



## INSTALLATION INSTRUCTIONS

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

### THINGS TO CHECK BEFORE YOU BEGIN:

- Check that the crankshaft and crank bolt holes are clean and free of burrs.
- Check that the flywheel is clean and free of burrs.
- **DO NOT** radius or chamfer the holes on the flywheel or crankshaft. This will reduce the area of surface contact.

### INSTALLATION:

- Entry chamfers on the ring gears should be on the same side as the pinion.
  - Washers should be used on aluminum flywheels.
  - Quarter Master recommends using ARP bolts.
1. Clean all surfaces, bolts and holes thoroughly.
  2. Loctite, or similar chemical locking agent, may be applied to the bolts, taking care to keep it away from the crank flange.
  3. Install the flywheel and snug the bolts.
  4. Torque the bolts in a star pattern, refer to Table 1 for torque recommendations.
  5. Refer to your starter instructions to set up the proper pinion-to-ring gear clearance. Quarter Master recommends .100" +/- .040" for the clearance.

### MAINTENANCE:

- Regularly inspect the flywheel and ring gear for fatigue cracks. Dye Penetrant (for aluminum flywheels) and Magnaflux (for steel flywheels) are the recommended methods to check for possible fatigue cracks.
- Check for signs of overheating (excessive blue discoloration), uneven wear, hot spots or warpage, and replace the flywheel if necessary.
- The maximum warpage of any clutch surface is .006". Excessive warpage will lead to clutch failure.
- Check that the ring gear teeth do not have chips or gouges.
- Some Quarter Master aluminum flywheels have steel inserts that can be replaced.
- Some steel flywheels can be resurfaced, contact Quarter Master for details.
- Some designs use pressed in clutch bolts. These bolts can be pressed out and replaced, contact Quarter Master for details.

Table 1: Recommended Bolt Torques	Torque
7/16-20	80 ft-lbs
1/2-13	111 ft-lbs
10mm	54 ft-lbs
11mm	80 ft-lbs