



Star Machine
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INSTRUCTIONS
ACCESSORY DRIVE MANDREL
#STR.04.07.000

This mandrel is another example of Star Machines' continuing effort to supply the motor sports industry with only the finest components.

The mandrel contains a Chevrolet bolt pattern and should fit any BB balancer with or without an MSD trigger wheel or a small block with a trigger wheel. The machined diameter found on the rear of the mandrel must fit neatly into the balancer or the trigger wheel in order to insure that the mandrel runs true on center.

A traditional balancer retaining bolt and washer MUST be used to properly secure the balancer before attaching the mandrel. When installing the mandrel be sure that the balancer retainer bolt does not come in contact with the relieved area in the rear of the mandrel preventing it from sitting flush with the balancer or crank trigger.

If you are using the optional V belt pulley, the pulley must be attached to the mandrel before installation using ALL six flat head screws provided. We highly recommend these screws be installed with Loctite.

INSTALLING ADDITIONAL PULLEYS

The mandrel is supplied complete with all necessary hardware, spacers, 1 1/4" hex hat nut and one pulley flange to accommodate one Star Machine vacuum pump pulley (supplied separately). We recommend that any pulleys used on this mandrel be placed as close to the balancer where possible. Since it is known that some external oil pumps can require as much as 10 HP to turn, we highly recommend that any pulley placed on this mandrel to drive an external oil pump be placed closest to the balancer. Since the mandrel is splined the entire length to accommodate the corresponding splines found in the hex hat nut and the hole for the hat nut retaining bolt is tapped 3 5/8 " deep, the mandrel can be shortened if necessary without having to re-machine either of these features.

The long black spacer can be shortened to accommodate other pulleys and/or pulley flanges. When shortening the mandrel, remember that when assembled, the inside of the hex hat washer MUST NOT bottom out on the face of the mandrel. Star Machine recommends a gap of .050" be maintained in order for all components on the mandrel to be tightly squeezed together when tightening the hex hat nut retaining bolt. The key must also be shortened and NEVER come in contact with the face of the flange on the hex hat nut. Loctite should be used on the hex hat nut retaining bolt at final assembly.

The 7075 hard coated and splined hex hat nut can now be used confidently for years to rotate the engine in either direction without loosening or over tightening a long crank bolt. Additional pulley flanges and other components are available from Star Machine. These instructions as well as instructions for all Star Machine products are available on our web site.

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