

0F3OR320A110000

SLIPPER CLUTCH FOR KTM 450/525

ASSEMBLY INSTRUCTIONS

- Pre-assemble the hub pack: place at the bottom of the bottom of the grooves the 6 steel balls (001MG025) onto the hub (0F3MR320A11A1A3) using a small amount of grease. With an M6 screw fix the clutch drum (0F3MR320A1102A3) onto the clutch hub (0F3MR320A11A1A3) in an at-rest position.
- Insert the hub pack onto the main shaft.
- Reinstall the clutch plates remembering to respect the position as in the original clutch. The total thickness of the disc pack should be $21,7 \pm 0,3\text{mm}$.
- Remove the screw used to hold hub (0F3MR320A11A1A3) and drum (0F3MR320A1102A3) together.
- Insert the drum stopper hub (0F3MR250E150009) into the hub housing (0F3MR320A11A1A3) taking care that the three pins (0F3CR620E070038) inside the hub (0F3MR320A11A1A3) place themselves in the three holes present on the drum stopper hub (0F3MR250E150009) and that they are on a level with the superior surface of the drum stopper hub.
- Verify that the secondary spring support (0F3SR540B140016) is well inserted into its own housing inside the drum (0F3MR320A1102A3).
- Insert the secondary spring (0S2085) in its seat into the drum (0F3MR320A1102A3) with some grease.
- Verify that the primary spring support (003SUZ118) is well inserted in its own housing inside the pressure plate (0F3MR320A11A003).
- Insert the Evoluzione Racing spring (0S1125) into the pressure plate (0F3MR320A11A003).
- In order to assemble the complete spring stopper hub kit start from the spring stopper washer (0F3MR320A110008) with the shaped part facing up as shown in the picture. Insert the load bearing (003MG P07) and the spring stopper hub (0F3MR320A110007).
- Finally, place the complete spring stopper pack inside the Evoluzione Racing spring (0S1125) beforehand mounted onto the pressure plate (0F3MR320A11A003). At this point insert the pressure plate on the drum (0F3MR320A1102A3).
- Insert the notched washer (901RD004) in the relevant opening placed on the upper part of the spring stopper hub (0F3MR320A110007), with the convex part facing up, then insert and screw the nut (0F3MR320A110013). Lock with the dynamometric tool to the torque suggested by the manufacturer.
- Assemble the complete bearing rest: mount the clutch push piece, bearing and thrust washer of the original clutch into the bearing rest housing (0F3MR320A11A004).
- Position the bearing rest (0F3MR320A11A004) into the relevant opening of the pressure plate (0F3MR320A11A003) taking care to correctly align the openings and fix it with the six screws (907VT018) and with the six (6) self locking washer (901RD007).
- After the mounting of the clutch, check if the pressure plate works correctly activating the clutch lever.

NB: once the assembly is completed, repeatedly operate the clutch lever to check that pressure plate correctly performs the opening and closing movements

GENERAL SAFETY REGULATIONS

THIS SHEET REPORTS THE INSTRUCTIONS TO CORRECTLY PERFORM THE MAIN CLUTCH ASSEMBLY PROCEDURES
STM RESERVES THE RIGHT TO MODIFY THE PRODUCT AT ANY TIME AND WITHOUT NOTIFICATION
THE ASSEMBLY OPERATIONS MUST BE SCRUPULOUSLY OBSERVED AND CARRIED OUT BY A SKILLED TECHNICIAN
BEFORE INSTALLING THE CLUTCH AN INSPECTION MUST BE CARRIED OUT TO VERIFY THE PRESENCE OF DEFAULTS OR ANOMALIES OF THE VEHICLE
MAKE SURE THAT THERE ARE NO MISSING OR DAMAGED PARTS IN THE PACKAGE
SOME PARTS OF THE CLUTCH OR OF THE CLUTCH COMPONENTS CAN PRESENT A SHARP SURFACE: PLEASE HANDLE WITH CARE
SOME CLUTCH COMPONENTS ARE SMALL AND COULD BE SWALLOWED: KEEP AWAY FROM CHILDREN

