

**IMPORTANT!**  
When replacing rear air fan clutches, always replace the pulley bearings at the same time.

Must have 90-120 psi going into the fan clutch to fully disengage.

## Rear Air Fan Clutch Installation Instructions

### REMOVAL OF OLD CLUTCH

1. Remove clutch to be replaced. There are 6 bolts that secure the clutch to the hub (pulley). These are Allen head bolts. Use a 5/16" Allen wrench to remove. There are 6 access holes in the front of the clutch that allow you to access and remove the Allen bolts. If the access holes are not aligned with the Allen bolts, you can apply air to the clutch to disengage it. Then rotate the hosing until the access holes line up with the Allen bolts for removal.
2. Remove the pulley from the bracket/shaft.
3. Remove the pulley bearings by following the directions included in the appropriate bearing kit (sold separately).
4. Clean and inspect the bracket shaft and the inside of the pulley.
5. Install the new pulley bearings by following the directions included in your bearing kit.

### REPLACEMENT

1. The airshaft (in the center of the pulley) should be wiped clean.
2. Remove the plastic coupling from the new fan clutch and place it on the airshaft of the hub. (see picture below)
3. Be sure the exposed o-ring, (located on the backside of your new fan clutch) that will be placed in the hub's airshaft, is lubricated and intact (it comes pre-lubed). Line up the slot on the shaft (on the new fan clutch ) so it will slip into the plastic coupling you have placed on the hub's airshaft.
  - i. The most common cause of premature failure is, during installation the exposed shaft o-ring is cut or nicked while placing the clutch onto the hub.
4. You will need to line up the mounting holes on the replacement fan clutch with the holes on the pulley.
5. Torque the 6 Allen head bolts to 45 lbs.-ft. (clutch to pulley)
6. Install fan on fan clutch. Torque to 26 lbs.-ft.

