



TRACTOR SERVICE INFO



TB2069

BELARUS- 1221 & 1523 SERIES Fitting Instructions

BELARUS 1221 SERIES

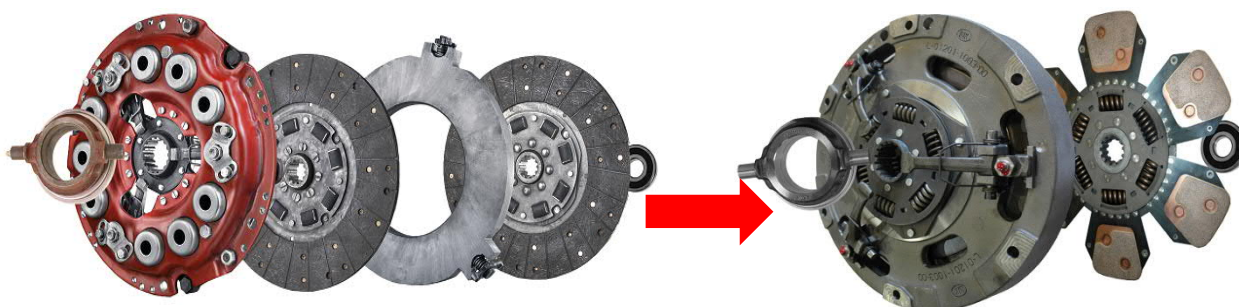
633 3341 09 = 133 0295 10 + 333 0259 10

633 3341 00 = 133 0295 10 + 333 0259 10 + 500 1303 40 + 410 0043 40

BELARUS 1523 SERIES

633 3227 09 = 133 0292 10 + 333 0259 10

633 3227 00 = 133 0292 10 + 333 0259 10 + 500 1303 40 + 410 0043 40



- The following points must be observed to ensure that you obtain a satisfactory service life from the quality LuK clutch components to be fitted.
- Ensure that you have the correct components for your vehicle.
- Always replace ALL the clutch related parts including flywheel, pilot and the release bearings.
- Leaking oil seals will contaminate the new clutch parts resulting in clutch slip and failure.
- Worn release carriers, forks, bushes, shafts and cables will all reduce the release mechanism travel and result in clutch drag.
- Correct alignment is essential to prevent damage to new clutch parts.
- **For correct operation and lifetime of the clutch It is essential to use a tractor splitting kit to ensure correct alignment and installation**

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Step 1 – Remove and discard 3 pins from flywheel.

Remove 3 Pins



Step 2 – Remove and discard 6 tubes





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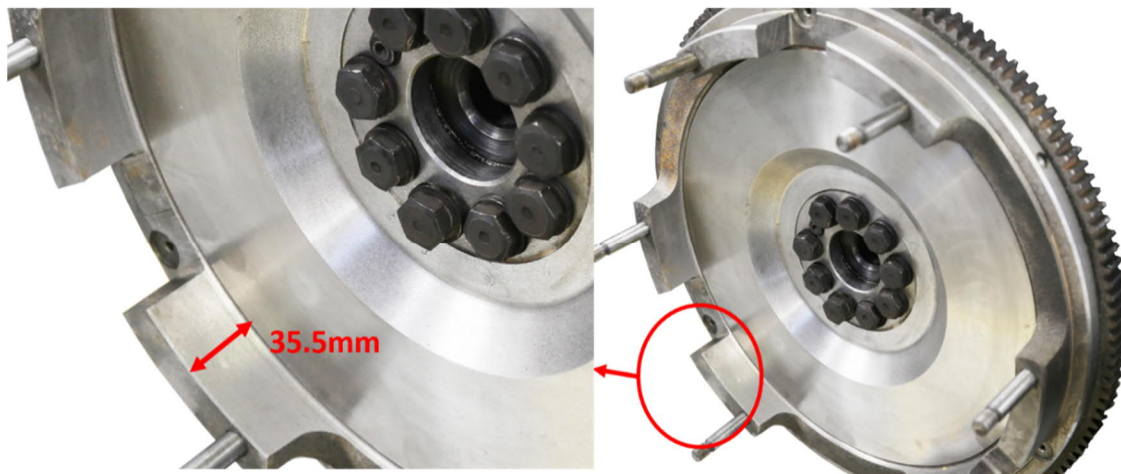
Step 3 – Remove flywheel centre bearing



Step 4 – The condition of the flywheel wear face is critical, It must be flat with in 0.01mm across its diameter with no grooves, ridges ect. A glazed or polished appearance must be removed by grinding.

