

# SUPERCHARGER PULLEY REPLACEMENT PROCEDURE

**NOTE:** Removing the original ATI installed pulley will void your supercharger warranty! Review the warranty information in your owner's manual for further details or contact ATI's Technical Service Department.

## WARNING

It is very important that you do not exceed the maximum impeller rpm of your supercharger. For information regarding maximum impeller rpm's refer to your owner's manual or contact ATI's Technical Service Department.

Never strike the supercharger pulley with a hammer or other object when removing or installing the pulley. Such impact can damage the supercharger bearings.

Never pry on the pulley as damage to the input shaft seal can occur. Using heat resistant gloves (or similar) remove the supercharger pulley and set aside to cool. Caution: Input shaft of supercharger will be hot!

## ON CAR PROCEDURE

1. With the belt still installed, loosen the pulley bolt using the appropriate sized socket (9/16" for P series, 5/8" for SC, D, & F series). If unable to loosen the bolt, it may be necessary to use an impact wrench. Remove bolt and washer.
2. Note the installation orientation of the pulley. Some applications use offset pulleys or shims behind the pulley. Correct orientation is important to maintain proper belt alignment.
3. Remove pulley. If pulley does not easily slide off of input shaft, using a propane torch, apply heat to the front of the pulley in a circular pattern around the hub of the pulley. It usually takes 1 to 5 minutes of heating in order to loosen the pulley.  
**Warning: Do not pry on pulley as damage to the input shaft seal can occur. Using heat resistant gloves (or similar) remove the supercharger pulley and set aside to cool. Caution: Input shaft of supercharger will be hot!**
5. After input shaft has cooled, remove old key(s), clean shaft and install new key(s) into keyway(s).

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6. Install new pulley, lining up the keyway(s) in pulley with key(s) on the shaft. If new pulley does not easily slide on the shaft, heat the new pulley around the hub with a propane torch (or in an oven at 300 deg.) for 2-3 minutes. Using heat resistant gloves (or similar) install new pulley, lining up keyway(s) in pulley with key(s) on shaft. Warning: Never strike the supercharger pulley with a hammer or other object when installing the pulley. Such impact can damage the supercharger bearings. Allow pulley to cool.
7. Re-install drive belt.
8. Apply thread locker (Loctite<sup>®</sup> 262 or similar) to pulley bolt and re-install bolt and washer. Torque bolt (40 lb-ft for P series, 60 lb-ft for SC, D, & F series).

## OFF CAR PROCEDURE

1. Using an impact wrench, loosen the pulley bolt using the appropriate sized socket (9/16" for P series, 5/8" for SC, D, & F series). Remove bolt and washer.
2. Note the installation orientation of the pulley. Some applications use offset pulleys or shims behind the pulley. Correct orientation is important to maintain proper belt alignment.
3. Remove pulley. If pulley does not easily slide off of input shaft, using a propane torch, apply heat to the front of the pulley in a circular pattern around the hub of the pulley. It usually takes 1 to 5 minutes of heating in order to loosen the pulley.  
**Warning: Do not pry on pulley as damage to the input shaft seal can occur. Using heat resistant gloves (or similar) remove the supercharger pulley and set aside to cool. Caution: Input shaft of supercharger will be hot!**
4. After input shaft has cooled, remove old key(s) and install new key(s) into keyway(s) on input shaft.
5. Install new pulley, lining up the keyway(s) in pulley with key(s) on the shaft. If new pulley does not easily slide on input shaft, heat new pulley around the hub with a propane torch (or in an oven at 300<sup>∞</sup>) for 2-3 minutes. Using heat resistant gloves (or similar) install new pulley, lining up keyway(s) in pulley with key(s) on shaft. Warning: Never strike the supercharger pulley with a hammer or other object when installing the pulley. Such impact can damage the supercharger bearings. Allow pulley to cool.
6. Apply thread locker (Loctite<sup>®</sup> 262 or similar) to pulley bolt and re-install bolt and washer. Torque bolt (40 lb-ft for P series, 60 lb-ft for SC, D, & F series).