

ROCKFORD

Drive Line



***Borg-Warner, Saginaw, Spicer
& Toyota Series***

MANUFACTURER OF DRIVELINE COMPONENTS
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How to Use This Section

Determine which type of CV Head Assembly you need by referring to the illustrations and descriptions at the top of each page.

To identify a cv head assembly

1. **End Yoke Style** indicate the cv assembly will bolt up to a constant velocity style end yoke. **Flanged Yoke Style** indicate the cv assembly will bolt up to a companion flange and will incorporate a pilot hole for alignment. **Borg-Warner Style** are used on articulated vehicles (loaders, dozers, loggers & tractors).
2. Within the **Series** of the yoke you can look at the Bolt Dimensions. **(A)** and **(B)** are the bolt pattern and **(C)** is the hole diameter or the thread sizes. Listings that have a flange on one end will also provide the **Bolt Circle** to simplify the sorting.
3. Determine the butt diameter **(G)** by measuring the inside diameter of the tubing & adding .010".
Note: You are adding .010" to the inside diameter of the tube to achieve the press fit required between the tubing and the head assembly.
4. Pilot Diameter **(H)** will be the dimension followed by **(F)** if it is a **female pilot** diameter and **(M)** for **male pilot** diameters.

Center Line to Center Line of the H Yoke, Center Line to Weld & Overall Length are also included for additional identification.

Part series are shown in **Bold Italics** for easy lookup - RDL universal joint numbers are also shown to the far right of each series for quick referencing.

RDL Part Nbr.	Bolt Circle	Bolt Hole Dimensions			D CL to CL H Yoke	E CL to Weld	F Overall Length	G Butt Dia.	H Pilot Dia
		A	B	C					

2.5R Series

Use RDL Kit - K2532

R25-91-23143	3.340	2.360	2.360	.410	3.075	1.515	6.063	2.437	1.809-M
R25-91-13138	3.575	2.696	2.364	.328	2.825	1.515	5.813	2.437	1.809-M
R25-91-23139	3.575	2.696	2.364	.328	3.075	1.515	6.063	2.437	1.809-M

How to Use This Section

CV Head Assembly (Bill Of Materials)

1. Within the **Part Series** the Head Assemblies are sorted by the **Size Of The Tubing** they would work with.
2. If multiple applications are offered that use the same size tube they will then be sorted by the **Weld Yoke** and then the **Centering Assembly**.

H Yokes & Universal Joint part numbers are also shown but will not vary except for the 2.5R series Toyota Components that offer a first and second design assembly.

Part series are shown in **Bold Italics** for easy lookup.

RDL Part Nbr.	Use With Tube Size	Weld Yoke	H Yoke	Centering Assembly	Universal Joint
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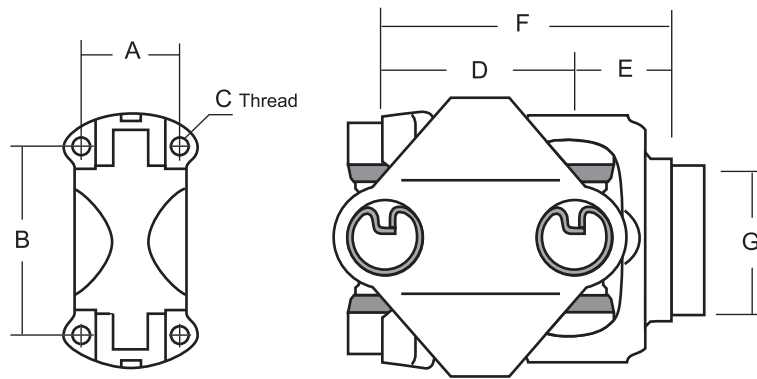
1210 Series

R2-91-12717	2.0 X .065	R2-28-2717	R2-26-457	R2-21-1342	K443
R2-91-12407	2.5 X .065	R2-28-2407	R2-26-457	R2-21-1342	K443
R2-91-22407	2.5 X .065	R2-28-2407	R2-26-457	R2-21-1489	K443

Notice: The data contained in this catalog has been thoroughly checked for accuracy, however we cannot assume any responsibility for errors, omissions or typographical mistakes that may appear.

