Rapid Hawk Clutch Retrofit Kit

Assisted Tube Rolling System



Clutch Retrofit Installation Instructions



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Disassembly of Powerhead

1. Remove the four screws from the lower guard using a 3/16" hex key.



2. Remove the 6 screws using a 5/32" hex key from both side covers to expose the transducer and motor shaft inside the housing.



3. Unscrew the transducer cable and move out of the power head.



4. Loosen both motor mount screws using a 5/16" hex key and slide the motor out the back of the power head. Ensure that the transducer stays forward on the front drive shaft while removing the motor.



5. Remove both nuts on the transducer retention bracket using a 1/2" wrench and slide off the bridge piece.



6. Slide the transducer off the front drive shaft and remove from the power head.



7. Unscrew transducer retention bracket 1/2" hex bolts from the nuts retained in the front face plate. Remove the bolts, nuts, and sleeves from the front face plate.



8. Unscrew the locknuts on the motor mount at the rear of the powerhead using a 9/16" wrench, then unthread the bolts from the back plate of the powerhead. Note that the holes in the back plate are threaded and the bolts should be removed after the nuts.



Clutch Retrofit Re-assembly

1. Using the included 3/8"-16 x 2-3/4" socket cap screws stack the new motor mount spacer onto the motor mount. Install the bolts into the same hole set they were disassembled from on the back plate using a 5/16" hex key.



2. Assemble the clutch, clutch adapter, and 3/16" x 3/16" x 1" key together to the transducer. Assemble the transducer bracket with the included M4 x 12mm socket cap screw and 4mm stainless flat washer. Leave the screw loose enough to rotate the bracket around during assembly.



3. Install the clutch assembly and transducer on the front drive shaft. The transducer needs to be installed with the cable connection pointing down.



4. Rotate the transducer bracket to align the mounting hole to the threaded hole on the back plate and install the 3/8"-16 x 3/4" socket cap screw using a 5/16" hex key and tighten hand tight being careful not to crush the mount.



5. Side motor into the motor mount on the back of the power head taking care to align the square drive on the motor with the square drive on the transduce.



6. Align clutch, transducer, and drive shafts until seated with minimal gap between each piece and tighten the motor mount screws with a 5/16" hex key followed by the transducer mount screw with a 3mm hex key.



7. Attach the transducer cord to the port on the transducer and tighten the cable nut.



8. Attach both side panels to the power head and tighten all 6 cap screws per side firmly using a 5/32" hex key.



9. Attach the new bottom plate taking care to align the indented portion and notch of the bottom plate to the rear of the power head and projected cable and tighten the four screws using a 3/16" hex key.



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