



REAR MOUNT BELLHOUSING

INSTALLATION INSTRUCTIONS

Thank you for purchasing a Quarter Master bellhousing. Please take a few minutes to read through these instructions before you install your new Quarter Master Rear Mount Bellhousing.

THINGS TO CHECK BEFORE YOU BEGIN:

- With the bellhousing bolted to the engine, check that the transmission mounting face of the bellhousing is parallel to the crankshaft face within .006" total indicated run-out. Clean block mounting surface, making sure that it is free from nicks, burrs, paint, etc. Refer to Figure 2.
- The transmission mounting hole of the bellhousing should be concentric to the crankshaft within .006" total indicated run-out. *The closer, the better.* Refer to Figure 2. If the measurement is not within specification, you will need to relocate the dowel pins in the engine block. Note: Quarter Master bell housings meet or exceed these requirements from the factory.

INSTALLATION:

- Quarter Master Rear Mount bell housings are designed for cover –mount ring gears on 4.5", 5.5" and 7.25" clutches.
 - Quarter Master offers billet aluminum engine mounts, kit P/N 110515, for all Optimum Reverse Mount bells.
1. Mock up engine mounts (if appropriate) to verify engine position in chassis.
 2. Install the clutch and flywheel per manufacturer's instructions.
 3. Set up release bearing clearance per manufacturer's instructions.
 4. Set up starter clearance. Quarter Master recommends .100" +/- .040" pinion-to-ring gear clearance and .025" backlash (if adjustable).
 5. Install the bellhousing. Refer to Table 2 for bolt size and torque.
 6. Install the transmission. Refer to Table 2 for bolt size and torque.

Table 1: Part Numbers	Chevrolet	Dodge	Ford
Aluminum	110100	110200	110300
Optimum Aluminum	110150	110250	110350
Optimum Magnesium	110155	110255	110355

Table 2: Recommended Bolt Sizes and Torques	Chevrolet	Dodge	Ford
Bellhousing Bolt Size	3/8-16	3/8-16	7/16-14
Bellhousing Bolt Torque	25-30 ft-lbs	25-30 ft-lbs	45-50 ft-lbs
Transmission Bolt Size	1/2-13	1/2-13	1/2-13
Transmission Bolt Torque	70-75 ft-lbs	70-75 ft-lbs	70-75 ft-lbs

