



Manufacturing & Parts Co.
American Made Clutches Since 1967

AMERICAN MADE

We take pride in being the last American made heavy duty clutch manufacturer that produces its' own friction material. We have worked hard and smart, keeping our product quality high and our prices low.

Want to save American Jobs? Choose Ace.

1-800-325-6138

Ace Manufacturing & Parts Co., 300 Ramsey Street, Sullivan, MO 63080
www.ace-mfg.com

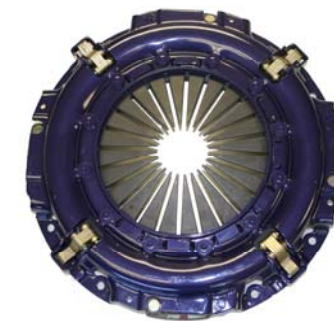
ACE MANUFACTURING
PRESENTS...

PATENTED



TECHNOLOGY

CENTRIFUGAL ASSIST CLUTCH



1-800-325-6138

Revised 7/1/09

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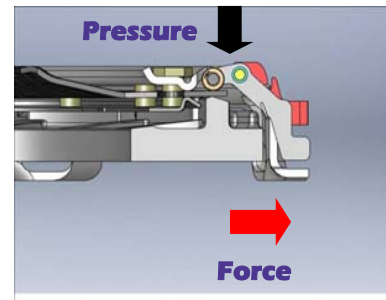
WHAT IS POWERFORCE TECHNOLOGY?

Ace **POWERFORCE** is a new clutch line that offers drivers increased clutch performance without increasing clutch pedal effort. This borrows from the technology and our 15 years experience of designing and producing ultra high performance drag racing clutches for NHRA racers.

HOW DO WE DO THIS?

Centrifugal Force.

Our clutches increase pressure plate load as the engine increases RPM. As the engine speeds up, our patented lever assist technology pushes down on the pressure plate increasing plate loads by 15% or more.



As the engine spins, forces are exerted outward; the same way spinning in a circle causes a person's arms to raise from their side. Our levers experience the same force and the outer edge of the lever gets pulled away from the clutch as the engine spins faster. This causes the lever to rotate on a pivot point and push on the pressure plate resulting in a greater pressure plate load to help keep the clutch from slipping. This combined with Ace's superior friction materials on our heavy duty clutch discs makes Ace **POWERFORCE** the logical, affordable choice for towing and high performance applications.

300 Ramsey Street, Sullivan, MO 63080 Ph. (573)468-4181 Fax (573)468-5584

Toll Free(800)325-6138

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ACE MANUFACTURING & PARTS CO.

A BRIEF HISTORY

Ace has been in the heavy duty clutch business since 1967. Starting as a pressure plate grinding company, Ace has grown to become a leader in the heavy duty clutch industry, machining and assembling all of its own clutches and clutch parts.

In 1992, Ace introduced its first racing clutch disc for drag racing and street cars, spawning the Ace Racing division. Ace Racing has developed many products since then and has also become a leader in racing clutches for drag racing, circle track and tractor pulling.

Ace owns several patents and has expanded itself over the years with a constant flow of new product offerings. While production methods have changed from hand grinders to CNC machining cells, Ace has never compromised quality.

COMMITMENT TO QUALITY

Ace Manufacturing & Parts Co. is committed to continually improve the quality and delivery of our products and services, to better satisfy the needs and expectations of our customers. We are devoted to delivering on time and every time, defect free product, by reviewing our quality and engineering standards, benchmarks, productivity and acting on customer feedback.

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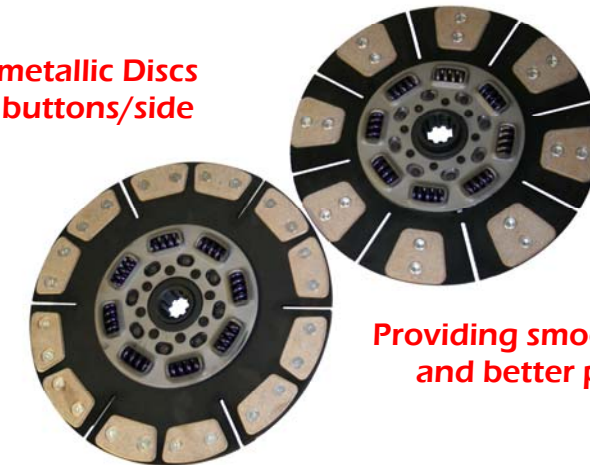


CLUTCH DISCS



Ace offers both organic and cerametallic discs for our *POWERFORCE* line of clutches. This versatility offers greater performance while extending clutch life and maintaining or improving drivability.

