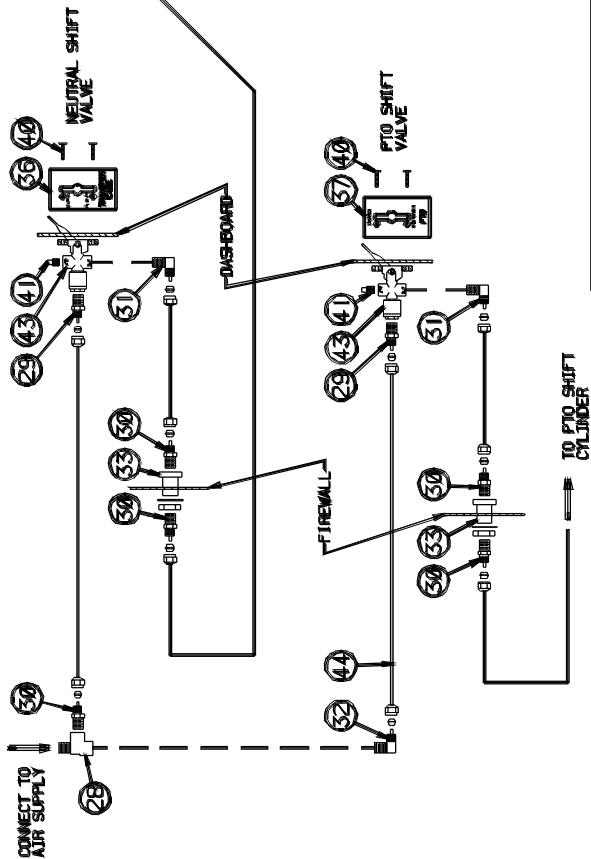
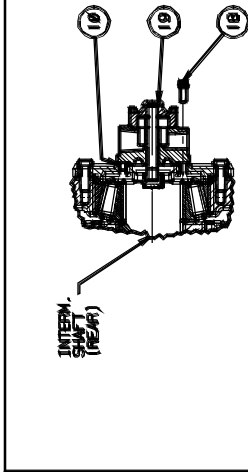
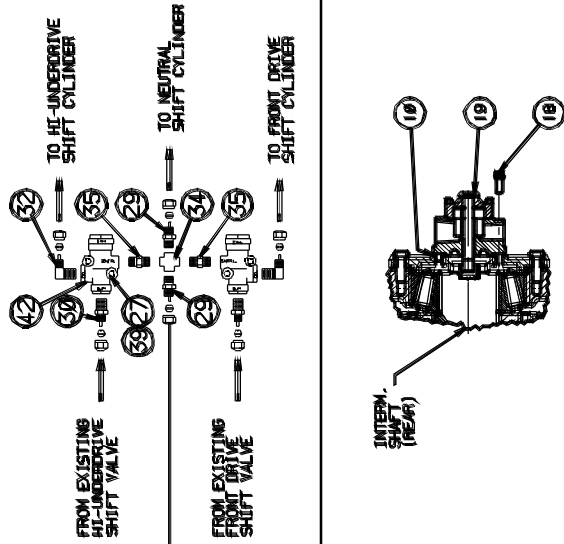
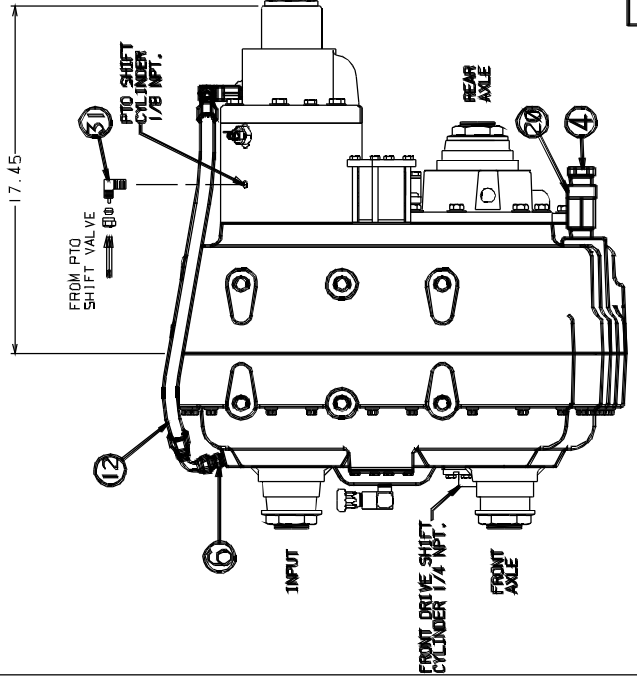
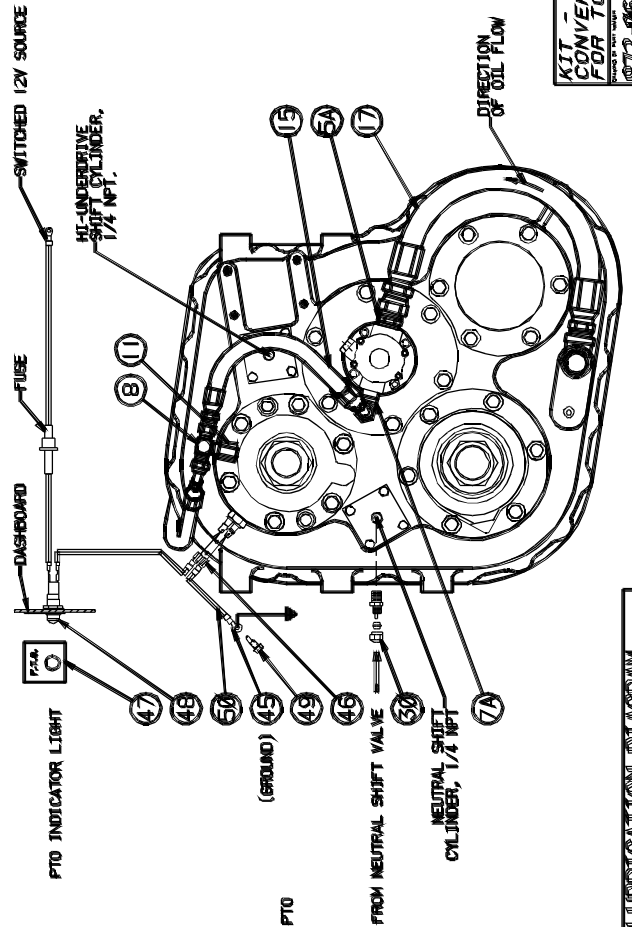


