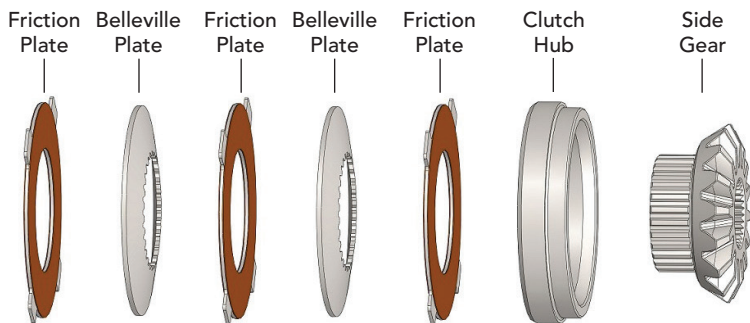


# Yukon Assembly Instructions for Spicer 60 & 70 Powr Lok Discs & Plates



1. To reduce clutch chatter, soak the clutches & discs in Yukon friction modifier overnight (Yukon part # OILADD).
2. Install one Clutch Hub onto a Side Gear.
3. Place one Friction Plate against the Clutch Ring. It does not matter which side of the Friction Plate faces the Clutch Ring.
4. Place one of the Belleville Plates against the Friction Plate with the convex side in. The inner diameter of the Belleville Plate should contact the Friction Plate.
5. Place one Friction Plate against the Belleville Plate. Again, it does not matter which side faces the Belleville Plate.
6. Repeat steps 4 and 5.
7. Repeat steps 2 through 6 for the opposing side gear.
8. Install the side gear & clutch assemblies into the case halves one at a time. Hold each case half upside down and push the side gear & clutch assembly up into place. Attempting to drop the side gear & clutch assembly down into a case half that is face up may result in the clutches falling off the side gear.
9. Place the top carrier case half into position and torque the carrier case bolts to 45 ft./lbs.
10. With the carrier assembly installed into the housing and the differential cover in place, fill the differential with the proper amount of gear oil and a bottle of friction modifier (Yukon part #OILADD).