**New H.P. Cerametallic Discs
with 8 and 12 buttons/side**



**Providing smoother drivability
and better performance!**

FEATURES

- CRYOGENICALLY TREATED HUB SPRINGS
- HIGH FRICTION ORGANIC FACING
- FITS WITH *O.E.* CLUTCHES
- MADE FOR LONGEVITY AND CONSISTENCY
- MADE IN THE USA!

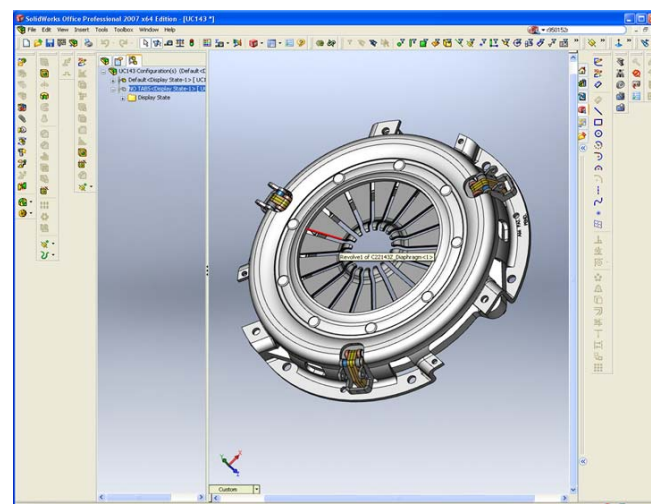
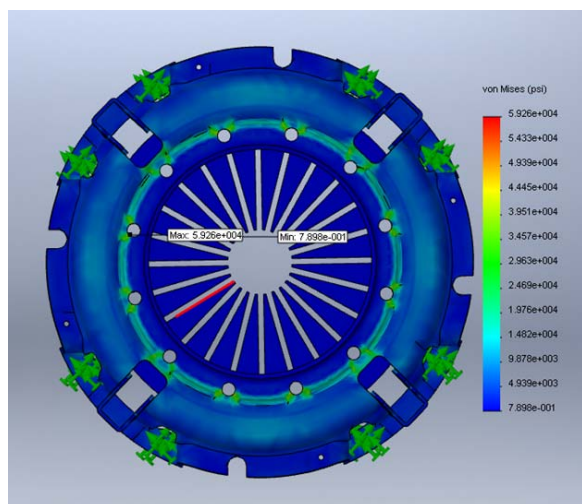


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ENGINEERING



POWERFORCE, Like all Ace clutches and clutch components, goes through rigorous F.E.A. analysis and three dimensional modeling before going into production, so that stress levels do not exceed the design's capabilities. Our products are engineered to offer you the best performance possible without sacrificing quality or safety. **POWERFORCE** covers, pressure plates, and flywheels are S.F.I. Approved!!

FORD POWERSTROKE 7.3L TURBO (DI)

**ACCESSORIES/COMPONENT PARTS
1998-2003 F250-F550 6-SPEED**

<i>RAC241K</i>	LEVER ASSIST COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>RNL241K</i>	NON-ASSISTED COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>R130206</i>	FLYWHEEL,, SOLID MASS 13" PATTERN W/PILOT BEARING
<i>RCAD-102K</i>	PADDLE STYLE 8-SPRING CERAMIC BUTTON DISC, MOST AGGRESSIVE
<i>RCAD-102HPK</i>	ROUND STYLE 8-SPRNG CERAMIC BUTTON DISC, MILDLY AGGRESSIVE
<i>RCAD-105K</i>	ORGANIC 8-SPRING DISC, LEAST AGGRESSIVE
<i>RRB241BP</i>	RELEASE BEARING, 6-SPEED 1998-2003 POWERSTROKE
<i>RAT1375FBP</i>	ALIGNMENT TOOL
<i>RPB944BP</i>	O.E. PILOT BEARING
<i>RFCB-M12X50BP10</i>	FLYWHEEL BOLTS, M12 X 50MM, POWERSTROKE 1994-2003

