

### Centrifugal Clutch Installation

1. Set the clutch drum on the bench so the one-way clutch side faces up (**Figure 27**).
2. Set the drive plate assembly into the clutch drum so the drive plate boss sits in the one-way clutch. Turn the drive plate assembly clockwise (**Figure 28**) and press it into the one-way clutch until it bottoms.
3. Lubricate the crankshaft, primary drive gear bore and washer with engine oil.
4. Install the washer (**Figure 26**) onto the crankshaft.
5. Align the splines of the drive plate with those of the crankshaft, and slide the centrifugal clutch (**C**, **Figure 25**) onto the crankshaft. Rotate the change clutch as necessary so the primary drive gear (**B**, **Figure 25**) aligns with the cutout in the change clutch (**A**).
6. Install the washer (**B**, **Figure 23**) onto the crankshaft.

#### NOTE

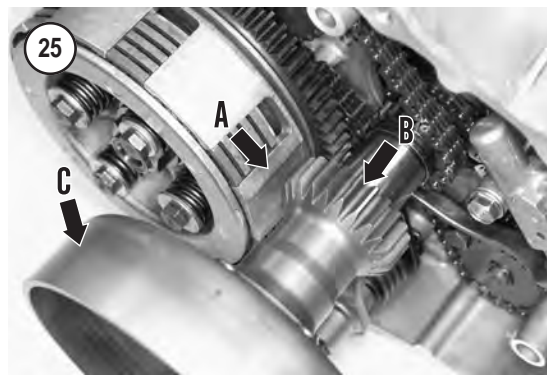
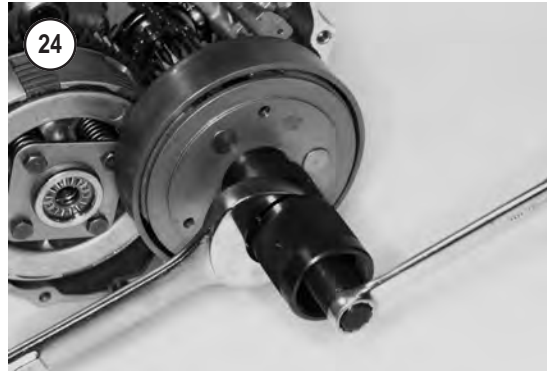
*The centrifugal clutch nut has left-hand threads.*

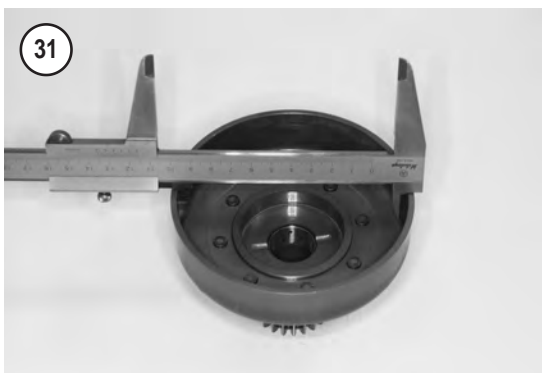
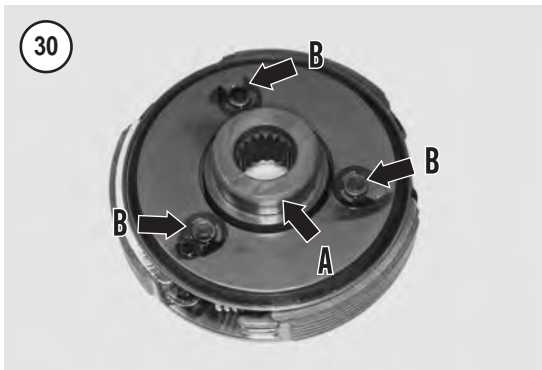
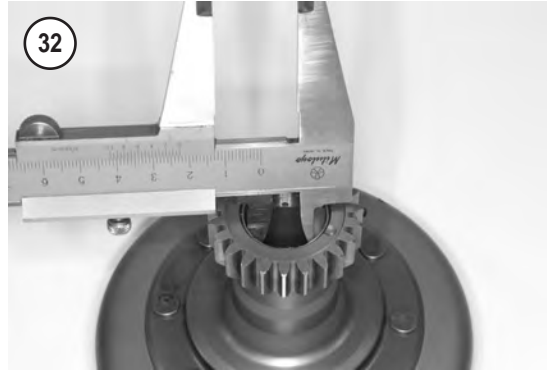
7. Apply engine oil to the threads and flange of a new centrifugal clutch nut, and install the nut (**A**, **Figure 23**).
8. Hold the centrifugal clutch with the same tool used during removal (**Figure 22**), and tighten the centrifugal clutch nut to 88 N•m (65 ft.-lb.).
9. Stake the edge of the clutch nut (**Figure 19**) to the notch in the crankshaft.
10. Clean the oil filter cover as described in *Engine Oil and Filter* in Chapter Three.
11. Install the oil filter cover (**B**, **Figure 20**). Apply ThreeBond 1333B to the threads of the mounting bolts and tighten the bolts (**A**, **Figure 20**) securely.
12. Install the clutch cover as described in this chapter.

### Clutch Drum Inspection

Refer to **Table 1** when inspecting the clutch drum components. Replace parts that are out of specification or damaged.

1. Check the one-way clutch operation by performing the following:
  - a. Set the clutch drum on the bench so the one-way clutch side faces up (**Figure 27**).





- b. Set the drive plate assembly into the clutch drum so the drive plate boss sits in the one-way clutch. Turn the drive plate assembly (**Figure 28**) clockwise and press it into the one-way clutch until it bottoms.
  - c. Hold the clutch drum and turn the drive plate assembly. It should turn *clockwise* within the clutch drum but not counterclockwise.
2. Remove the drive plate assembly from the clutch drum.
  3. Mark the one-way clutch (**Figure 27**) so its up side can be identified. The one-way clutch must be reinstalled with the same orientation during assembly.
  4. Remove the one-way clutch (**Figure 29**) from the clutch drum. Inspect the one-way clutch for signs of heat damage, cracks or other damage. Replace the one-way clutch if there is visible damage or if it failed to operate as described in Step 1.
  5. Inspect the drive plate bearing boss (A, **Figure 30**) for excessive wear or damage. Check for signs of overheating.
  6. Check the exterior of the clutch drum for cracks or damage, and check the inside diameter for excessive wear or damage. Measure the clutch drum inside diameter with a vernier caliper (**Figure 31**).
  7. Measure the inside diameter of the clutch drum bushing (**Figure 32**).
  8. Check the clutch drum bushing (A, **Figure 33**) for burning, scoring or other signs of damage.
  9. Inspect the primary drive gear (B, **Figure 33**) for broken or excessively worn teeth.
  10. Measure the outside diameter of the crankshaft at the two points shown in **Figure 34**.
  11. Lubricate the one-way clutch and its housing in the clutch drum with engine oil. Install the one-way