



US006907667B2

(12) **United States Patent**
Joyner et al.

(10) **Patent No.:** **US 6,907,667 B2**
(45) **Date of Patent:** **Jun. 21, 2005**

(54) **METHOD FOR FACILITATING THE ASSEMBLY OF A UNIVERSAL JOINT**

(75) Inventors: **Robert G. Joyner**, Toledo, OH (US);
James L. Oess, Toledo, OH (US)

(73) Assignee: **Torque-Traction Technologies, Inc.**,
Holland, OH (US)

(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 138 days.

(21) Appl. No.: **10/270,088**

(22) Filed: **Oct. 14, 2002**

(65) **Prior Publication Data**

US 2003/0110634 A1 Jun. 19, 2003

Related U.S. Application Data

(60) Provisional application No. 60/328,745, filed on Oct. 12, 2001.

(51) **Int. Cl.**⁷ **B21D 53/10**

(52) **U.S. Cl.** **29/898.07**; 29/898.08;
29/281.1; 29/467

(58) **Field of Search** 29/898.08, 898.07,
29/898.09, 464, 467, 559, 271, 281.1, 281.5,
251

(56) **References Cited**

U.S. PATENT DOCUMENTS

3,039,183 A	6/1962	Laster	
3,230,617 A	1/1966	Spiess et al.	
3,237,291 A *	3/1966	Kelso	29/257
3,290,754 A	12/1966	Pitner	
3,517,433 A *	6/1970	Pitner	29/434
3,529,942 A	9/1970	Pitner	
3,722,066 A	3/1973	Spiess	
3,786,544 A	1/1974	Ferguson	

4,162,568 A *	7/1979	Spiess	29/281.3
4,558,502 A *	12/1985	Gossmann et al.	29/434
4,704,782 A *	11/1987	Spiess et al.	29/434
4,977,660 A *	12/1990	Maynard	29/251
5,715,600 A *	2/1998	Marriott et al.	29/898.07
5,836,078 A *	11/1998	Aiken et al.	29/898.07
5,857,252 A *	1/1999	Jansen	29/257
6,035,533 A	3/2000	Warnke et al.	
6,855,060 B2 *	2/2005	Breese et al.	464/130

FOREIGN PATENT DOCUMENTS

JP 110264422 9/1999

* cited by examiner

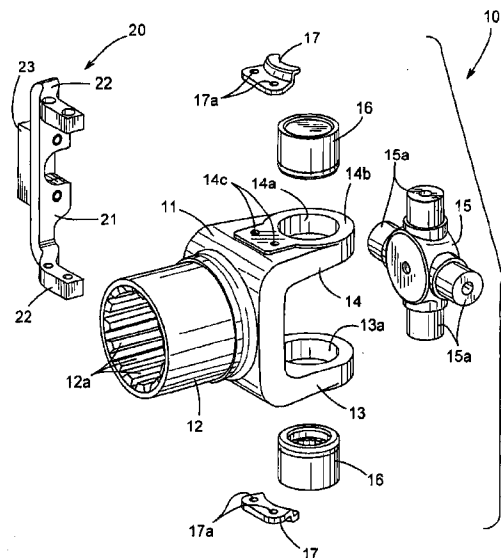
Primary Examiner—Essama Omgba

(74) *Attorney, Agent, or Firm*—MacMillan, Sobanski & Todd, LLC

(57) **ABSTRACT**

A method of assembling components of a universal joint, such as a cross and a yoke, positions and maintains the rotational center axes thereof in co-axial alignment during the assembly process. The universal joint includes a yoke including a body portion and first and second arms, wherein the first and second arms have respective openings formed therethrough. The universal joint also includes a cross including a body portion having a plurality of trunnions extending outwardly therefrom. Initially, an assembly tool having a recess formed therein is supported on the yoke such that the recess is precisely positioned relative to the rotational center axis of the yoke. Then, the cross is supported on the assembly tool such that one of the trunnions is received within and supported by the recess formed in the assembly tool. As a result, the rotational center axis of the cross is co-axially aligned with the rotational center axis of the yoke. Lastly, bearing cups are installed within the openings and respectively about the trunnions of the cross to complete the assembly.

