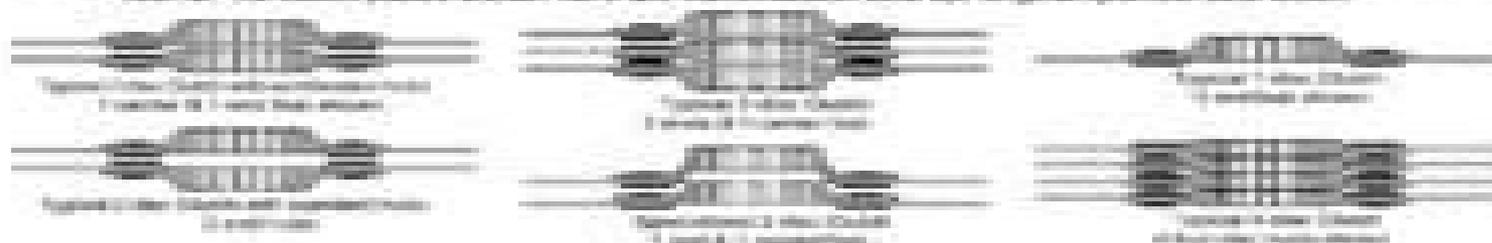


CLUTCH INSTALLATION INSTRUCTIONS & TECHNICAL GUIDE

- These instructions apply to all PowerTrax 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.
- Buy components that may affect clutch performance such as, in good condition and suitable for the use for which they are intended. (i.e. Distributing System, clutch-release system, pilot bearing, etc.)
- Check that pilot bearing in the crankshaft, is properly lubed & free of excess rust, with no evidence of scoring, out of roundness, 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.
- The transmission input shaft must be accurately aligned to the engine crankshaft. The following performs this critical alignment function. Check your distributing to insure 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 in 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.powertrax.com). Performing this step avoids excessive input shaft wear on the clutch hub and input shaft. It also helps prevent clutch hub, disc, face shifting, and other problems.
- Inspect the input shaft and clutch disc surfaces for wear and/or. Do not lubricate. Check the new clutch disc splines for 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 insure that 6 to 8 mil wear pits are not present or feared.
- Inspect the clutch hub that mates with your clutch, from the backside of the flywheel. (Some flywheels do not require this.) Check the used flywheel housing surface for corrosion, pitting, cracks, or excessive debris. The flywheel must fit against an abutting flat on the disc mounting surface, with no evidence of rocking inside the flywheel. Torque the flywheel mounting bolts according to the engine or used manufacturer's instructions. PTT recommends the use of a medium-strength powdered thread locking compound (Loctite® or similar product) (DO NOT USE STAIN RESISTANT).
- Check to see that the clutch disc release the flywheel hub is interference fit with the flywheel bolts or crankshaft.
- Decrease the clutch disc gap, back clutch pressure plate and the bearing) prior to installation. Keep organic springs clean and dry, taking special care to avoid oil or grease contamination.**
- 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 needs stamped PTT on the top and bolts must face down after. In the center disc use the labeling on either direction. Flat disc clutches need to have the flat bolts angled up in the same position. Please refer to the drawing below for proper hub assembly on to the crankshaft that came with your clutch.

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



Clutch Installation Instructions Technical Guide

**United States. Dept. of the
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