

Assembly

Assembly is in the reverse order of disassembly. Pay attention to the following points.

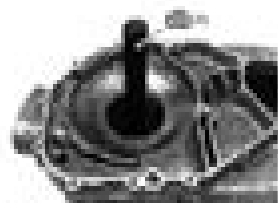
- Install the oil seal with the special tool.

NOTICE

- The removed oil seal must be replaced with a new one.
- The marked side of the oil seal must face the front drive face side.

Special tool

(A) 99913-7010 (Bearing installer set)



99913-7010

- Install the bearing with the special tool.

Special tool

(A) 99913-7010 (Bearing installer set)

NOTICE

- The removed bearing must be replaced with a new one.
- The sealed side of the bearing must face the oil seal side.



99913-7010

- Fit the bearing retainers.
- Apply a small quantity of thread lock to the bearing retainer screws, and tighten them securely.

(B) 1 Thread lock cement 99906-32000
(THREAD-LOCK CEMENT 10000)



99906-32000

- Apply grease to the O-ring and oil seal lip.
- Install the collar (1).

(A) 1 Grease 99906-32001 (SUGUO SUPER GREASE-A)

NOTICE

Replace the O-ring with a new one.



99906-32001

- After installing the clutch wheel, check that the clutch wheel rotates smoothly.



99906-32001

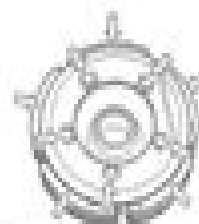
SA-21 Automatic Transmission**Clutch Related Parts Inspection**

Refer to "V-belt Inner Cover Disassembly and Assembly" (Page SA-18).

Clutch Shoe

Inspect the face and centrifugal weight balance sections for looseness, damage and operation.
Inspect the clutch shoe for damage and flaking with oil on the surface.

If any defects are found, replace the clutch shoe assembly with a new one.

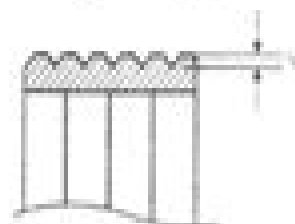


99906-32001

Check the depth of the grooves on the clutch shoes. If there is no groove at any part of the shoes, replace the clutch shoes.

Clutch shoe thickness "C"

Service limit: No groove at any part



99906-32001

Clutch Wheel

Inspect the clutch wheel for any abnormal surface damage. Measure the inside diameter of the clutch wheel. If the measurement exceeds the service limit, replace the clutch wheel with a new one.

Clutch wheel I.D.

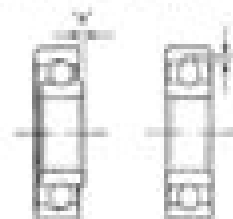
Service limit: 140.5 mm (5.53 in)



99906-32001

V-belt Inner Cover Bearing

Rotate the inner race by finger to inspect for abnormal play, noise and smooth rotation. If there is anything unusual, replace the bearing with a new one.



99906-32001

One Way Clutch

- 1) Install the one way clutch (1) into the clutch wheel.

NOTE

When installing the one way clutch (1) into the clutch wheel, make sure that the "OUTSIDE" letter "A" in the one way clutch faces to the clutch wheel.



99906-32001

Suzuki King Quad 400 Service Manual 2015

Editors of Haynes Manuals



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