



Installation Instructions

6747 Whitestone Road • Baltimore, MD 21207 • (410) 298-4343 • FAX: (410) 298-3579
www.atiracing.com

HIGH PERFORMANCE SPRAG ASSEMBLY FOR TF-904

Part # 905320

- | | |
|---|--|
| <input type="checkbox"/> 1 905330M Inner Race | <input type="checkbox"/> 4 Shoulder Bolts, 1/4" x 5/8" |
| <input type="checkbox"/> 1 905340 Outer Race | <input type="checkbox"/> 1 949131 Reamer |
| <input type="checkbox"/> 1 905345 Sprag | <input type="checkbox"/> Instruction Sheet |

Packed by: _____

This new ATI rear (low) clutch for the 904 is a 1000 FT LB element clutch and has 800% More contact area than the conventional roller clutch. It is retained to the case by 3-1/4 dowels and 4 -1/4 shoulder bolts that act as dowels and retain the outer race to the case.

To install:

- 1 Mill or drill the heads off the existing rivets.
- 2 Punch the rivets out. Remove and discard the OEM roller clutch and outer race.
- 3 Ream the holes .250" with the supplied reamer (in and out at low rpm)
- 4 Position the new outer race, aligning the holes in the race to the case
- 5 Install the 4 shoulder screws using red loctite and tighten.

On the transmission assembly use the supplied sprag clutch and inner race making certain it locks in the proper direction (counter clockwise). When looking in the case, the inner race will lock counter clockwise and spin free clockwise.