

## ASSEMBLY

**NOTE:** After assembling, principally reverse disassembly procedure and refer to Fig. 15.

1. When installing the brake plate, first guide the thicker, external spiral brass disc (27, Fig. 15) in brass housing.

2. Install the coiled springs (18) with the convex side alternately facing the brake plate. Commence with convex side of spring facing the brake plate. Use plate J27-D14 of special tool J27-D14 (see Fig. 12) to press springs together.



1 Clutch Ring  
2 External Coiled Springs

Fig. 16 - Housing & Clutch Drum

3. Install snap ring (5) as shown in Fig. 17.

4. Retain the coiled springs, making sure that the outer spring is seated in the slot of the snap ring all around.



1 Clutch Ring  
2 External Coiled Springs

5. Install packing in clutch drum (Fig. 15). Make sure it is not twisted.



1 Piston Ring  
2 Piston  
3 Piston and Piston  
4 Piston Ring

Fig. 19 - Piston and Clutch Drum

6. Install piston ring (5, Fig. 19) on piston (2). Note steel and hole (3) for alignment of piston in clutch drum (5).



1 Clutch Ring  
2 External Coiled Springs

Fig. 20 - Housing & Clutch Drum

7. In order to ease assembly of piston, align steel with hole in piston and make a light scribe mark (1 and 2, Fig. 20) on clutch drum in line with steel and on piston.

8. Compress piston ring (5) by hand and insert piston into drum.



1 Clutch Ring  
2 External Coiled Springs  
3 Piston and Piston  
4 Piston Ring

Fig. 21 - Housing & Clutch Drum

9. Push piston into clutch drum until steel enters hole.

10. Install first coiled spring with convex side against piston, then alternate convex sides up, down, up.

11. Compress coiled springs with special tool J27-D14 and install snap ring (5, Fig. 21).

12. Install external and internal spiral brass disc. Installation should start and end with an external spiral disc.

**NOTE:** Make sure that a thin internal spiral brass disc is installed (see 48, Fig. 15).

13. Install thrust washer (5, Fig. 15) and turn gear with clutch hub (5).



1 Clutch Ring  
2 External Coiled Springs  
3 Piston and Piston  
4 Piston Ring  
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Fig. 22 - Piston Assembly

14. To line gearsliders, align marks (1, Fig. 22) in sun gear between marks (2) on planet pinion.

15. Assemble planetary as shown in Fig. 23.

# John Deere Model 400 Service Manual

**Ian Pickup**



## **John Deere Model 400 Service Manual:**

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