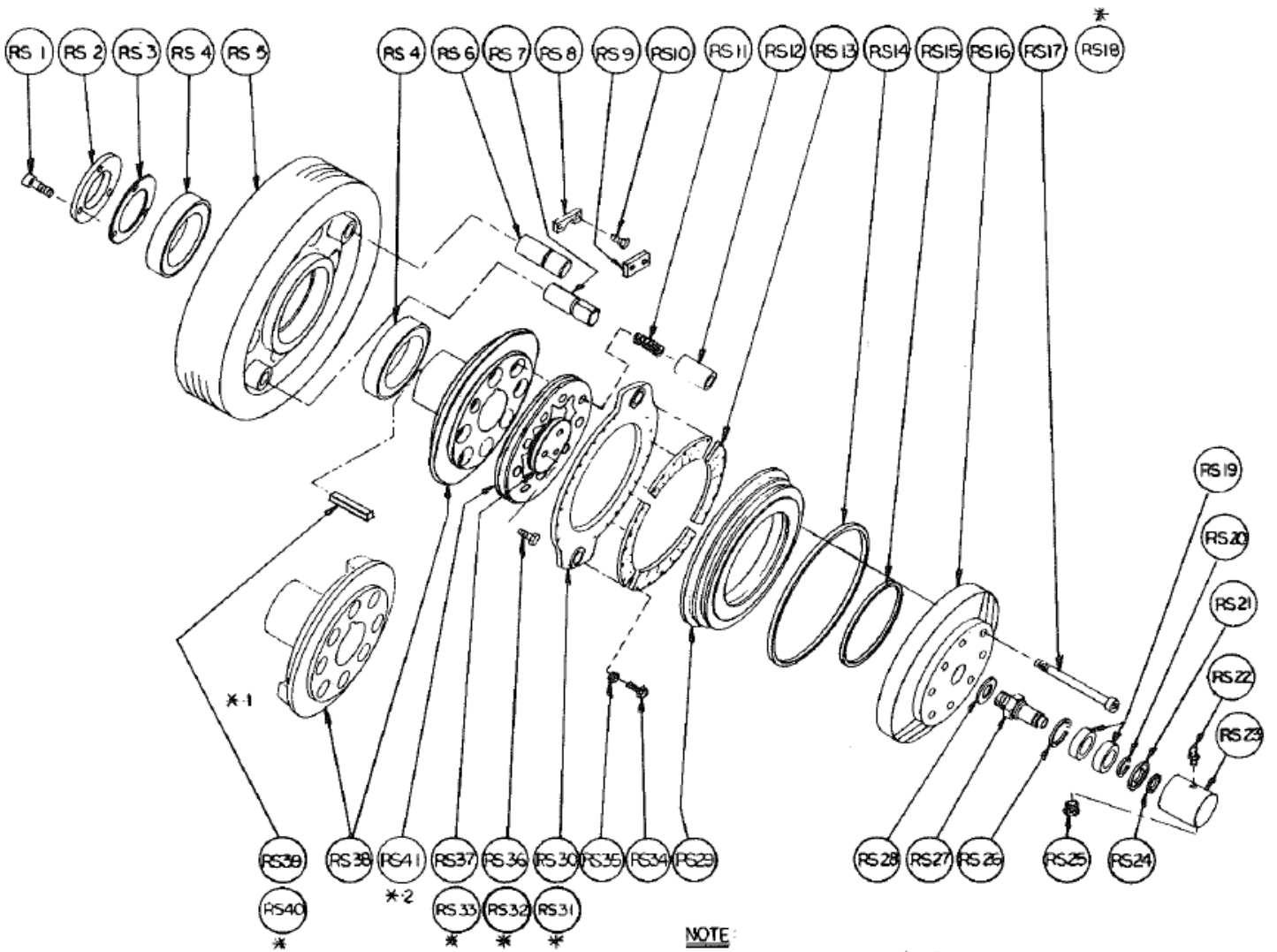


**TYPE "SU" AIR FRICTION CLUTCH**



**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 3

# TYPE "SU" AIR FRICTION CLUTCH

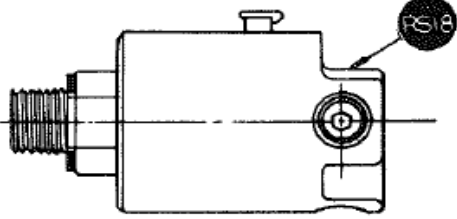