KIT - PTO
CONVERSION
FOR TC-200
872-0615



AIR SHIFT DIAGRAM



LUBRICATION DIAGRAM



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Livermore California 94551
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FAX (925) 454-9501

BY: J-M.T.
DATE: 6/28/01

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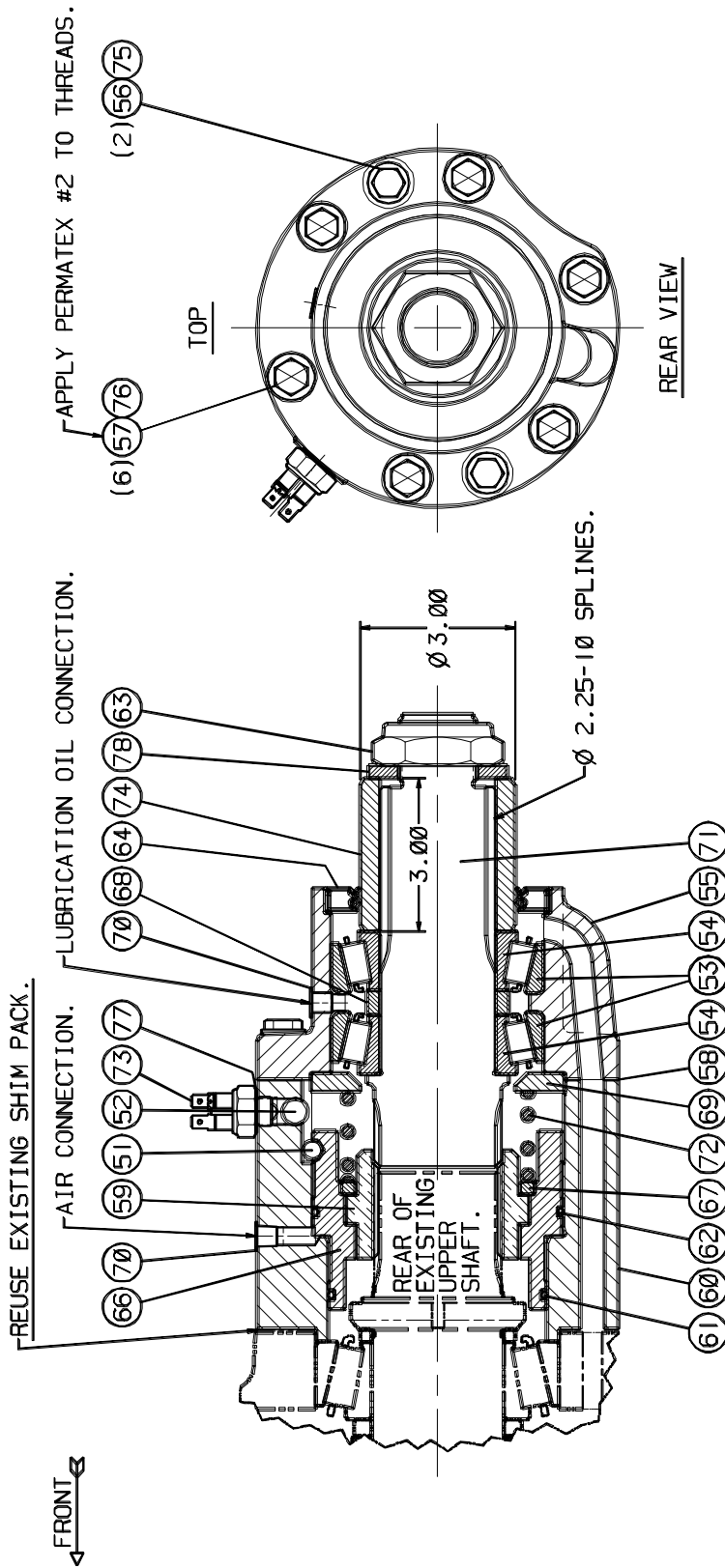
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 Livermore, California 94551
 Telephone (925) 454-9500
 FAX (925) 454-9501