21 Claims, 7 Drawing Sheets



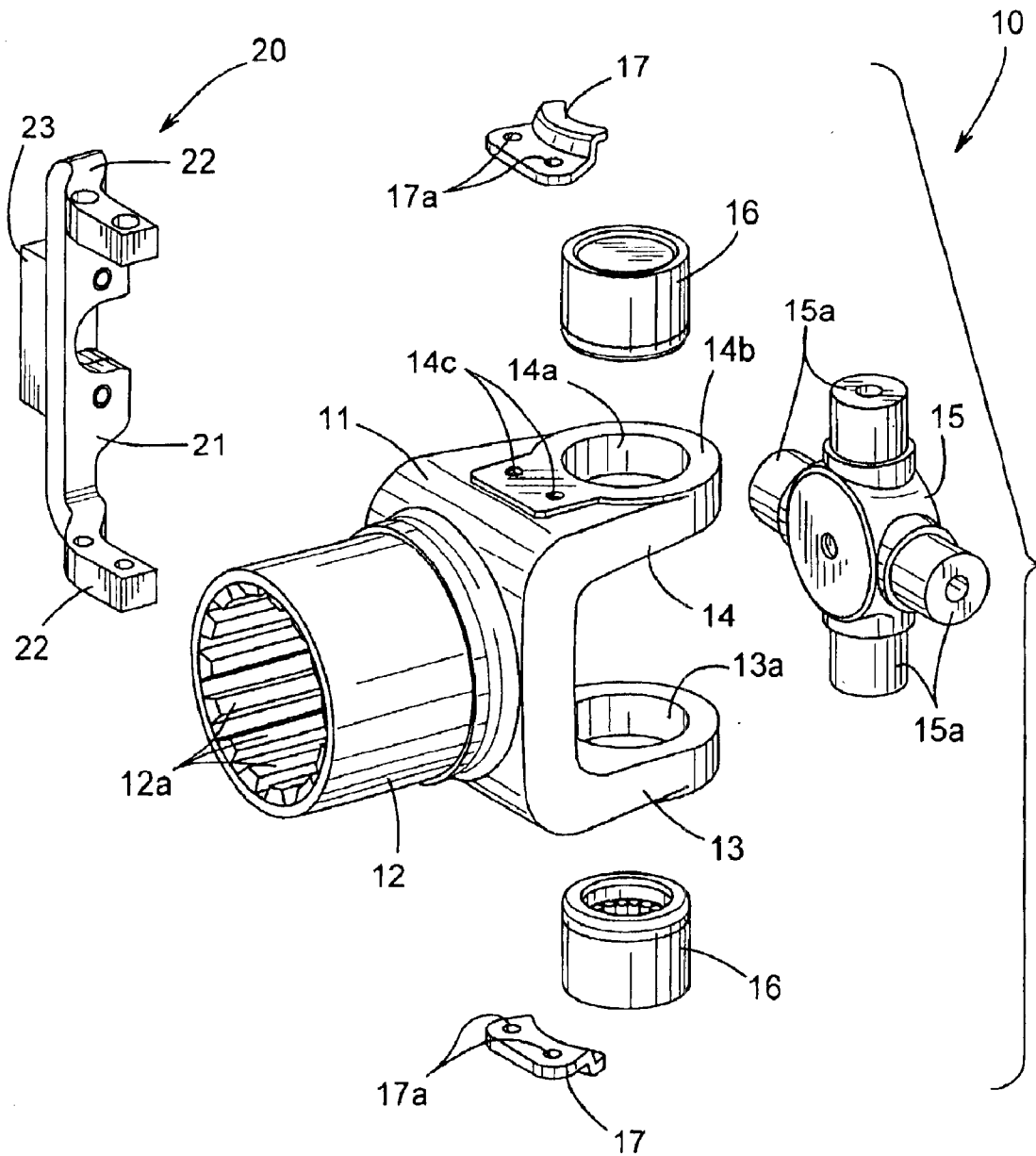


FIG. 1

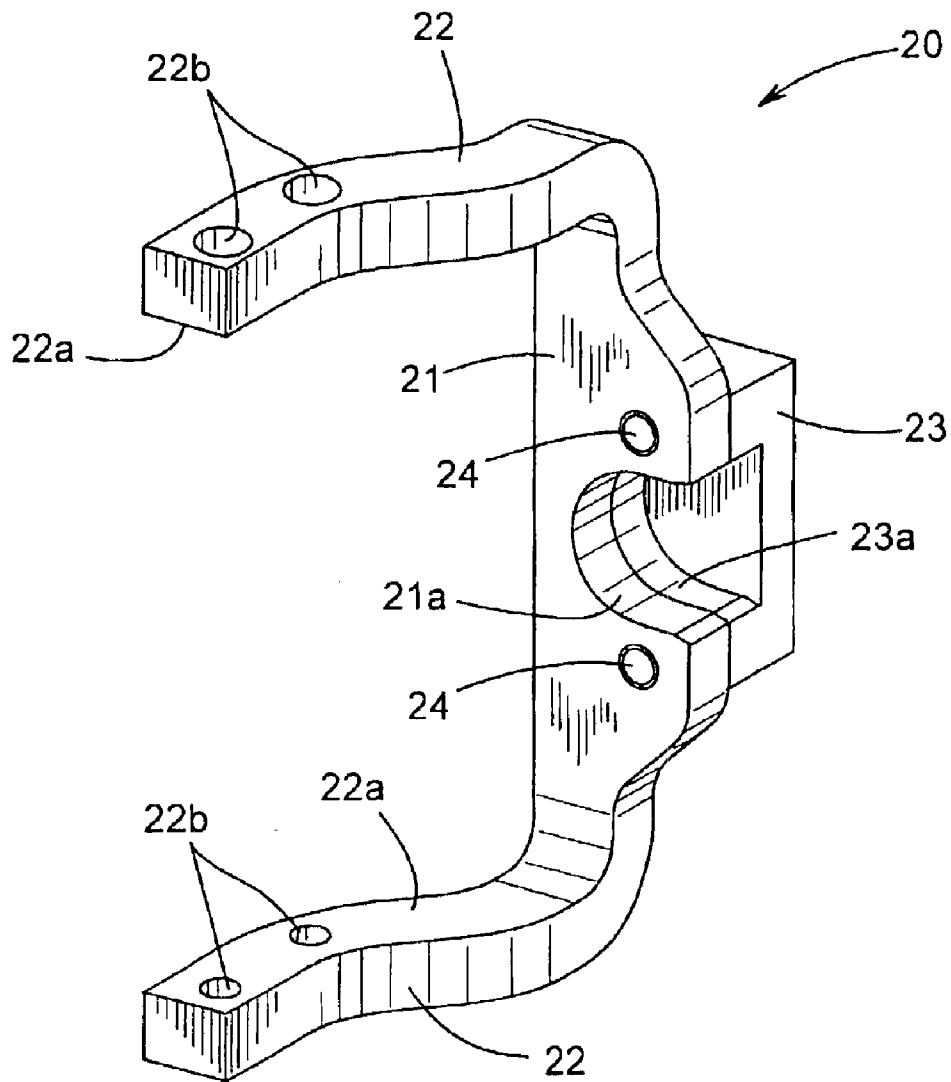


FIG. 2

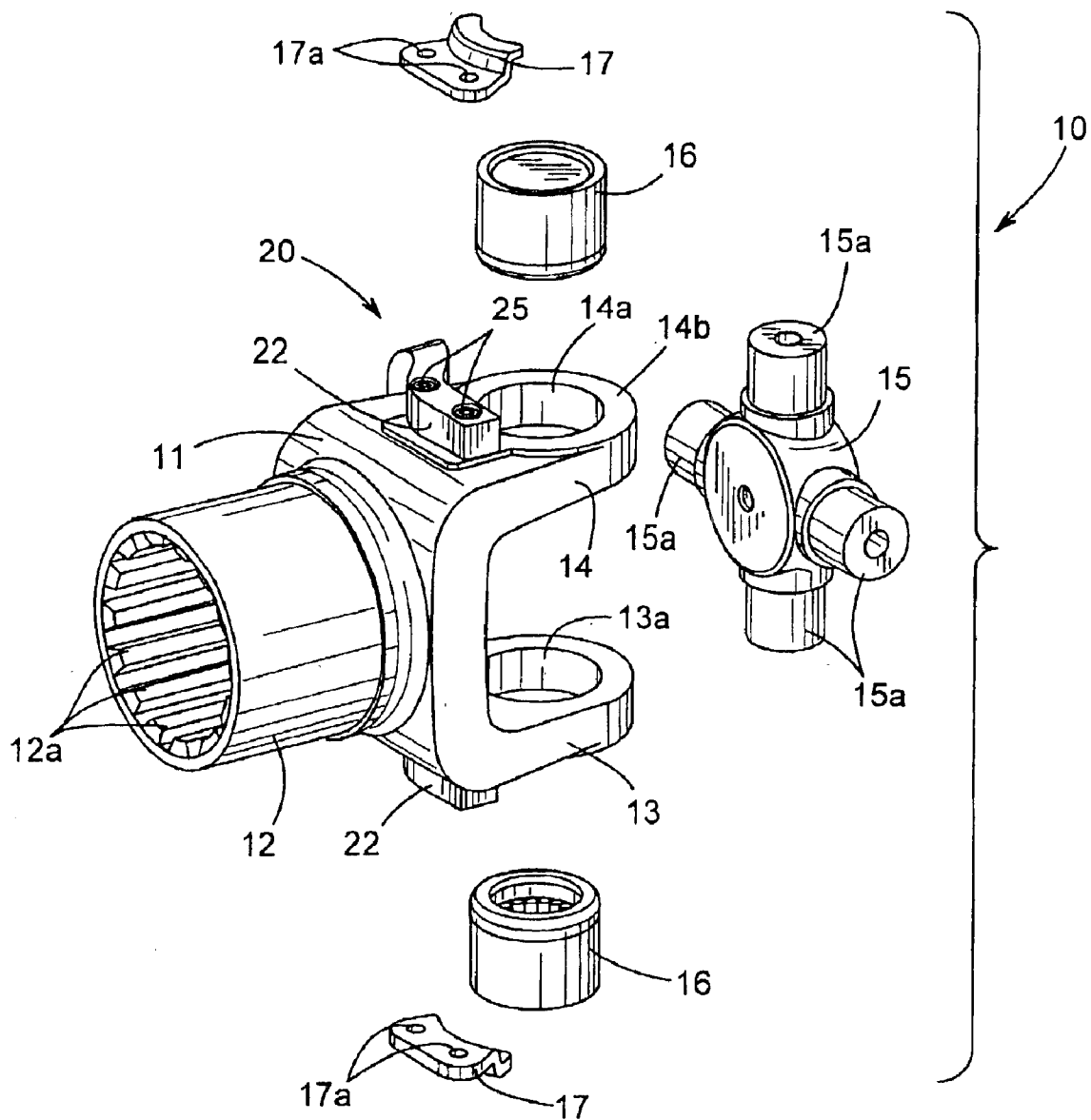


FIG. 3

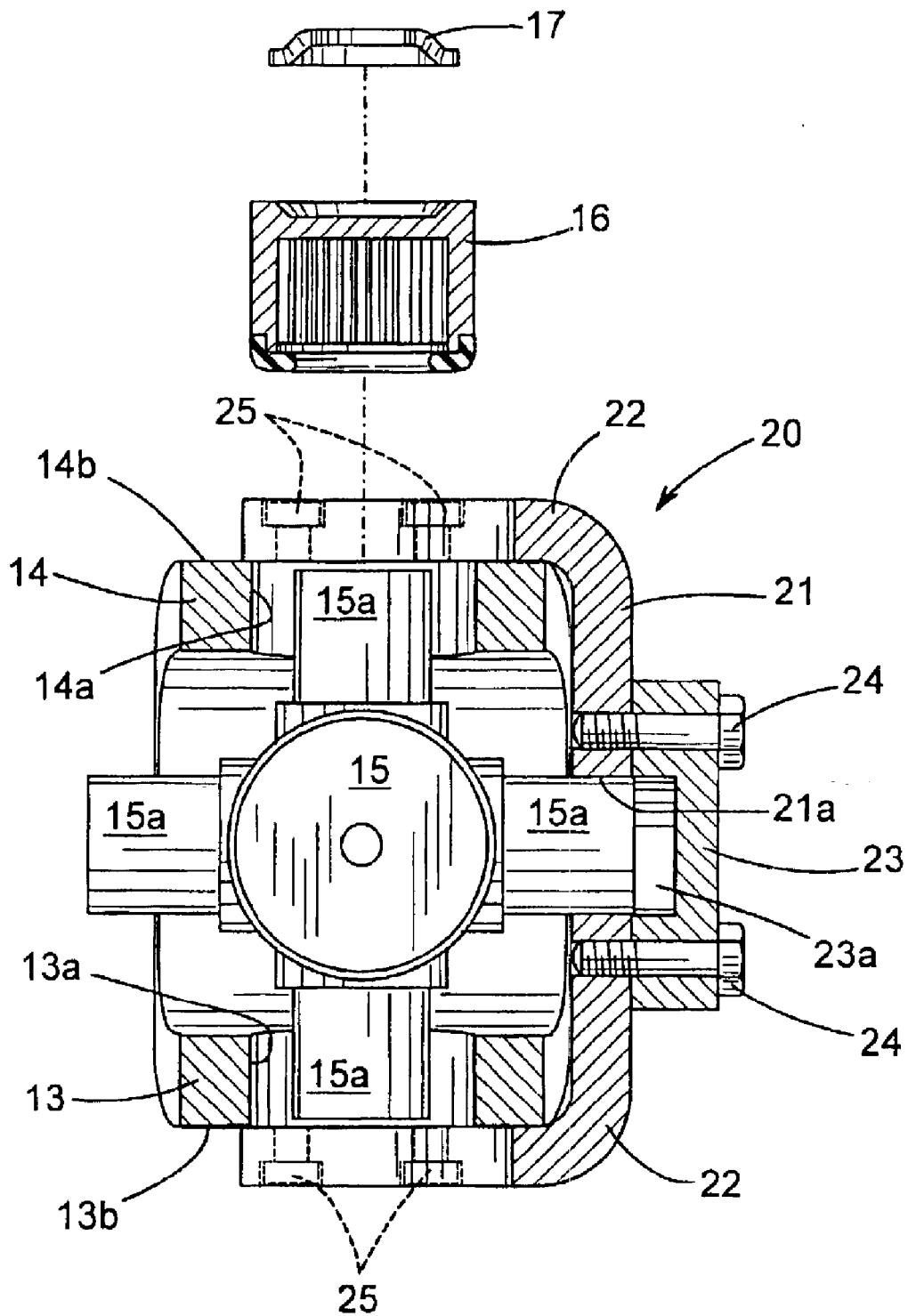


FIG. 5

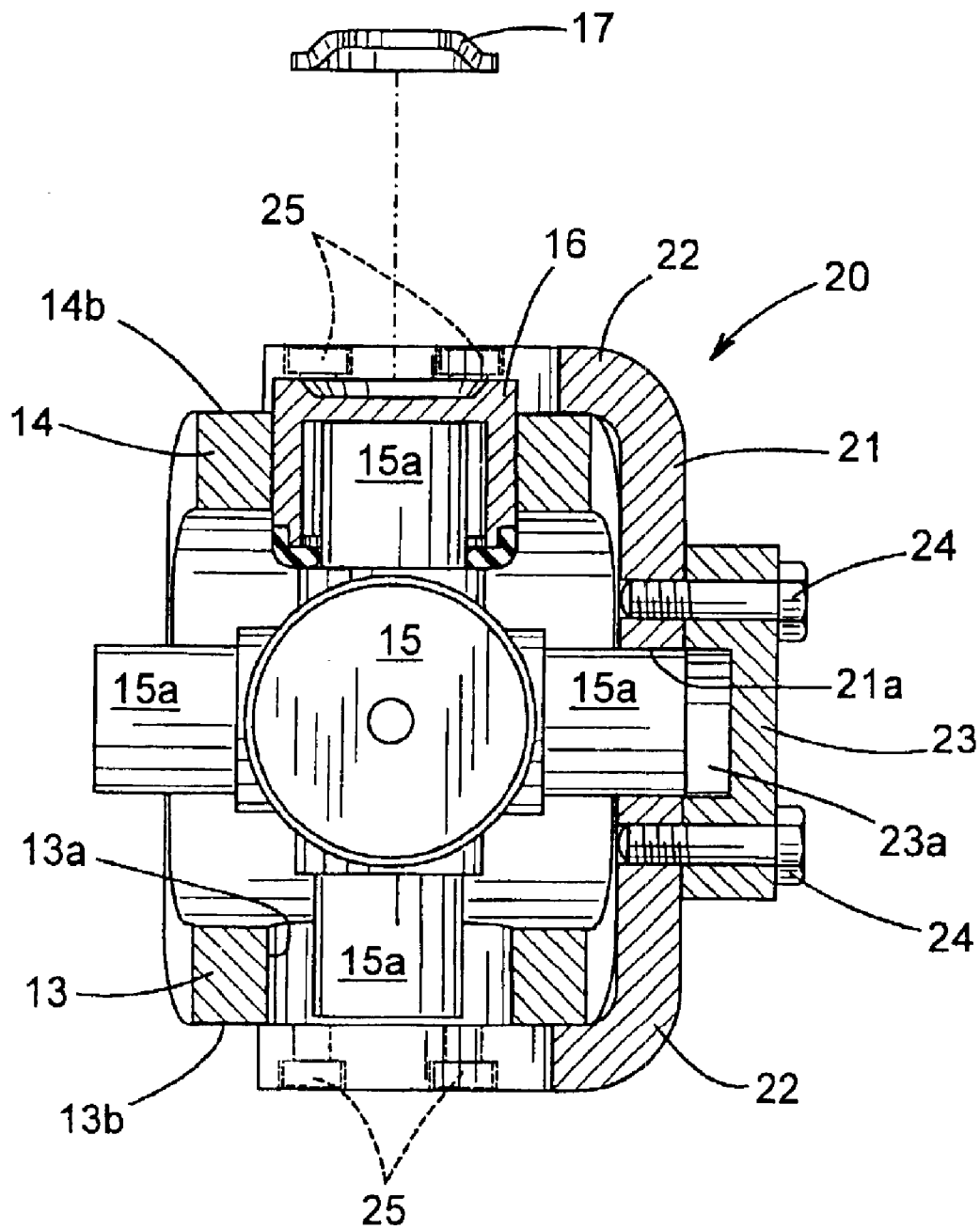


FIG. 6

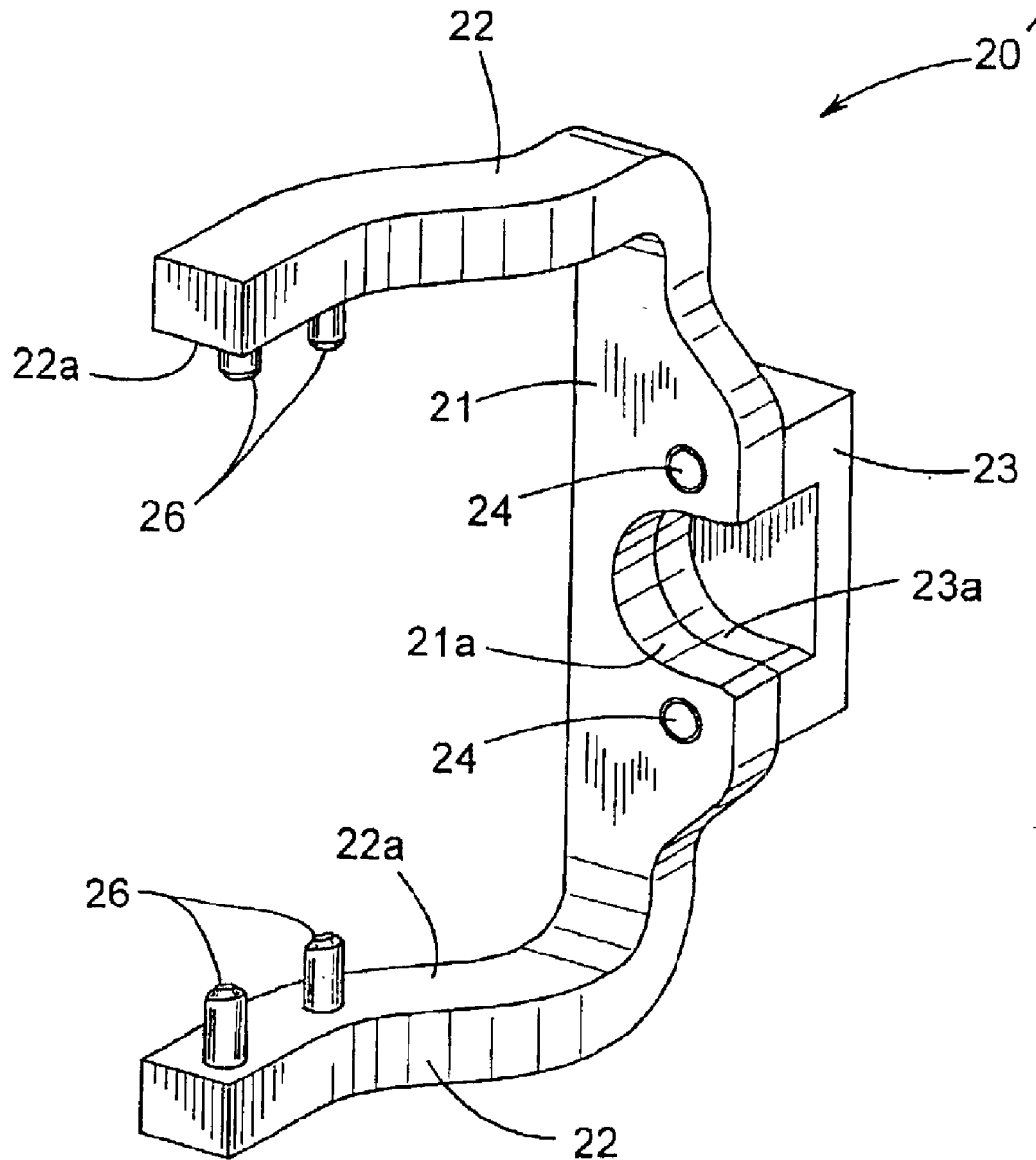


FIG. 7

1

METHOD FOR FACILITATING THE ASSEMBLY OF A UNIVERSAL JOINT

CROSS REFERENCE TO RELATED APPLICATION

This application claims the benefit of U.S. Provisional Application No. 60/328,745, filed Oct. 12, 2001.

BACKGROUND OF THE INVENTION

This invention relates in general to universal joints for providing a driving connection between two members that are adapted to rotate about non-aligned axes of rotation. In particular, this invention relates to a method and an apparatus for facilitating the assembly of the components that make up such a universal joint.

Universal joints are well known devices that provide a driving connection between two members that are adapted to rotate about non-aligned axes of rotation. A typical universal joint includes a cross having a central body portion with four cylindrical trunnions extending outwardly therefrom. The trunnions are oriented in a single plane and extend at right angles relative to one another. A hollow cylindrical bearing cup is mounted on the end of each of the trunnions. Needle bearings or similar means are provided between