



# Installation Instructions

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## HEAVY DUTY REAR SPRAG ASSEMBLY FOR TF-904

Part # 905320 (4.810" OD)

### PACKING LIST

- |                                                             |                                                                  |
|-------------------------------------------------------------|------------------------------------------------------------------|
| <input type="checkbox"/> (1) #905330M Inner Race            | <input type="checkbox"/> (4) #959039 Shoulder Bolts, 1/4" x 5/8" |
| <input type="checkbox"/> (1) #905340 Outer Race For #905320 | <input type="checkbox"/> (1) #949131 Reamer                      |
| <input type="checkbox"/> (1) #905345 Sprag                  | <input type="checkbox"/> (1) #905320-I Instruction Sheet         |

Packed by: \_\_\_\_\_

The 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. ATI still recommends a Low Gear Band Apply valve body for higher HP and/or heavier cars.

**NOTE!** The outer race must be on center and FLAT in the case. Look for any casting protrusions or areas that may not allow the outer race to sit 100% flat. The race must be 100% on center with the governor support hole in the case or it will fail prematurely and the off centering will be easy to see as the outer race will be hurt on one side only.

To install:

1. ATI recommends this job being done on a mill with the case being indicated in place so that it is on center to the output shaft hole.
2. Mill or drill the heads off the existing rivets.
3. Punch the rivets out. Remove and discard the OEM roller clutch and outer race.
4. Ream the holes .250" with the supplied reamer (in and out at low rpm).
5. Stone / sand any and all pushed metal from the drilling and reaming until this area is perfect!
6. Position the new outer race, aligning the holes in the race to the case.
7. Install the 4 shoulder screws using red Loctite and tighten.

### **Double check the rotation!**

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. Pre-lube the sprag and race before final assembly.