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Quick Reference for FORD POWERSTROKE 7.3L TURBO (DI)

1994-1997 — 7.3L 5-SPEED 13" DISC/PRESSURE PLATE 1 1/4" x 10 T DISC HUB

ULTIMATE RPF944CB LEVER ASSIST CERAMETALLIC DISC 800-1,500 LB-FT	EXTREME RPF944 LEVER ASSIST ORGANIC DISC 525-825 LB-FT	HIGH RPNL944CB NON-LEVER CERAMETALLIC DISC 800 LB-FT	MILD RPNL944 NON-LEVER ORGANIC DISC 525 LB-FT
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1998-2003 — 7.3L 6-SPEED; 13" DISC/PRESSURE PLATE 1 3/8" X 10T DISC HUB

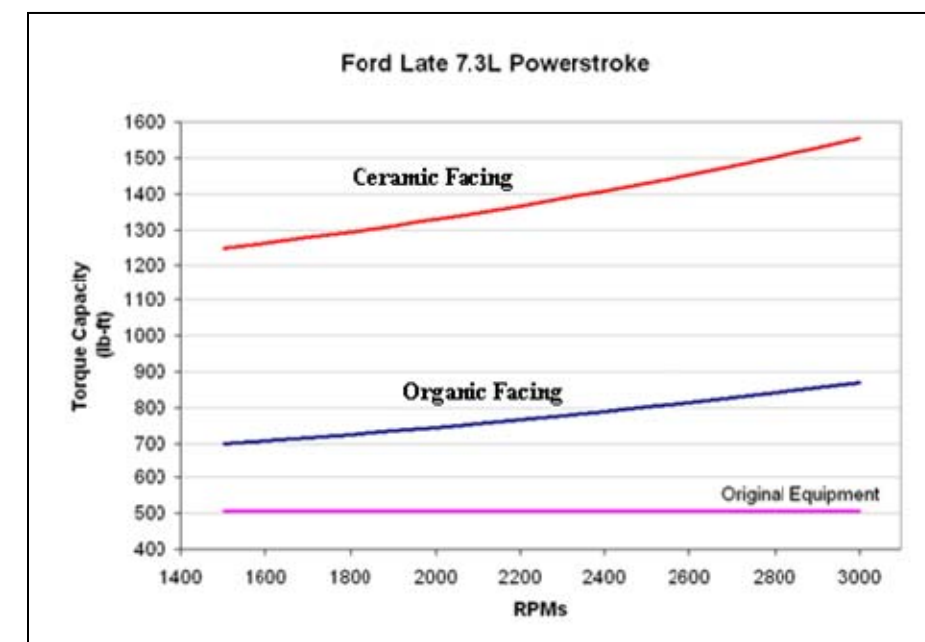
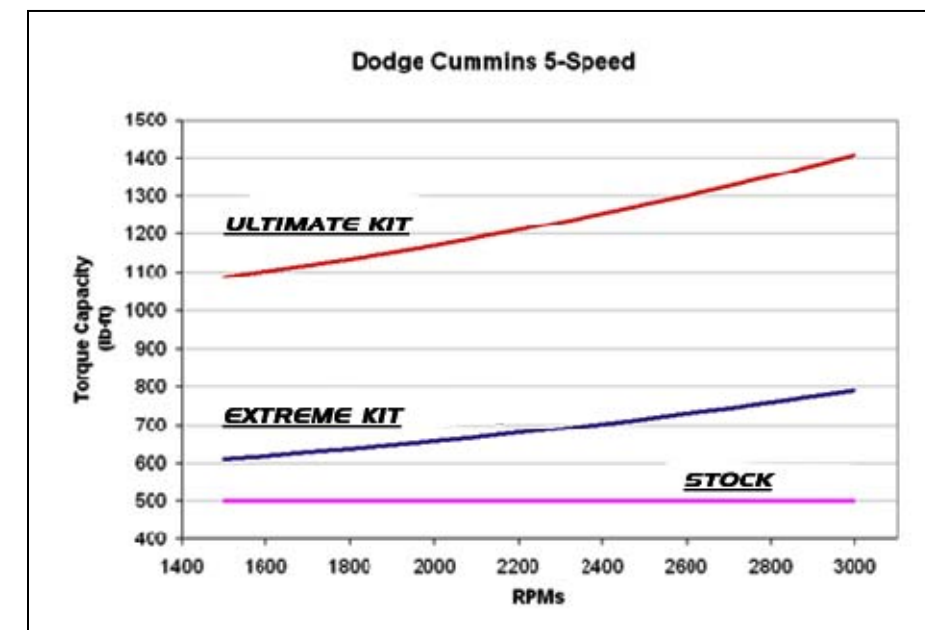
ULTIMATE RPF241CB LEVER ASSIST CERAMETALLIC DISC 800-1,500 LB-FT	EXTREME RPF241 LEVER ASSIST ORGANIC DISC 525-825 LB-FT	HIGH RPNL241CB NON-LEVER CERAMETALLIC DISC 800 LB-FT	MILD RPNL241 NON-LEVER ORGANIC DISC 525 LB-FT
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NOTE: ALL POWERSTROKE KITS ARE SOLID MASS SYSTEMS