- Do not alter any register diameter on the flywheel.

Flywheel pot depth of $35.5\text{mm} \pm 0.25\text{mm}$



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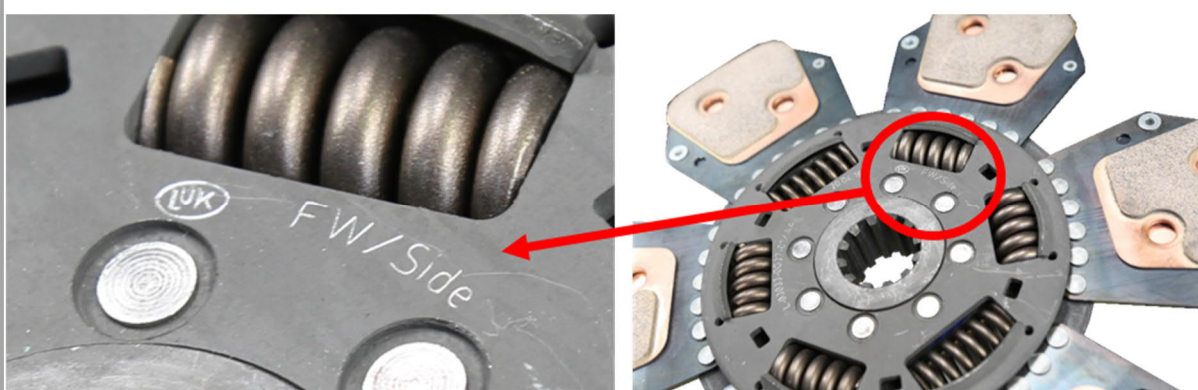


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Step 5 – Refit new flywheel centre bearing



Step 6 – NOTE Flywheel sides markings. This side towards flywheel



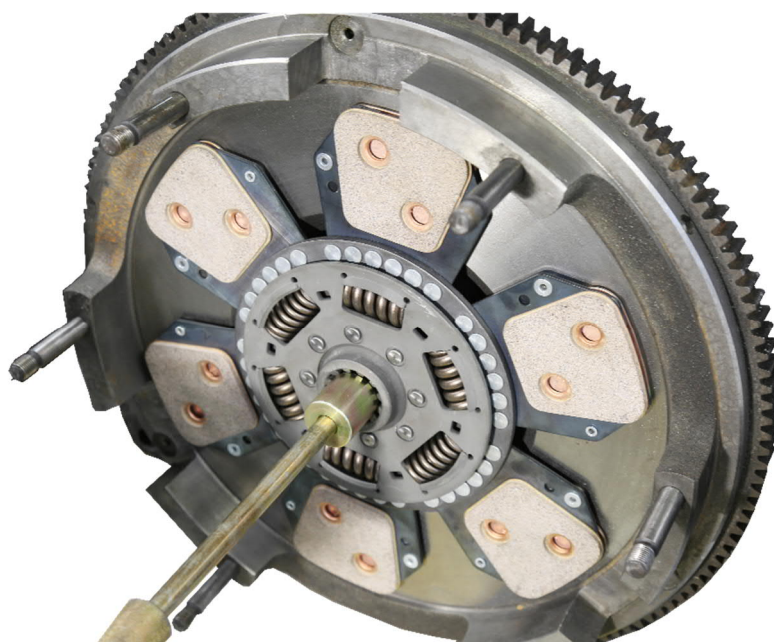


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Step 7 – Centrally align disc with tool 400 0434 10



