

## MEASURING COLLAR LENGTH FOR TRIMMING AS NEEDED

Some 5 and 6 speed applications dual disc require trimming the input collar to clear the hub on the top disc for dual disc clutches. This is the procedure to measure and trim.

## TRANSMISSIONS THAT SEPARATE FROM THE BELLHOUSING

1. With the transmission removed but bellhousing installed, use a straight bar to measure from the bellhousing face to the top of the clutch disc hub near the splines (A).
2. On the transmission, measure from the end of the collar where the input shaft protrudes, to the face of the transmission where it mates to the bellhousing face (B).
3. Subtract the B measurement from the A measurement. If the B measurement is a negative number or less than .100", the collar end will need to be trimmed. Determine the material to be removed and allow for a minimum of .100" clearance between the end of the collar and the hub of the top disc.
4. The best method to remove this material is to put the collar in a lathe and cut it back.

## TRANSMISSIONS THAT DO NOT SEPARATE FROM THE BELLHOUSING

1. Using a typical hydraulic setup guide sheet ([https://d1ai84il7jig74.cloudfront.net/2019/12/b1002-1a\\_worksheet.pdf](https://d1ai84il7jig74.cloudfront.net/2019/12/b1002-1a_worksheet.pdf)), determine the A + C measurement for the clutch height from the back of the block.
2. Measure from the fingers of the clutch to the top of the disc hub, near the splined area (E.)
3. Subtract this E number from the A+C to determine the distance from the back of the block to the top of the splined hub.
4. Measure from the bellhousing face on the transmission to the top of the quill tube or collar on the transmission (F.)
5. Subtract the F measurement from the E measurement. If the result is a negative number, the input collar/quill will need to be trimmed to allow for a minimum of .100" clearance between the tube and the top disc hub.
6. The best method to remove this material is to remove the transmission front plate and press the quill tube out to trim in a lathe. Alternatively it can be cut back with a cutoff wheel but EXTREME care must be exercised not to damage the input shaft.