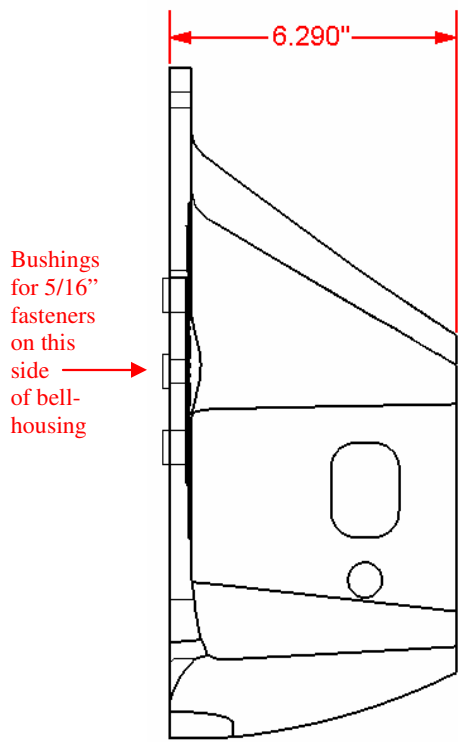


Figure 1: Side view of bellhousing

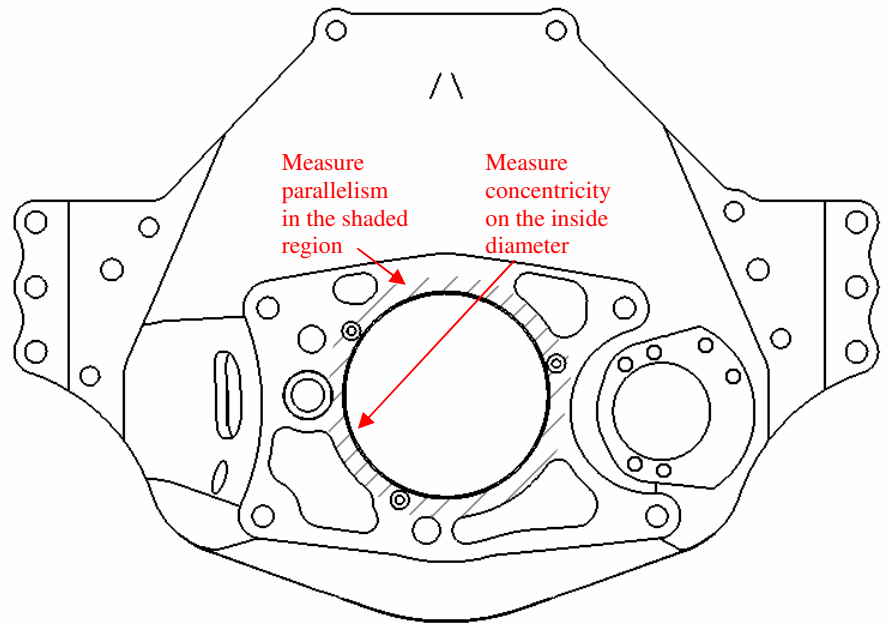


Figure 2: Back view of bellhousing

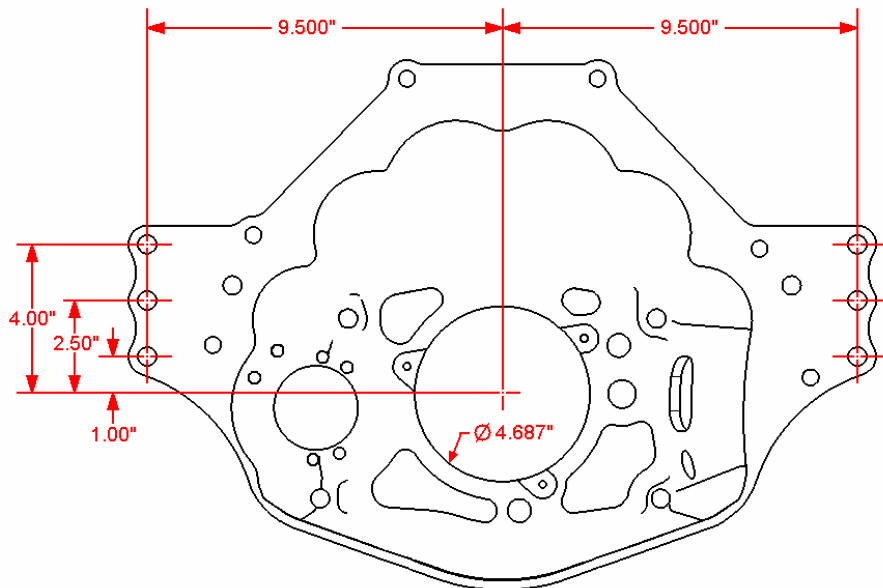


Figure 3: Front view of bellhousing

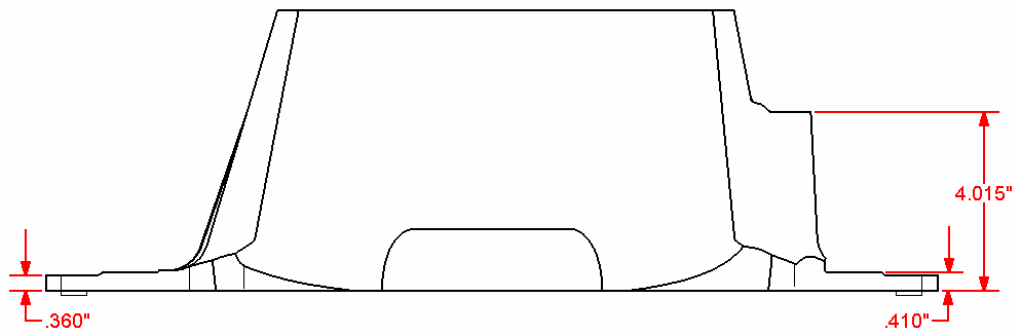


Figure 4: Bottom view of bellhousing