

**a. Disassembly**

- (1) Drain the oil from the crankcase.
- (2) Remove the kick starter arm.
- (3) Remove the 8mm locking nut from the clutch adjusting bolt. (C50, C50M, C65, C65M only)
- (4) Remove the right crankcase cover.

**b. Reassembly**

- (1) Reassemble in the reverse order of disassembly (Caution)
- a. Exercise caution not to damage the right crankcase cover gasket or to install it misaligned.
- b. Install the kick starter arm by aligning the punch marks on the spindle and the arm.

**i. CLUTCH**

The function of the clutch is to temporarily disengage the transmitting of the rotary motion between the engine and the transmission during the gear change and then after the gear change, permit a smooth power transition. The condition of the clutch will have a varying effect on the direct transmission of the engine rotary output.

The clutch mechanism on the C50, C50M, C65 and C65M models are conventional wet type multiple disc, whereas the S50 and S65 models incorporates a new clutch lift mechanism of further improve the smoothness of the clutch operation. (Fig. 3.64, 3.65A, 3.65B)

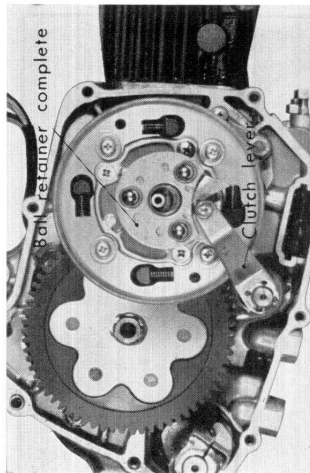


Figure 3-64. Gear shift and clutch mechanism

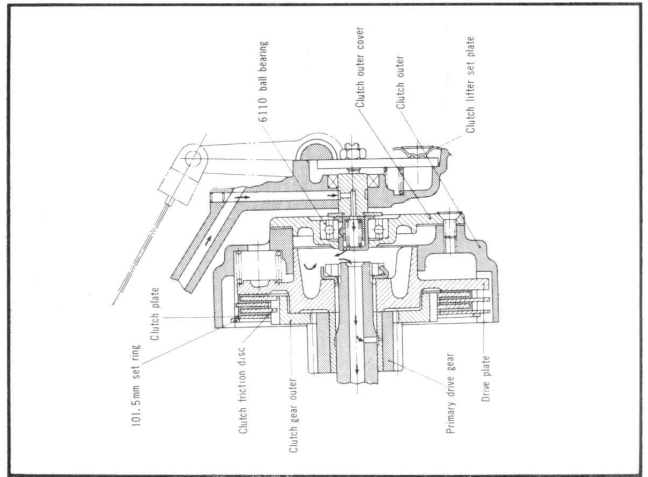


Figure 3-65A. Clutch assembly and oil passage diagram S50, S65

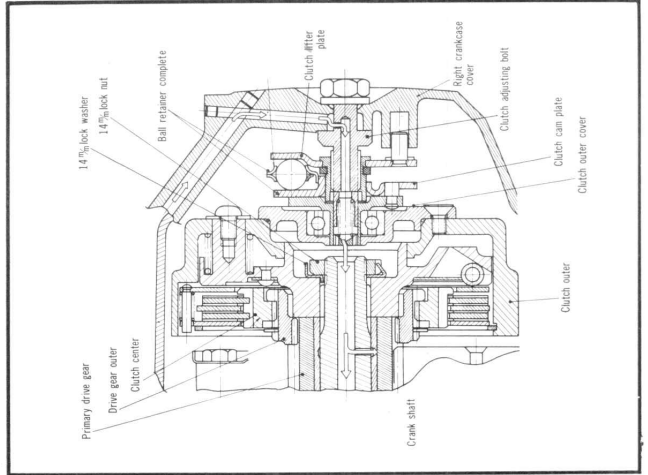


Figure 3-65B. (C50, C50M, C65, C65M)