Step 8 – Secure new clutch to flywheel – 80Nm



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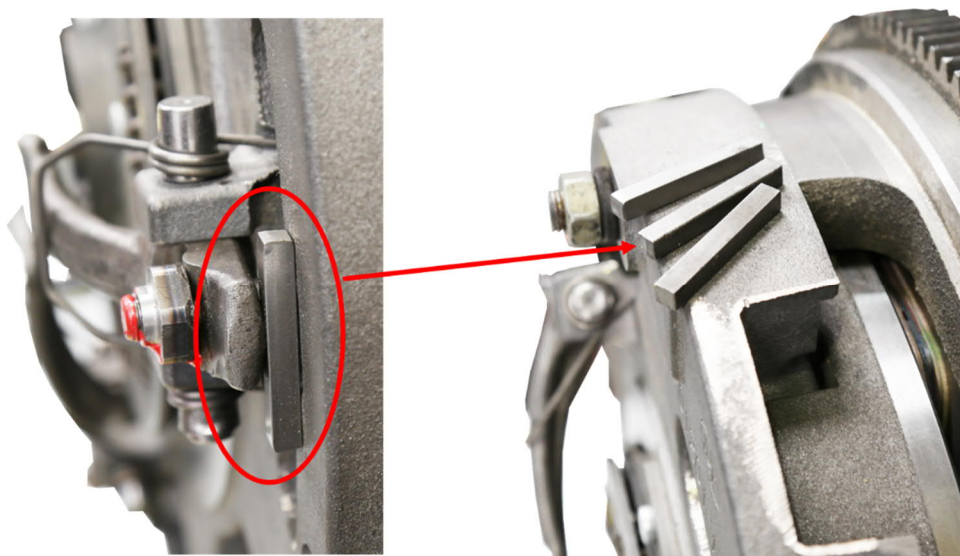


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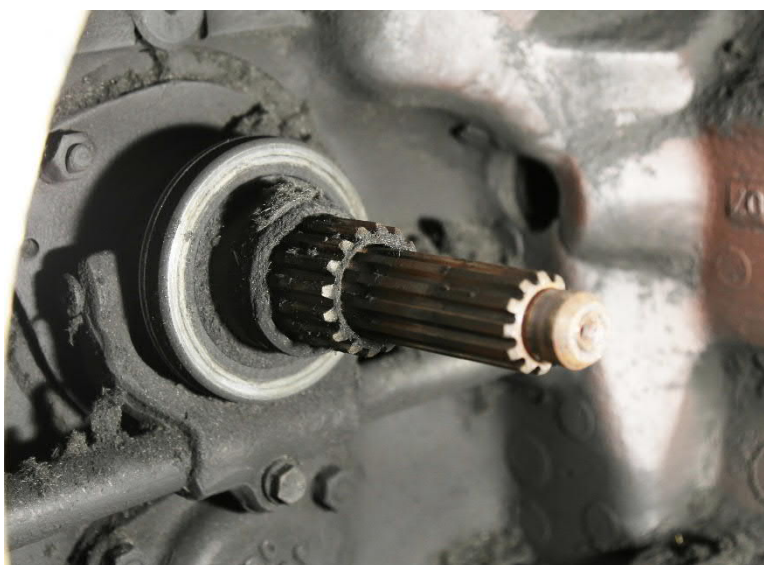


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Step 9 – Remove and discard 3 clutch transport bars



Step 10 – Remove release bearing – Make area free of oil and debris. Replace any leaking transmission seals



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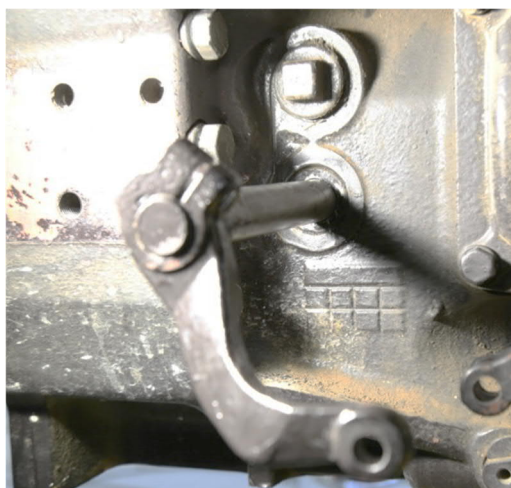
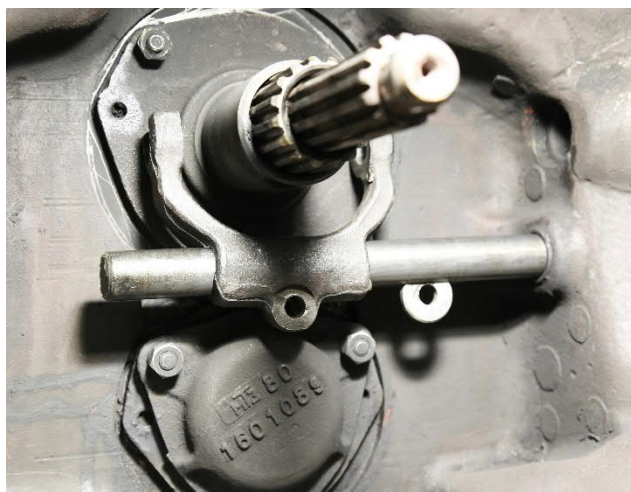


