

TECHNICAL BULLETIN

TB NO. 1018
REV. 0

**Subject: Proper Assembly Procedures For a
4Y-1699 Governor Adapter & Drive Assembly
For In-Line 825 Series Engines.**

Whenever assembling new or rebuilding the referenced assembly one (1) of a P-020-358 shim must be included in the parts list. This shim pack is required to properly set the end-play of the shaft and bearing assembly in the housing. The shim must be placed between the bearing spacer and the lower bearing. The correct assembly procedure is as follows:

1. Install the upper bearing onto the shaft (insure that the bearing is flush against the flange of the shaft).
2. Install the shaft & bearing into the housing.
3. Slide the bearing spacer and the shim onto the shaft.
4. Slide the lower bearing onto the shaft.
5. Place the pinion gear onto the shaft and snug it up to the shaft shoulder with the nut.
6. Check the shaft and bearing assembly end-play (dial indicator or other acceptable means). Record the amount of movement.
7. Remove the nut, gear, lower bearing & shim pack. Peel shims from the pack, equal to the amount of end-play that was measured.
8. Re-install the shim pack, lower bearing, Woodruff key, gear, washer and nut. Torque the nut (per a standard torque chart).

This should result in the inner and outer races of the ball bearings being properly centered over the balls of the bearings. The remaining end-play will be limited to the clearance between the balls and the races of the bearings themselves.

Failure to properly set the end-play of the assembly will result in premature failure of the bearings and drive.

For further information concerning governor adapters, drive assemblies or assembly procedures, please contact **EnDyn's** Technical Service Department or your local authorized **PowerParts®** Distributor.

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