

## SVI, LLC 14APR2021

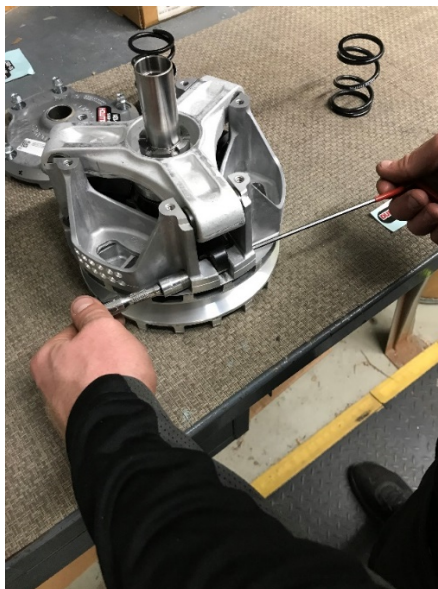
4. Loosen 6 clutch cover bolts with 3/8-inch socket in an alternating pattern so cover comes up evenly. Mark clutch cover and spider like picture below for reassembly later in step 8. Remove cover bolts and cover.



5. Remove weight pins, weight pin nuts, weights and primary spring.



6. Install new 10-171 RG-75 weights into clutch, install the 3 new weight pins in the same direction and weight pin nuts provided in kit.  
With 3/8" thin wall socket and 1/8" hex wrench, tighten weight pins and nuts. Nut will bottom out on shoulder of weight pin.



7. Install new 50-016 primary spring provided with kit.  
8. Install clutch cover making sure that the X markings line up on cover and spider. Pull sheave up, push cover down compressing spring to get cover bolts started. Tighten bolts in an alternating pattern. Tighten all screws firmly. Torque spec is 7-11 ft-lbf.



9. Install new 97-047 DECAL-PRIMARY CLUTCH 10-216 on clutch cover.



10. Secondary Clutch. Remove 4 cam screws with T25. If stuck apply a small amount of heat to screw head. Remove cam.



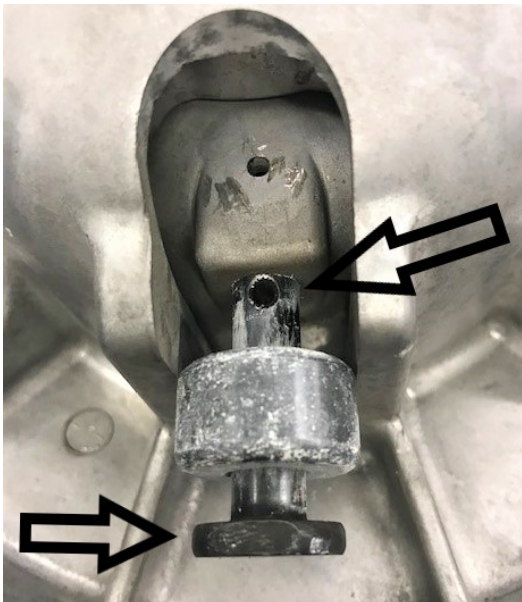
11. Remove roller slotted spring pins using a 1/8" punch and hammer. The pins will drop out the bottom so take care.



12. Remove roller pins and rollers



13. Install new rollers onto pins, install pins back into secondary, take note that the roller pins have a flat spot on the outer radius, this side has the larger hole for the slotted spring pin, have this side up. Install slotted spring pins with 1/8" punch until flush.



14. Install new 10-198 423549 Cam provided in kit making sure to match the X's on cam and sheave.



15. Install cam screws placing a drop of Blue Loctite, provided with kit, on to end of threads. Tighten screws with T25. Torque Spec is 42-52 in-lbs.



16. Install secondary onto shaft. Place Blue Loctite, provided with kit, onto end of threads of secondary bolt and tighten to 50 ft-lbf.
17. Clean the engine tapered shaft and Primary clutch bore with alcohol or degreaser. Do not lubricate.
18. Install Belt & DURACLUTCH Primary. Place belt in secondary clutch so you can read the belt part number. Use belt tool to open secondary slightly to allow belt to drop into sheaves. Place belt into primary and install onto the shaft. Tighten primary bolt to 60 ft-lbf.
19. Install outer clutch housing. Ensure seal is good or replace with new seal. The DURACLUTCH primary is slightly larger than the original equipment primary. To ensure the primary does not rub against the cover push up and back on the housing while lightly snugging the bottom screws. Then tighten the top rear screw followed by the other top screws. Then tighten all remaining screws including the bottom screws evenly. After starting the engine if you hear the primary rubbing, push on the cover while the engine is running in different directions to see which way will eliminate the rubbing. Stop the engine and loosen the housing screws and retighten using the above sequence while pushing on the cover in the direction that eliminated the rubbing. If this does not eliminate the rubbing, try installing a new gasket and go through the bolt tightening sequence again. If you cannot eliminate the rubbing the cover is heat warped and you may have to install a new cover and perhaps a new back plate. You may also try using a heat gun to remove heat sag in the cover.
20. Drive vehicle for 5 miles to break-in DURACLUTCH kit components.

For installation video go to [www.duraclutch.com](http://www.duraclutch.com)