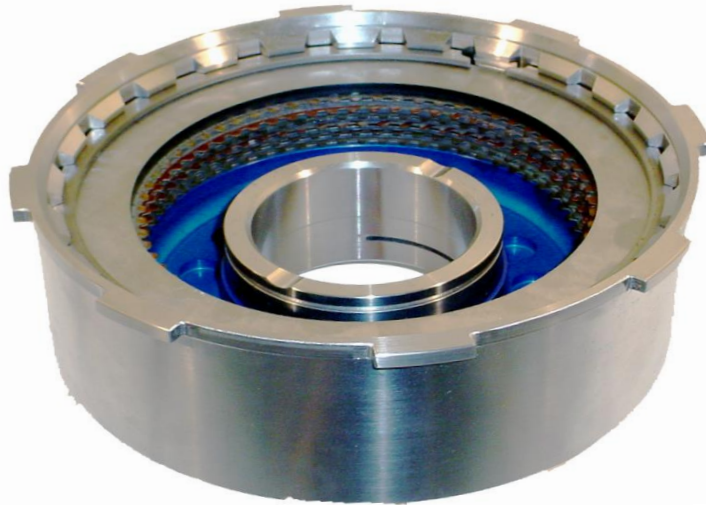




INSTALLATION INSTRUCTIONS

PART #: K123900, K123900S, & K123900AS
727 Front Drum

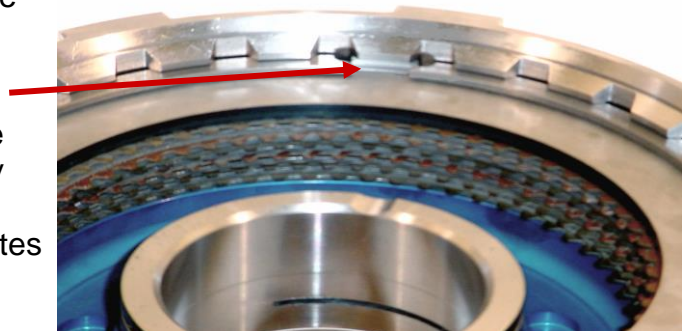
Congratulations on your purchase of our **Super 727 Front Drum Kit**. We at TCS strive to build Performance products that are superior to any other on the market today. **TCS BUILT BEST – BACKED BEST**. The following information will aid you in the installation of your **727 Front Drum Kit**.



Step 1 Decide if you are going to install 5 or 6 Friction Plates. Note: the Pressure Plate supplied with the Kit is to be used when **installing 6 Plates**

Step 2 Stack your frictions and steels, and complete the stack with your pressure plate and retaining snap ring

Step 3 Check the clearance with a Feeler Gauge by inserting the gauge between the Snap Ring & Pressure Plate. The Industry Standard gap is to have .010" Clearance **Per Friction Plate** i.e. if you've used 5 plates the minimum clearance should be .050", 6 plates would then be .060" (6 x .010).



Step 4 If your clearance is too loose (greater than .050" – 5 plates or, .060" – 6 plates) then add an additional Steel Plate and re-check the clearance.

TCS TRANSMISSION PRODUCTS

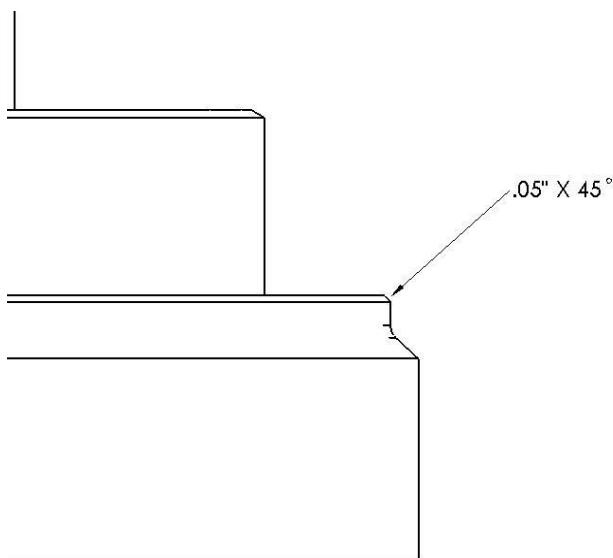
Phone: (604) 533-8675 Toll Free: 1-800-960-1177

E-Mail: sales@tcsproducts.com www.tcsproducts.com

Step 5 Assemble the Front Drum over the Rear Drum to insure no contact – see step 6

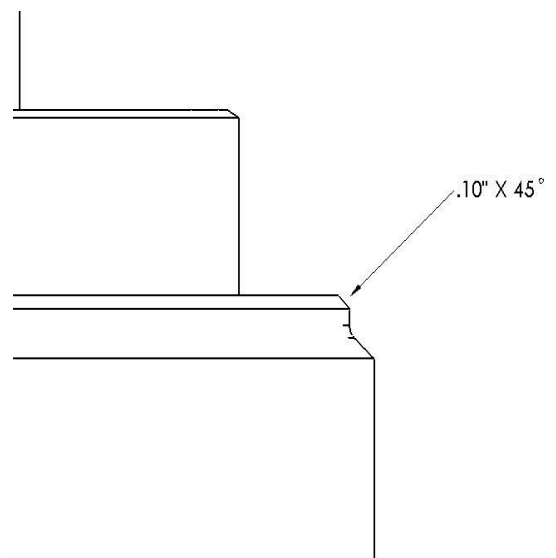
Step 6. HOW TO ENSURE YOU HAVE THE CORRECT CLEARANCE

- 1 Assemble the empty Direct (Front) Drum over the Forward (Rear) Drum, ensuring that the selective washer is in place.
- 2 Looking down at the center of the Aluminum Direct (Front) Drum, ensure that the Drum is contacting and is supported by the Fiber Washer. The Forward (Rear) Drum should rotate smoothly and not wobble.
- 3 If the Direct Drum contacts the Forward (Rear) Drum and is not supported by the Fiber Washer you must either;
 - a. Have the transition on the Forward (Rear) Drum machined with a larger chamfer (see diagrams below) enough to allow complete contact or,
 - b. use a later model or Type II (see below) Forward (Rear) Drum.



Type I Forward (Rear) Drum Design

Drum chamfer is **.050"** x 45°, which is not enough clearance to ensure a proper fit



Type II Forward (Rear) Drum Design

Necessary size of chamfer **.100"** x 45 deg

Thank you for buying TCS if we can be of any more assistance to you, please call us anytime. We're happy to hear from you.

Have a great Race Season and Good Luck from all of us at TCS Products. Be sure to give us a follow on Facebook and/or Instagram!

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