



## Mid-USA Part # 75834

# Manual Primary Chain Adjuster Installation Instructions

1. Remove the two screws mounting the OE automatic tensioner from the primary case. Remove the tensioner. Save the two screws.
2. Install the lower adjuster from the kit using two screws from previous tensioner. Tighten screws to (21-24 ft-lbs).
3. Install the upper adjuster with shoe. Install the two hex cap screws through the lock plate and the side plate, loosely assemble to upper adjuster
4. Check the primary chain tension. Push on the upper strand to verify that it has free up and down movement midway between the engine compensation sprocket and the clutch sprocket.
5. Measure the free play to be sure that it falls within the range specified for a hot or cold engine.

**NOTE:**

To prevent primary drive damage, remove adjustment screw from tensioner when adjustment is complete.

6. Using a ball end hex driver for the socket head cap screw, adjust the chain tension to specifications.
7. Tighten side plate screws to (55-60 in-lbs). Bend a tab of the lock plate for each hex cap screw choosing a tab that is closest to a flat on head of the hex cap screw.
8. Remove the adjuster screw after tightening and save the screw to reuse.

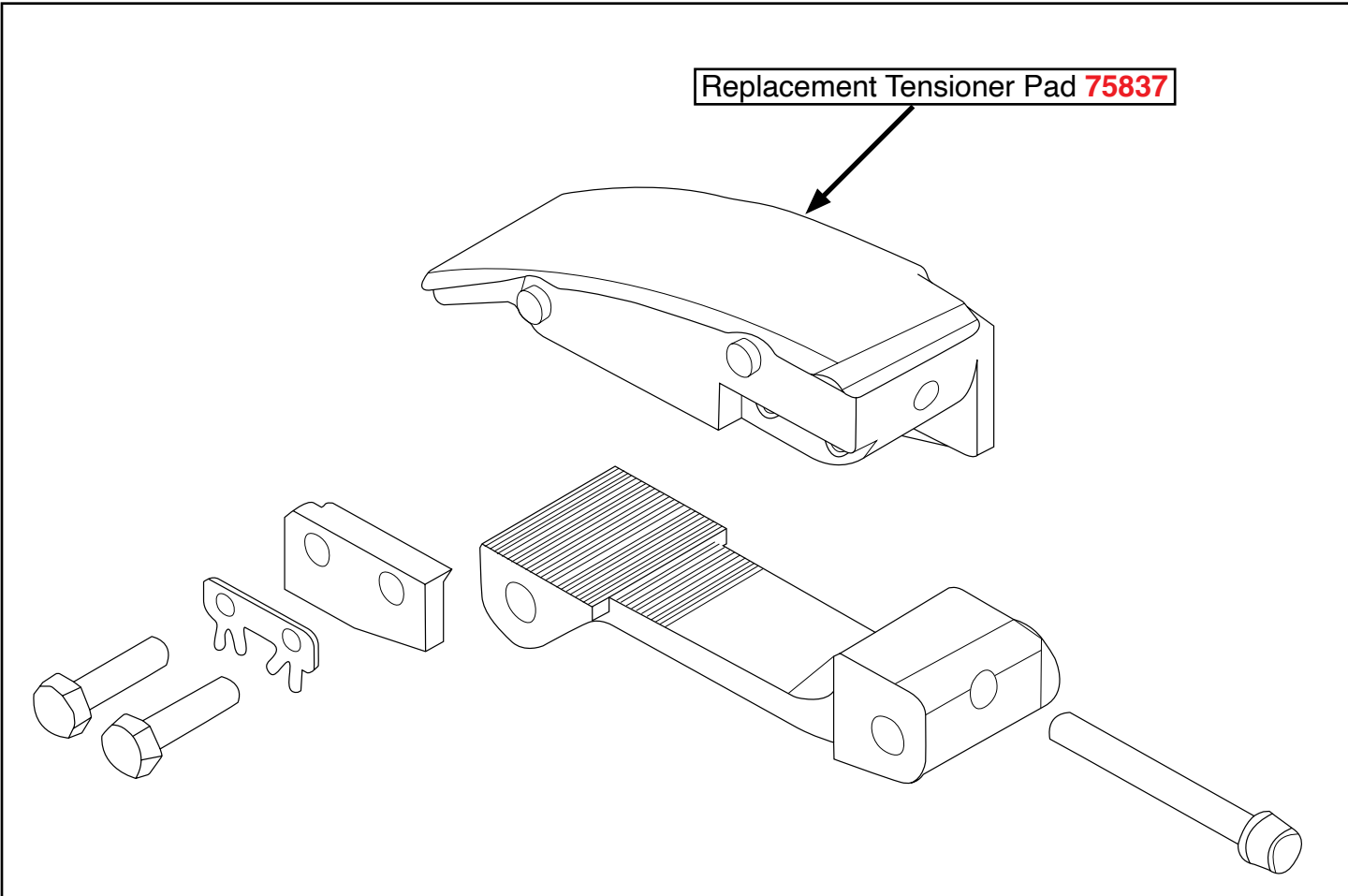
**NOTE:**

As chains stretch and wear, they run tighter at one spot than another. Always adjust free play at the tightest spot in the chain. Replace the primary chain if it is worn to the point where it cannot be properly adjusted.

Always keep the primary chain properly adjusted. Allowing the chain to run too tight or too loose will result in excessive chain and sprocket wear.

9. Replace the primary cover and fill with lubricant as needed.

Replacement Tensioner Pad **75837**



<b>FREEPLAY</b>	<b>INCHES</b>	<b>MILLIMETERS</b>
Cold Engine	5/8-7/8 inch	15.9-22.2 mm
Hot Engine	3/8-5/8 inch	9.5-15.9mm