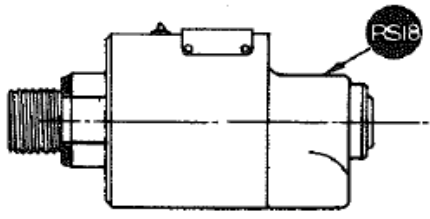
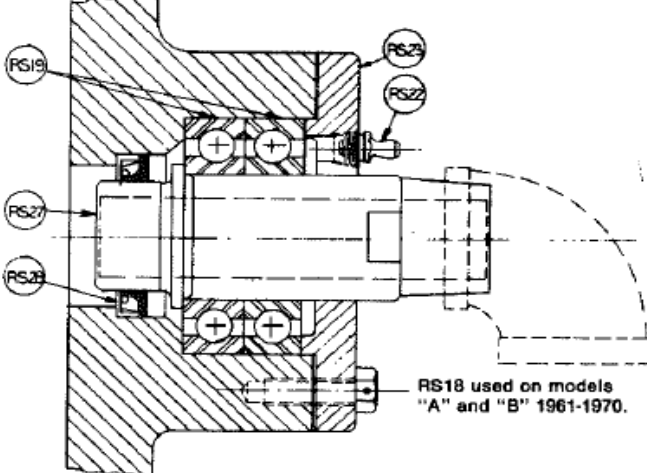
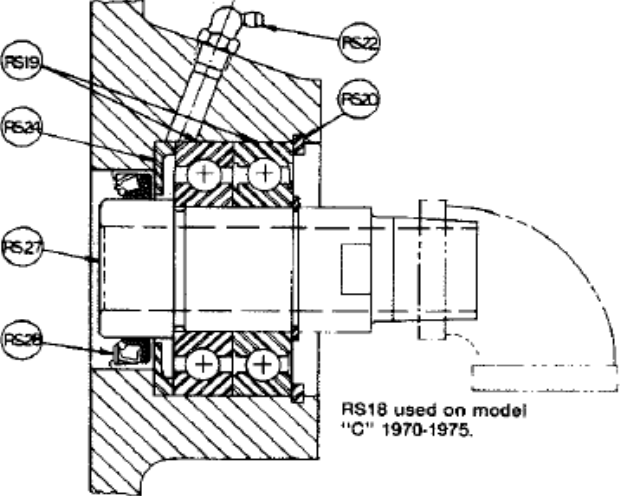
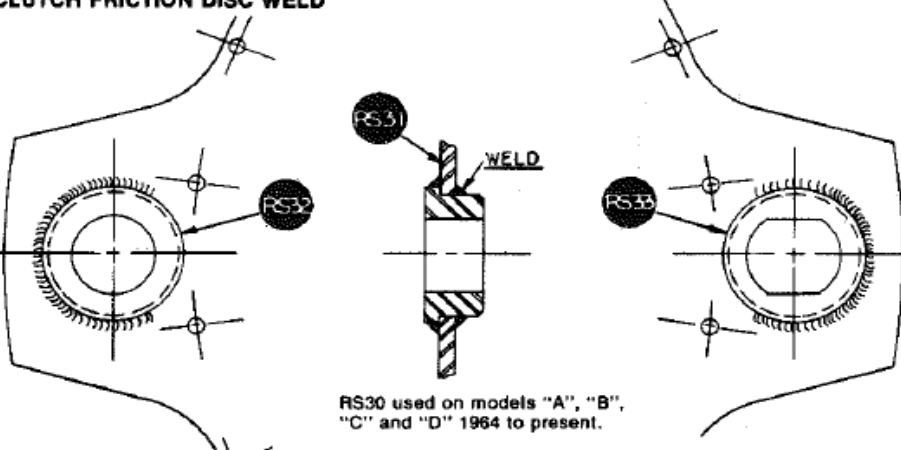
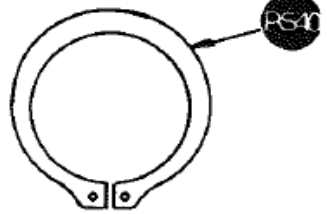
# MODEL 81

