

CLUTCH INSTALLATION INSTRUCTIONS & TECHNICAL GUIDE

- 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.
- 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 (a little oil, with no evidence of metal chips, 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 properly 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 face to fit bearing in the transmission housing surface of the distributing within 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 face and input shaft. It also helps prevent clutch chatter, disc, face chattering, 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 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 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 (medium to low locking compound) Loctite® or similar product (DO NOT USE STAIN RESISTANT).
- Check to see that the clutch disc release the flywheel face by interference with the flywheel bolts or crankshaft.
- Decrease the clutch, clutch disc, input shaft, pressure plate and the flywheel prior to installation. Keep organic bearings 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 discs feature the engine on the disc clutches, the flywheel bolts, stamped PTT, and the timing plate area. On these disc clutches, the flat most needs stamped PTT on the top and bolts need face down area. In the order they can be installed in other direction. Flat disc clutches need to have the flat bolts stamped on in the same position. Please refer to the drawing below for proper flat assembly on to the crankshaft that come with your clutch.

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



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