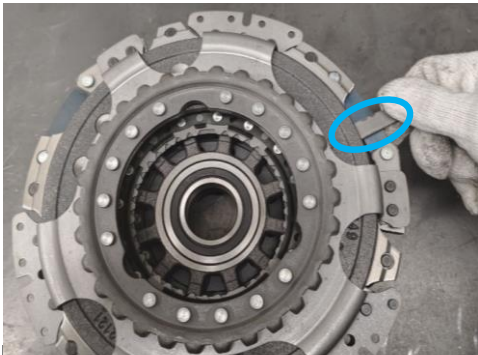


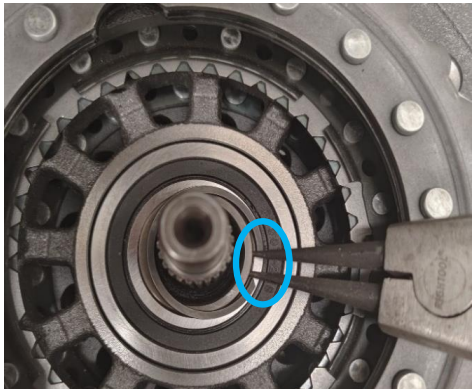
HKDCT1000 Installation Instructions



① Measure the free clearance of K1 and K2 by using feeler gauges, and then choose suitable washers according to the table below.



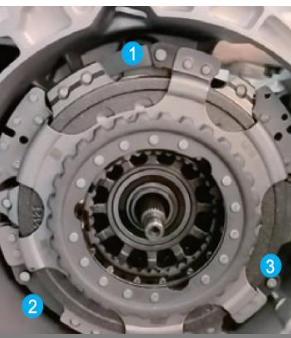
② Stand the gearbox vertically, install the selected washers on the release bearing first, then install the clutch vertically. Use the special indenter with the pressing tool to press the clutch into place.
Note: Hammer is strictly prohibited.



③ Install the snap ring with the snap ring pliers.

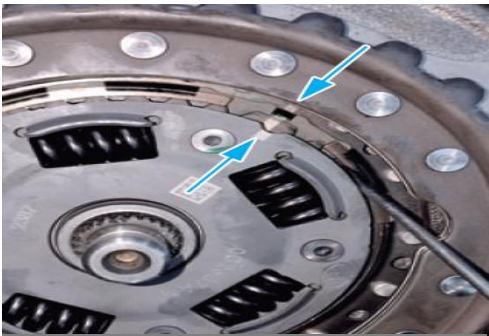


④ After installing the snap ring, use a special tool to turn the fork 2-3 times to eliminate the gap between the snap ring and the clutch.



⑤ Use feeler gauges to measure the clearance of the K1/K2 clutch in three measuring points. K1/K2 clearance must be between **0.5-0.8mm** at all measuring points.

! Be sure to adjust the clutch clearance to the recommended value before proceeding to the next step (A clutch adjusted to the right position will be more durable.)



⑥ Install the clutch disc hub and the snap ring.
Note: The hub can only be used in one position due to the wider gear tooth. The position of the ring must be centred in relation to the sheet metal tab.

Note:

- Before installing the clutch, firstly check if the large/small fork can move smoothly. If the release bearing rotation is flexible, then clean the gearbox housing, release the bearing and washers to prevent dust pollution of the new clutch.**
- The clearance may not reach the recommended value after first time installation, you can replace the washer with one of different thickness and reinstall it until the clearance is adjusted to the recommended value.**

Clutch release bearing washer matching table (recommended)

Standard clearance: K1(0.8mm-1.0mm); K2(0.6mm-0.8mm)			
K1 free clearance	Recommended washer thickness	K2 free clearance	Recommended washer thickness
1.1	2.0-2.2	1.1	0.8-1.0
1.2	2.2-2.4	1.2	1.0-1.2
1.3	2.4-2.6	1.3	1.2-1.4
1.4	2.6-2.8	1.4	1.4-1.6
1.5	2.8-3.0	1.5	1.6-1.8
1.6	3.0-3.2	1.6	1.8-2.0
1.6-1.8	3.0-3.3	1.6-1.8	2.2-2.8

NOTE

- Since there will be errors in the installation size of each gearbox, this table is for reference only.
- Washers for K2 allows combination.