## CLUTCH SIZE / PART NUMBER

Item No.	Description	Quantity	81-SU Mod.C Apr.1970	81-SU Mod.D Aug.1975
RS-1	Bearing Collar Screw	6 pcs.	6326-0-0213-2	
	Bearing Collar Screw	3 pcs.		6326-0-0213-2
RS-2	Bearing Collar	1 pc.	3382-A-2146-2	3382-A-2146-2
RS-3	Fw. Bearing Shims			
	.005" Thk. - Blue	2 pcs.	0043-3-0165-2	3124-A-5120-2
	.002" Thk. - Red	5 pcs.	0043-3-0164-2	3124-A-5119-2
RS-4	Flywheel Bearings	2 pcs.	6250-0-0125-2	6250-0-0125-2
RS-5	Flywheel	1 pc.	Check Record	Check Record
RS-6	Friction Disc Pin - Round	1 pc.	0042-3-0615-2	3263-A-4127-2
RS-7	Friction Disc Pin - Flat	1 pc.	0042-3-0616-2	3261-A-6140-2
RS-8	Keeper Plate - Round	1 pc.	0043-3-0250-2	0043-3-0250-2
RS-9	Keeper Plate - Flat	1 pc.	0042-3-0427-2	0042-3-0427-2
RS-10	Keeper Plate Screws	4 pcs.	1314-3-0008-2	1314-3-0008-2
RS-11	Brake Springs	4 pcs.	6661-0-0008-2	6661-0-0008-2
RS-12	Drive Pins	8 pcs.	0047-3-0008-2	0047-3-0008-2
RS-13	Clutch Linings	8 pcs.	0042-1-0136-2	0042-1-0136-2
RS-14	U-Packing - Outer	1 pc.	2314-A-6186-2	2314-A-6186-2
RS-15	U-Packing - Inner	1 pc.	5920-0-0041-2	5920-0-0041-2
RS-16	Air Cylinder	1 pc.	3684-C-9123-2	3684-C-9125-2
RS-17	Air Cylinder Bolts	8 pcs.	2011-A-8228-2	2011-A-8228-2
*RS-18	Air Swivel Assembly	1 pc.		0048-1-0231-4
RS-19	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.	2125-A-0058-2	2125-A-0053-2
RS-21	U-Packing	1 pc.	Not Used	5920-0-0110-2
RS-22	Alemite Fitting	1 pc.	2294-A-2462-2	8393-0-0150-2
RS-23	Housing	1 pc.	Not Used	0048-2-0233-2
RS-24	Spacer Ring	1 pc.	3318-A-6112-2	0048-3-0234-2
RS-25	Reducer Bushing	1 pc.	2222-Z-4208-2	2222-Z-1011-2
RS-26	Retainer Ring	1 pc.	2125-A-1042-2	2125-Z-1039-2
RS-27	Swivel Sleeve	1 pc.	3369-A-9132-2	0048-2-0236-2
RS-28	Sleeve Gasket	1 pc.	2311-A-2167-2	0048-3-0237-2
RS-29	Air Cylinder Piston	1 pc.	0047-1-0021-2	0047-1-0021-2
RS-30	Clutch Friction Disc Assembly	1 pc.	3684-B-4213-4	3684-B-4213-4
*RS-31	Clutch Friction Disc	1 pc.	3491-C-3107-2	3491-C-3107-2
*RS-32	Clutch Friction Disc Bush. - Round	1 pc.	3341-B-6102-2	3341-B-6102-2
*RS-33	Clutch Friction Disc Bush. - Flat	1 pc.	3344-B-9104-2	3344-B-9104-2
RS-34	Clutch Lining Screws	24 pcs.	2011-Z-1583-2	2011-Z-1583-2
RS-35	Clutch Lining Screw Nuts	24 pcs.	5815-0-0004-2	5815-0-0004-2
RS-36	End Plate Screws	3 pcs.	1314-3-0015-2	1314-3-0015-2
RS-37	End Plate - (Crankshaft)	1 pc.	0043-3-0048-2	3286-A-2119-2
RS-38	Clutch Body	1 pc.	0043-1-0196-2	3684-C-7826-2
RS-39	Shaft Key	1 pc.	5560-0-0267-2	5560-0-0267-2

NOTE: - Item numbers that are preceded by an asterisk (\*) have been impacted by a design page - see page 3

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