ACCESSORIES/COMPONENT PARTS 1994-1997

<i>RAC944K</i>	LEVER ASSIST COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>RNL944K</i>	NON-ASSISTED COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>R130205</i>	FLYWHEEL,, SOLID MASS 13" PATTERN W/ PILOT BEARING
<i>RCAD-107K</i>	PADDLE STYLE 8-SPRING CERAMIC BUTTON DISC, MOST AGGRESSIVE
<i>RCAD-107HPK</i>	ROUND STYLE 8-SPRNG CERAMIC BUTTON DISC, MILDLY AGGRESSIVE
<i>RCAD-106K</i>	ORGANIC 8-SPRING DISC, LEAST AGGRESSIVE
<i>RRB944BP</i>	RELEASE BEARING, 5-SPEED 1994-1997 POWERSTROKE
<i>RAT1250FBP</i>	ALIGNMENT TOOL
<i>RPB944BP</i>	O.E. PILOT BEARING
<i>RFCB-M12X50BP10</i>	FLYWHEEL BOLTS, M12 X 50MM, POWERSTROKE 1994-2003

PERFORMANCE



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PERFORMANCE

As shown in these dyno test results, you can see the effects of the *POWERFORCE* lever system as the engine RPM's increase. *POWERFORCE* technology really does work and significantly increases clutch performance. Whether towing a rig to the track, everyday driving, or high performance, *POWERFORCE* will suit the needs of almost any application. *POWERFORCE* is ideal for the Diesel enthusiast looking for Dual Disc performance without the cost!

WARRANTY

Ace Manufacturing & Parts Company products are warranted for 12 months/12,000 miles from the date of purchase to the original buyer. This limited warranty covers any defects in material or workmanship during the warranty period and does not cover incidental or consequential damages, product damaged by misuse or improper installation.

Ace Manufacturing & Parts Company reserves the right to inspect any product returned for a warranty claim to determine if the claim is a result of material or workmanship deficiency and will, at its option repair or replace products found to be faulty.

Part(s) being returned for warranty claim should be returned through the dealer of distributor of original purchase. Items returned to Ace Manufacturing by the consumer must have a RGA number issued by Ace and be returned to the factory freight pre-paid with a copy of the original purchase invoice and a detail of why the product is being returned. Collect shipments will be refused.

Some states do not allow the exclusion or limitation of incidental or consequential damages or limitation on how long an implied warranty is in effect which may or may not apply to you. This warranty gives you specific legal rights. Other rights may apply and vary from state to state.

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DODGE CUMMINS ACCESSORIES – (Con't.)

