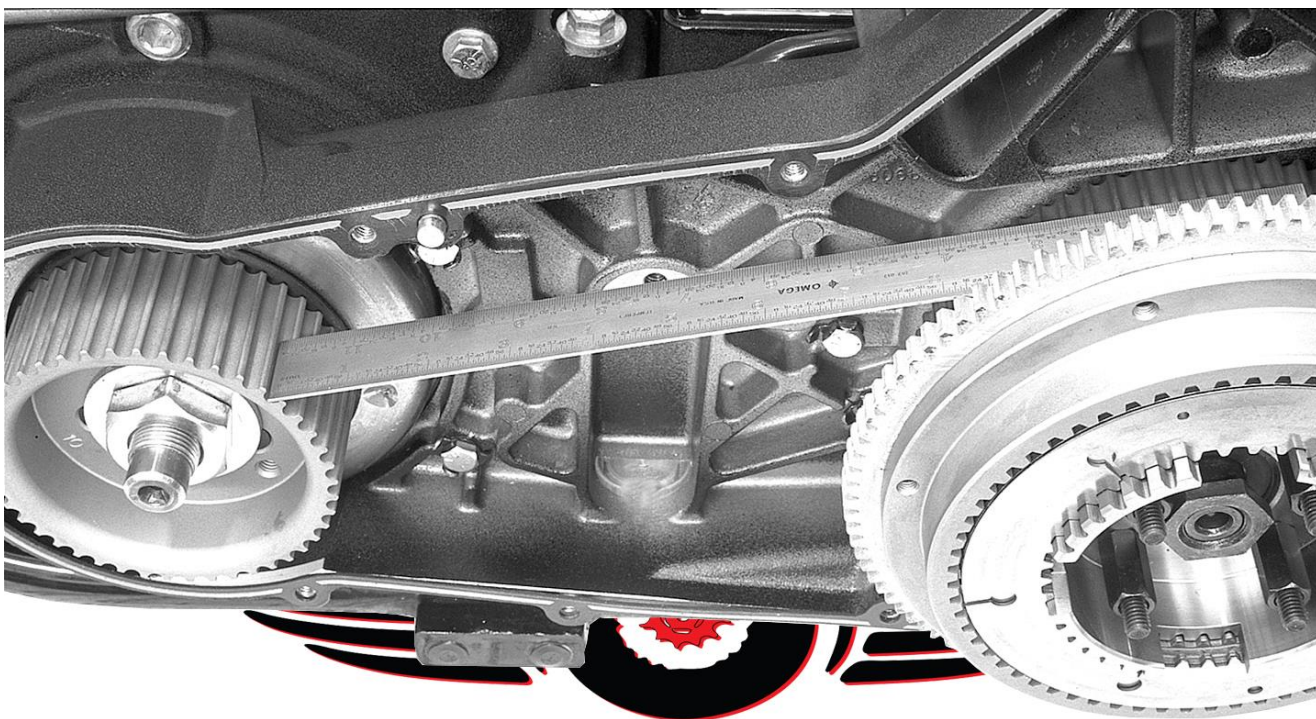


Belt Pulley Alignment by American Prime Mfg. Inc.

After installing and adjusting clutch, track the belt by turning the pulleys. If needed use a straight edge between the front and rear pulleys to check alignment. Improper alignment of the pulleys will result in reduced belt life. Spacing the motor pulley outward will cause the belt to track towards the outer primary cover. If spaced too far out the belt will rub on the inside of the clutch shell.

Before installing the primary cover be sure that everything inside clears both the outer and inner covers. In some cases a small amount of metal may need to be removed from one or more of the bosses on the inner or outer primary cover.



American Prime Mfg.

FREE PLAY: This term describes the amount of up and down movement in the belt taken at the center-top with a cold drive train. Both pulleys must be securely tightened ready to run. The correct way to measure free play is to grasp the belt top-center and push up and down using about 10 pounds of force. **The correct free play for enclosed installations is approximately 1/2"-3/4"**. Free play is critical. Both the pulleys and the primary cover expand under the influence of heat during normal operation.

VENTING: It is **highly** recommended that enclosed belt installations be vented to allow cool air to circulate into and out of the primary case. This will keep heat expansion to a minimum & extend belt life.