

Instructions for Installation and Adjustment of Lipe 15/380 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.

We suggest that a pair of standard 7/16-14 NC 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 check for free movement (.008" - .010" clearance).

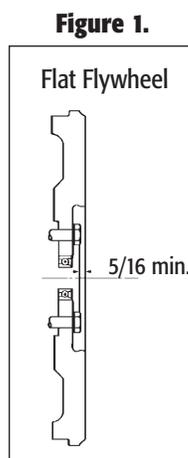
Two disc assemblies for a two plate clutch, in most cases, are not identical or interchangeable. The disc assemblies will be marked either flywheel side or pressure plate side. They must be positioned with the side of the disc as marked, next or adjacent to the respective part. A minimum of 5/32" must be maintained between the pilot bearing and the flywheel side disc hub. The minimum distance of 5/16" must be maintained between the flywheel friction face and the flywheel to crankshaft mounting bolt heads (Figure 1).

Position the adapter ring on the flywheel, ensuring that the ventilating slots are on flywheel side and the slots for intermediate plate face the transmission.

With a spline alignment tool, align the drive discs and intermediate plate on the flywheel adapter ring. The intermediate plate is directional and must be placed on the adapter ring as marked - "Press. Plate Side" - to the back, towards the transmission. Attach the clutch cover assembly to the flywheel using the 12 cap screws and lockwashers provided in the adapter kit. Do not tighten any cap screws until all 12 have been installed and are finger tight.

Tighten gradually in a cross hatch fashion until the cover is drawn up tight, using a final torque of 55 lbs.-ft.

15/380 Adapter Kit AK-322 Components: (1) Adapter Ring C130-24, (12) Cap Screws C78-39, (12) Lockwashers X10-181.



AK-322

Figure 2.

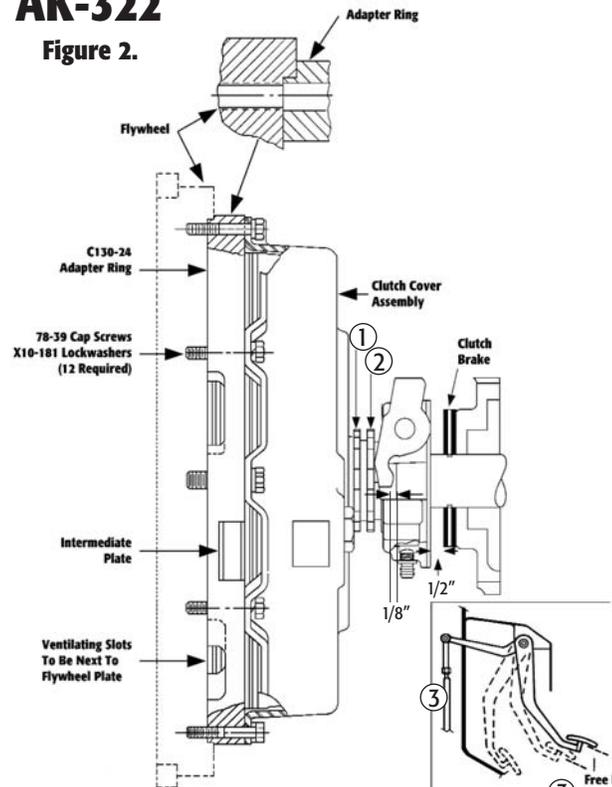


Figure 3.

- STEP 1:** Unlock sleeve locknut ①.
 - STEP 2:** Turn slotted adjusting nut, ②, to obtain release travel clearance of 1/2" (13mm). Tolerance ± 1/8" (3mm).
 - STEP 3:** Securely lock sleeve locknut, ①, against release lever spider.
 - STEP 4:** Connect linkage to cross shaft adjusting arm and adjust external clutch linkage, ③, to obtain a yoke clearance of 1/8" (3mm). This will usually result in a nominal 1 1/2" (38mm) free pedal travel.
- PLEASE NOTE:** While performing STEPS 2 and 4, hold the release bearing assembly toward the transmission to remove backlash.

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