the outer cylindrical surfaces of the trunnions and the inner cylindrical surfaces of the bearing cups to permit relative rotational movement therebetween. The bearing cups mounted on a first opposed pair of the trunnions are connected to a first yoke secured to an end of a first member, while the bearing cups mounted on a second opposed pair of the trunnions are connected to a second yoke secured to an end of a second member.

A full round end yoke is one type of yoke that is commonly used in a universal joint. A typical full round end yoke includes a body portion having a pair of opposed yoke arms extending therefrom. Each of the opposed yoke arms has a cylindrical opening formed in the end thereof. The two openings are co-axially aligned with one another, each extending between an outer surface and an inner surface of the associated yoke arm. To assemble the universal joint, two of the opposed trunnions of the universal joint cross (having no bearing cups mounted thereon) are initially inserted within the two openings formed through the yoke arms. Then, the bearing cups are moved axially inwardly through the openings from the outer surfaces of the yoke arms toward the inner surfaces thereof. In this manner, the bearing cups are installed over the ends of the opposed trunnions within the openings formed through the yoke arms. A pair of retainer clips or other retaining structures may then be secured to the full round end yoke to retain the bearing cups within the two openings formed through the yoke arms and on the associated trunnions.

During the assembly of the various components that make up the universal joint, it is important that the rotational center axis of the cross be precisely co-axially aligned with the rotational center axis of the yoke. If this co-axial alignment is not maintained, then undesirable rotational imbalances may be created within the universal joint. Such rotational imbalances can, if not corrected, result in the generation of undesirable noise and vibration when the universal joint is rotated during use. The correction of such imbalances usually involves the securement of one or more balance weights to the yoke, some other portion of the universal joint, or the driveshaft itself, which can result in undesirable additional time and expense during the assembly process. Thus, it would be desirable to provide an apparatus

2

and method for facilitating the assembly of the components of a universal joint in such a manner that positions and maintains the rotational center axis of the cross co-axially aligned with the rotational center axis of the yoke during the assembly process.

SUMMARY OF THE INVENTION

This invention relates to a method and an apparatus for assembling components of a universal joint, such as a cross and a yoke, such that the rotational center axes thereof are co-axially aligned during the assembly process. The universal joint includes a yoke including a body portion and first and second arms, wherein the first and second arms have respective openings formed therethrough. The universal joint also includes a cross including a body portion having a plurality of trunnions extending outwardly therefrom. Initially, an assembly tool having a recess formed therein is supported on the yoke such that the recess is precisely positioned relative to the rotational center axis of the yoke. Then, the cross is supported on the assembly tool such that one of the trunnions is received within and supported by the recess formed in the assembly tool. As a result, the rotational center axis of the cross is co-axially aligned with the rotational center axis of the yoke. Lastly, bearing cups are installed within the openings and respectively about the trunnions of the cross to complete the assembly.

Various objects and advantages of this invention will become apparent to those skilled in the art from the following detailed description of the preferred embodiments, when read in light of the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is an exploded perspective view of a plurality of components of a portion of a conventional universal joint and a first embodiment of a tool in accordance with this invention for facilitating the assembly of such components.

