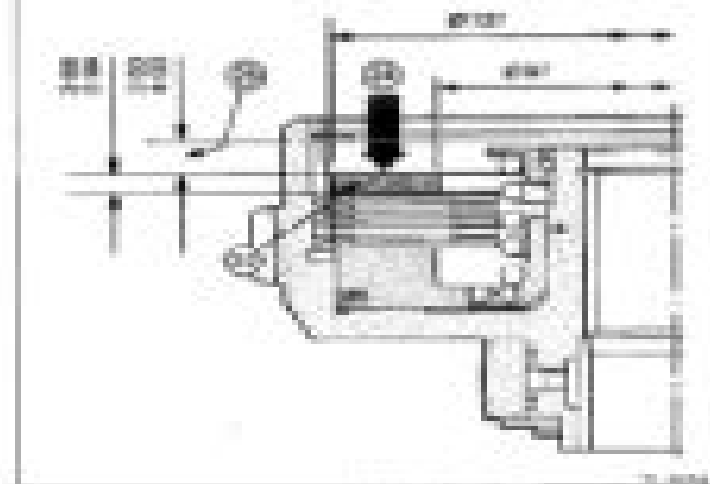


Reassembly

20. Check that the lubrication jet in the plates is not blocked, use compressed air to clean it.
21. Fit new internal and external plate-rings, lubricate the piston with clean transmission oil and assemble into the clutch housing.
22. Make a steel ring as shown in the illustration to replace the retainer plate for checking the clutch plate clearance.
23. Assemble all the clutch plates, friction and steel, into the clutch housing, fit the lock described in procedure 22 and replace the spring ring. There are five friction and five steel plates.
24. Apply a pressure of approximately 5 kgf (11 lb) to the clutch pack to compress all the plates.
25. Using a feeler gauge measure the gap between the plate and the underside of the spring ring. The distance should be 3.50-4.00 mm (0.138-0.157 in). If the gap is not correct add or take more shims between the discs and the retainer plate depending on the gap. Shims are available in the following sizes:

Clutch shim plates		
Part number	Modulo	Imperial
1870 010 M1	0.51 mm	0.020 in
1870 011 M1	0.76 mm	0.030 in

26. Remove the spring ring, checking ring and clutch plates.
27. Fit the spring and retainer ring.
28. Place the clutch assembly under a hydraulic press and using the bridge piece compress the spring and replace the steel ring.
29. If new friction plates are being used they should be soaked in clean transmission oil for a minimum period of 30 minutes before assembly.
30. Re-assemble the plates starting with a steel plate, alternating with a friction plate, finally fitting the steel plate(s).
31. Fit the retainer plate and spring ring.
32. Fit new PTFE sealing rings to the feed ring.
33. Re-assemble the feed ring, thrust washer and snap ring.
34. If necessary, replace the needle roller bearing in the gear hub.
35. With the aid of some petroleum jelly, stain the thrust washer inside the gear and hub.
36. Check that the spring ring (4) retaining the clutch



37. With the aid of two lengths of 3mm (1/8 in) diameter rod, opening ring and centre at the internal teeth of the friction discs.
38. With the aid of an air line compress the clutch pack so that all the plates are clamped tight.
39. With oil holding the pressure on the clutch pack, insert the hub and drive gear so that it passes down through the pack of plates. When fully installed the gear will be within approximately 3 mm (1/8 in) of the clutch housing.
40. If the clutch is not being fitted immediately it is recommended that some form of security band is placed around the clutch to retain the hub and drive gear in place.
41. Fit the clutch assembly.

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