



INSTALLATION INSTRUCTIONS FOR *HI-TORQUE™ STARTER* *BELLHOUSING MOUNT*

REMOVAL OF THE ORIGINAL STARTER

1. **CAUTION!** Before proceeding, the negative (-) or ground terminal **must** be removed from the battery. Failure to do so can result in damage to the vehicle and/or injury to the installer!
2. Remove the large cable from the starter motor.

Remove the two (2) mounting bolts holding the starter to the engine. Keep these for re-use.

INSTALLATION OF THE *HI-TORQUE* STARTER MOTOR

1. Run an appropriate tap through the mounting bolt holes to clean out any grease or debris.
2. Hold the starter motor temporarily up into position on the mounting bellhousing, and between the headers/exhaust system. Rotate the starter until you have roughly equal clearance on both sides of the motor. Using a felt tipped marker, mark across the mounting plate and the body of the starter motor. Remove the starter motor and the mounting plate from the engine. Position the mounting plate onto the starter motor. Install the two 5mm allen screws into the pair of holes which allow the closest alignment of the previously made marks. Using a metric allen wrench, temporarily tighten the bolts.
3. End clearance between the ring gear and the pinion gear teeth in the retracted position is critical. On the *Hi-Torque* starter, the pinion gear extends past the mounting plate flange by $\frac{1}{2}$ " in the retracted position. The distance from the motor mount plate to the front edge of the ring gear must be measured. Calculate the clearance by subtracting $\frac{1}{2}$ " from this dimension. If you are using the spacer in your installation, then subtract an additional 0.4". The clearance should be between .040" to .100". If the measurement is less than this, you will have to add a circular shim (supplied with the starter) between the starter motor and the mounting plate. Each shim is .074" thick. After determining the proper number of shims, apply **LOCTITE® 262** (or equivalent) to the bolts and tighten them to 95 IN/LBS. We recommend that you use a 4mm or 5mm hex driver with an inch pound torque wrench to do this.
4. Using the original mounting bolts, install the starter motor. Tighten the bolts evenly to 25 FT/LBS.

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