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TC-200A POWER TAKE OFF UNIT

NOTE: ALL PARTS SHOWN ARE ASSEMBLED AT FACTORY EXCEPT THE SIX MOUNTING BOLTS AND WASHERS MARKED WITH AN X.

WHERE USED	KIT - PTO CONVERSION FOR TC-200	DRAWING OR PART NUMBER	REV.	SHEET
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PTO FIELD INSTALLATION INSTRUCTIONS

These instructions have been included with a PTO kit that is designed to mount on the Fabco TC-200 (873-0042-011) Air Shift Transfer Case.

I. REFER TO PAGES 2 AND 3 FOR DRAWINGS


- A. The PTO unit has been assembled at Fabco. The air shift cylinder is integral to the unit.
- B. The PTO kit you have received also includes:
 - 1. Indicator light and associated parts
 - 2. Lubrication Pump
 - 3. Delivery Lines
 - 4. All Lubrication Line Fittings
 - 5. Necessary mounting bolts and screws
 - 6. Air fittings, valves, and tubing

II. INSTALL PTO

- A. Clean the transfer case exterior of dirt and grime.
- B. The PTO may be installed while the transfer case is still in the vehicle, or has been removed to a bench or pallet.
- C. Drain the case of oil.
- D. Remove the six (6) rear input shaft cap bolts, and the bell shaped cap. Discard the cap. Clean and set aside the shims from under the cap, as they will be reused under the PTO.
- E. Apply PERMATEX #2 or equal to all bolt and pipe threads.
- F. Mount existing shims (from step 2D) and PTO assembly in orientation shown on page 2. Use the six (6) new mounting bolts (item #57, sheet 3) and flat washers (item #76). Torque bolts evenly to 40- 45 ft. lbs.

III. INSTALL LUBRICATION SYSTEM

- A. Refer to sheet 2 for location and assembly of the oil pump and other lubrication parts.
- B. Install the reductor (item #11) and the tee (item #8) onto the PTO unit (see sheet 3).

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PTO FIELD INSTALLATION INSTRUCTIONS CONT'D.

III. INSTALL LUBRICATION SYSTEM CONT'D.

- C. Remove 1/4 inch NPT plug that is located in the front of the transfer case housing just above the input shaft.
- D. Install the adapter (item #6) in place of th plug.
- E. Remove the 3/4 NPT plug located on the bottom rear face of the transfer case housing.
- F. Install the tee (item #20) and the oil strainer (item #4) in place of the plug.
- G. Remove 6 (six) inner bolts holding the small oil lpump blanking cap to the intermediate shaft rear cap. Discard the blanking cap, bolts, washers and gasket.
- H. Install the 90° elbow (item #7A) to the oil pump. The adapter should be tight and in its final position before installing the pump.


