

Torque Fuses[®]

Light, Medium & Heavy Duty

NOTE: Each fuse is stamped with an I.D. to indicate the point at which they shear. Visit www.sonnax.com for torque fuse I.D. and related shear torque specifications.

Installation for Weld-In Drive-Shaft Units

IMPORTANT: Failure to follow the instructions below could result in premature torque fuse breakage and may cause damage to the PTS unit.

Be sure the wheels are blocked, engine is shut off and brakes are locked on before removing or installing torque fuses.

1. Loosen nuts on each of the torque fuses until they clear the recess in which they sit. Remove the broken torque fuses from the slots.
2. Turn the front of the driveshaft to line up the timing marks on the Power Train Saver flanges. (Figure 1).

WARNING: Do not use hammer to insert fuses.

3. Install the torque fuses one at a time. Tighten the back end nuts only as you are installing them (Figure 2).
4. Tighten the front end nuts evenly in stages (Figure 3) then torque down all fuse nuts to specifications listed here.



Torque Fuse	Fuse I.D.	Torque to
Light Duty Series Weld in Unit	1E through 1Q	80 ft-lb
Medium Duty Series Weld in Unit	0 through 13	140 ft-lb
Heavy Duty Series Weld in Unit	F through Z	220 ft-lb

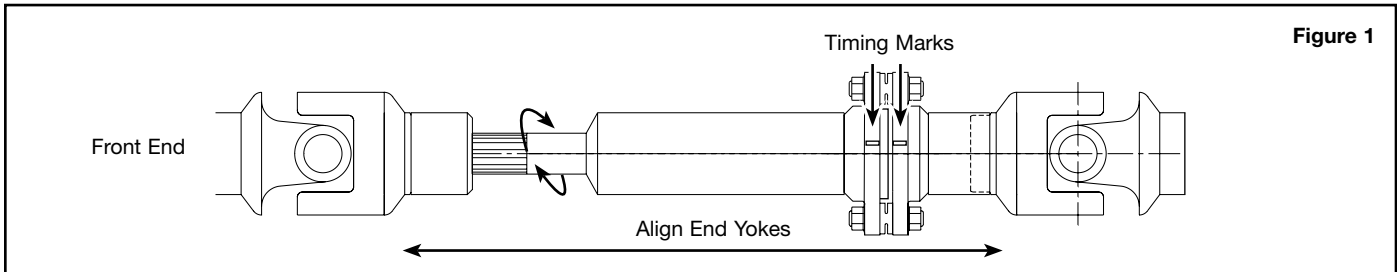


Figure 1

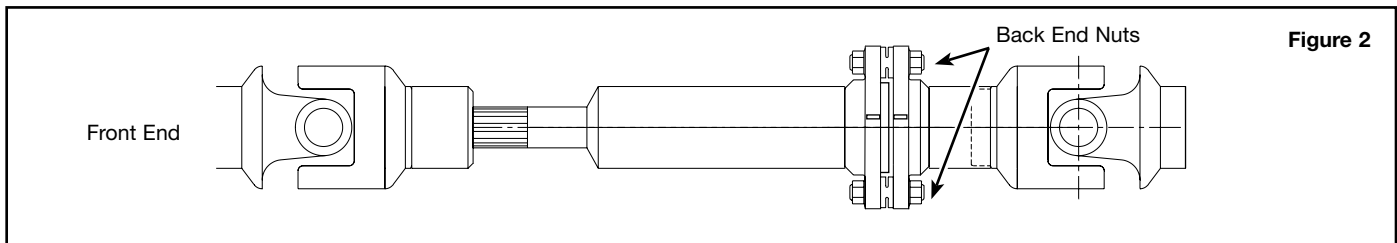


Figure 2

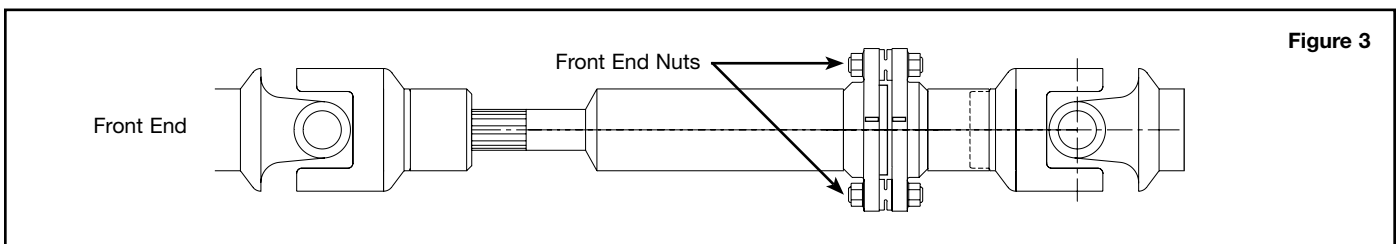


Figure 3

Installation for Industrial & Marine Flange Units

IMPORTANT: Failure to follow the instructions below could result in premature torque fuse breakage and may cause damage to the PTS unit.

Be sure the engine/motor is shut off, if applicable, and brakes are locked on before removing or installing torque fuses.

1. Loosen nuts on each of the torque fuses until they clear the recess in which they sit. Remove the broken torque fuses from the slots.
2. Turn the unit to line up the timing marks on the Power Train Saver flanges. (Figure 4).

WARNING: Do not use hammer to insert fuses.

3. Install the torque fuses one at a time. Tighten the driven end nuts only as you are installing them (Figure 5).
4. Tighten the power end nuts evenly in stages (Figure 6) then torque down all fuse nuts to specifications listed here.

Torque Fuse	Fuse I.D.	Torque to
Medium Duty Series Weld in Unit	0 through 13	140 ft-lb
Heavy Duty Series Weld in Unit	F through Z	220 ft-lb

