

**STEP 15:**

Torque button head screws in kitty-corner pattern to 80 inch. lbs. Check all to make sure none were missed.

**STEP 16:**

Apply 100 PSI of air pressure to the air port on the side of the fan clutch and remove cage nut.

**STEP 17:**

Apply small amount of 242 loctite to Jack bolt thread and thread.

**STEP 18:**

With 100 PSI of air applied, hand tighten fan mounting disc. Remember this is a left hand thread.

**STEP 19:**

Using proper tool, tighten Jack bolt to 100 ft. lbs.

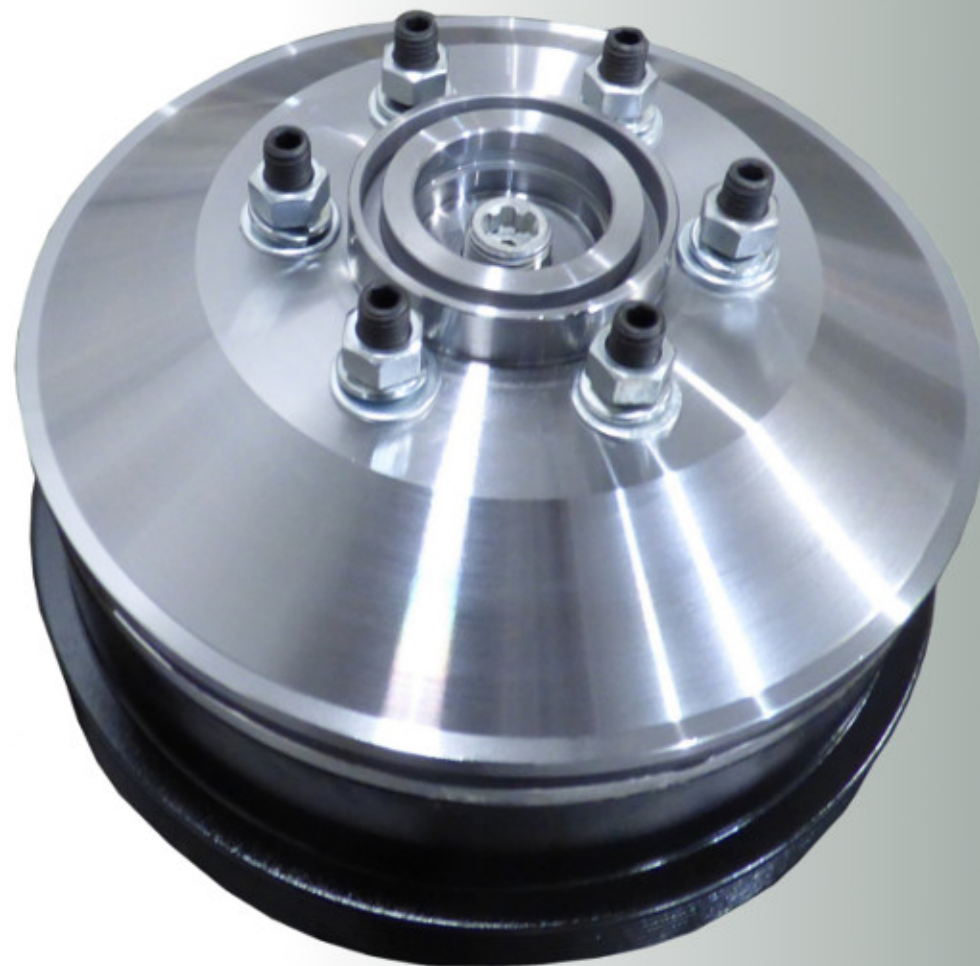
**STEP 20:**

Using 100 PSI of air pressure, apply and release two or three times. Be sure you have no air leaks and that the clutch completely engages and disengages.

**STEP 21:**

Be sure the fan stat and thermal switch are working properly to ensure your fan clutch will last and do its job. Protect your investment (Always check for air leaks in system)

Drivemaster Repair Kit Installation Instructions

**295568**

**STEP 1:**

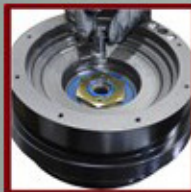
Lube inside surface so sheave bearing slides in easier. Fully support the sheave, then press bearing in all the way to the bottom. Be sure to use proper bearing combination so there is no play after the nut is tightened.

**STEP 2:**

When installing spacers, they need to be placed on top of the bearing. Spacers can vary in thickness but always need to be installed on the top of the bearing.

**STEP 3:**

Place appropriate bearing spacers on shaft then use 242 locktite on bearing nut, bevel down. Tighten bearing nut to 130 ft. lbs. Once again, check to see if you have any up and down play.

**STEP 4:**

Place o-rings on air cartridge and lubricate with o-ring lube. Be careful not to damage air cartridge surface.

**STEP 5:**

Install cartridge and lock in place with snap rin.

**STEP 6:**

Install face seal into air chamber cap. Be sure to lube o-ring and torque to 10 in. lbs.

**STEP 7:**

Install air chamber cap. Be sure to lube outside o-ring.

**STEP 8:**

Install lock clip to hold air chamber cap in place. Be sure lock clip is in gro

**STEP 9:**

Lube inside of sheave where large v-seal will be placed.

**STEP 10:**

Install large cup seal. Be sure the "V" of the seal faces down in the sheave.

**STEP 11:**

Lube inside of seal.

**STEP 12:**

Install clutch pack carefully making sure that the clutch pack is lowered evenly so seal is not pinched.

**STEP 13:**

Align holes for lining and be sure that the clutch pack is all the way down flush with top of sheave.

**STEP 14:**

After applying 242 locktite on button head screw threads, install in all 8 hole.