CAUTION: DO NOT TORQUE THE PUMP FITTINGS ABOVE 30 LB.-FT. TO PREVENT PUMP FAILURE.

- I. Install the oil pump (item #19), using a new oil pump gasket (item #10). The pump should be oriented so that the 3/4" inlet (outlet is 1/2") is on the right and rotated down by 15° (see sheet 2). Make sure the pump shaft fits into the slot in the rear of the intermediate shaft. Torque the front bolts (item #18) evenly to 15 lb.-ft.
- J. Install the 3/4 NPT oil pump inlet adapter (item #5A) to the oil pump, see the torque caution above.
- K. Install the first hose assembly (item #17) from the oil strainer tee to the pump inlet adapter.
- L. Install the second hose assembly (item #15) from the elbow at the pump outlet to the tee at the PTO unit. The end of the hose assembly with the 45° elbow should be connected to the 90° elbow at the pump outlet.
- M. Install the third hose assembly (item #12) from the tee at the PTO unit to the adapter at the front of the transfer case housing. The end of the hose assembly with the 45° elbow should be connected to the tee at the PTO unit.

IV. INSTALL AIR SHIFT SYSTEM

- A. Refer to page 2 for recommended air line and valve arrangements.

CAUTION: DO NOT CONNECT TO AIR BRAKE SYSTEM! REFER TO APPROPRIATE BODYBUILDERS DATA BOOK FOR RECOMMENDED AIR SYSTEM TAP-IN POINT!

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IV. INSTALL AIR SHIFT SYSTEM CONT'D.

- B. The inversion valves (item #42) are to be installed in line with the existing air shift supply lines. Take note of the configuration on the drawing on sheet 2. Mount inversion valves on the frame rails near transfer case or transfer case mounting brackets.
- C. Route air tubing and secure with supplied plastic tyrap. Keep plastic lines away from heat sources, moving parts, and sharp edges.


V. INSTALL PTO INDICATOR LIGHT

Parts and a suggested wiring schematic for a PTO indicator light are shown on sheet 2. Connect fused side of indicator light to accessory terminal of ignition switch or equivalent switched 12V source. Tape terminals watertight with plastic electrical tape.

VI. OIL LEAK CHECK

- A. Install PTO output yoke or flange on the shaft. Torque retaining nuts to 350 to 400 lb.-ft.
- B. Run the transfer case in neutral and check for oil leaks.

VII. RECHECK TRANSFER CASE OIL LEVEL

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SERVICE PARTS LIST

TRANSFER CASE MODEL — TC-200

KIT NUMBER 872-0615TITLE: Kit, Conversion, PTO REFER TO DRAWING NUMBER 872-0615

ITEM	PART NUMBER	DESCRIPTION	QTY	FOOT NOTE
<u>LUBRICATION LINES & FITTINGS</u>				
4	345-0268	STRAINER, OIL	1	
5A	357-0245	ADAPTER, 3/4 MNPT TO #12 AN	1	
6	357-0287	ADAPTER, 1/4 MNPT x #6 AN	1	
7A	357-0293	ELBOW 90°, 1/2 MNPT x #8 AN	1	
8	357-0922	TEE, #6 AN x 1/4 MNPT x #6 AN	1	
11	357-0933	REDUCER, 1/4 FNPT x 1/8 MNPT	1	
10	427-0468	GASKET, OIL PUMP	1	
12	469-0822-022	HOSE ASSEMBLY, #6, 18.9" LONG	1	
15	469-0823-008	HOSE ASSEMBLY, #8, 13.0" LONG	1	
17	469-0825-005	HOSE ASSEMBLY, #12, 17.8" LONG	1	
18	724-0233	SCREW, CAP 5/16-24 x 3/4", 12PT FLANGED	4	
19	786-0299-001	PUMP ASSEMBLY	1	
20	824-0275	TEE, 3/4 FNPT x 3/4 FNPT x 3/4 MNPT	1	
<u>AIRLINES, FITTINGS & RELATED PARTS</u>				
26	255-0392	TYRAP	24	
27	265-0464	BOLT, HH 1/4-28 x 1 3/4	4	
28	355-0482	STREET TEE, 1/4	1	
29	355-0599	CONNECTOR, 1/8P x 1/4T, MALE	4	
30	355-0622	CONNECTOR, 1/4P x 1/4T, MALE	8	
31	355-0632	CONNECTOR, 1/8P x 1/4T, 90° MALE	3	
32	355-0634	CONNECTOR, 1/4P x 1/4T, 90° MALE	3	
33	355-0646	FITTING, BULKHEAD	2	
34	355-0696	FITTING, 1/8 PIPE CROSS	1	
35	355-0697	FITTING, 1/8 HEX NIPPLE	2	
36	535-0443	LABEL, NEUTRAL SHIFT	1	
37	535-0445	LABEL, PTO SHIFT	1	
38	535-0446	LABEL, PTO INSTRUCTION	1	
39	688-0677	NUT, 1/4-28, LOCK	4	
40	724-0339	SCREW, PAN HD, #10-24 x 3/4 LONG	4	



