

## 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, 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 fits a properly 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 flats of the input shaft free to fit inside the transmission housing 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](http://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 shifting, and other problems.
5. Ensure the input shaft and clutch disc rollers are clean and dry. Do not lubricate. Check the new clutch disc rollers against the proper engagement on your input shaft. They must fit snugly on the input shaft splines and not bind, swimming or bottom out. Take the opportunity now to look at the input shaft splines closely to ensure that they do not even appear rounded or beveled.
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 flats. The flywheel must be aligned to the distributor flat on the crank mounting surface, with no evidence of rocking inside the flywheel. Torque the flywheel mounting bolts according to the engine or crank manufacturer's instructions. PTT recommends the use of a medium-strength powdered thread locking compound (Loctite® or similar product) (DO NOT USE STAIN RESISTANT).
7. Check to see that the clutch disc release the flywheel flat to interference with the flywheel bolts or crankshaft.
8. **Decrease the clutch disc gap, finger plate(s), pressure plate and the housing) 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 timing plate area. On three disc clutches, the flat most needs stamped PTT on the top and bolts must face down such area. In the center disc use the labeling in other direction. Flat disc clutches need to have the flat bolts angled up in the same position. Please refer to the drawing below for proper flat assembly on to the distributors that come with your clutch.

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



# Clutch Installation Instructions Technical Guide

**John B. Raffa, John Harold Haynes**



## **Clutch Installation Instructions Technical Guide:**

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## **Table of Contents Clutch Installation Instructions Technical Guide**

1. Understanding the eBook Clutch Installation Instructions Technical Guide
  - The Rise of Digital Reading Clutch Installation Instructions Technical Guide
  - Advantages of eBooks Over Traditional Books
2. Identifying Clutch Installation Instructions Technical Guide
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Clutch Installation Instructions Technical Guide
  - User-Friendly Interface
4. Exploring eBook Recommendations from Clutch Installation Instructions Technical Guide
  - Personalized Recommendations
  - Clutch Installation Instructions Technical Guide User Reviews and Ratings
  - Clutch Installation Instructions Technical Guide and Bestseller Lists
5. Accessing Clutch Installation Instructions Technical Guide Free and Paid eBooks

- Clutch Installation Instructions Technical Guide Public Domain eBooks
  - Clutch Installation Instructions Technical Guide eBook Subscription Services
  - Clutch Installation Instructions Technical Guide Budget-Friendly Options
6. Navigating Clutch Installation Instructions Technical Guide eBook Formats
    - ePub, PDF, MOBI, and More
    - Clutch Installation Instructions Technical Guide Compatibility with Devices
    - Clutch Installation Instructions Technical Guide Enhanced eBook Features
  7. Enhancing Your Reading Experience
    - Adjustable Fonts and Text Sizes of Clutch Installation Instructions Technical Guide
    - Highlighting and Note-Taking Clutch Installation Instructions Technical Guide
    - Interactive Elements Clutch Installation Instructions Technical Guide
  8. Staying Engaged with Clutch Installation Instructions Technical Guide
    - Joining Online Reading Communities
    - Participating in Virtual Book Clubs
    - Following Authors and Publishers Clutch Installation Instructions Technical Guide
  9. Balancing eBooks and Physical Books Clutch Installation Instructions Technical Guide
    - Benefits of a Digital Library
    - Creating a Diverse Reading Collection Clutch Installation Instructions Technical Guide
  10. Overcoming Reading Challenges
    - Dealing with Digital Eye Strain
    - Minimizing Distractions
    - Managing Screen Time
  11. Cultivating a Reading Routine Clutch Installation Instructions Technical Guide
    - Setting Reading Goals Clutch Installation Instructions Technical Guide
    - Carving Out Dedicated Reading Time
  12. Sourcing Reliable Information of Clutch Installation Instructions Technical Guide
    - Fact-Checking eBook Content of Clutch Installation Instructions Technical Guide
    - Distinguishing Credible Sources
  13. Promoting Lifelong Learning
    - Utilizing eBooks for Skill Development

- Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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