2005.5-2008 — 5.9L & 6.7L 6-SPEED G-56 TRANSMISSION* 13" 1 3/8" X 10T DISC HUB

<i>RAC023-G56K</i>	LEVER ASSIST COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>RNL023K</i>	NON-ASSISTED COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>R130207</i>	FLYWHEEL,, SOLID MASS 13" PATTERN W/HD PILOT BEARING
<i>RCAD-101K</i>	PADDLE STYLE 8-SPRING CERAMIC BUTTON DISC, MOST AGGRESSIVE
<i>RCAD-101HPK</i>	ROUND STYLE 8-SPRNG CERAMIC BUTTON DISC, MILDLY AGGRESSIVE
<i>RCAD-103K</i>	ORGANIC 8-SPRING DISC, LEAST AGGRESSIVE
<i>RRB119BP</i>	RELEASE BEARING,
<i>RAT1375BP</i>	ALIGNMENT TOOL
<i>RPB119BP</i>	O.E. PILOT BEARING
<i>RAC-HMC0508</i>	2003-UP PRE-BLED HYDRAULIC UPGRADE KIT <i>INCLUDES MASTER CYLINDER, SLAVE CYLINDER, RESERVOIR ASSEMBLED</i>
<i>RFCB-M12X50BP8</i>	FLYWHEEL BOLTS, FOR USE WITH R130207 FLYWHEEL
<i>RCW-M12BP</i>	FLYWHEEL WASHER KIT, FOR USE WITH R130207 FLYWHEEL

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DODGE CUMMINS ACCESSORIES

1994-2002 — 5.9L 5-SPEED NV4500, 12.25" DISC/PRESSURE PLATE - 1 1/4" x 10 T DISC HUB

<i>RAC119K</i>	LEVER ASSIST COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>RNL119K</i>	NON-ASSISTED COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>R122200</i>	FLYWHEEL,, SOLID MASS 12.25" PATTERN W/HD PILOT BEARING
<i>RCAD-100K</i>	PADDLE STYLE 8-SPRING CERAMIC BUTTON DISC, MOST AGGRESSIVE
<i>RCAD-100HPK</i>	ROUND STYLE 8-SPRNG CERAMIC BUTTON DISC, MILDLY AGGRESSIVE
<i>RCAD-104K</i>	ORGANIC 8-SPRING DISC, LEAST AGGRESSIVE
<i>RRB119BP</i>	RELEASE BEARING,
<i>RAT1250BP</i>	ALIGNMENT TOOL
<i>RPB119BP</i>	O.E. PILOT BEARING
<i>RFCB-M12X32BP8</i>	FLYWHEEL BOLTS, M12 X 32MM, DODGE 1994-2005
<i>RCW-500X063BP</i>	FLYWHEEL WASHERS, DODGE 1994-2005

2001-2005 — 5.9L 6-SPEED NV5600* 13" DISC/PRESSURE PLATE 1 3/8" X 10T DISC HUB

<i>RAC023K</i>	LEVER ASSIST COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>RNL023K</i>	NON-ASSISTED COVER/PRESSURE PLATE KIT W/ RELEASE BEARING
<i>R130206</i>	FLYWHEEL,, SOLID MASS 13" PATTERN W/HD PILOT BEARING
<i>RCAD-101K</i>	PADDLE STYLE 8-SPRING CERAMIC BUTTON DISC, MOST AGGRESSIVE
<i>RCAD-101HPK</i>	ROUND STYLE 8-SPRNG CERAMIC BUTTON DISC, MILDLY AGGRESSIVE
<i>RCAD-103K</i>	ORGANIC 8-SPRING DISC, LEAST AGGRESSIVE
<i>RRB119BP</i>	RELEASE BEARING,
<i>RAT1375BP</i>	ALIGNMENT TOOL
<i>RPB119BP</i>	O.E. PILOT BEARING
<i>RAC-HMC0508</i>	2003-UP PRE-BLED HYDRAULIC UPGRADE KIT <i>INCLUDES MASTER CYLINDER, SLAVE CYLINDER, RESERVOIR ASSEMBLED</i>
<i>RFCB-M12X32BP8</i>	FLYWHEEL BOLTS, M12 X 32MM, DODGE 1994-2005
<i>RCW-500X063BP</i>	FLYWHEEL WASHERS, DODGE 1994-2005

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QUICK REFERENCE GUIDE

Complete Kits For:

**DODGE CUMMINS 5.9/6.7L
FORD POWERSTROKE 7.3L**

When we say complete, we mean **COMPLETE**. All kits come with a solid mass flywheel, disc, pressure plate assembly, alignment tool, pilot bearing already pressed in the flywheel, release bearing, as well as all new flywheel bolts, washers(where applicable) and clutch mounting bolts.

NEW!! - "HP" Disc now available with ULTIMATE and HIGH performance kits! Providing smoother engagement and less chatter without compromising torque capacity! Just add "-HP" to the part number.

