



INSTALLATION INSTRUCTIONS

Thank you for purchasing a Quarter Master bellhousing. Please take a few minutes to read through these instructions before you install your new Quarter Master OE Style Bellhousing.

THINGS TO CHECK BEFORE YOU BEGIN:

- With the bellhousing bolted to the engine, check that the transmission mounting face of the bellhousing is parallel to the crankshaft face within .006” total indicated run-out. Clean block mounting surface, making sure that it is free from nicks, burrs, paint, etc. Refer to Figure 2.
- The transmission mounting hole of the bellhousing should be concentric to the crankshaft within .006” total indicated run-out. *The closer, the better.* Refer to Figure 2. If the measurement is not within specification, you will need to relocate the dowel pins in the engine block.
- Quarter Master bell housings exceed both parallelism and concentricity requirements when new.

INSTALLATION:

- Refer to your release bearing installation instructions for release bearing clearance.
 - To mount the bellhousing and transmission, refer to Table 1 for bolt sizes and torque specifications.
1. Install the clutch and flywheel per manufacturer’s instructions.
 2. Set up release bearing clearance per manufacturer’s instructions.
 3. Set up starter clearance. Quarter Master recommends .100” +/- .040” pinion-to-ring gear clearance and .025” backlash (if adjustable).
 4. Install the bellhousing. Refer to Table 1 for bolt size and torque.
 5. Install the transmission. Refer to Table 1 for bolt size and torque.

Table 1: Recommended Bolt Sizes and Torques	Chevrolet	Dodge	Ford
Bellhousing Bolt Size	3/8-16	3/8-16	7/16-14
Bellhousing Bolt Torque	25-30 ft-lbs	25-30 ft-lbs	45-50 ft-lbs
Transmission Bolt Size	1/2-13	1/2-13	1/2-13*
Transmission Bolt Torque	70-75 ft-lbs	70-75 ft-lbs	70-75 ft-lbs*

Table 2: Bellhousing (with mounts) Part Numbers

Chevrolet	Dodge R3	Dodge R5	Ford
110107	110202	110206	110308
	110204		110309
	110205		

* Some Fords use 7/16-14 bolts, which would be torqued to 45-50 ft-lbs.

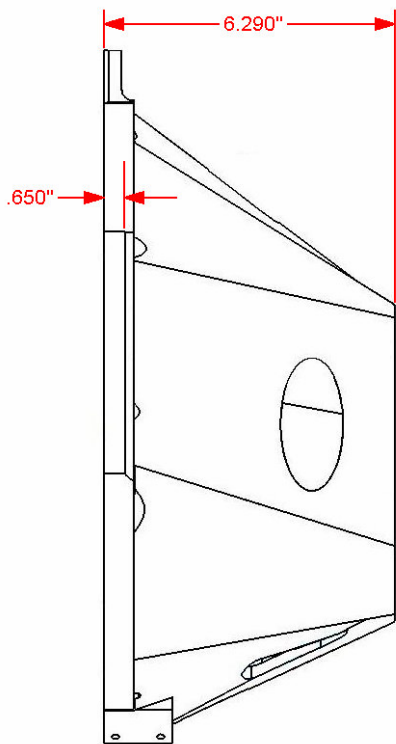


Figure 1: Side view of bellhousing

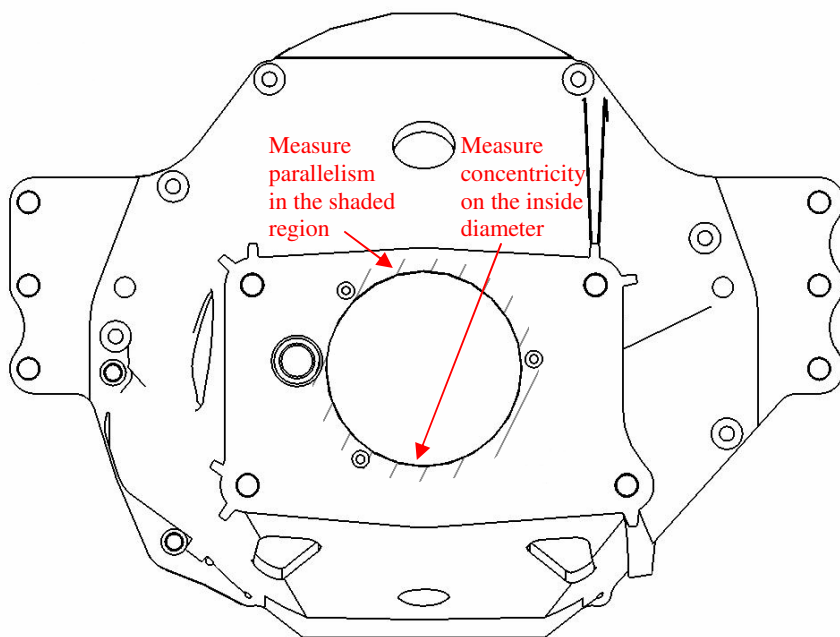


Figure 2: Back view of bellhousing

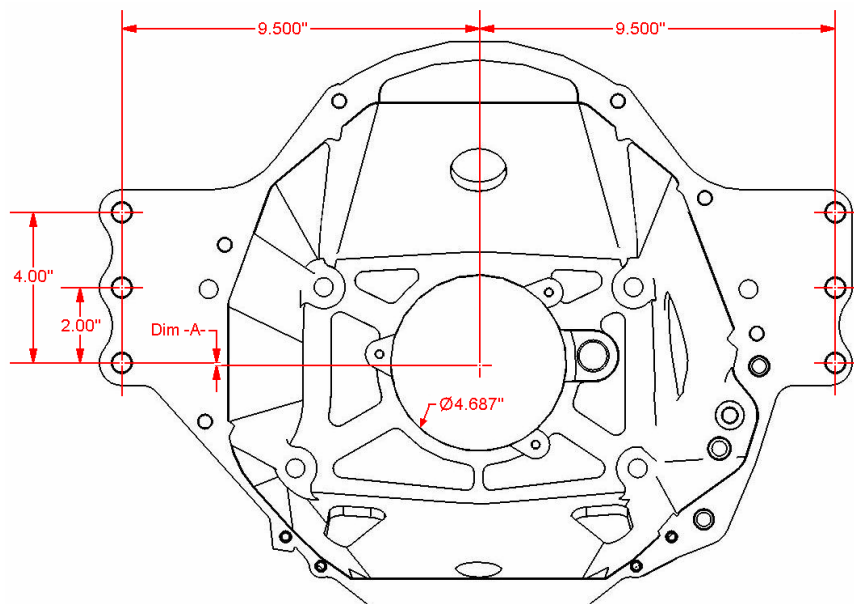


Figure 3: Front view of bellhousing

Table 3: Dimensions	Chevrolet	Dodge	Ford
Dim -A-	.00"	.00"	.30"