

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 obtained 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, 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 rounded 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 flywheel mounting surface for corrosion, pitting, scratches, or damaged bolts. The flywheel must be aligned to accurately fit on the disc mounting surface, with no evidence of binding. Install the Synchro. Torque the flywheel 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 disc drive, finger splines, pressure plate and the flywheel prior to installation. Keep splines, fingers 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 are not stamped PTT, have the engine, the input shaft splines, the flywheel bolts, stamped PTT, must be facing each other. On three disc clutches, the flat must locate stamped PTT on the two end bolts, and three disc clutch on the center disc can be installed in either direction. Four disc clutches need to have the flat locate stamped all on the same direction. Please refer to the drawing below for proper disc assembly as to the orientation that come with your clutch.

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



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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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