

## 2. Friction disc and clutch plate (Fig. 3.69)

Item	Standard value	Serviceable limit
Thickness of disc	2.6~2.9 mm (0.1102~0.1141 in)	2.4 mm (0.0944 in)
Thickness of clutch plate	1.93~2.07 mm (0.0760~0.0815 in)	Replace if under 1.85 mm (0.073 in)
Warping of plate	0.2 mm (0.0079 in)	0.5 mm (0.0196 in)

## 3. Clutch outer and drive plate or clutch plate.

Item	Standard value	Serviceable limit
Backlash clutch plate	0.2 (0.008 in)	Replace if over 0.7 (0.036 in)
Backlash friction disc	0.2 (0.008 in)	Replace if over 0.7 (0.036 in)

## 4. Clutch center guide (Fig. 3.70)

Item	Standard value	Serviceable limit
Crankshaft to center guide clearance	0.005~0.047 mm (0.0002~0.0019 in)	Replace if over 0.15 (0.060 in)

## 5. Primary drive gear (Fig. 3.71)

Item	Standard value	Serviceable limit
Inside dia.	24.00~24.02 mm (0.945~0.946 in)	Replace if over 24.15 (0.951 in)
Chordal distance across 3 teeth	13.96~13.98 mm (0.5496~0.5504 in)	Replace if under 13.93 mm (0.5484 in)

## D. Reassembly

1. Into the clutch outer, assemble the clutch spring, drive plate, friction disc and clutch plates, and then compress the drive plate in accordance with the procedure in section 8-B-4 and install the set ring; also install clutch damper spring.
2. Assemble the drive gear, clutch center guide together with the clutch assembly on the crankshaft.

Torque the lock nut to 380~450 kg cm  
(54~64 lbs. ft)

## NOTE:

The lock washer ① must be locked by bending the tab after torquing the nut; if the side of the nut does not align with the tab, tighten the nut further to permit locking, do not loosen. (Fig. 3.72)

3. Assemble the clutch outer cover.
4. Install the right crankcase cover.
5. Install the clutch cover together with the clutch lifter and oil guide.

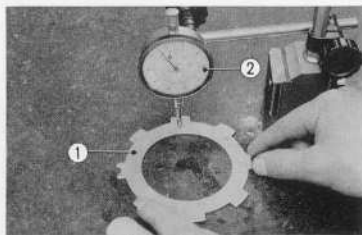


Fig. 3.69 Inspecting the clutch plate  
① Clutch plate ② Dial gauge



Fig. 3.70 Clutch center guide

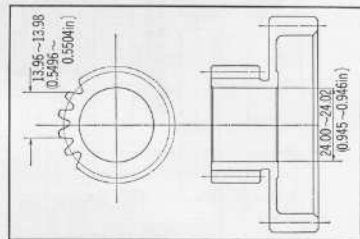


Fig. 3.71 Primary drive gear

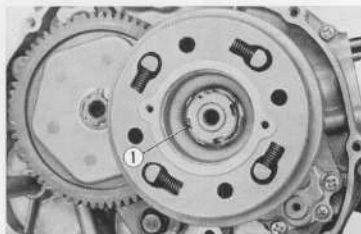


Fig. 3.72 Bend up tab of the lock washer  
① Lock washer