

# Installation Manual for your NP203/NP025 Adapter Kit

## Part 4

### Clocking Your Adapter & Installing the NP205

#### Step 1:

On the Center Index ring, lightly grease the O-ring gland and O-ring for the best seal.



#### Step 2:

With the adaptor side facing you, turn your NP203 range box to the rotation you would like it to be in the truck. Standard, 90° Right, 90° Left, or 180° Upside down. Inverted doesn't sit flat on the bench very well, it is a good idea to prop it up.



Make sure it is stable, an unstable range box can fall injuring you or destroying the cast iron case.

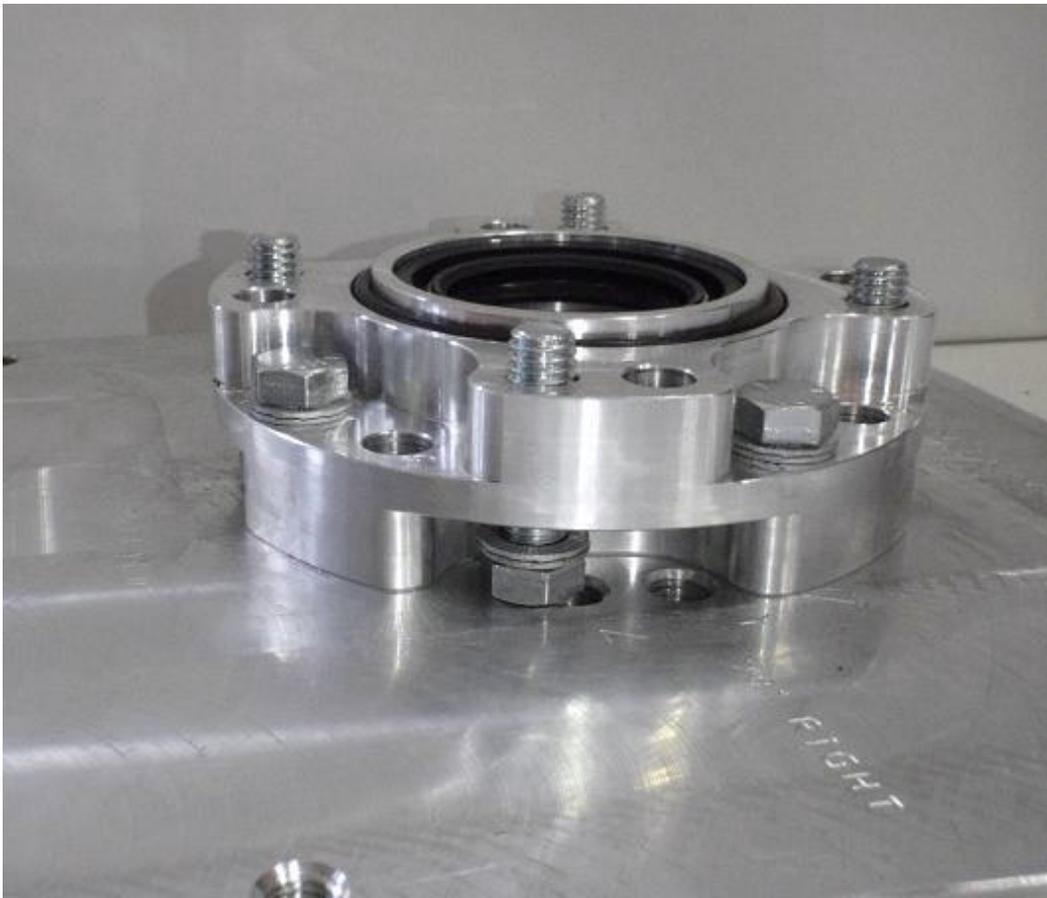
### Step 3:

With the O-Rings properly seated in the clocking ring, slide (4) 7/16"x1 1/2" cap screws with Nord lock washers into desired clocking hole 1 or 2, with threads facing the NP205. Now slide (4) more 7/16"x1 1/2" cap screws into holes 3 or 4 in clocking ring with threads facing the 203 adapter plate.



## Step 4:

Finger tighten cap screws through holes 3 or 4 into 203 adapter plate. Make sure clocking ring goes into adapter plate square. Accomplish this by alternating bolts until snug and tighten to 220 inch-lbs.



