

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" inner diameter. Before proceeding, ensure that you have selected, and obtained the correct clutch for your application.
- Buy components that may affect clutch performance such as, in good condition and suitable for the job for which they are intended. (i.e. Distributing, Synchro, clutch-release system, pilot bearing, etc.)
- Check that pilot bearing in the crankshaft. It should have a hole of proper size, with no evidence of misalignment, out of roundness, cracking or splitting. A PTT Synchro-A-Lign clutch alignment 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 ensure that the transmission register hole is concentric within 0.002" (2 mils) to misaligned run-out in the engine crankshaft. Two flats on the engine block face to the register in the transmission mounting 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.powertraintech.com). Performing this step avoids excessive spline wear on the clutch hub and input shaft. It also helps prevent clutch chatter, shock, load shifting, and other problems.
- Ensure the input shaft and clutch disc splines are clean and dry. Do not lubricate. Check the new clutch disc's splines for proper engagement on your input shaft. They must fit easily on the input shaft splines and not bind, requiring an undue effort. Take the opportunity now to look at the input shaft spline closely to ensure that it is not even slightly corroded or bent.
- Inspect the clutch bolts that come with your clutch, from the backside of the flywheel. (Some flywheels do not require this.) Check the used Synchro-mounting surface for corrosion, pitting, scratches, or damaged bolts. The flywheel must be clean to all substantially flat on the drive mounting surface, with no evidence of scoring. Install the Synchro. Torque the Synchro-mounting bolts according to the engine or user's manufacturer's instructions. PTT recommends the use of a medium-strength preloaded torque locking compound (Loctite® or similar product) (DO NOT USE STAIN REMOVER!).
- Check to see that the clutch disc between the Synchro has no interference with the Synchro bolts or crankshaft.
- Decrease the clutch clutch disc, finger plate, pressure plate and the flywheel prior to installation. Keep organic coatings clean and dry, taking special care to avoid oil or grease contamination.**
- Ensure that the clutch is assembled correctly. If your discs are labeled showing clutch disc orientation, install the clutch discs according to the labels. On race disc clutches that were tested against PTT bases, ensure the degree of run out disc clutches, the flatness levels, tapered PTT discs for racing clutch sets. On these disc clutches, the flat must be tested against PTT on the two end faces, and the run out. If the clutch disc can be installed in either direction. Flat disc clutches need to have the run out levels applied all in the same direction. Please refer to the drawing below for proper disc assembly on to the crankshaft that came with your clutch.

NOTE: All clutch parts shown here are transmission side up; alignment/shaft side down.



Clutch Installation Instructions Technical Guide

**Magnus Colbjørn Ihlseng, Eugene
Benjamin Wilson**



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How to Ride a Motorcycle: A Rider's Guide to Strategy, Safety and Skill Development Pat Hahn, A beginner's manual especially geared to the needs of entry level riders this book provides all the basic instruction necessary to become a motorcycle rider with an emphasis on the challenges faced by neophyte riders Starting at neophyte level and evolving into a serious intelligent expert How to Ride a Motorcycle tells the reader how to be a motorcycle rider with a strong emphasis on safety and big picture strategy think about it this way as opposed to do this *Technical Manual, 1942* *Direct and General Support and Depot Maintenance Manual, 1990*

Operator's, Unit, Direct Support, and General Support Maintenance Manual, 1992 *National Guard Bureau Manual United States. National Guard Bureau, 1947* *Direct support and general support maintenance manual for truck, cargo, tactical, 1-1/4 ton, 4x4, M1008 (2320-01-123-6827), 1983* *Direct and General Support Maintenance Manual for Transmission Assembly, Automatic, Model TX 200-2A, Allison Division, GM, 2520-860-7342, Transmission Assembly, Automatic, Model TX 200-2B, Allison Division, GM, 2520-964-9207, Transmission Assembly, Automatic, Model TX 200-6, Allison Division, GM, 2520-045-3108, 1969* *Direct Support, General Support, and Depot Maintenance Manual, Including Repair Parts and Special Tools List, 1990* **Field and Depot Maintenance Manual, 1959** **Truck service manual, 1984** *The Toyota Camry 1997-2001: An Essential Guide to Owner Maintenance and Repair* Pasquale De

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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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