

**Instruction for 18-0099, 18-0100, 18-0101, 18-0170, 18-3153, 18-3154**

Clutch Pressure Plate must be pre-assembled as follows:

Place clutch releasing disc on hub. Position springs on pins and studs. Place spring collar over springs. Note that stud holes are arranged so it fits in only one position. Turn adjusting locknut on adjusting screw until head is flush, then turn into screw pressure plate with 1-3/4 inch washer under nut. Remove assembly from hub.

Place key in slot in mainshaft. Slip clutch hub onto shaft. Install new oil seal in clutch hub nut. Position lockwasher followed by hub nut. Tighten nut to 50 to 60 ft-lbs. torque. Bend over the ear on washer matching hub nut flat. Grease clutch shell bearing and install clutch shell.

Install lined and steel discs in clutch shell, staggering position of steel disc buffers in key slots in shell. Make sure steel discs are installed with side stamped "OUT" facing outward.

Install pressure plate assembly. Draw down adjusting nut until stud nuts may be started. Turn down nut until 1-3/4 inch washer is loose. Remove washer and replace adjusting nut.

Draw down stud nuts evenly until distance from back of pressure plate to front of clutch releasing disc is 1-1/32 inch.