



# REPAIR TIPS



## MODELS

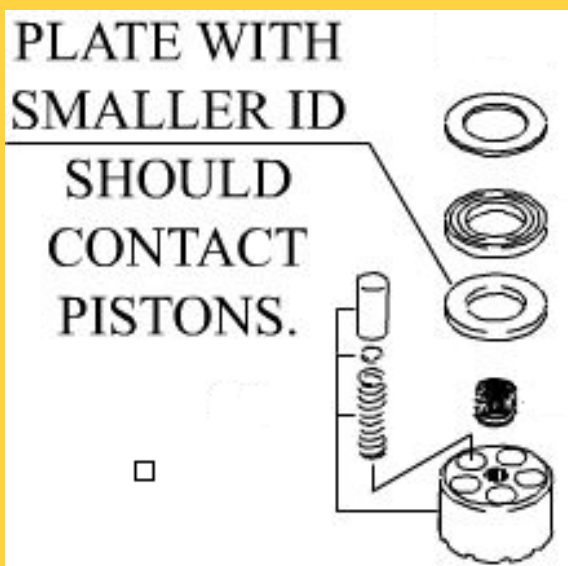
- K46
- K57
- K574
- T40

**ISSUED BY:**  
**TUFF TORQ**  
**SERVICE**

# TORQ TIPS

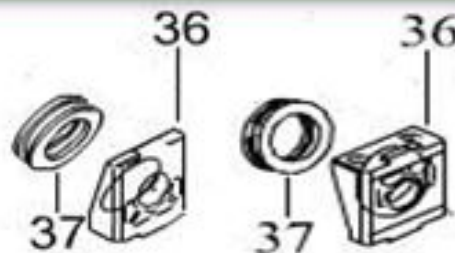
- **Clean and flush the unit. Units that are not cleaned properly could result in a premature failure or void the parts warranty. Brake parts cleaner can be used to clean the internals.**
- **If you choose to inspect any parts make sure these parts are placed back into the proper orientation. (Ex. If you remove a bearing or a plate make sure that it is placed back into the proper position. Plate with smaller ID (INSIDE DIAMETER) should contact Pistons.) The notes are listed on most drawings so be sure to follow these tips properly. (Fig#1 )**
- **Note the original position of the Motor Housing. (Fig.#2)**

**FIG #1**



**FIG #2**

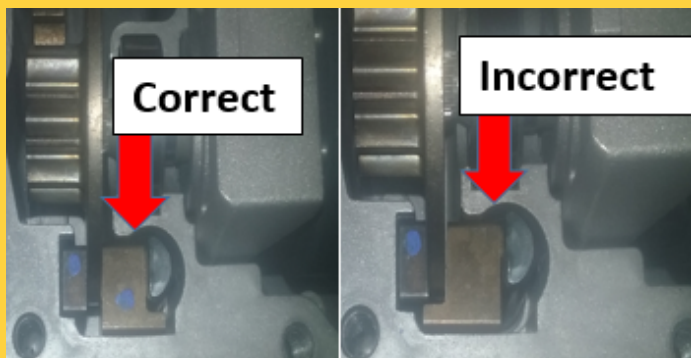
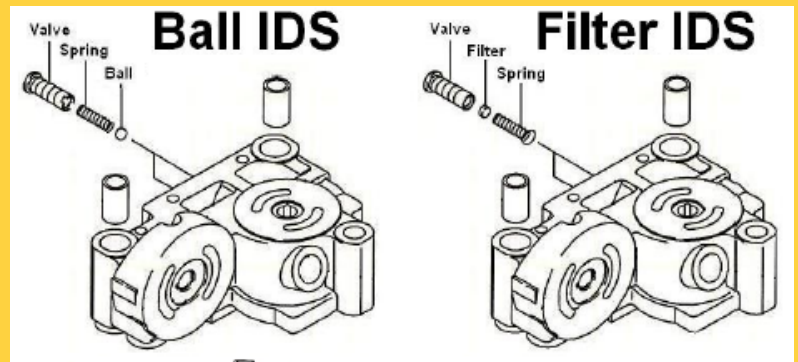
**Note: Please pay attention to the orientation of the Motor Housing (#36) before removal. This is model specific.**



# TORQ TIPS

- Once you are ready to install the parts be sure to coat the mating surfaces with oil. This will help lubricate the contact surfaces.
- Make sure to re-install the bypass pin and washer from the original center case and motor cylinder block. You can use a light amount of automotive grease or Vaseline to keep these two parts in position while putting the parts back in.
- If unit has IDS valves, be sure to note the correct position of the ball or the filter compared to the drawing (Fig.#3). Keep in mind some units may not have the IDS system, but the new center-cases will have Pilot holes (Fig.#5), however the holes will not be machined for IDS. This is simply in the mold of the new center-case, so no worries.

**FIG #3**



**FIG #4**

# TORQ TIPS

- Note orientation of brake actuator and brake shoe during reassembly (Fig.#4).
- New style magnet holder and two magnets (Fig.#6) for proper orientation.
- Bolt torques are: M8 (lower case bolts) are 16 – 18 ft. lb.  
M10 (center case bolts) are 33 – 40 ft. lb.
- Once all parts are installed check to see if everything will rotate freely.
- You must obtain proper oil level and oil type before running the unit. Oil level should be maintained at 20~25 mm (3/4"~1") below the lip of (black cap) port, when oil temperature is at room temperature (20C or 68 F).Tuff Torq Tuff Tech Oil is highly recommended when rebuilding Tuff Torq transaxles. (DO NOT use ATF Automatic Trans Fluid)



**FIG #6**

**FIG #5**