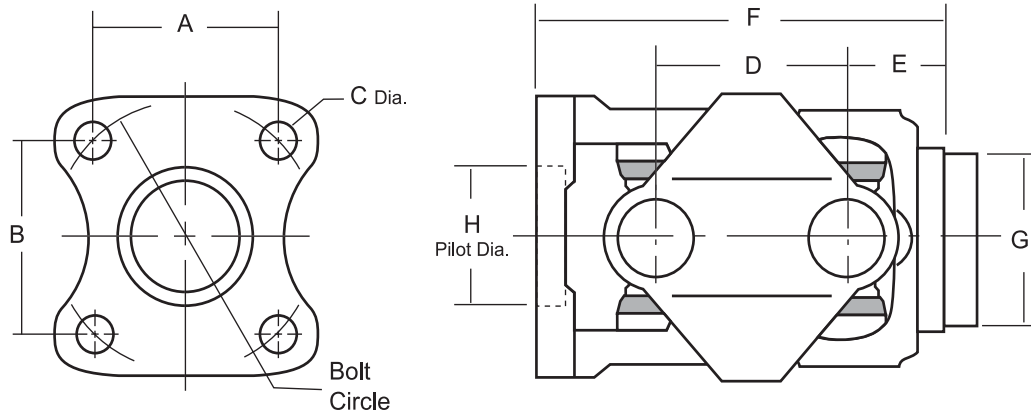


CV HEAD ASSEMBLY (End Yoke Style)



RDL Part Nbr.	Bolt Circle	Bolt Hole Dimensions			D CL to CL H Yoke	E CL to Weld	F Overall Length	G Butt Dia.	H Pilot Dia
		A	B	C					
1210 Series					Use RDL Kit - K443				
R2-91-12717	—	1.500	2.343	.250-28Thd	2.690	1.312	4.000	1.844	—
R2-91-12407	—	1.500	2.343	.250-28Thd	2.690	1.312	4.000	2.380	—
1310 Series					Use RDL Kit - K153				
R2-91-12807	—	1.500	2.343	.312-24Thd	2.690	1.438	4.125	1.016	—
R2-91-12827	—	1.500	2.343	.312-24Thd	2.690	1.438	4.125	1.570	—
R2-91-12867	—	1.500	2.343	.312-24Thd	2.690	1.438	4.125	1.770	—
R2-91-12947	—	1.500	2.343	.312-24Thd	2.690	1.438	4.125	1.770	—
R2-91-12887	—	1.500	2.343	.312-24Thd	2.690	1.438	4.125	2.344	—
R2-91-12957	—	1.500	2.343	.312-24Thd	2.690	1.438	4.125	2.344	—
R2-91-13087	—	1.500	2.343	.312-24Thd	2.690	1.438	4.125	2.380	—
R2-91-12927	—	1.500	2.343	.312-24Thd	2.690	1.438	4.125	2.844	—
R2-91-12907	—	1.500	2.343	.312-24Thd	2.690	1.438	4.125	2.875	—
1330 Series					Use RDL Kit - K213 or K1203				
R2-91-12157	—	1.500	2.875	.312-24Thd	2.750	1.375	4.125	1.770	—
R2-91-12137	—	1.500	2.875	.312-24Thd	2.750	1.375	4.125	2.344	—
R2-91-12187	—	1.500	2.875	.312-24Thd	2.750	1.375	4.125	2.844	—
R2-91-13447	—	1.500	2.875	.312-24Thd	2.750	1.375	4.125	2.844	—
1350 Series					Use RDL Kit - K178				
R3-91-13132	—	1.625	2.750	.312-24Thd	2.875	1.469	4.344	2.344	—
R3-91-11327	—	1.625	2.750	.312-24Thd	2.875	1.469	4.344	2.844	—

CV HEAD ASSEMBLY (Flange Yoke Style)



RDL Part Nbr.	Bolt Circle	Bolt Hole Dimensions			D CL to CL H Yoke	E CL to Weld	F Overall Length	G Butt Dia.	H Pilot Dia
		A	B	C					

1210 Series

Use RDL Kit - K443

R2-91-22407	3.500	2.478	2.478	.484	2.690	1.312	5.625	2.380	2.000-F
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1310 Series