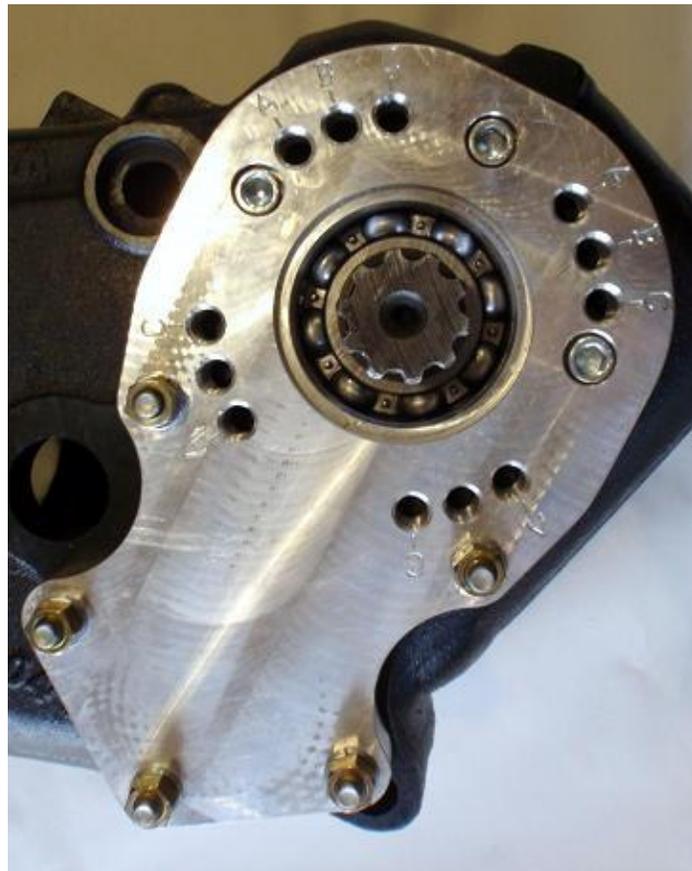
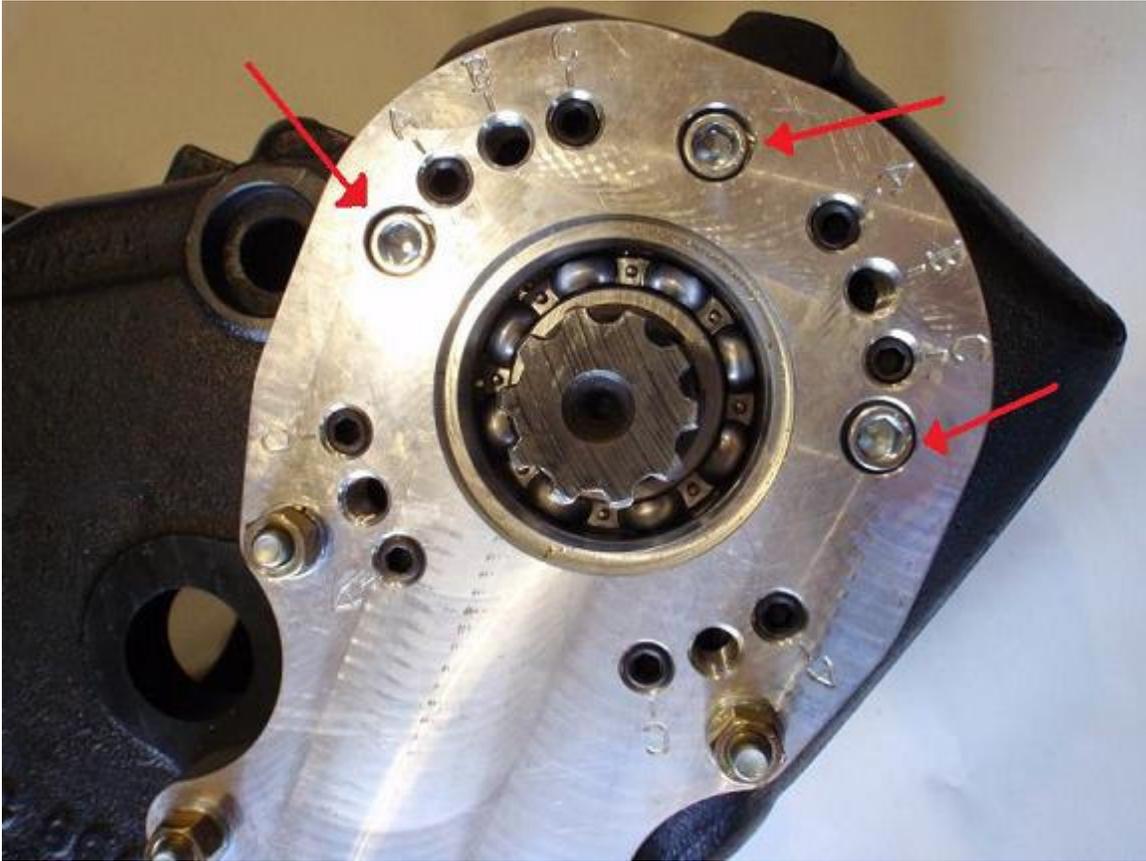
## Step 5:

We now focus our attention on the NP205 mounting plate. Install 5 studs into your cleaned up 205. For Round Pattern 205's such as the Ford install 6 studs. A technique to do this is "locking" two nuts together on the stud and then tightening using a socket or wrench. Then prep your 205 face with a thin coat of Gasket Prep such as RTV Sealant. Place the supplied gasket over the studs and onto the thin coat and rub to assure it adheres flat. After allowing the sealant to tack, apply another thin coat to the backside of the paper gasket and install the 205 plate over studs. Note: We at NWF use higher tolerances than those used on the NP205. Because of this, studs may be a fraction out of place, and the plate may not slide over the studs easily. If this is the case you may drill those holes out using a slightly larger bit and drill press.



## Step 6:

Now install (3) Socket cap screws into the NP205 assuring that the head sits flush or lower than the plate. Finish attaching the 205 plate by threading on a 3/8 NC nut on top of a lock washer on each stud.

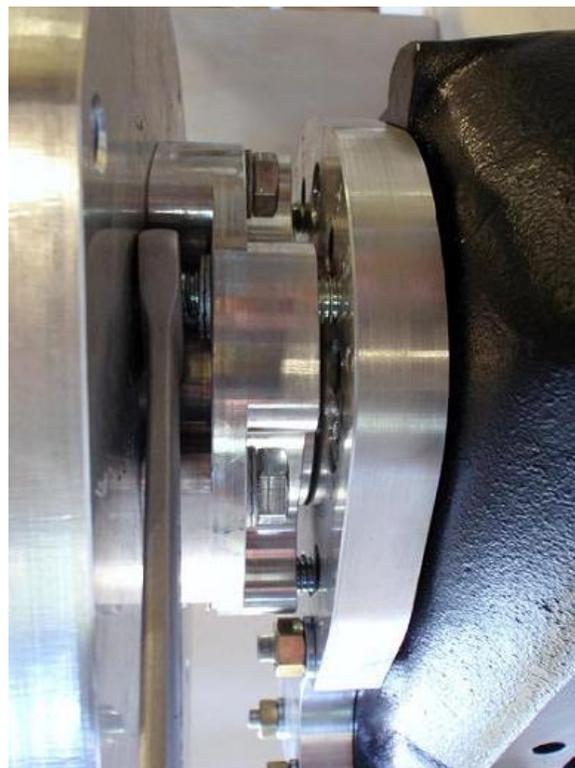


Also install the (8) black socket set screws into what are going to be your unused clocking holes. That is, if you already determined you are going to clock with hole B, thread into all A and C.



### Step 7:

We are now going to join the 203 and 205 together. Line up the (4) cap screws protruding from the clocking ring (see Pic. Step 4) with previously chosen clocking hole (A, B, or C) on the 205 plate.



There is enough room to get a box head 5/8" wrench in to turn the cap screw about a third of a turn.  
Again tighten in a manner to ensure the threads go in strait, after a couple of turns of the wrench,  
alternate bolts until tight.

## Step 8:

Lastly thread in the breather (3/8 NPT plug) into the 203 adapter plate. Don't forget to fill your fluids!



Congrats, you have now finished your NP203 / NP205 Adapter Kit Install!

- NWF