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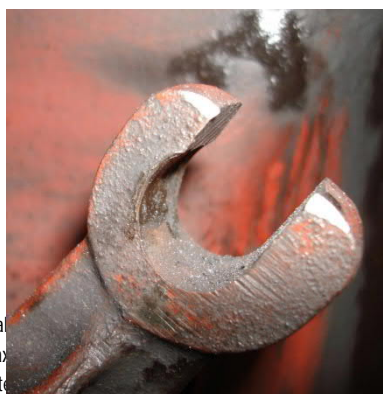


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Step 11 – Remove clutch cross shaft and inspect for wear



Step 12 – Replace worn shaft and support bushes in gearbox housing



Step 13 – Replace worn release fork

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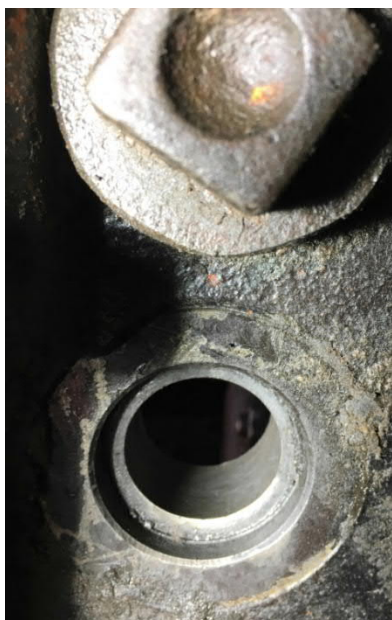


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Step 14 – Remove old bush



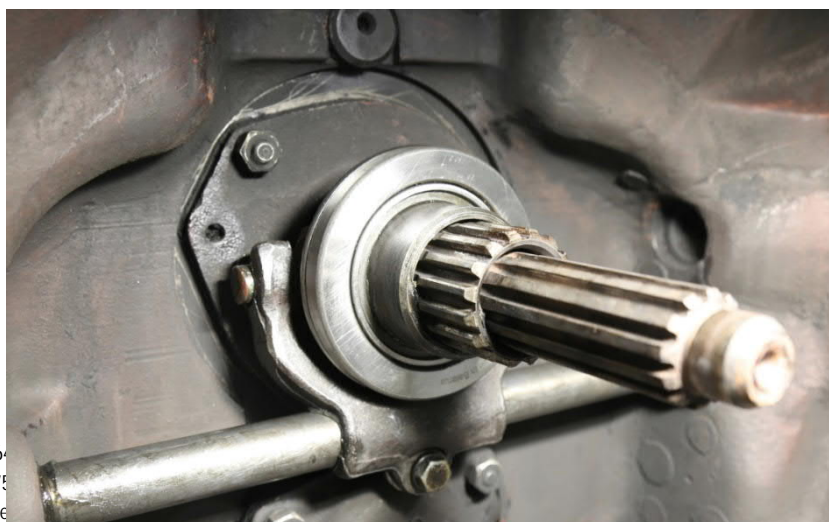
Step 15 – Fit new bush



Step 16 – Fit new shaft and lubricate



Step 17 – Reassemble release system, check for free movement, Clean shaft splines



