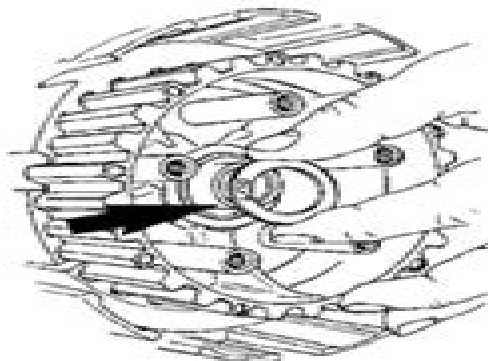


5. While holding clutch outer drum in position, refit the splined sleeve and needle roller bearing. When the sleeve is correctly fitted, it is flush with clutch drum face.



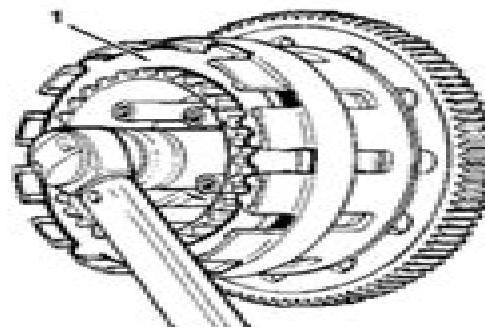
CAUTION: Re-check the drive gear position on the 4 cylinder balancer and repeat operations 2, 3, 4 and 5 if the balancer is not correctly aligned. Severe engine damage could result from incorrect balancer alignment.

6. Fit the shim and large washer to the outer drum.
7. Fit the clutch inner drum.
8. Fit the Belleville washer ('out' mark facing outwards), and centre nut.



Belleville Washer 'Out' Mark

9. Lock the inner and outer drums together using service tool 3880025. Depress the rear brake pedal to prevent the engine from turning, and tighten the clutch centre nut to **105 Nm**. Remove the service tool.



1. Service tool 3880025

10. Disengage first gear and check for free rotation of the clutch inner drum.



CAUTION: If the inner drum does not rotate freely, it must be removed and re-shimmed to prevent severe engine damage.

NOTE:

- Friction plates and clutch plates must be inspected for signs of wear, damage or distortion before re-use, and replaced if not in a serviceable condition. (see Friction plate wear/warp).
11. Soak all clutch plates in oil before fitting to the clutch basket in the same order as removal.
 12. Carefully refit the clutch pushrod and end piece ensuring that the pushrod seals in the crankcase do not become displaced or damaged.
 13. Refit the clutch pressure plate together with the springs and bolts. Tighten the bolts to **10 Nm**.
 14. Clean and refit the clutch cover using a new gasket. Tighten the clutch cover bolts to **12 Nm**.
 15. Refit the breather hose and clip (where fitted).
 16. Re-fill the engine with the correct grade and type of engine oil.

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Anthony S. Fauci



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