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TRANSFER CASE MODEL — TC-200

KIT NUMBER 872-0615TITLE: Kit, Conversion, PTO REFER TO DRAWING NUMBER 872-0615

ITEM	PART NUMBER	DESCRIPTION	QTY	FOOT NOTE
<u>AIRLINES, FITTINGS & RELATED PARTS CONT'D.</u>				
41	758-0238	PLUG, 1/8 PIPE	2	
42	825-0633	VALVE, INVERSION	2	
43	825-0729	VALVE, 2-WAY	2	
44	883-0226	TUBE, 1/4"	50'	
<u>INDICATOR LIGHT KIT</u>				
45	353-0267	TERMINAL, 1/4 RING	1	
46	353-0276	TERMINAL, FEMALE	2	
47	535-0438	LABEL, PTO LIGHT	1	
48	544-0264	LIGHT, WARNING, WIRED	1	
49	724-0558	SCREW, SELF DRILLING, 1/4 x 3/4	1	
50	947-0268	WIRE, JUMPER	1	
<u>PTO PARTS (ASSEMBLED AT FACTORY)</u>				
51	225-0222	BALL, 3/8" DIAMETER	1	
52	225-0286	BALL, 1/2" DIAMETER, STEEL	1	
53	233-0545	BEARING CUP	2	
54	233-0546	BEARING CONE	2	
55	237-0586	CARRIER, PTO	1	
56	265-0483	BOLT, 3/8-16 x 1 3/4	2	
57	283-0236	BOLT, 7/16-14 x 6 1/2	6	
58	427-0528	GASKET, PTO CARRIER	1	
59	432-0664	GEAR, PTO DECLUTCH	1	
60	478-0249	HOUSING, PTO DECLUTCH	1	
61	675-0241-V14	O-RING, 3 7/8 ID x 1/8	1	
62	675-0246-V14	O-RING, 4 1/2 ID x 1/8	1	
63	688-0694	NUT, LOCK, 1 1/2-12	1	
64	732-0397	SEAL, OIL	1	
65		NOT USED		
66	753-0247	PISTON, PTO DECLUTCH	1	
67	756-0254	RING, PISTON, PTO DECLUTCH	1	



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SERVICE PARTS LIST

TRANSFER CASE MODEL — TC-200

KIT NUMBER 872-0615TITLE: Kit, Conversion, PTO REFER TO DRAWING NUMBER 872-0615

ITEM	PART NUMBER	DESCRIPTION	QTY	FOOT NOTE
<u>PTO PARTS (ASSEMBLED AT FACTORY) CONT'D.</u>				
68	756-0264-001	RING, BEARING SPACER, .485 THICK, AS REQUIRED	1	
68A	756-0264-002	RING, BEARING SPACER, .490 THICK, AS REQUIRED	1	
68B	756-0264-003	RING, BEARING SPACER, .495 THICK, AS REQUIRED	1	
68C	756-0264-004	RING, BEARING SPACER, .500 THICK, AS REQUIRED	1	
68D	756-0264-005	RING, BEARING SPACER, .505 THICK, AS REQUIRED	1	
69	756-0265	RING, SPRING RETAINER, PTO	1	
70	758-0373	PLUG, 1/8 NPT, PLASTIC	2	
71	776-0268	SHAFT, PTO, OUTPUT	1	
72	777-0542	SPRING, PTO, DECLUTCH	1	
73	798-0245	SWITCH, SHIFT, INDICATOR	1	
74	884-0226	TUBE, SLEEVE, PTO	1	
75	927-0337	WASHER, FLAT, 3/8	2	
76	927-0347	WASHER, FLAT, 7/16	6	
77	927-0427	WASHER, COPPER	1	
78	927-0775-005	WASHER, SHAFT END	1	



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