



PRW INDUSTRIES, INC.
1722 ILLINOIS AVENUE
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PQ SERIES SFI FLUID DAMPER INSTALLATION INSTRUCTIONS

PARTS LIST	
ITEM	QUANTITY
<i>Vibration Damper</i>	<i>1 each</i>
<i>SFI 18.1 Certification Sticker</i>	<i>1 each</i>

Step 1

Make certain the engine is cold.

Step 2

Line up the TDC mark on the damper with the timing tab before removal. Then, pull the original damper from the crank snout using your damper removal tool. If marks don't line up after the new damper is installed, you will need to get an aftermarket bolt-on timing tab.

Step 3

Check the end of the crank to ensure the crank has a tapped hole and that the threads are clean and not damaged. If the damper bolt does not thread easily into the crank, run a tap into the threads to clean them up.

Step 4

Examine the key. If it is damaged or loose in the keyway, replace it. Make sure the key does not sit too high in crank.

Step 5

Replace the oil seal in the front timing cover. This is optional but highly recommended.

Step 6

For external balanced engines remove the outer ring from the hub, then balance. After balancing is complete, the damper ring can be re-installed. Be sure to properly torque all bolts.

P/N's 2540001 & 2540011: 28 foot-pounds

P/N's 2545401 & 2545411: 38 foot-pounds

P/N's 2530201, 2530211, 2530202, & 2530212:

24 foot-pounds

Step 7

For internal balanced engines balance the assembly without the damper. The inertia ring inside is balanced at a close tolerance to the OE specs.

Step 8

Use emery cloth to remove burrs, nicks, and sharp edges on damper snout and any sharp keyway corners.

Step 9

Prior to installation heat the damper in boiling water or place in a preheated oven at a maximum of 250° Fahrenheit for 15 minutes. Use insulated heatproof gloves to handle after heating.

Step 10

Apply an anti-seize compound on crankshaft snout and in the damper hub.

Step 11

Position the damper on the crank snout. Rotate to align the keyway in the damper precisely with the key in the crank.

Step 12

Install the damper using the proper installation tool. Do not "hammer" the damper on. (this will void the warranty) You should meet smooth steady resistance until the damper is fully seated against the timing gear or spacer.

Step 13

Install damper bolt and washer to proper torque specs.

Small Block Chevy: 70 foot-pounds

Big Block Chevy: 110 foot-pounds

Ford: 110 foot-pounds

Mopar: 150 foot-pounds

Pontiac, Oldsmobile, & Buick: 160 foot-pounds

Timing Check

Step 1

Check the ignition timing marks. Note: some engines have been equipped with different timing tabs over the years.

Step 2

Use the positive stop method to locate the true TDC (Top Dead Center). Relocate the timing tab if necessary.

Limited Warranty

Performance Quotient and PRW Industries, Inc. ("PRW") warrants that all of its products are free from defects in material and workmanship, and against excessive wear for a period of (1) one year from the date of purchase. This **limited warranty** shall cover the original purchaser.

PRW's obligation under this warranty is limited to the repair or replacement of its product. To make a warranty claim, the part must be returned within (1) one year of purchase to the address listed below, freight prepaid. Items covered under warranty will be returned to you freight collect.

It is the responsibility of the installer to ensure that all of the components are correct before installation. PRW assumes no liability for any errors relative to tolerances, component selection, or installation.

There is absolutely no warranty on the following:

- i. Any parts used in racing applications, or;
- ii. any product that has been physically altered, improperly installed or maintained, or;
- iii. any product used in improper applications, abused, or not used in conjunction with the proper parts.

There are no implied warranties of merchantability or fitness for a particular purpose and no warranties which extend beyond the description of the face hereof.

PRW will not be responsible for incidental and consequential damages, property damage or personal injury damages to the extent permitted by law. Where required by law, implied warranties or merchantability and fitness are limited for a term of (1) one year from the date of original purchase. This warranty may give you specific legal rights. You may also have other legal rights, which vary from state to state.

Pulley Installation

Step 1

Install the pulley onto the damper with damper or pulley mandrel. If mandrel is not used this could lead to side loads on the crankshaft. If necessary, drill new bolt holes in the pulley. Do not drill new holes in the damper. This could lead the damper to leak and void the warranty.

Notes: 1) P/N's 2545501 & 2545511 do not match stock pulley holes. For matching pulley refer to March Performance P/N 13041, and 2) P/N's 2539001 & 2539011 require aftermarket pulleys. Please refer to March Performance P/N 1971 for 1V pulley, P/N 1973 for 2V pulley, P/N 1975 for 3V pulley.

Step 2

Hand turn crank to insure there is no wobble to the damper or pulley.

If you need technical information, or additional information regarding the installation of this product please call us.

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