FIG. 2 is an enlarged perspective view of the first embodiment of the assembly tool illustrated in FIG. 1.

FIG. 3 is an exploded perspective view similar to FIG. 1 showing the first embodiment of the assembly tool installed upon the yoke.

FIG. 4 is an exploded perspective view similar to FIG. 3 showing the cross installed upon the first embodiment of the assembly tool within the yoke.

FIG. 5 is an end elevational view, partially in cross section, of the components of the universal joint and the first embodiment of the assembly tool illustrated in FIG. 4.

FIG. 6 is an end elevational view similar to FIG. 5 showing the bearing cup installed upon the cross.

FIG. 7 is an enlarged perspective view of a second embodiment of the assembly tool illustrated in FIGS. 1 through 6.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Referring now to the drawings, there is illustrated in FIG. 1 a plurality of components, indicated generally at 10, that can be assembled to form a portion of a conventional universal joint. The components 10 of the illustrated portion of the universal joint include a yoke 11 including a sleeve portion 12 having a pair of opposed arms 13 and 14 extending therefrom. The sleeve portion 12 is generally hollow and cylindrical in shape and has a plurality of spines 12a formed on an inner surface thereof to facilitate a rotational driving engagement with a driveshaft (not shown)

3

or other member. The arms **13** and **14** of the yoke **11** have respective openings **13a** and **14a** formed therethrough that are co-axially aligned with one another. The arms **13** and **14** of the yoke **11** also have respective outer surfaces **13b** and **14b** formed about each of the openings **13a** and **14a**. As is well known, the outer surfaces **13b** and **14b** are formed (typically by machining) on the arms **13** and **14** of the yoke **11** in such a manner as to provide surfaces that are precisely positioned relative to the rotational center axis of the yoke **11**. Thus, the machined outer surfaces **13b** and **14b** are precisely spaced apart from one another by a predetermined distance on either side of the rotational center axis of the yoke **11**. A pair of threaded bores, such as shown at **14c** in FIG. **1**, are formed through each of the machined outer surfaces **13b** and **14b** into each of the arms **13** and **14**. The purposes for the aligned openings **13a** and **14a**, the machined outer surfaces **13b** and **14b**, and the threaded bores **14c** will be explained below.

The components **10** of the illustrated portion of the universal joint also include a cross **15** that includes a central body portion and having four generally cylindrical trunnions **15a** extending outwardly therefrom. As is well known, the trunnions **15a** extend radially outwardly from the body portion in a common plane and at right angles relative to one another. Two of the trunnions **15a** are adapted to be received within the openings **13a** and **14a** of the arms **13** and **14** of the yoke **11** in the manner described below. The components **10** of the illustrated portion of the universal joint further include a pair of bearing cups **16** that are each generally hollow and cylindrical in shape, having one closed end and one opened end. The bearing cups **16** are adapted to be within the openings **13a** and **14a** formed through the arms **13** and **14** of the yoke **11** and about the trunnions **15a** extending therein in the manner described below. Lastly, the components **10** of the illustrated portion of the universal joint include a pair of retainer clips **17** having respective apertures **17a** formed therethrough. The retainer clips **17** are adapted to retain the bearing cups **16** within the openings **13a** and **14a** formed through the arms **13** and **14** of the yoke **11** in the manner described below. The various components **10** of the illustrated portion of the universal joint thus far described are all conventional and are intended to be representative of any of a variety of such components that can be assembled to form a universal joint that can be used to provide a driving connection between two members that are adapted to rotate about non-aligned axes of rotation.

A first embodiment of a tool, indicated generally at **20**, is provided to facilitate the assembly of the components **10** of the illustrated portion of the universal joint. As best shown in FIG. **2**, the first embodiment of the assembly tool **20** is generally U-shaped, including a central body portion **21** having a pair of end portions **22** extending laterally therefrom. The central body portion **21** has a recess **21a** formed therein. In the illustrated embodiment, the recess **21a** is generally semi-cylindrical in shape. However, the recess **21a** may have any desired shape (including a circular counterbore, for example) and may be embodied as any surface on the first embodiment of the assembly tool **20** that is capable of engaging or supporting the cross **15** thereon in a predetermined position relative to the yoke **11**. The purpose for this recess **21a** will be explained below. Preferably, the central body portion **21** has a length that is approximately the same as the precise predetermined distance between the machined outer surfaces **13b** and **14b** formed on the arms **13** and **14** of the yoke **11**, as discussed above. Thus, the end portions **22** of the first embodiment of the assembly tool **20** have respective inner surfaces **22a** that are also

4

spaced apart from one another by approximately the same precise predetermined distance. A pair of apertures **22b** are formed through each of the end portions **22** of the first embodiment of the assembly tool **20**. As will be explained in greater detail below, the apertures **22b** are positioned to be aligned with the threaded bores **14c** formed in the machined outer surfaces **13b** and **14b** and into the arms **13** and **14** of the yoke **11**.

If desired, an extension member **23** can be provided on the central body portion **21** of the first embodiment of the assembly tool **20**. In the illustrated embodiment, the extension member **23** is formed from a separate piece of material that is secured to the central body portion **21** of the first embodiment of the assembly tool **20** by a pair of threaded fasteners **24**. However, the extension member **23** can be secured to the central body portion **21** by any conventional means, and can, if desired, be formed integrally from a single piece of material with the central body portion **21**. The extension member **23** has a recess **23a** formed therein. In the illustrated embodiment, the recess **23a** is generally semi-cylindrical in shape and is co-axially aligned with the recess **21a** formed in the central body member **21**, although such is not required. The extension member **23** is provided to increase the overall strength of the first embodiment of the assembly tool **20**, as will be explained below.