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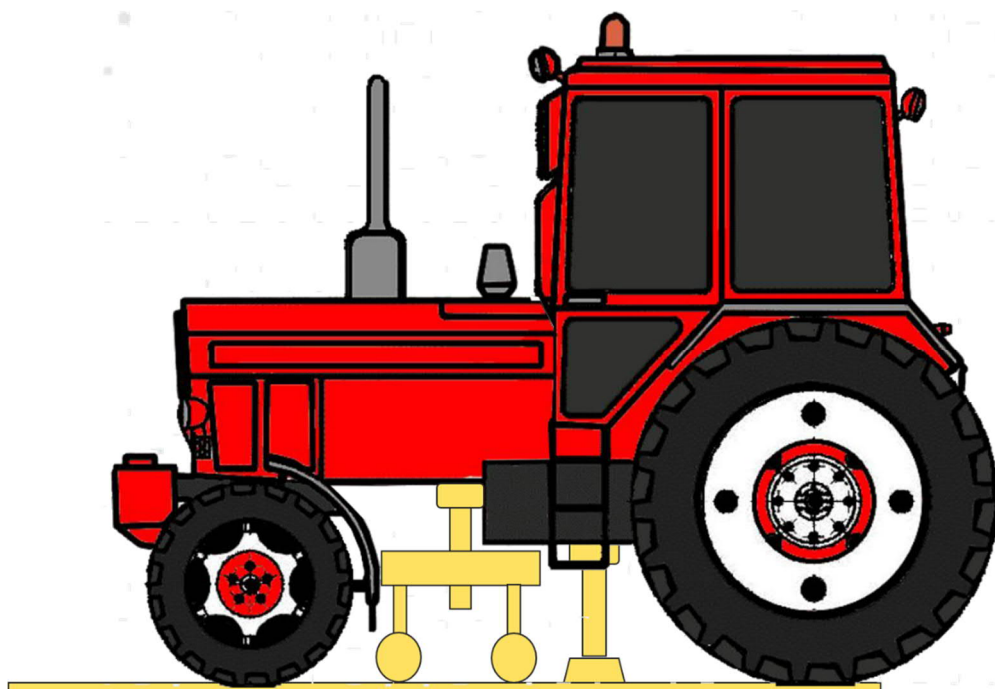


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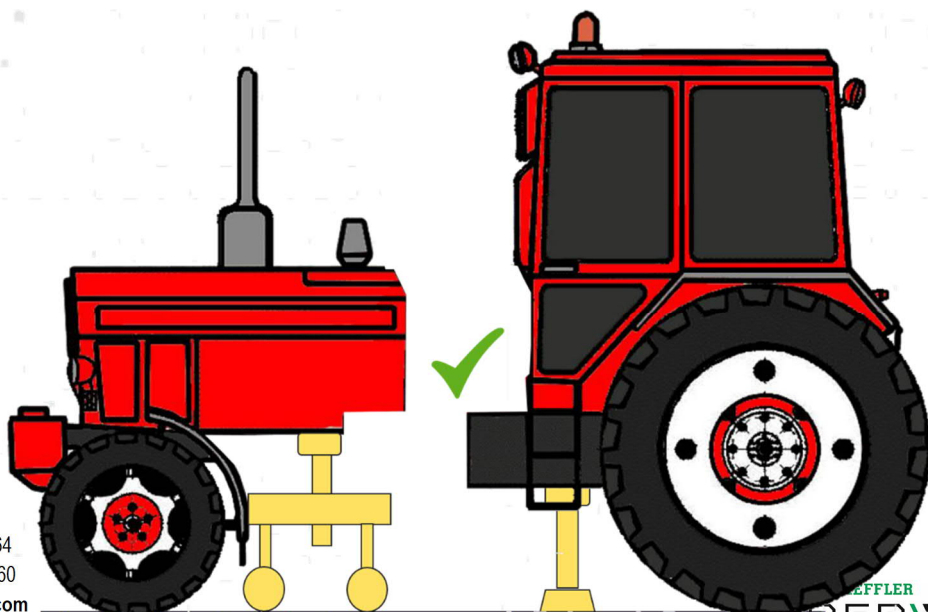


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Using a rail system is extremely accurate



