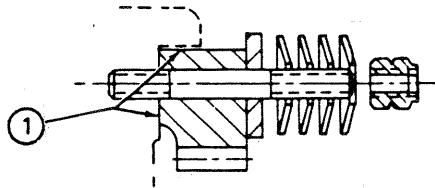


FLYWHEEL RING GEAR INSTALLATION PROCEDURE

The 212517 Kit Includes:

1	Ring Gear
24	Stud
96	Belleville Washer
24	Stud Nut
1	Instruction Sheet

- ① — REMOVE ALL BURRS FROM FLYWHEEL MOUNTING FACE & PILOT BORE, CLEAN WITH SOLVENT. THE ENGINE FLYWHEEL & HOUSING MUST CONFORM TO STANDARD S.A.E. NO. 1 — S.A.E. J927 TOLERANCE SPECIFICATIONS FOR PILOT BORES, ECCENTRICITIES & MOUNTING FACE DEVIATIONS. CHECK ENGINE CRANKSHAFT "END PLAY", MUST BE THE SAME VALUE BEFORE AND AFTER THE TORQUE CONVERTER IS MOUNTED TO THE ENGINE.
- ② — INSTALL THREE (3) STUDS — EQUALLY SPACED. TIGHTEN 33 TO 36 LBS. FT. [4,6-5,0 Kg-m] OF TORQUE.
- ③ — INSTALL RING GEAR — BY TAPPING LIGHTLY IN PLACE.
- ④ — INSTALL REMAINING STUDS. TIGHTEN 33 TO 36 LBS. FT. [4,6-5,0 Kg-m] TORQUE.
- ⑤ — INSTALL BACKING PLATE *
- ⑥ — LUBRICATE STUD THREADS, BELLEVILLE WASHERS & NUTS WITH S.A.E. #10 OIL.
- ⑦ — INSTALL BELLEVILLE WASHERS & ELASTIC STOP NUTS AS SHOWN, THEN TIGHTEN TO TORQUE INDICATED IN ILLUSTRATION BELOW.



* If the backing ring is to be replaced order Part No. 217598 backing plate.

