	PIN-SPRING, UNBRAKO#31-S-125-0562/EQ