Both halves of the tractor are always supported and remain level



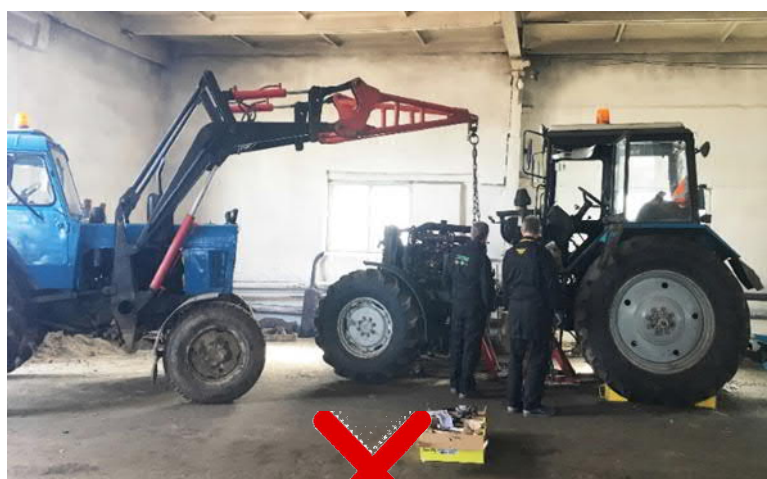
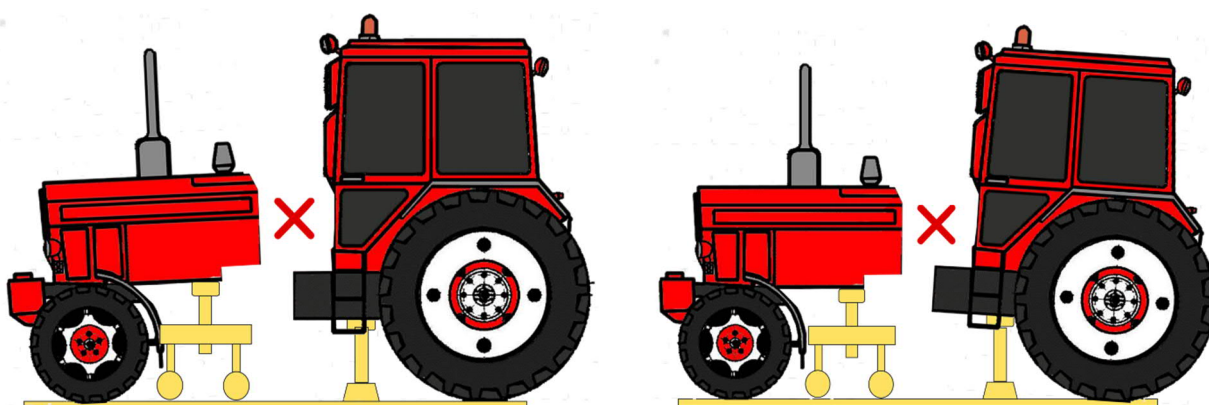
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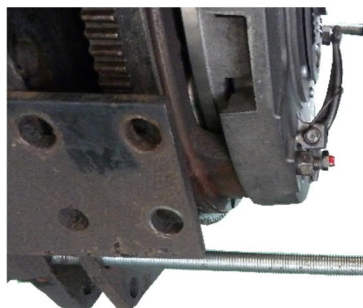


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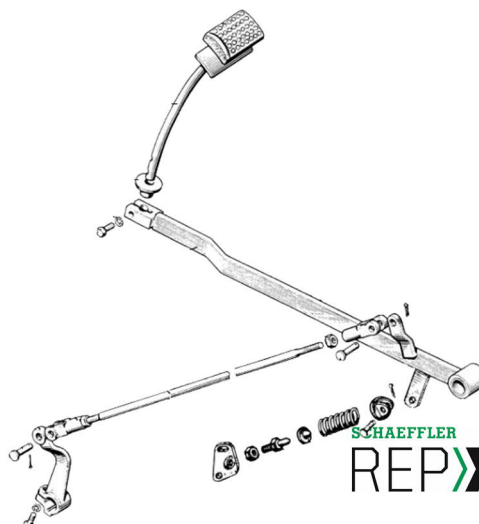
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Step 19 – Dowel studs are recommended to assist correct safe and level alignment of tractor



Step 20 – Clutch adjustments.

Mechanical rod operated, set 3>5mm clearance between release bearing and clutch levers



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Step 21 – Clutch adjustments.

Hydraulic boost operated, set clevis pin hole halfway across cross shaft pin hole. This will give clearance between release bearing and clutch levers of approximately 3 to 5mm

