



## Lovejoy D1 to D14 U-Joint Assembly Instructions

Drill or grind off the head of the rivet pin (item 05) and remove. Follow assembly instructions in reverse to disassemble. Reassemble the universal joint per the assembly instructions. A replacement rivet pin will be needed to reassemble the universal joint.

The following is a list of the replacement rivet pins for the D1 to D14 universal joints. These rivet pins can be ordered by the corresponding UPC number. Repair kits consist of block, half pins and main pin.

U-Joint Size	Rivet Pin UPC #	Repair Kit UPC #
D 1	68514449988 (SET OF 25)	
D 2	68514449989 (SET OF 25)	68514450003
D 3	68514449990 (SET OF 25)	68514450004
D 4	68514449991 (SET OF 25)	68514450005
D 5	68514449992 (SET OF 25)	68514450006
D 6	68514449993 (SET OF 25)	68514450007
D 7	68514449994 (SET OF 25)	68514450008
D 8	68514449995 (SET OF 25)	68514450009
D 10	68514449996 (SET OF 10)	68514450010
D 11	68514449997 (SET OF 10)	68514450011
D 12	68514449998 (SET OF 10)	68514450012
D 13	68514449999 (SET OF 10)	68514450013
D 14	68514450000 (SET OF 10)	68514450014

Lubrication is recommended for universal joints; boots and lubricant extend U-joint life.

*Universal joint technical support (630) 852-0500 x1532*

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LOVEJOY, INC.

2655 Wisconsin Avenue, Downers Grove, IL 60515-4299 U.S.A.  
Phone: 630-852-0500 Fax: 630-852-2120 <http://www.lovejoy-inc.com>



Recommended grease specifications for universal joints:

NLGI Grade	2
Color	Not black
Appearance	Smooth
Worked Penetration(ASTM D-217)	265-295
Dropping Point (ASTM D-2265)	335°F (168°C)
Thickener	Optional
Timken Load Carrying Test (ASTM D-2265)	40 lbs. Min.
Temperature Operating Range	-5°F to 266°F (-21°C to 130°C)

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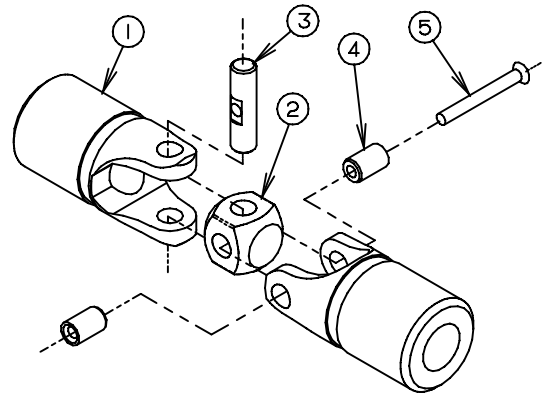
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PARTS LIST		
ITM.	Q	PN
01	2	YOKE
02	1	BLOCK
03	1	MAIN PIN
04	2	HALF PIN
05	1	RIVET PIN


ASSEMBLY INSTRUCTIONS: (D-1 THRU D-14)

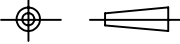
- A. APPLY A FILM OF OIL ON ITEMS 2, 3, & 4
- B. INSERT BLOCK (2) INTO YOKE (1).
- C. INSERT MAIN PIN (3) THRU YOKE AND BLOCK. ALIGN SMALL HOLE IN MAIN PIN WITH HOLE IN BLOCK. HOLD ENDS OF MAIN PIN FIRMLY BETWEEN THUMB AND FORE FINGER TO KEEP HOLES IN LINE.
- D. ASSEMBLE OTHER YOKE (1) OVER BLOCK KEEPING HOLES IN LINE.
- E. INSERT RIVET PIN (5) INTO ONE HALF PIN (4) (FLAT END DOWN) AND INSERT RIVET THRU HOLE IN MAIN PIN. TURN HALF PIN UNTIL FLUSH WITH O.D. OF ASSEMBLY. TURN ASSEMBLY AND INSERT OTHER HALF PIN OVER RIVET TURNING UNTIL FLUSH. PEEN OVER PLAIN END OF RIVET UNTIL FLUSH WITH O.D. OF ASSEMBLY. (A PRESS MAY BE REQUIRED).



THIS DWG REPLACES 3016107

UNLESS OTHERWISE SPECIFIED:

DECIMALS XX ± .015  
XXX ± .005  
CONCENTRICITY T.I.R. .005  
ANGLES ± 1° .125  
MACHINE SURFACE   
DIMENSIONS IN ( ) ARE REFERENCE DIMS.. NO TOLERANCES ARE IMPLIED

 THIRD ANGLE PROJECTION  
BREAK ALL SHARP CORNERS  
REMOVE ALL BURRS  
ALL DIMENSIONS ARE IN INCHES.  
ANSI Y14. 5M  
STANDARDS APPLY

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REV	DESCRIPTION	DATE	CKD

DRAWN	ALB	DATE	07-11-90
CHECKED	HIW	DATE	07-10-90
APPROVED	ALB	DATE	07-23-90
SCALE	NONE	WT.	

TITLE  
D-1 THRU D-14  
UJOINT ASS'Y  
INSTRUCTIONS



DOWNERS GROVE, IL. 60515 / SOUTH HAVEN, MI. 49090

UPC NO. 68514449903

SHEET  
1 OF 1