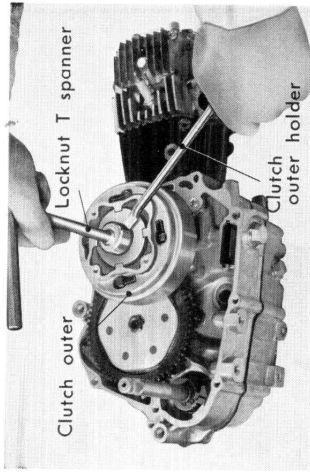


Figure 3-66. Removing clutch unit

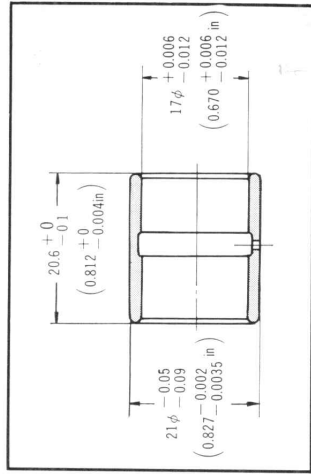


Figure 3-67. Clutch center guide

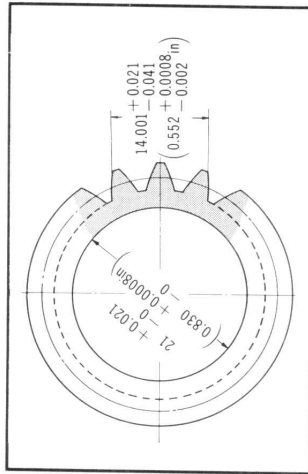


Figure 3-68. Primary drive gear

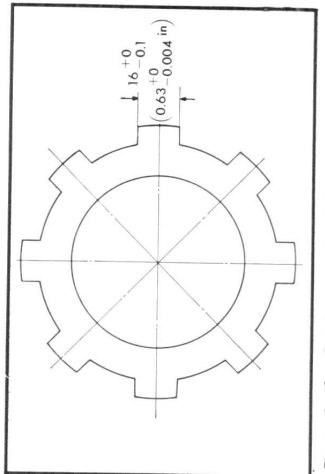


Figure 3-69. Clutch plate tab width

**a. Disassembly**

- (1) Remove right crankcase cover.
- (2) Remove clutch outer cover.
- (3) Unlock the 14mm lock washer, remove the 14mm lock nut and the clutch can be removed as a complete unit.
- (4) The work of disassembling the clutch unit can be simplified by the use of special tools. (Fig. 3.66)

**b. Inspection**

- (1) Clutch center guide. (Fig. 3-67)

	Standard Value	Serviceable Limit
Inside dia	17 mm (0.670 in.) +0.006 (0.0002 in.) -0.012 (0.0004 in.)	Replace if over 17.1 (0.674 in.)
Outside dia	21 mm (0.827 in.) -0.05 (0.002 in.) -0.09 (0.0035 in.)	Replace if under 19.98 (0.787 in.)
Length	20.6 (0.812 in.) +0 (0 in.) -0.1 (0.004 in.)	Replace if under 20.4 (0.8 in.)
Runout	0.03 max. (0.0012 in.) 0.15 (0.006 in.)	Replace if over 0.15 (0.006 in.)

- (2) Primary drive gear (Fig. 3-68) [ ] for C50, C50M, S50

	Standard Value	Serviceable Limit
Inside dia.	21 mm (0.830 in.) +0.021 (0.0008 in.) -0.00 (0.000 in.)	Replace if over 21.15 (0.833 in.)
Chordal distance across teeth (3 teeth)	13.723 (0.541 in.) +0.021 (0.0008 in.) -0.041 (0.002 in.) 14.001 -0.021 (0.551 in. -0.002 in.)	Replace if under 13.7 (0.540 in.)

- (3) Thickness of clutch friction disc.  
Standard value→3.5 (0.138 in)  
Serviceable limit→Replace if under 3.1 (0.122 in)

- (4) Clutch plate (Fig. 3-69)

	Standard Value	Serviceable Limit
Width of claw	16 (0.630 in.) +0 (+0 in.) -0.1 (0.004 in.)	Replace if under 15.7 (0.620 in.)
Thickness	1.6 ± 0.05 (0.063 ± 0.0020 in.)	Replace if under 1.5 (0.059 in.)

- (5) Width of clutch outer claw groove  
Standard value→16 +0.1/-0.1 ~ 16.3 +0.1/-0.1  
(0.63 +0.004/-0.004 ~ 0.642 +0.004/-0.004 in)

- (6) Clearance between the clutch outer and drive plate or with the clutch plate, in the direction of rotation.  
Standard value→0.3 ~ 0.5 (0.012 ~ 0.02 in)