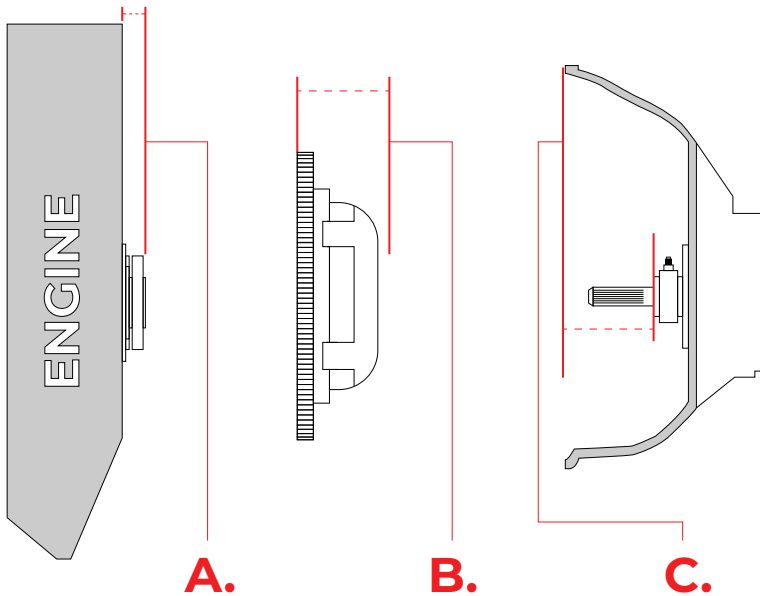




HYDRO BEARING INSTALL

Required tools: Dial Caliper and Straight Edge

It is very important to install your Action Clutch hydraulic bearing using the correct air gap. Failure to install correctly will cause the clutch to slip, premature failure and/or bearing failure.



MEASUREMENT A.

CRANKSHAFT AND BACK OF ENGINE BLOCK DISTANCE.

Sit the straight edge flush onto the crank and measure the distance between the crank & the back of the engine block. Some applications the engine crank will sit flush with the block, if this is the case the measurement will be 0.00.

MEASUREMENT B.

CLUTCH AND FLYWHEEL STACK HEIGHT.

Bolt down the entire clutch pack onto the flywheel to required specifications as you normally would install to the engine. Sit the back flange of the flywheel onto a flat surface. Make sure the back of the flange is sitting on a flat surface to ensure proper measurement.

MEASUREMENT C.

BELL HOUSING TO BEARING.

Mount your Action Clutch hydraulic bearing onto the transmission (as well as any spacers if applicable). **DO NOT** install any shims at this point. Lay the straight edge across the face of the bell housing and measure the distance between the face of the transmission to the face of the bearing using the dial calipers.

Be sure you subtract the thickness of the straight edge.

CLUTCH KIT TYPE	REQUIRED AIR GAP
1OS, 1KS, 1MS, 1MD, 2MS, 2MD, IRONMAN	0.120" - 0.130"
TWIN DISC	0.090" - 0.120"

Now add measurement A and B, this will be the "clutch to engine block" measurement. Subtract the clutch to block measurement from the C measurement, this will give you the exact air gap measurement.

[Measurement C - Clutch to Engine Block = Air Gap]

If your air gap is a **negative number**, the bearing is too tall. Remove shims or bearing spacers to increase the bell housing to bearing measurement (measurement C).

If the air gap is **more** than the required measurement then add shims to the bearing to reduce the bell housing to bearing measurement (measurement C).

If you have any questions please email us at erik@actionclutch.com or call us at (323) 269-6051.