



Step 1: Disassemble clutch using a piece of threaded rod or clamping device.



Step 2: Remove stock helix, spring and roller hub.



Step 3: Remove the rollers from the stock hub to avoid any damage while drilling the hub assembly.



Step 4: Cut out the paper template (as shown).



Step 5: Place the template over the hub & mark the three (3) holes.



Step 6: Using the supplied 1/4" carbide drill bit, drill the three (3) holes. Drill slowly using some cutting fluid such as Rapid Tap as hub assembly is case hardened.



Step 7: The holes in the hub should be chamfered on the inside where it contacts the edge of the hole. This can be done by using a die grinder or Dremel tool.



Step 8: Drill 1/4" hole in the movable sheave spring pocket (as indicated).



Step 9: Reassemble rollers, washers & circlips back on the hub assembly. Using the supplied spring, place the white tipped end in the middle hole of the hub assembly.



Step 10: To Reassemble place the sheave on the threaded rod along with the spring & hub assembly. Place the spring in the drilled hole in the bottom of the sheave.



Step 11: Start helix onto the rollers and now insert the two (2) pieces of the supplied stick to support the hub while spring tension is applied.



Step 12: Apply a small amount of spring pressure while rotating helix clockwise by hand. Once the helix starts over the humps, screw down the spring pressure until helix starts to rotate down into the sheave.



Step 13: Using a long screw driver, insert between the hub assembly & helix, applying a small amount of pressure so stick can be removed. *Repeat for opposite side.*



Step 14: Once sticks are removed continue applying pressure to the spring. Helix will rotate as spring pressure is applied.



Step 15: Apply spring pressure until helix is about 1/16" from the sheave.



Step 16: Using supplied lever tool, apply enough clockwise pressure to align the helix holes. Use Blue Loctite to install the 2 bolts, holding pressure on the lever. *It's easier with 2 people.* Install remaining 2 bolts & torque to MFG specs.