Use RDL Kit - K278

R2-91-82947	3.125	2.210	2.210	.328	2.690	1.438	5.750	1.770	1.770-M
R2-91-62947	3.340	2.360	2.360	.410	2.690	1.438	5.750	1.770	1.809-M
R2-91-22807	3.500	2.478	2.478	.484	2.690	1.438	5.750	1.016	2.000-F
R2-91-22867	3.500	2.478	2.478	.484	2.690	1.438	5.750	1.770	2.000-F
R2-91-22947	3.500	2.478	2.478	.484	2.690	1.438	5.750	1.770	2.000-F
R2-91-22887	3.500	2.478	2.478	.484	2.690	1.438	5.750	2.344	2.000-F
R2-91-22957	3.500	2.478	2.478	.484	2.690	1.438	5.750	2.344	2.000-F
R2-91-23087	3.500	2.478	2.478	.484	2.690	1.438	5.750	2.380	2.000-F
R2-91-42947	3.575	2.364	2.696	.328	2.690	1.438	5.750	1.770	1.809-M
R2-91-92947	3.575	2.364	2.696	.394	2.690	1.438	5.750	1.770	1.809-M
R2-91-52947	3.670	2.426	2.750	.394	2.690	1.438	5.750	1.770	1.809-M
R2-91-72947	3.670	2.596	2.596	.445	2.690	1.438	5.750	1.770	1.809-M
R2-91-02947	3.730	2.642	2.642	.394	2.690	1.438	5.750	1.770	2.559-M
R2-91-32827	4.250	3.000	3.000	.500	2.690	1.438	5.750	1.570	3.125-F
R2-91-32947	4.250	3.000	3.000	.500	2.690	1.438	5.750	1.770	3.125-F
R2-91-32987	4.250	3.000	3.000	.500	2.690	1.438	5.750	2.625	3.125-F

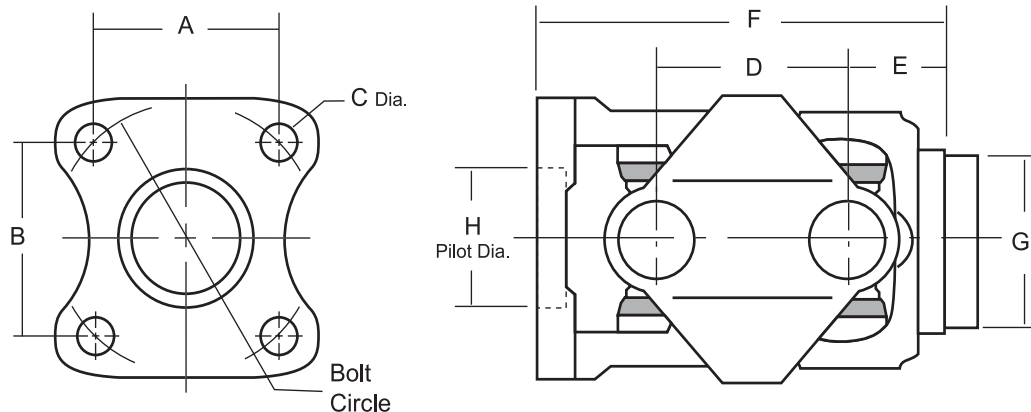
1330 Series

Use RDL Kit - K213

R2-91-42187	4.000	2.656	2.953	.453	2.750	1.375	5.750	2.844	3.125-F
R2-91-23067	4.250	3.000	3.000	M12x1.75	2.750	1.375	5.750	2.344	2.000-F
R2-91-33277	4.250	3.000	3.000	.453	2.750	1.375	5.750	2.312	3.125-F
R2-91-33067	4.250	3.000	3.000	.453	2.750	1.375	5.750	2.344	3.125-F
R2-91-33447	4.250	3.000	3.000	.453	2.750	1.375	5.750	2.844	3.125-F



CV HEAD ASSEMBLY (Flange Yoke Style)



RDL Part Nbr.	Bolt Circle	Bolt Hole Dimensions			D CL to CL H Yoke	E CL to Weld	F Overall Length	G Butt Dia.	H Pilot Dia
		A	B	C					

