INSTRUCTIONS FOR INSTALLATION AND ADJUSTMENT OF LIPE 13/330 TWO-PLATE FLYWHEEL ADAPTER KITS

Carefully inspect the flywheel for scores, heat cracks, taper and parallelism to the crankshaft mounting surface. Remachine if necessary. If the flywheel is heat checked or worn it should be replaced.

**Pot/Recess Flywheels:** The distance between the cover mounting surface and the flywheel friction surface must be within a specific dimension (pot depth). Refer to Lipe Service Manual LL30002.

**Flat Flywheels:** The cover assembly mounting bolt holes must conform to the following specifications.

The 330 two-plate on a flat flywheel requires an adapter ring. Order the adapter ring kit according to flywheel bolt circle (see chart below).

<table>
<thead>
<tr>
<th>Bolt Circle</th>
<th>Adapter Kit No.</th>
<th>Adapter Ring No.</th>
<th>Cap Screws Qty/C78-XX</th>
</tr>
</thead>
<tbody>
<tr>
<td>14.125&quot;</td>
<td>AK-313</td>
<td>C130-12</td>
<td>12/(27)</td>
</tr>
<tr>
<td>14.500&quot;</td>
<td>AK-314</td>
<td>C130-7</td>
<td>12/(27)</td>
</tr>
<tr>
<td>14.625&quot;</td>
<td>AK-315</td>
<td>C130-11</td>
<td>12/(31)</td>
</tr>
</tbody>
</table>

We suggest that a pair of standard 3/8-16 cap screws 3” long be used as pilots. Cut the heads from these cap screws, saw a screwdriver slot in the end and install them in opposite holes in the flywheel. These pilots will support the adapter ring as the clutch is installed.

Before installing a two-plate assembly, the intermediate plate should be set into the driving slots of the adapter ring and checked for free movement (.008" - .010" clearance).

Position the adapter ring with the non-slot side next to the flywheel.

Install the flywheel side disc, intermediate plate and pressure plate side disc in the adapter ring and insert the proper spline alignment tool through both disc assembly hubs and seat into the flywheel pilot bearing (ensure that disc hubs slide freely over splines on alignment tool). **Note:** The intermediate plate that is used with this adapter ring is directional and must be installed as labeled.

The 330 cover assembly must be positioned on the adapter ring so that the section of the cover labeled "Align Lug Here" is directly over one drive lug of the intermediate plate.

After all 12 cap screws have been installed, tighten by torquing the 3/8-16 screws to 35-45 ft. lbs. in a cross-corner sequence.

Remove the wood blocks and then remove the spline alignment tool. Bring the transmission forward slowly and insert the input shaft into the disc hub splines carefully. Be sure the input shaft splines line up with the driven disc hub splines correctly. If the input shaft splines and the disc hub splines do not line up, put the transmission in any gear and turn the output shaft to line up the spline. **DO NOT** force the input shaft into the disc hubs as irreparable damage can result.

When the input shaft is properly seated in the flywheel pilot bearing attach the transmission bell housing to the engine using the proper cap screws. Reinstall the driveline, connect and adjust the release linkage for 1/8" (3.17mm) clearance between the release bearing face and the contact surface of the release levers.