



## **BELT DRIVES LTD.**

### **PG-100A INSTALLATION INSTRUCTIONS**

Read complete instruction sheet before you begin installation



The PG-100A Pinion gear is 4.560" long and is an extended version for custom applications. There is no spring or internal spacer in the PG-100A kit. The PG-100A has (4) pieces to the kit.

The (4) pieces are:

- 1) The Pinion Gear.
- 2) The End Cap Reducer.
- 3) The 1/4-20 X 3.450" SHCS
- 4) The 10-32 X 3.450" SHCS.

The torque specifications on the SHCS or Allen Head Screws are as follows, the 10-32 X 3.450" is 3-5 Ft. Lbs. or 36 – 60 Inch pounds with some sort of Blue thread locker, the 1/4-20 X 3.450" is 10 -12 Ft. Lbs. or 120-144, inch pounds with some sort of blue thread locker on the threads. We suggest that you apply a dab of Anti-Seize on the end of the PG-100A that rides in the starter housing bushing.

You will need a 5/32" Allen wrench for the 10-32 screw. And a 3/16" Allen wrench for the 1/4-20 Allen head screw. Do Not over torque the screws as this can and will affect the pinion gear alignment to the starter ring gear and function of the starter if over tightened

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1, First take the (2) supplied SHCS and select the correct size that will screw into your starter motor. Set that screw aside to use later.



2, Apply a drop or two of the blue thread locker onto threads of the starter shaft of starter,



3, Insert the PG-100A pinion gear onto the starter shaft.



4, Insert the endcap reducer into the open end of the PG-100A.



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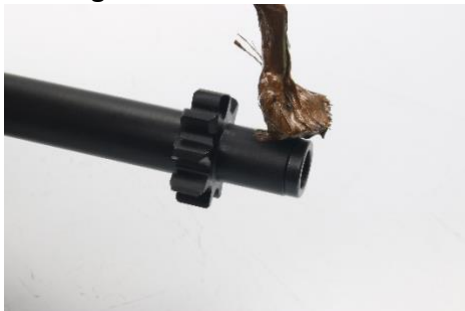
5, Insert the correct Allen Head screw "SHCS" into End Cap reducer and through the PG-100A  
And engage / start the threads.



6, using the correct size Allen wrench tighten the pinion gear Allen head screw



7, Apply a small dab of Anti Seize to the end of the pinion gear that rides in the starter housing bushing.



Complete the rest of the work and test the PG-100A alignment with start ring gear, and that you have good engagement with the ring gear.

Dated, 10-27-2021