2.5R Series

Use RDL Kit - K2532

R25-91-23143	3.340	2.360	2.360	.410	3.075	1.515	6.063	2.437	1.809-M
R25-91-13138	3.575	2.696	2.364	.328	2.825	1.515	5.813	2.437	1.809-M
R25-91-23139	3.575	2.696	2.364	.328	3.075	1.515	6.063	2.437	1.809-M
R25-91-13142	3.575	2.696	2.364	.394	2.825	1.515	5.813	2.437	1.809-M
R25-91-23144	3.670	2.596	2.596	.445	3.075	1.515	6.063	2.437	1.809-M
R25-91-13140	3.670	2.750	2.426	.394	2.825	1.515	5.813	2.437	1.809-M
R25-91-23141	3.670	2.750	2.426	.394	3.075	1.515	6.063	2.437	1.809-M

3R Series

Use RDL Kit - K3147

R3R-91-23113	4.250	3.000	3.000	.453	3.250	1.937	6.875	1.770	3.125-M
R3R-91-23111	4.250	3.000	3.000	.453	3.250	1.937	6.875	2.625	3.125-M

1350 Series

Use RDL Kit - K178

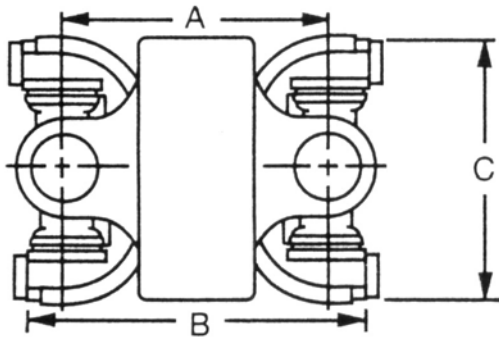
R3-91-23133	4.250	3.000	3.000	M12x1.75	2.875	1.750	6.250	2.594	2.000-F
R3-91-31527	4.250	3.000	3.000	M12x1.75	2.875	1.750	6.250	3.342	2.688-F

1355 Series

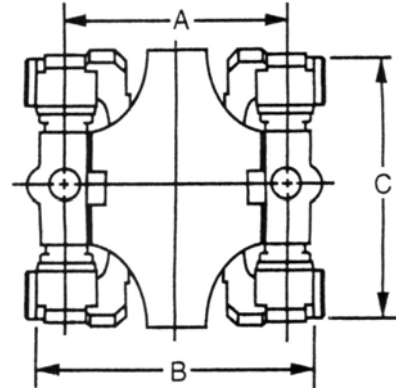
Use RDL Kit - K178

R3-91-27316	4.250	3.000	3.000	M12x1.75	3.488	2.094	7.250	2.594	2.000-F
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CV HEAD ASSEMBLY (Borg-Warner Style)



Round Bearing Design



Wing Bearing Design

RDL Part Nbr.	Bolt Hole Dimensions			Design Notes
	A	B	C	
5R Series	Round Bearing Design			Use RDL Kit - 505-10
531	5.000	6.813	4.781	
6C Series	Wing Bearing Design			Use RDL Kit - 506-10
534	5.000	6.375	5.531	200 Lb. Spring (For Torque Applications)
534A	5.000	6.375	5.531	80 Lb. Spring (For Constant Speed Applications)
7R Series	Round Bearing Design			Use RDL Kit - 507-10
532	6.406	8.406	6.375	



C.V. HEAD ASSEMBLY (Bill Of Materials)

RDL Part Nbr.	Use With Tube Size	Weld Yoke	H Yoke	Centering Assembly	Universal Joint
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1210 Series

R2-91-12717	2.0 X .065	R2-28-2717	R2-26-457	R2-21-1342	K443
R2-91-12407	2.5 X .065	R2-28-2407	R2-26-457	R2-21-1342	K443
R2-91-22407	2.5 X .065	R2-28-2407	R2-26-457	R2-21-1489	K443

