

CLUTCH INSTALLATION INSTRUCTIONS & TECHNICAL GUIDE

1. These instructions apply to all PowerTrain Technology, Inc. (PTT) multi-disc racing clutches from 4-1/2" up to 7-1/2" disc diameter. Before proceeding, ensure that you have selected, and received, the correct clutch for your application.
2. Any components that may affect clutch performance must be in good condition and suitable for the use for which they are intended. (i.e. Distributing System, clutch-release system, pilot bearing, etc.)
3. Check that pilot bearing in the crankshaft is properly lubed & free of excess oil or dirt, with no evidence of scoring, rust or corrosion, cracking or spalling. A PTT Synthetic-Lube clutch adjustment shaft can be used for checking the proper size of the pilot bearing. It has a precisely sized pilot on the end. Simply insert it into your pilot bearing and check for correct fit.
4. The transmission input shaft must be accurately aligned to the engine crankshaft. The following performs this critical alignment function. Check your distributing system to ensure that the transmission input shaft is concentric within 0.002" (2 mils) misalignment maximum to the engine crankshaft. Two feet of the input shaft free to the bearing in the transmission mounting surface of the distributing shaft (0.002" (2 mils) or less). Detailed instructions for this inspection procedure can be found at the PTT website (www.powertrain-tech.com). Performing this step avoids excessive input shaft wear on the clutch hub and input shaft. It also helps prevent clutch chatter, disc, face chattering, and other problems.
5. Ensure the input shaft and clutch disc rollers are clean and dry. Do not lubricate. Clean the new clutch disc rollers before proper engagement on your first start. They must be dry on the input shaft splines and not have any oil, grease or debris on them. Take the opportunity now to look at the input shaft splines closely to ensure that they do not have any pits, cracks or burrs.
6. Inspect the clutch bolts that come with your clutch, from the backside of the flywheel. (Some flywheels do not require this.) Check the used flywheel mounting surface for corrosion, pitting, cracks, or excessive debris. The flywheel must be clean and substantially flat on the area mounting surface, with no evidence of scoring, chattering, or flexing. Torque the flywheel mounting bolts according to the engine or used manufacturer's instructions. PTT recommends the use of a medium-strength penetrant to avoid locking components. (Lubrol-1 or similar product) (DO NOT USE STANOLUB®)
7. Check to see that the clutch disc release the flywheel free to rotate freely with the flywheel bolts in crankshaft.
8. **Decrease the clutch disc gap, finger plate(s), pressure plate and the bearing) prior to installation. Keep finger settings clean and dry, taking special care to avoid oil or grease contamination.**
9. **Check that the clutch is assembled correctly.** If your discs are labeled showing clutch disc orientation, install the clutch discs according to the labels. On our disc clutches the most used stamped PTT label shows the engine on the disc clutches, the flywheel bolts, stamped PTT, and the bearing side view. On three disc clutches, the flat most used stamped PTT on the two end bolts, read from each side. In the center disc use the labeling on either direction. Flat disc clutches need to have the two bolts stamped all in the same direction. Please refer to the drawing below for proper flat assembly on to the distributing shaft with your clutch.

NOTE: All clutch parts shown here are transmission side up; engagement side down.



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