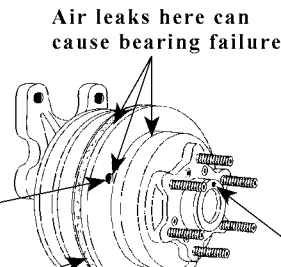


BEFORE REPLACING A HORTON FAN CLUTCH DETERMINE THE CAUSE OF PREVIOUS FAN CLUTCH FAILURE.



EMERGENCY OPERATION ONLY.

Align two holes in clutch disc with two holes in sheave. Install two Grade 8 5/16-18 x 1" bolts tighten to 25 ft. lbs.

Friction Disc Lining

Replace Clutch when worn to 1/16" thick

Air leaks here can cause bearing failure

Air leaks here when cartridge is bad.

Check Clutch plate for discoloration and / or blistered paint. Sign of clutch slippage, can cause bearing failure, replace clutch.

| Problem | Result | Check and Correct |
|----------------------------|--|--|
| Low air pressure to clutch | Causes clutch to slip excessively, resulting in abnormal heat, causing seals, bearings and clutch friction disc to glaze over and / or deteriorate, and abnormal clutch plate wear. | 90 PSI of air pressure minimum at clutch is required. If lower check for, A. Restricted air line. B. Restricted air solenoid. C. Low system air pressure, check for leaks. |
| Excessive clutch cycling | Causes clutch to create excessive heat to clutch plate and friction disc. This heat is transferred to the seals making them hard and brittle and lose their sealing capacity. This heat is also transferred to the bearing causing the grease to turn into a liquid and evacuates all lubrication from the bearing. Both cause premature clutch failure. | Thermal Switch setting should engage the clutch 10 degrees higher than the full open temperature of the thermostat. A. Check A/C freon for overcharge. B. Check A/C switch, pressure setting too low. C. Check switches for proper ground and other electrical connections for current. D. Check for proper shutter operation or other restrictions in front of radiator. E. Replace faulty thermal switch. |
| Fan clutch fails to engage | Engine over heats | ** Check thermal switch *N/O or *N/C application, should be opposite of solenoid valve. A. Check electrical connections. B. Check wiring according to diagram. C. Test solenoid valve. D. Replace thermal switch. E. If parts are not available you can lock the clutch into its engaged position temporarily by following the emergency operation only procedure. Plug air line going to clutch and check for air leaks. Repair As Soon As Possible. |

* N/O = NORMALLY OPEN
* N/C = NORMALLY CLOSED