The assembly of the components **10** of the illustrated portion of the universal joint using the first embodiment of the assembly tool **20** of this invention will now be described. Initially, the first embodiment of the assembly tool **20** is mounted or otherwise supported on or relative to the yoke **11**, such as shown in FIG. **3**. To accomplish this, the first embodiment of the assembly tool **20** can be moved toward the yoke **11** such that the inner surfaces **22a** of the end portions **22** about the machined outer surfaces **13b** and **14b** of the arms **13** and **14** of the yoke **11**. However, the first embodiment of the assembly tool **20** can be adapted to engage, directly or indirectly, and be supported on or relative to any other portion of the yoke **11**. Preferably, the apertures **22b** formed through the end portions **22** of the first embodiment of the assembly tool **20** are aligned with the threaded bores **14c** formed in the arms **13** and **14** of the yoke **11**. If desired, the first embodiment of the assembly tool **20** can be positively secured to the yoke **11** by a pair of threaded fasteners **25** (see FIG. **3**) that extend through the apertures **22b** formed through the end portions **22** of the first embodiment of the assembly tool **20** into engagement with the threaded bores **14c** formed in the arms **13** and **14** of the yoke **11**.

As discussed above, the semi-cylindrical recesses **21a** and **23a** are formed in the central body portion **21** and the extension member **23** of the first embodiment of the assembly tool **20**. The recesses **21a** and **23a** are preferably located precisely at the midpoint between the inner surfaces **22a** of the end portions **22** of the first embodiment of the assembly tool **20**. Because the inner surfaces **22a** of the first embodiment of the assembly tool **20** about the machined outer surfaces **13b** and **14b** of the arms **13** and **14** of the yoke **11**, and further because the machined outer surfaces **13b** and **14b** of the arms **13** and **14** of the yoke **11** are precisely positioned relative to the rotational center axis of the yoke **11**, the semi-cylindrical recesses **21a** and **23a** formed in the central body portion **21** and the extension member **23** of the first embodiment of the assembly tool **20** are precisely positioned relative to the rotational center axis of the yoke **11** when the first embodiment of the assembly tool **20** is mounted on the yoke **11**.

Next, the cross **15** is moved within the yoke **11** such that two of the opposed trunnions **15a** on the cross **15** are

5

received within the aligned openings **13a** and **14a** formed through the arms **13** and **14** of the yoke, as shown in FIGS. **4** and **5**. At the same time, one of the other trunnions **15a** of the cross **15** is received within the recesses **21a** and **23a** formed in the central body portion **21** and the extension member **23** of the first embodiment of the assembly tool **20**. The recess **21a** is preferably sized to snugly receive the trunnion **15a** therein with little play. The recess **23a** can be sized in a similar manner or can be somewhat larger in size to facilitate the insertion of the trunnion **15a** within the recess **21a**. Regardless, the disposition of the trunnion **15a** within the recesses **21a** and **23a** causes the rotational center axis of the cross **15** to be precisely positioned relative to the rotational center axis of the yoke **11**. Such precise positioning is important to prevent or minimize the occurrence of undesirable noise and vibration when the universal joint is operated, as discussed above.

Then, one or both of the bearing cups **16** can be installed through the openings **13a** and **14a** formed through the arms **13** and **14** of the yoke **11** and onto the opposed trunnions **15a**, such as shown in FIG. **6**. Such bearing cups **16** can be installed using any conventional mechanical press, hydraulic press, or similar device. As the bearing cups **16** are being installed, the first embodiment of the assembly tool **20** functions to support the cross **15** during the installment of the bearing cup **16** and to maintain the rotational center axis of the cross **15** precisely positioned relative to the rotational center axis of the yoke **11**. Once one or both the bearing cups **16** are installed as shown in FIG. **6**, the frictional engagement of the bearing cups **16** with the arms **13** and **14** of the yoke **11** will maintain the rotational center axis of the cross **15** precisely positioned relative to the rotational center axis of the yoke **11**. Thus, the first embodiment of the assembly tool **20** can be removed. Lastly, the retainer clips **17** can be secured in a conventional manner to the machined outer surfaces **13b** and **14b** using the same threaded fasteners **25** used to secure the first embodiment of the assembly tool **20** to the yoke **11**.

FIG. **7** illustrates a second embodiment of a tool, indicated generally at **20'**, for facilitating the assembly of the components **10** of the illustrated portion of the universal joint. The second embodiment of the assembly tool **20'** is similar to the first embodiment of the assembly tool **20** described above, and like reference numbers are used to designate similar structures. The end portions **22** of the second embodiment of the assembly tool **20'** do not have the apertures **22b** formed therethrough, as discussed above. Rather, each of the end portions **22** of the second embodiment of the assembly tool **20'** has a pair of spring loaded pins **26** provided thereon. The spring loaded pins **26** are, of themselves, conventional in the art and are movable between the extended positions illustrated in FIG. **7**, wherein the pins **26** are extended inwardly from the respective end portions **22** toward one another, and retracted positions, wherein the pins **26** are retracted within such respective end portions **22**.

The second embodiment of the assembly tool **20'** is mounted or otherwise supported on or relative to the yoke **11** by moving it toward the yoke **11** such that the inner surfaces **22a** of the end portions **22** abut the machined outer surfaces **13b** and **14b** of the arms **13** and **14** of the yoke **11**, as described above. To accomplish this, the spring loaded pins **26** must be moved from their extended positions illustrated in FIG. **7** outwardly apart from one another to their retracted positions within the arms **22**. This can be effected in any desired manner, such as by manually pushing the spring loaded pins **26**, using a separate retraction tool to move the spring loaded pins, and the like. Alternatively, the ends of

6

the spring loaded pins **26** may be chamfered as shown in FIG. **7** such that lateral engagement thereof by the arms **13** and **14** of the yoke **11** cause such pins **26** to be moved to their retracted positions. In any event, the second embodiment of the assembly tool **20'** is then positioned relative to the yoke such that the spring loaded pins **26** carried on the arms **22** are aligned with the threaded bores **14c** formed in the arms **13** and **14** of the yoke **11**. When this occurs, the spring loaded pins **26** moved inwardly within such threaded bores **14c** to positively position the second embodiment of the assembly tool **20'** relative to the yoke **11**. The second embodiment of the assembly tool **20'** can be used in substantially the same manner as described above to facilitate the installation of the cross **15** on the yoke **11**.

In accordance with the provisions of the patent statutes, the principle and mode of operation of this invention have been explained and illustrated in its preferred embodiments. However, it must be understood that this invention may be practiced otherwise than as specifically explained and illustrated without departing from its spirit or scope.

