

## R1 98 - '03 SLIPPER CLUTCH CONVERSION WITH SPRINGS

13203 Antihopping clutch kit R1 – 2003 - coil springs version - mounting instructions

This clutch should be installed by an experienced service center, or experienced mechanic.

1. Read this instructions with photos before you start. Make sure the kit includes all parts.
2. Remove the old clutch ( according Yamaha workshop manual ), clean the threads on the shaft of old glue perfectly. Clean this with brake cleaner.
3. Make sure the original spacer between basket and hub is in it's position.
4. Install the clutch assembly to the gearbox shaft.
5. The kit includes small parts for mounting. Put KIT washer in first . After install the main nut. Nut torque moment 120 Nm ( pic. f.g. ), use glue Loctite No. 620 (red) to secure.
6. Install clutch plates . This clutch is designed for using new OEM plates. NEVER mount friction plate with judder rings as first. Put a normal friction plate as first, then a steel plate and then the narrow friction plate with judder rings. The remaining plates install as original.
7. Install the push rod to shaft .
8. Mount the pressure plate . Install KIT clutch springs with kit spring retainers and kit bolts .
9. Check the clearance between pressure plate and clutch hub via the small holes in the pressure plates. The correct clearance is about 1.0 mm, minimal clearance is 0.5mm. When the clutch wears to this dimension, install all new friction plates.
10. Every time use new engine gasket.
11. Install clutch cover according Yamaha workshop manual, adjust clutch cable .

### LIST OF PARTS

- 1 pc. premounted clutch drum
- 1 pc. pressure plate
- 1 pc. curved washer
- 6 pcs. spring retainer
- 6 pcs. spring retainer for more spring preload
- 6 pcs. M5 x 25 bolt