ULTIMATE - This is the top of the line performance from *POWERFORCE*. This clutch is designed for the heavily upgraded diesel enthusiast. Clutch is the most aggressive with the highest torque capacity using the lever assist clutch and cerametallic disc. Aggressiveness can prove problematic with towing depending on driving style.

EXTREME - This package is essentially the same as the **ULTIMATE**, only with an organic disc instead of cerametallic, allowing for a smoother engagement. This lever assist clutch option is ideal for the moderately tuned truck that does a lot of towing and city driving.

HIGH - The high performance package is the more economical, non lever assisted clutch with a cerametallic disc. This offers a considerable increase in torque capacity over stock, while not breaking the bank.

MILD - This clutch is the unit of choice for the person who wants a similar to stock replacement. You get a greater torque capacity than your stock clutch, leading to increased clutch life. It is a non-lever assist unit packaged with an organic disc, making an affordable complete solid mass conversion kit.

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Quick Reference for DODGE CUMMINS

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1 1/4" x 10 T DISC HUB

ULTIMATE RPF119CB LEVER ASSIST CERAMETALLIC DISC <i>1,000-1,400 LB-FT</i>	EXTREME RPF119 LEVER ASSIST ORGANIC DISC <i>550-850 LB-FT</i>	HIGH RPNL119CB NON-LEVER CERAMETALLIC DISC <i>800 LB-FT</i>	MILD RPNL119 NON-LEVER ORGANIC DISC <i>550 LB-FT</i>
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2001-2005 — 5.9L 6-SPEED NV5600* 13" DISC/PRESSURE PLATE

ULTIMATE RPF023CB LEVER ASSIST CERAMETALLIC DISC <i>1,100-1,500 LB-FT</i>	EXTREME RPF023 LEVER ASSIST ORGANIC DISC <i>600-850 LB-FT</i>	HIGH RPNL023CB NON-LEVER CERAMETALLIC DISC <i>1,000 LB-FT</i>	MILD RPNL023 NON-LEVER ORGANIC DISC <i>600 LB-FT</i>
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2005.5-2008 — 5.9L & 6.7L 6-SPEED G-56 TRANSMISSION* 13"
1 3/8" X 10T DISC HUB

ULTIMATE RPF023-0508CB LEVER ASSIST CERAMETALLIC DISC <i>1,100-1,500 LB-FT</i>	EXTREME RPF023-0508 LEVER ASSIST ORGANIC DISC <i>600-850 LB-FT</i>	HIGH RPNL023-0508CB NON-LEVER CERAMETALLIC DISC <i>1,000 LB-FT</i>	MILD RPNL023-0508 NON-LEVER ORGANIC DISC <i>600 LB-FT</i>
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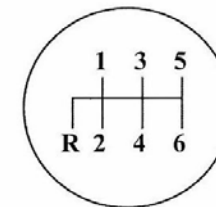
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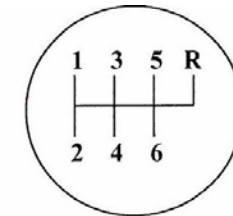
FAQ'S for DODGE CUMMINS

Q. I HAVE A 2005 CUMMINS WITH A 6 - SPEED, BUT HOW DO I KNOW IT IS A G-56 OR A NV5600?

a. THE EASIEST WAY TO TELL IS BY THE LOCATION OF REVERSE IN YOUR SHIFT PATTERN.



G-56



NV5600

Q. WHAT IS THE HYDRAULIC UPGRADE FOR AND WHAT YEARS DOES IT WORK FOR?

a. THE EASIEST WAY TO TELL IS BY THE LOCATION OF REVERSE IN YOUR SHIFT PATTERN. THE HYDRAULIC UPGRADE IS FOR MODEL YEARS 2003-UP, USED FOR PERFORMANCE CLUTCHES AND SOLID MASS CONVERSIONS. THE STOCK CYLINDERS DO NOT CREATE ENOUGH TRAVEL OR PRESSURE FOR THE RELEASE BEARING FOR MOST SOLID MASS UPGRADE KITS. IF YOU HAVE PREVIOUSLY CONVERTED TO SOLID MASS AND UPGRADED THE CLUTCH MASTER/SLAVE CYLINDERS,

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