1310 Series

R2-91-12807	1.25 X .120	R2-28-2807	R2-26-497	R2-21-1544	K278
R2-91-22807	1.25 X .120	R2-28-2807	R2-26-497	R2-21-1543	K278
R2-91-12827	1.75 X .095	R2-28-2827	R2-26-497	R2-21-1544	K278
R2-91-32827	1.75 X .095	R2-28-2827	R2-26-497	R2-21-1452	K278
R2-91-12947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-1355	K278
R2-91-32947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-1452	K278
R2-91-22947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-1229	K278
R2-91-42947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-3114	K278
R2-91-52947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-3115	K278
R2-91-62947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-3116	K278
R2-91-72947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-3123	K278
R2-91-82947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-3162	K278
R2-91-92947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-3174	K278
R2-91-02947	2.0 X .120	R2-28-2947	R2-26-497	R2-21-3191	K278
R2-91-12867	2.0 X .120	R2-28-2867	R2-26-497	R2-21-1544	K278
R2-91-22867	2.0 X .120	R2-28-2867	R2-26-497	R2-21-1543	K278
R2-91-23087	2.5 X .065	R2-28-3087	R2-26-497	R2-21-1543	K278
R2-91-13087	2.5 X .065	R2-28-3087	R2-26-497	R2-21-1544	K278
R2-91-12957	2.5 X .083	R2-28-2957	R2-26-497	R2-21-1355	K278
R2-91-22957	2.5 X .083	R2-28-2957	R2-26-497	R2-21-1229	K278
R2-91-22887	2.5 X .083	R2-28-2887	R2-26-497	R2-21-1543	K278
R2-91-12887	2.5 X .083	R2-28-2887	R2-26-497	R2-21-1544	K278
R2-91-32987	2.75 X .065	R2-28-2987	R2-26-497	R2-21-1452	K278
R2-91-12907	3.0 X .065	R2-28-2907	R2-26-497	R2-21-1544	K278
R2-91-12927	3.0 X .083	R2-28-2927	R2-26-497	R2-21-1544	K278

1330 Series

R2-91-12157	2.0 X .120	R2-28-2157	R2-26-527	R2-21-1179	K213
R2-91-12137	2.5 X .083	R2-28-2137	R2-26-527	R2-21-1179	K213
R2-91-23067	2.5 X .083	R2-28-3067	R2-26-527	R2-21-1631	K213
R2-91-33067	2.5 X .083	R2-28-3067	R2-26-527	R2-21-1868	K213
R2-91-33277	2.5 X .095	R2-28-3277	R2-26-527	R2-21-1868	K213
R2-91-13447	3.0 X .083	R2-28-3447	R2-26-527	R2-21-1996	K213
R2-91-33447	3.0 X .083	R2-28-3447	R2-26-527	R2-21-1868	K213
R2-91-12187	3.0 X .083	R2-28-2187	R2-26-527	R2-21-1179	K213
R2-91-42187	3.0 X .083	R2-28-2187	R2-26-527	R2-21-1606	K213

C.V. HEAD ASSEMBLY (Bill Of Materials)



RDL Part Nbr.	Use With Tube Size	Weld Yoke	H Yoke	Centering Assembly	Universal Joint
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1350 Series

R3-91-13132	2.5 X .083	R3-28-3132	R3-26-757	R3-21-2019	K178
R3-91-23133	2.75 X .083	R3-28-3133	R3-26-757	R3-21-2024	K178
R3-91-11327	3.0 X .083	R3-28-1327	R3-26-757	R3-21-2019	K178
R3-91-31527	3.5 X .083	R3-28-1527	R3-26-757	R3-21-2025	K178

1355 Series

R3-91-27316	2.75 X .083	R3-28-7316	R3-26-7327	R3-21-7324	K178
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2.5R Series

R25-91-13138	65 X 3mm	R25-21-419	R25-26-486	R25-2-3138	K2532
R25-91-13140	65 X 3mm	R25-21-419	R25-26-486	R25-2-3140	K2532
R25-91-13142	65 X 3mm	R25-21-419	R25-26-486	R25-2-3142	K2532
R25-91-23139	65 X 3mm	R25-21-420	R25-26-491	R25-2-3139	K2532
R25-91-23141	65 X 3mm	R25-21-420	R25-26-491	R25-2-3141	K2532
R25-91-23143	65 X 3mm	R25-21-420	R25-26-491	R25-2-3143	K2532
R25-91-23144	65 X 3mm	R25-21-420	R25-26-491	R25-2-3144	K2532

