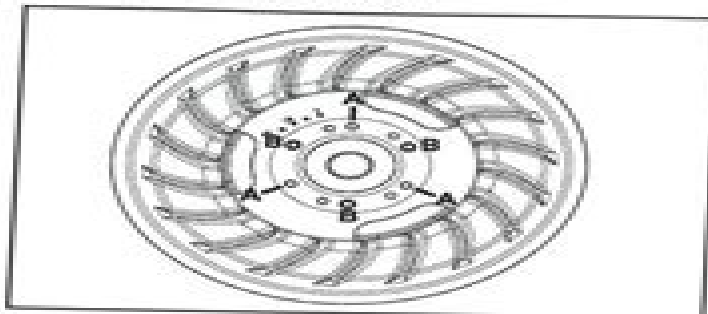


9. Assemble the clutch by sliding components down on to stationary sheave shaft.
10. When assembling the deflection cam, pins, and fasteners, reference the locations for each component in the illustration.



- A - 3 threaded hole inline with raised line marks = Deflection Cam Screws.
- B - 3 non-threaded holes = Deflection Pins
- The remaining 4 threaded holes are for the L wrench tool.

11. Align the helix alignment hole with the "X" on the moveable sheave.



12. Align the wide gap in the helix splines with the skip tooth in the stationary sheave shaft.
13. Visually verify the rollers are positioned underneath each corresponding helix ramp.
14. Compress the helix down into the sheave. Install the washer and snap ring. Verify the snap ring is fully seated in the groove with the sharp edge upward.
15. Carefully release the clutch compressor.
16. Align the two "X" marks and install the cover. Torque fasteners to specification.

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Penton Staff



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