



## ***Ring Gear Mounting Instructions***

**Congratulations, you now have the finest flywheel in the world for both increased engine performance and crankshaft and bearing life!**

**Your flywheel requires mounting of the ring gear. A competent party with knowledge and experience in this area must do this work. The party installing the ring is responsible for this job.**

### **Ring Gear Removal**

- 1. Be sure to note which direction the ring gear tooth bevel is facing if it has one! The new ring must be installed with the bevel facing the same direction.***
2. Remove button head screws and washers securing ring gear.
- 3. Place the flywheel on a Press with a piece of steel under the teeth of the ring gear allowing room to press the flywheel down. Be sure the counter bores for the old mounting hardware are facing up!***
4. Press the flywheel down in evenly spaced steps all the way around the flywheel. Pressing evenly in steps will help ensure the ring gear doesn't shave material from the flywheel during removal.

### **Ring Gear Installation**

1. Heat new ring gear to 550 degrees Fahrenheit for 1 hour.
- 2. Slip new ring gear onto flywheel with the Bevel on the teeth facing the SAME DIRECTION as the previously installed ring gear*** to ensure proper starter engagement and disengagement.
- 3. Allow proper time for cooling of ring gear.***
4. Inspect the ring gear placement. Be sure it is seated completely against the shoulder of the flywheel. Use the Press to push into place if the ring gear is raised.
5. Use a 5/8" counter bore if the flywheel is drilled and tapped for 1/4-20 button head screws or a 7/16" counter bore if it is drilled and tapped for a 10-32 button head screws matching the depth from the previous counter bore that still remains in the flywheel.
6. Use the Loctite provided in the ring gear mounting holes and install the washers and button head screws provided to further secure ring gear. Allow time for Loctite to dry before you install the flywheel. This completes the ringing process.