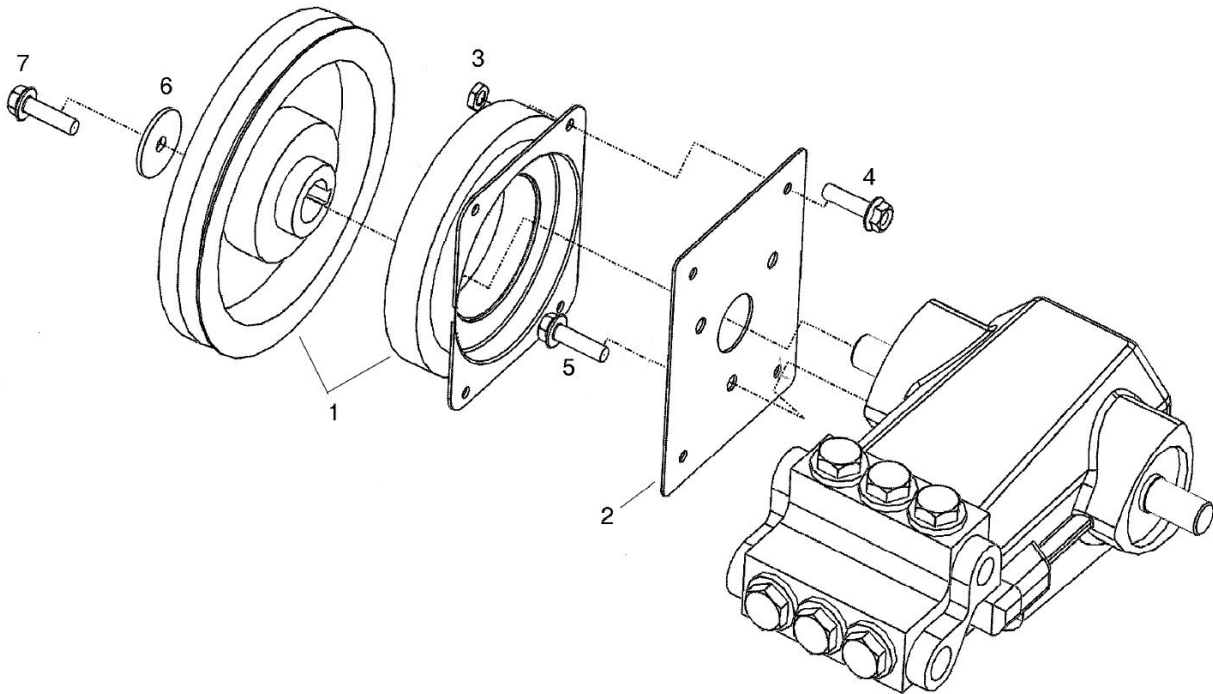


# Instructions for 23920 clutch assembly (For P54, P55, P56, P58 and P59 pumps)

## Parts List

Item #	Part #	Description	Qty
1	06429	24mm Clutch	1
2	06387	Mounting Flange	1
3	06522	1/4-20 Hex Nut	4
4	10440	Hex Screw	4
5	07544	Socket Head Screw	3
6	05626	Fender Washer	1
7	08198	M8-1.25 Screw	1



## Assembly Instructions

1. With a Phillips-head screwdriver, remove the existing bearing cover screws.
2. Place the mounting plate (2) over the crankshaft and secure with screws (5).
3. Secure clutch (1) to mounting flange by sliding clutch over crankshaft\* and attaching with screws (4) and hex nuts (3). Secure set screw on pulley shaft.
4. Thread the M8-1.25 screw (7) and Fender Washer (6) over the hub of the clutch (1) into the crankshaft of the pump.
5. Attach lead wire to (+) or pressure flow / switch as desired.
6. Attach "A or AX section" belt of required length
7. Engage and disengage the clutch several times to ensure it is functioning properly. If full torque will be required from the pump immediately, the clutch should be properly burnished. (Burnishing involves cycling the clutch at a reduced speed not more than 4 times per minute so the surfaces can mate together. In most applications, 20-50 cycles are required for burnishing.)  
\*If clutch does not easily slide onto the crankshaft, use a honing tool on the inner diameter of clutch.

**NOTE:** If an operation manual is needed for the above pump models, please consult your local distributor.