3R Series

R3R-91-23113	2.0 X .120	R3R-28-3113	R3R-26-057	R3R-21-482	K3147
R3R-91-23111	2.75 X .065	R3R-28-3111	R3R-26-057	R3R-21-482	K3147

5R Series

531		525	505	516	505-10
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6C Series

534		526	506	518	506-10
534A		526	506	518S	506-10

7R Series

532		527	507	517	507-10
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PART NUMBER INTERCHANGE LIST

MFG. NO.	OUR NO.	MFG. NO.	OUR NO.
Neapco		Spicer (cont.)	
4137268	R3R-91-23113	915623	R2-91-12907
N910810	R2-91-12157	915628	R2-91-12807
N910811	R2-91-12137	915629	R2-91-12867
N912442	R2-91-12407	917279	R2-91-12867
N912747	R2-91-12957	918329	R2-91-12827
N912777	R2-91-12947	918523	R2-91-12867
N913797	R2-91-22407	918528	R2-91-23087
R921052	R3-91-23133	918571	R2-91-13447
R921054	R3-91-31527	918585	R2-91-23067
Rockford (Old Numbers)		918623	R2-91-12137
421	R25-91-13138	918729	R2-91-12807
481	R3R-91-23113	919279	R2-91-22887
482	R3R-91-23111	919510	R2-91-13447
411-70	R2-91-12947	919754	R3-91-11327
411-70B	R2-91-22947	919898	R2-91-12827
413-70	R2-91-12957	920151	R2-91-13087
413-70A	R2-91-22807	920517	R2-91-12137
418-70	R2-91-12137	920546	R3-91-11327
421B	R25-91-13140	921054	R3-91-31527
421D	R25-91-13142	922091	R2-91-33277
481T	R2-91-42947		
R25-91-421	R25-91-13138		
R25-91-421B	R25-91-13140		
R25-91-421D	R25-91-13142		
R25-91-421E	R25-91-23143		
R25-91-421F	R25-91-23144		
R2-91-2442	R2-91-12407		
R2-91-3160	R2-91-33067		
R2-91-8523	R2-91-12867		
R2-91-8585	R2-91-23067		
R3-91-3119	R3-91-27316		
Spicer			
902959	R2-91-12867		
904096	R2-91-12957		
907873	R2-91-12927		
910810	R2-91-12157		
910811	R2-91-12137		
912442	R2-91-12407		
913797	R2-91-22407		
914982	R2-91-12717		
915444	R2-91-12947		
915621	R2-91-12887		
915622	R2-91-12887		

PART NUMBER INDEX



PART NUMBER	PG	PART NUMBER	PG
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534A	7, 9	R3-91-13132	4, 9
R2-91-02947	5, 8	R3-91-23133	6, 9
R2-91-12137	4, 8	R3-91-27316	6, 9
R2-91-12157	4, 8	R3-91-31527	6, 9
R2-91-12187	4, 8	R3R-91-23111	6, 9
R2-91-12407	4, 8	R3R-91-23113	6, 9
R2-91-12717	4, 8		
R2-91-12807	4, 8		
R2-91-12827	4, 8		
R2-91-12867	4, 8		
R2-91-12887	4, 8		
R2-91-12907	4, 8		
R2-91-12927	4, 8		
R2-91-12947	4, 8		
R2-91-12957	4, 8		
R2-91-13087	4, 8		
R2-91-13447	4, 8		
R2-91-22407	5, 8		
R2-91-22807	5, 8		
R2-91-22867	5, 8		
R2-91-22887	5, 8		
R2-91-22947	5, 8		
R2-91-22957	5, 8		
R2-91-23067	5, 8		
R2-91-23087	5, 8		
R2-91-32827	5, 8		
R2-91-32947	5, 8		
R2-91-32987	5, 8		
R2-91-33067	5, 8		
R2-91-33277	5, 8		
R2-91-33447	5, 8		
R2-91-42187	5, 8		
R2-91-42947	5, 8		
R2-91-52947	5, 8		
R2-91-62947	5, 8		
R2-91-72947	5, 8		
R2-91-82947	5, 8		
R2-91-92947	5, 8		
R25-91-13138	6, 9		
R25-91-13140	6, 9		
R25-91-13142	6, 9		
R25-91-23139	6, 9		
R25-91-23141	6, 9		

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