What is claimed is:

1. A method for assembling a portion of a universal joint comprising the steps of:

- (a) providing a yoke including a body portion and first and second arms, the first and second arms having respective first and second openings formed therethrough;
- (b) providing a cross including a body portion having first and second trunnions extending outwardly therefrom;
- (c) providing an assembly tool;
- (d) supporting the assembly tool on the yoke by providing a threaded bore in the yoke, providing an aperture through the assembly tool, and threading a threaded fastener through the aperture into threaded engagement with the threaded bore;
- (e) supporting the cross on the assembly tool such that the cross is positioned relative to the yoke and such that the first and second trunnions extend respectively within the first and second openings; and
- (f) installing first and second bearing cups respectively within the first and second openings and respectively about the first and second trunnions.

2. The method defined in claim **1** wherein said step (a) is performed by providing a yoke having a surface that is located relative to a rotational center axis of the yoke, and wherein said step (d) is performed by supporting the assembly tool on the surface of the yoke.

3. The method defined in claim **1** wherein said step (a) is performed by providing a yoke having a pair of opposed surfaces that are located relative to a rotational center axis of the yoke, and wherein said step (d) is performed by supporting the assembly tool on the opposed surfaces of the yoke.

4. The method defined in claim **1** wherein said step (d) is performed by securing the assembly tool to the yoke.

5. The method defined in claim **1** wherein said step (b) is performed by providing a cross including a third trunnion extending outwardly therefrom, said step (c) is performed by providing a recess on the assembly tool, and said step (e) is performed by inserting the third trunnion within the recess such that the cross is positioned relative to the yoke.

6. The method defined in claim **1** wherein said step (c) is performed by providing an assembly tool that is generally U-shaped, having a central body portion and a pair of end portions extending therefrom.

7. The method defined in claim **6** wherein said step (a) is performed by providing a yoke having a pair of opposed

7

surfaces that are located relative to a rotational center axis of the yoke, and wherein said step (d) is performed by supporting the end portions of the assembly tool on the opposed surfaces of the yoke.

8. The method defined in claim 6 wherein said step (b) is performed by providing a cross including a third trunnion extending outwardly therefrom, said step (c) is performed by providing a recess on the central body portion of the assembly tool, and said step (e) is performed by inserting the third trunnion within the recess such that the cross is positioned relative to the yoke.

9. A method for assembling a portion of a universal joint comprising the steps of:

- (a) providing a yoke including a body portion and first and second arms, the first and second arms having respective aligned first and second openings formed therethrough;
- (b) providing a cross including a body portion having first, second, and third trunnions extending outwardly therefrom;
- (c) providing an assembly tool having a recess formed therein;
- (d) supporting the assembly tool on the yoke;
- (e) supporting the third trunnion of the cross on the assembly tool such that the cross is positioned relative to the yoke and such that the first and second trunnions extend respectively within the first and second openings; and
- (f) installing first and second bearing cups respectively within the first and second openings and respectively about the first and second trunnions.

10. The method defined in claim 9 wherein said step (a) is performed by providing a yoke having a pair of opposed surfaces that are located relative to a rotational center axis of the yoke, and wherein said step (d) is performed by supporting the end portions of the assembly tool on the opposed surfaces of the yoke.

11. The method defined in claim 9 wherein said step (d) is performed by securing the assembly tool to the yoke.

12. The method defined in claim 11 wherein said step (d) is performed by providing a threaded bore in the yoke, providing an aperture through an end portion of the assembly tool, and threading a threaded fastener through the aperture into threaded engagement with the threaded bore.

13. The method defined in claim 9 wherein said step (d) is performed by providing a bore in the yoke, providing a pin in the assembly tool, and inserting the pin into the bore.

14. The method defined in claim 9 wherein said step (d) is performed by providing a bore in the yoke, providing a spring loaded pin in the assembly tool, and inserting the pin into the bore.

15. A method for assembling a portion of a universal joint comprising the steps of:

- (a) providing a yoke including a body portion and first and second arms, the first and second arms having respective first and second openings formed therethrough;

8

(b) providing a cross including a body portion having first and second trunnions extending outwardly therefrom;

(c) providing an assembly tool;

(d) supporting the assembly tool on the yoke;

(e) supporting the cross on the assembly tool such that the cross is positioned relative to the yoke and such that the first and second trunnions extend respectively within the first and second openings; and

(f) while the cross is supported on the assembly tool, installing first and second bearing cups respectively within the first and second openings and respectively about the first and second trunnions.

16. The method defined in claim 15 wherein said step (a) is performed by providing a yoke having a surface that is located relative to a rotational center axis of the yoke, and wherein said step (d) is performed by supporting the assembly tool on the surface of the yoke.

17. The method defined in claim 15 wherein said step (a) is performed by providing a yoke having a pair of opposed surfaces that are located relative to a rotational center axis of the yoke, and wherein said step (d) is performed by supporting the assembly tool on the opposed surfaces of the yoke.

18. The method defined in claim 15 wherein said step (d) is performed by providing a threaded bore in the yoke, providing an aperture through an end portion of the assembly tool, and threading a threaded fastener through the aperture into threaded engagement with the threaded bore.

19. The method defined in claim 15 wherein said step (d) is performed by providing a bore in the yoke, providing a pin in the assembly tool, and inserting the pin into the bore.

20. The method defined in claim 15 wherein said step (d) is performed by providing a bore in the yoke, providing a spring loaded pin in the assembly tool, and inserting the pin into the bore.

21. A method for assembling a portion of a universal joint comprising the steps of:

(a) providing a yoke including a body portion and first and second arms, the first and second arms having respective first and second openings formed therethrough;

(b) providing a cross including a body portion having first and second trunnions extending outwardly therefrom;

(c) providing an assembly tool;

(d) supporting the assembly tool on the yoke by providing a bore in the yoke, providing a spring loaded pin in the assembly tool, and inserting the pin into the bore;

(e) supporting the cross on the assembly tool such that the cross is positioned relative to the yoke and such that the first and second trunnions extend respectively within the first and second openings; and

(f) installing first and second bearing cups respectively within the first and second openings and respectively about the first and second trunnions.

* * * * *