



INSTALLATION FOR 8MM & 11MM 4 & 5 SPEED DRIVES USING STOCK HD CLUTCH HUB AND CLUTCH CLOSED PRIMARY AND 2" and 3" OPEN DRIVES (1936-80 Models)

Be sure to read the [Warranty](#), [Introduction](#), [belt tracking](#) and [starter gear problems, alignment procedure](#) and disconnect battery.

CLOSED PRIMARY INSTALLATION:

1. Remove existing drive and inner primary per HD manual and install an R-16 sealed bearing in primary.
2. Grind any bosses or areas in the primary that may obstruct belt or pulleys from turning properly.
3. Check engine seal for oil leaks and replace if necessary.
4. Make sure motor and transmission shafts are square and parallel with each other.
5. Shut off primary oil and re-plumb oil lines.
6. Install rear pulley with belt on clutch hub and install on transmission shaft, (refer to HD manual). Install front pulley on engine shaft using belt guides supplied, spacing of the front pulley may be necessary for proper alignment.
7. Rotate motor by hand using a socket wrench, the belt should track straight and away from the motor.
8. For 11mm drives with idler, install plate and idler on existing serrated plate with idler under belt, proper tension of belt is 1/2" total up and down on top of belt and 1/4" on each side of idler.
9. Install clutch pack. (Refer to HD manual).
10. Install outer primary cover WITH gasket, tighten all bolts to HD specifications.
11. REMOVE PRIMARY OIL DRAIN PLUG AND LEAVE OUT. "When running an enclosed primary belt drive"

OPEN PRIMARY INSTALLATION: DISCONNECT BATTERY

1. Remove existing drive and remove inner and outer primary.
2. Install bearing support with bearing over transmission shaft and bolt to transmission.
3. Follow steps 3-7 and 9 above.
4. Replace or install all proper safety guards before operation of the vehicle.

